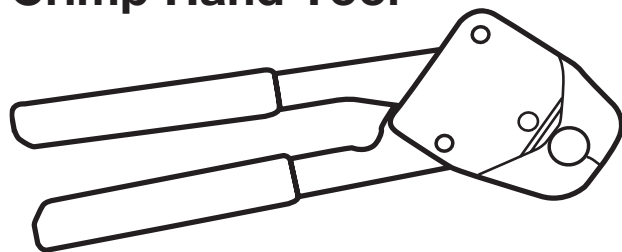


# Compact Angled PEX Crimp Hand Tool

**viega**



Congratulations on Purchasing the Compact Angled PEX Crimp Hand Tool, a full-circle crimp tool for PEX tubing. Use the Compact Angled PEX Crimp Hand Tool to install only manufacturer-approved crimp rings, pipe and fittings.



The Compact Angled PEX Crimp Hand Tool handles do not open like pliers. Forcing the handles apart could cause tool failure.

Use this tool to crimp only copper crimp rings made to ATSM F1807, F2159, and brass, copper, or plastic fittings for ASTM F876/F877 SDR9 PEX tubing. Tool may also be used to make crimp connections with PB tubing and appropriate rings and fittings.

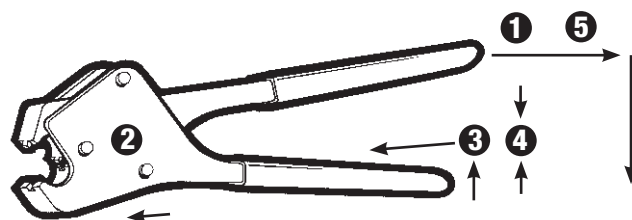
## Important Crimp Tool Instructions: Read Before Using

**DO NOT USE THIS TOOL UNLESS YOU CAN EXECUTE A PROPER CRIMP ACCORDING TO APPROVED METHODS AND RECOGNIZED STANDARDS.**

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.

### Operating Instructions:

- 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. (see illustration)
- 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 together to complete the crimp.  
**DO NOT CRIMP TWICE.**
- 5 Pull back on the moving handle to release the tool from the crimp ring.



- Completed crimps must meet the dimensional requirements of ASTM F1807, F2159, F845 or F1380 fitting standards.

### Dimensions of crimp ring after a proper, single crimp:

Nominal Tube Size	Minimum	Maximum
3/8"	0.580"	0.595"
1/2"	0.700"	0.715"
3/4"	0.945"	0.960"

The maximum out-of-roundness of a completed crimp shall not exceed .006". This is the difference between the minimum outside diameter of a properly crimped ring and the maximum outside diameter of the same properly crimped ring.

- Check each crimped ring with the Crimp Caliper (Viega stock code 53507) or other suitable measuring device.
- DO NOT make the measurement at the scared (jaw overlap point) portion of the ring.
- If the GO side does NOT fit over the ring, it is under crimped. The connection must be cut out, the fitting replaced and new crimp rings used. The tool must be adjusted before proceeding.
- If the NO GO side fits over the ring, it is OVER crimped. The connection must be cut out, the fittings replaced and new crimp rings used. The tool must be adjusted before proceeding. See "Tool Adjustment Procedures".
- Refer to the fitting and tubing manufacturer's product assembly instructions for the correct procedure for joining and gauging.
- 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 Compact Angled PEX Crimp Hand Tool is user adjustable. When the tool makes unsatisfactory crimps it must be adjusted.
- The Compact Angled PEX Crimp Hand Tool must be checked for correct adjustment at the start of every day. Each crimp ring shall be gauged to ensure that it has been crimped properly and for the accuracy of the tool.

### Maintenance Instructions:

Tool maintenance can effect the life of your Compact Angled PEX Crimp Hand Tool and the quality of the tool's crimp. Lubricate the pivot points frequently with light oil to ensure smooth action and maximum tool life.

**DO NOT ATTEMPT TO REPAIR THE TOOL. FOR TOOL INFORMATION, CALL VIEGA, AT 800-976-9819.**

**IMPORTANT:** The Compact Angled PEX Crimp Hand Tool is under limited warranty for twelve (12) months from date of purchase. To ensure warranty availability, fill out the information on the reverse side and retain with a dated proof of purchase. Please include a copy of your proof of purchase when returning your tool for any adjustment or repair covered under warranty.

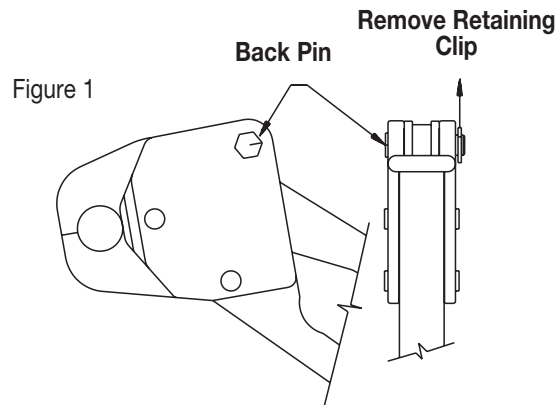
**TEL 800-976-9819 • FAX 800-976-9817**

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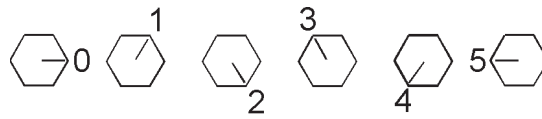
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## Tool Adjustment Procedures:

- 1 Note the number to which the line on the hex head of the back pin points.
- 2 Carefully remove the retaining clip (see Figure 1) by inserting a small flat blade screwdriver in the loop of the clip and turning the screwdriver. CAUTION! The retaining clip is made from spring steel and may fly off of the pin if not removed carefully, possibly causing eye damage and loss of the clip.



- 3 From the clip end of the back pin, push it towards the tool body until the hex head on the other end of the pin just clears the body.
- 4 Rotate the pin until the line on the hex head points to the next higher number on the frame.



To Reduce Crimp Size,  
Rotate Back Pin to Next Higher Number

- 5 Push the pin back into the frame and replace the retaining clip.
- 6 Crimp a test joint and check crimp ring for proper sizing with GO/NO-GO gauge or measurement. Severely worn tools may require further adjustment. As the tool continues to wear with use, simply repeat these instructions as required.

Viega, LLC Limited Warranty

### The Compact Angled PEX Crimp Hand Tool

Viega warrants that the Compact Angled PEX Crimp Hand Tools sold by Viega, under normal conditions of use, shall be free from failure caused by manufacturing defects for a period of twelve (12) months from date of sale.

This limited warranty does not apply: (1) if the failure is due to abuse in handling, using, storing, or maintaining the tool; (2) if the failure of the tool is the result of use of the tool in non-recommended application; (3) if the failure is due to unauthorized tampering (attempted repairs or adjustments) to the tool.

THE ABOVE LIMITED WARRANTY IS IN LIEU OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING THE IMPLIED WARRANTIES OF THE MERCHANTABILITY. Other than this limited warranty, Viega does not authorize any person or firm to create for it any other obligation or liability in connection with its products.

If there is a failure covered by this limited warranty during the warranty period, such failure must be reported within thirty (30) days to Viega, after such failure is discovered. Warranty claims and questions should be directed to Viega's sales department by writing to the address below or telephoning, toll free, 800-976-9819 to obtain a return merchandise authorization and directions on shipment. Within a reasonable time after notification, an investigation of the claimed failure will occur. If the conditions of the limited warranty are met, Viega will perform, free of charge, necessary repairs and return the tool, or, if repairs are not possible, a replacement tool will be provided. THESE ARE THE EXCLUSIVE REMEDIES FOR BREACH OF THIS LIMITED WARRANTY.

NEITHER THE MANUFACTURER OF THE TOOL NOR VIEGA SHALL BE LIABLE FOR CONSEQUENTIAL, SPECIAL OR INCIDENTAL DAMAGES BASED UPON BREACH OF WARRANTY, BREACH OF CONTRACT, NEGLIGENCE, STRICT TORT, OR ANY OTHER LEGAL THEORY, AND REGARDLESS OF WHETHER ASSERTED BY DIRECT ACTION, FOR CONTRIBUTION OR INDEMNITY, OR OTHERWISE. Such damages include, but are not limited to, damage to property and other economic loss, but do not include personal injury damages.

Some states do not allow the exclusion or limitation of incidental or consequential damages or implied warranties in certain types of transactions, so the above exclusion or limitation may not apply to you. This limited warranty gives you specific legal rights, and you may also have other rights which vary from state to state.

Viega LLC  
301 N. Main St. Floor 9  
Wichita, KS 67202

08.11

800-976-9819 (Continental U.S.) 316-425-7400 (outside U.S.)

PI-PF-560629-0811

Purchaser's Name \_\_\_\_\_ Tool Model No. \_\_\_\_\_

Address \_\_\_\_\_ Tool Serial No. \_\_\_\_\_

City \_\_\_\_\_ State \_\_\_\_\_ ZIP \_\_\_\_\_ Date Purchased \_\_\_\_\_

Tool Purchased From \_\_\_\_\_