ASTM F1807 Crimp™

American Society for Testing and Materials (ASTM) Standard Specification for **Metal Insert Fittings Utilizing a Copper Crimp Ring for SDR9 Cross-linked Polyethylene (PEX) Tubing and SDR9 Polyethylene of Raised Temperature (PE-RT) Tubing.**

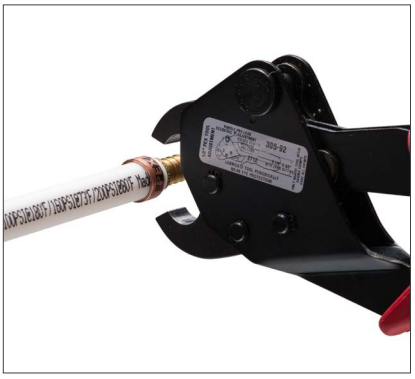
- F1807 fittings can be made from various listed materials. See ASTM standard for acceptable brass alloys. Assure your fitting is made from a listed material.
- F1807 systems use a copper crimp ring to compress around a fitting.
- Connection is made by positioning a crimp ring over a fitting's sealing barbs and compressing it into position.
- Fittings are reusable if barbs remain undamaged.

F1807 Installation

1. Cut tube at 90-degrees. Do not crush OD of tubing with cutters. Hint: Slightly rotate cutter during blade engagement.

2. Install PEX Crimp Ring onto OD of tubing.

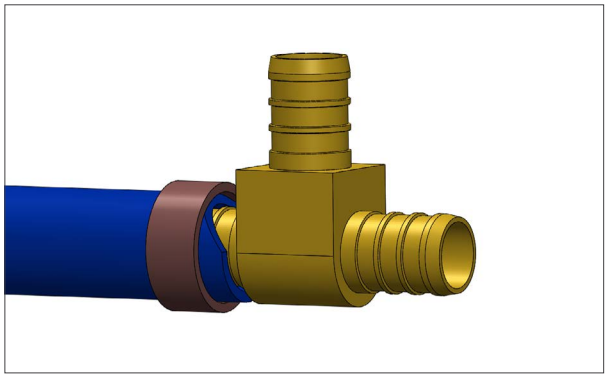
3. Install PEX fitting into tube end.



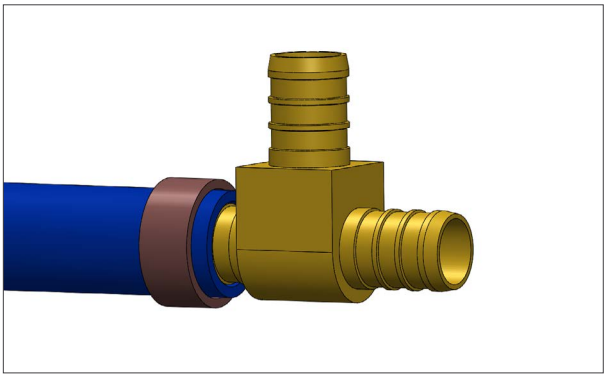
4. Position ring over sealing barbs of the fitting. The ring should be positioned approximately 1/8" to 1/4" from the end of the tube.

5. Compress tool perpendicular to tubing run. Compress only once. Remove defective connections. Use a gauge to assure a proper joint. Test completed joint.

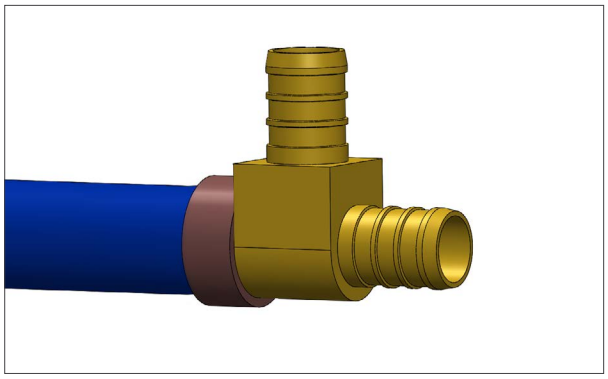
F1807 Application Problems



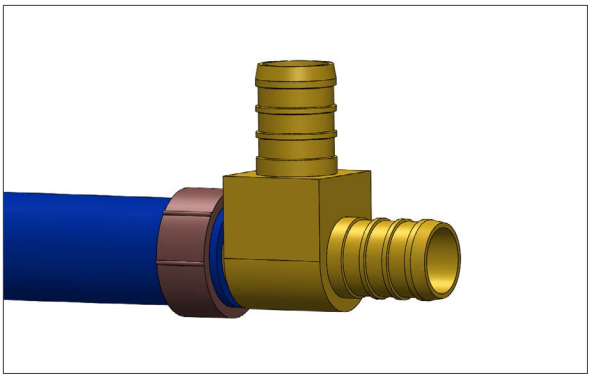
Tube not cut squarely – ring not compressing tube for a secure seal.



Fitting not inserted completely into tube end.

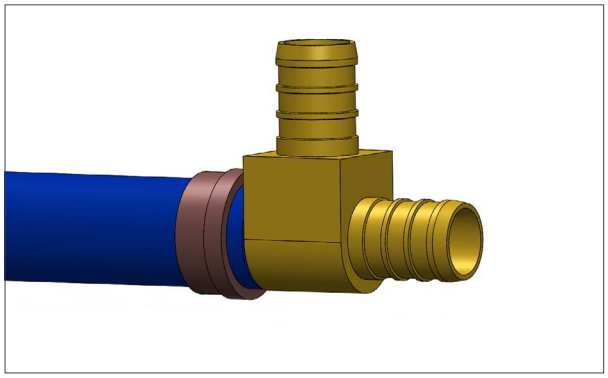


Ring not placed over sealing barbs of fitting. Ring too far forward or too far back & not fully over sealing barbs.



Crimp joint made with an improperly calibrated tool - not providing enough compression to joint.

Ring compressed multiple times possibly developing a leak path.



Crimp Tool did not engage the Crimp Ring over the entire surface of the ring.