

1/2" & 3/4" LARGE PEX CRIMP TOOL

#23251



INSTRUCTION GUIDE

CRIMPS CONFORM TO ASTM F 1807

CONNECTION ASSEMBLY

Cut the tube so that a clean, straight end is provided. Slide the crimp ring over the tube end. Insert the fitting into the tubing until the shoulder of the fitting contacts the tubing end. Position the crimp ring 1/8" to 1/4" (3.2 to 6.4 mm) from the cut end of the tubing. Place the opened jaws of the PEX Crimp Tool around the crimp ring. Check to be sure that the crimp ring is still properly positioned. Compress the tool handles to complete the assembly.

CHECK ALL CRIMPS WITH GO/NO-GO GAGE

GAGING PROCEDURE

1. Determine proper size of tubing: 3/8", 1/2", 3/4" or 1"
2. If GO cavity fits over crimped ring and NO-GO does not, tool is crimping properly.
3. If GO cavity does not fit then handle distance must be increased.
4. If GO fits—check NO-GO. If NO-GO fits over crimped ring, the ring is over-crimped, decrease handle distance. Recheck.

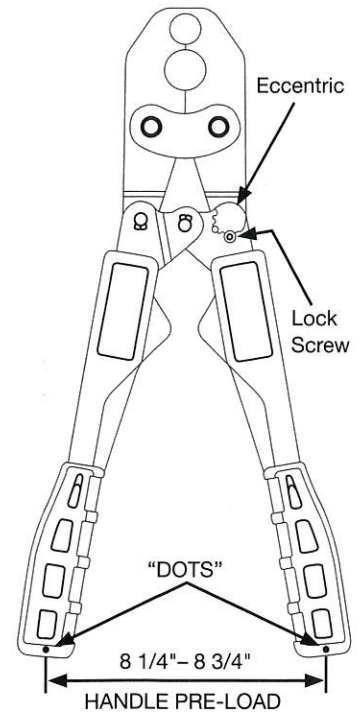
NOTE: Over-crimped and under-crimped rings must be removed from tubing. Crimp with a new copper ring.

ADJUSTMENT PROCEDURE

1. Close tool handles until pre-load is reached (this is the point at which jaws touch). Tool should not be completely closed.
2. Measure the distance between dots on the handle ends as shown. 8 1/4" – 8 3/4" is the correct distance. If the distance is not 8 1/4" – 8 3/4" the tool must be adjusted.
3. To change the handle ends distance, remove the #6-32 eccentric lock screw with an Allen wrench and push up eccentric from back. Rotate eccentric counter-clockwise to increase the handle distance and clockwise to decrease handle distance. Move eccentric until handle distance is between 8 1/4" – 8 3/4". Push down eccentric and re-install the #6-32 lock screw in the appropriate hole which most closely yields the desired handle distance.
4. Recheck the set distance after making three crimps. The distance should be 8 1/4" – 8 3/4" between the "dots" on the handles.
5. Check the crimps with the go/no-go gauge provided. If satisfactory crimps do not result, the tool is likely worn and should be replaced.

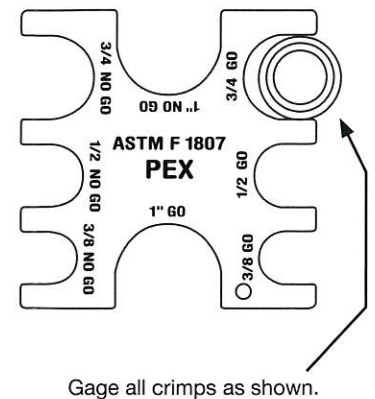
TOOL MAINTENANCE

1. Check tool calibration daily. It is recommended that at least the first and last crimps of the day are tested.
2. Never exceed the specified handle distance when adjusting your crimp tool. Premature wear will result.
3. Lubricate linkages on a regular basis to maximize tool life.



WARRANTY

When properly maintained and used as intended, the PEX Crimp Ring Tool is warranted against materials and manufacturing defects for a period of 1 year from date of purchase. This Warranty does not cover defects or damage arising from improper installation, lack of or improper maintenance, improper storage or handling, ordinary wear and tear, misuse, abuse, accident or use of parts with unauthorized products or parts. Liability is limited to repair or replacement of tool or component parts which are determined defective as covered by this Warranty.



Gage all crimps as shown.

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