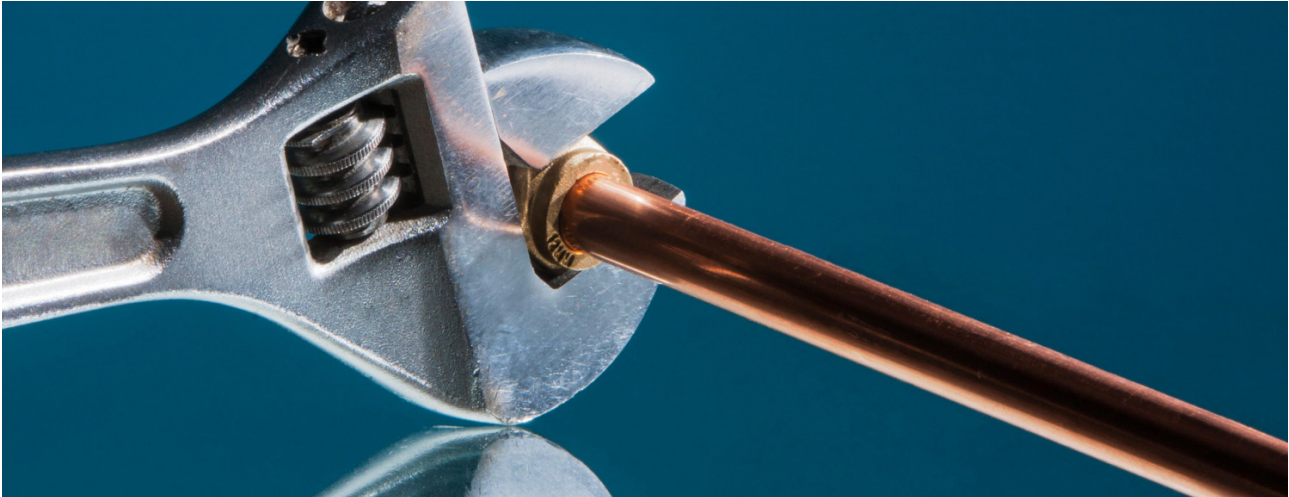


Compression Installation Instruction Data Sheet



Preliminary Information:

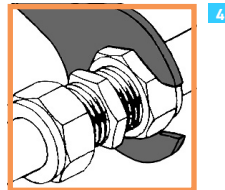
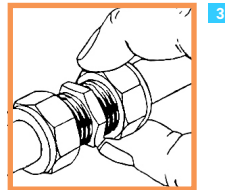
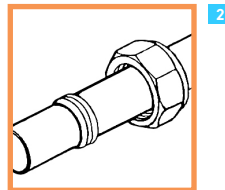
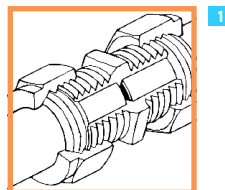
- A. The correct tube and fitting should be selected
- B. The sealing surfaces of the tube and fitting, including threads, should be clean and free from damage or contamination
- C. Application of a light oil to the threads can be helpful when using 35mm-54mm fittings

Assembly Preparation:

- A. Cut the tube square using a clean rotary cutter. If other cutting methods are used, such as a saw or hacksaw, use a clean, fine-toothed blade
- B. All burrs must be removed from the tube using a fine-toothed file or a deburring tool
- C. Ensure the copper tube is clean, not damaged or oval

Assembling the Fitting and Tube:

- A. Remove the nut and olive from the fitting
- B. Put the nut and olive onto the tube
- C. Insert the tube into the fitting, ensuring it is up to the tube stop ¹
- D. Move the olive and nut down the tube to meet the threads of the fitting ²
- E. Hand tighten the nut to the fitting ³
- F. The nut should then be tightened with a spanner ⁴



Further Installation Details:

- In rare cases there can be a small weep from the joint. If this is the case the nut can be removed, and an approved jointing compound applied to the sealing face before re-tightening the nut. It is also possible to apply PTFE tape to the threads instead
- Ensure the nut is not overtightened. If in doubt, please contact us
- In normal operating conditions, after hand tightening the nut, the number of turns required to form a robust joint would be:
 - i. 10-28mm 1 turn
 - ii. 35-54mm ¾ turn

Torque Settings:

15mm	40Nm
22mm	60Nm
28mm	80Nm
35mm	120Nm
42mm	180Nm
54mm	240Nm