

# PowerPEX<sup>®</sup>

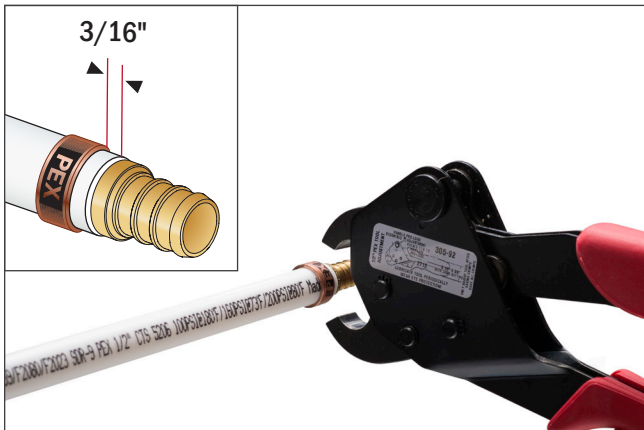
## ▶▶ ASTM F1807/F2159 Copper Crimp Ring Connection Guide



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. Install PEX fitting fully into tube end.

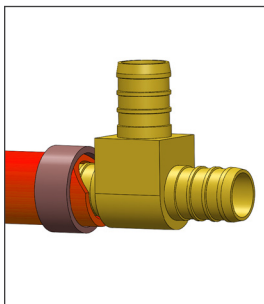


3. Position ring over sealing barbs of the fitting. The ring should be positioned  $3/16"$  ( $\pm 1/16"$ ) from the end of the tube.

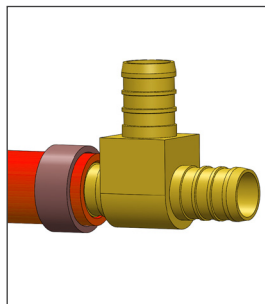


4. Compress tool perpendicular to tube. Compress only once. Remove defective connections. Use a gauge to assure a proper joint. Test all completed joints.

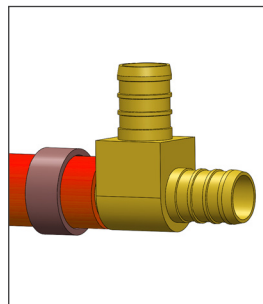
### Installation Notes: Take care to avoid the below issues when making joints with copper crimp rings



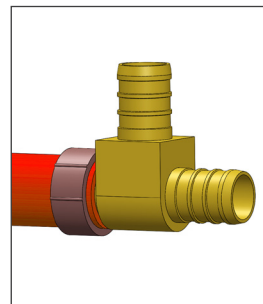
Tube not cut squarely - ring not compressing tube for a secure seal.



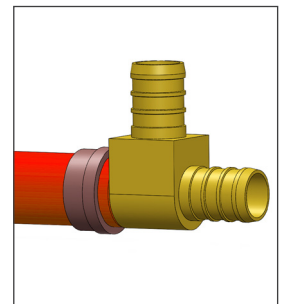
Fitting not inserted completely into tube end.



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



Improperly calibrated tool - not enough compression. Rings compressed multiple times may develop a leak path.



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