Making Viega PureFlow Crimp Connections

1. The tubing should be cut squarely and evenly without burrs. Uneven, jagged or irregular cuts will produce unsatisfactory connections.
2. The diagram shows a correctly cut tube compared with an incorrectly cut tube.
3. Slide the crimp ring onto the tubing and insert the fitting into the tube to the shoulder or tube stop.
4. Position the ring ⅛" to ¼" from the end of the tubing.
5. The ring must be attached straight. Center the crimping tool jaws exactly over the ring. Keep the tool at 90° and close the handles until it stops.

CAUTION!
Do not crimp twice!

1. When checking crimp connections with a caliper (GO/NO GO gauge), push the gauge STRAIGHT DOWN over the crimped ring. NEVER slide the gauge in from the side. Do not attempt to gauge the crimp at the jaw overlap area. The overlap area is indicated by a slight removal of the blackening treatment. A crimp is acceptable if the GO gauge fits the ring and the NO GO does not. A crimp is unacceptable if the GO gauge does not fit the ring or the NO GO gauge does fit. An incorrect crimp must be cut out of the tubing and replaced. If you check the crimp connections with a micrometer or caliper, use the dimensions shown in the table.

6. Crimp outside diameters should fall within the dimensions listed in the table below when measured with a micrometer or caliper.

<table>
<thead>
<tr>
<th>Ring Size (in)</th>
<th>Minimum (in)</th>
<th>Maximum (in)</th>
</tr>
</thead>
<tbody>
<tr>
<td>⅛</td>
<td>0.580</td>
<td>0.595</td>
</tr>
<tr>
<td>⅛</td>
<td>0.700</td>
<td>0.715</td>
</tr>
<tr>
<td>⅛</td>
<td>0.945</td>
<td>0.96</td>
</tr>
<tr>
<td>1</td>
<td>1.175</td>
<td>1.19</td>
</tr>
</tbody>
</table>

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Adjustment Procedure

This tool is adjusted at the factory and no further adjustment should be required before first use.

7. Should the tools, through extended use, require adjustment, follow these instructions:
   - Close tool handles until pre-load is reached (this is the point at which jaws meet).
   - Measure the distance between dots on the handle ends as shown. The correct distance is 8" to 8¼".
   - To increase the pre-load setting, remove the #6-32 eccentric lock screw (A) and push up eccentric from back to disengage. Rotate counter-clockwise to increase the handle pre-load and clockwise to decrease handle pre-load. Push down eccentric and re-install the #6-32 lock screw (A) in the appropriate hole which most closely yields the desired handle dimension.
   - Recheck the set distance after making three crimps.
   - Check the crimps with the Go/No-Go gauge provided. If crimps do not pass testing, the tool is likely worn and should be replaced.

Tool Maintenance

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