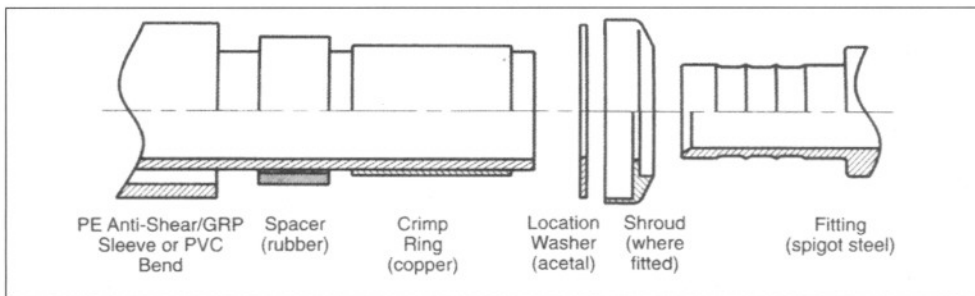


## Crimp jointing instructions - PE

### Tool required: Appropriate sized hand crimping tool (16mm - 63mm)

1. Cut polyethylene pipe to the required length. Ensure that the pipe is square and free from all burrs.
2. Slide the anti-shear/GRP sleeve or PVC bend onto the pipe as appropriate.
3. Slide the rubber spacer onto the pipe.
4. Remove and discard the cardboard protection. Slide the copper crimp ring onto the pipe.
5. Threaded fittings must first be installed in the required position as subsequent rotation would damage the crimp joint.
6. Push the pipe fully onto the spigot of the fitting.
7. Slide the crimp ring down the pipe to touch the acetal location washer (which should be in contact with the shoulder of the fitting, or in the recess of the shroud, where fitted).
8. Select the correct size of crimping tool and position centrally over the crimping ring. The shroud should be rolled back to avoid damage. Close the jaws of the tool lightly over the crimp ring and, once again, check that the tool is centrally positioned and completely covers the ring. Screw the arms of the tool fully together (ie. Until both crimp jaws fully close) to complete the joint. **DO NOT** attempt to re-crimp once the tool has been removed from the joint.
9. Remove the crimp tool and slide the rubber spacer onto the crimped ring. Connect the fitting and locate the anti-shear/GRP sleeve or PVC bend as necessary.
10. Test the service to the appropriate industry standards.
11. Apply protective wrapping as appropriate.
12. Check installation for compliance against statutory regulations.



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