**Product Instructions**
**Viega PureFlow® Crimp Compact Angled Hand Tool**

1. With the pipe, fitting, and crimp ring in assembly position: Pull back on the upper, moving handle and hold both handles closed with jaws in full open position.
2. Position jaws around the crimp ring.
3. Gently release hand pressure on the moving handle to let the jaws close properly and squarely over the crimp ring.
4. Firmly press the handles to complete the crimp.
5. Pull back on the moving handle to release the tool from the crimp ring.

**Dimensions of crimp ring after a proper, single crimp**

<table>
<thead>
<tr>
<th>Nominal Tube Size</th>
<th>Minimum (in)</th>
<th>Maximum (in)</th>
</tr>
</thead>
<tbody>
<tr>
<td>¾&quot;</td>
<td>0.58</td>
<td>0.60</td>
</tr>
<tr>
<td>½&quot;</td>
<td>0.70</td>
<td>0.72</td>
</tr>
<tr>
<td>⅜&quot;</td>
<td>0.95</td>
<td>0.96</td>
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</table>

**WARNING!**
Imported crimp tool instructions: read before use. Do not use this tool unless you can execute a proper crimp according to approved methods and recognized standards.

**Making a Crimp**

If you cannot complete a proper crimp with your tool (including the ability to apply enough force to make the tool work correctly) discontinue use of the tool.

**CAUTION!**
Do not crimp twice.

**Completed crimps must meet the dimensional requirements of ASTM F1807 and F2159 fitting standards.**

Check the first and last crimp of the day using either the included crimp caliper (GO gauge), Viega’s crimp caliper (part number 53507) or other suitable measuring device.

- Do not make the measurement at the scarred (jaw overlap point) portion of the ring.
- If the GO side does not fit over the ring, it is under cramped. The connection must be cut out, the fitting replaced and new crimp rings used. The tool must be adjusted before proceeding.
- The dimensional accuracy of the crimp caliper can be affected by normal field wear and tear. Therefore, it is recommended you check it with a suitable measuring device or change to a new gauge regularly to ensure measurement accuracy.
- The PureFlow crimp compact angled hand tool is user adjustable. When the tool makes unsatisfactory crimps it must be adjusted.