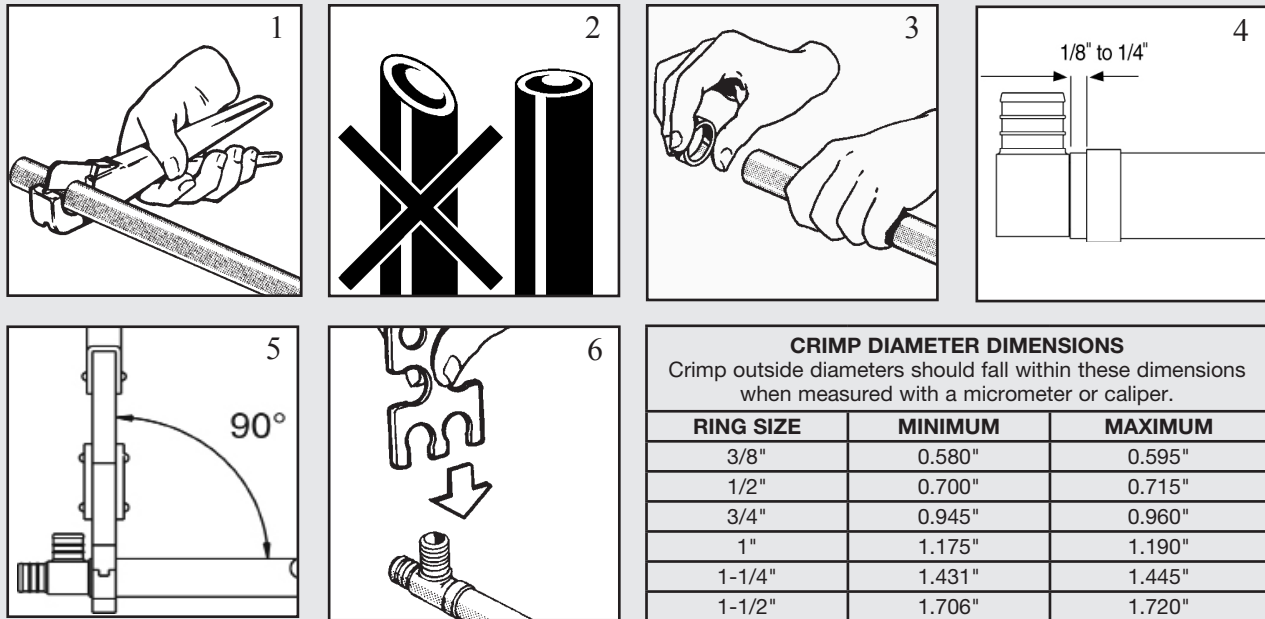


Product Instruction

Making Zero Lead PEX Crimp Connections



CRIMP DIAMETER DIMENSIONS		
Crimp outside diameters should fall within these dimensions when measured with a micrometer or caliper.		
RING SIZE	MINIMUM	MAXIMUM
3/8"	0.580"	0.595"
1/2"	0.700"	0.715"
3/4"	0.945"	0.960"
1"	1.175"	1.190"
1-1/4"	1.431"	1.445"
1-1/2"	1.706"	1.720"

1. The tubing should be cut squarely and evenly without burrs. Uneven, jagged or irregular cuts will produce unsatisfactory connections.
2. A correctly cut tube compared with an incorrectly cut tube.
3. Insert the fitting into the pipe to the should or tube stop. Position the ring 1/8" to 1/4" from the end of the tubing.
4. The ring must be attached straight. Center the crimping tool jaws exactly over the ring. Keep the tool at 90° and close the handles completely. **DO NOT CRIMP TWICE.**
5. When checking crimps with a 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.
6. You have a **good crimp** if the GO gauge fits the ring and the NO GO does not. You have a **bad crimp** if the GO gauge does not fit the ring or the NO GO gauge does fit. Bad crimps must be cut out of the tubing and replaced. If you check the crimps with a micrometer or caliper, use the dimensions shown in the chart above.

"ZERO LEAD" identifies Viega products meeting the lead free requirements of California and Vermont law, effective January 1, 2010, as tested and listed against NSF- 61, Annex G

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301 N. Main, 9th Floor • Wichita, KS 67202 • Ph: 800-976-9819 • Fax: 800-976-9817 • E-Mail: service@viega.com • www.viega.com

PI-PF-521112-1009 (Zero Lead PEX Crimp)