

# Installation Instructions

The DuoPEX Crimp System is simple and effective when executed in accordance with these jointing procedures.



**For more installation tips:**

- Pick up a copy of the DuoPEX Water Manual from your nearest Reece Store
- Visit [www.auspex.com.au](http://www.auspex.com.au)
- Call (03) 9770 3600
- Email [salesauspex@rmc.com.au](mailto:salesauspex@rmc.com.au)

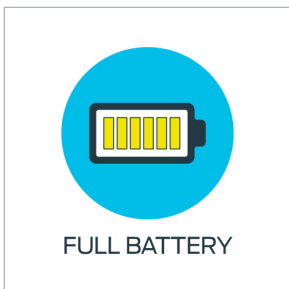
## Making A Joint

It is most important that the tool manual supplied with the tool is read in its entirety and the user becomes familiar with the maintenance, precautions and the proper use of this tool.

The following describes, in general terms, the jointing procedures but should not be regarded as a substitute for reading and applying the detailed instructions contained in the tool manual.

### Ineffective crimp may occur if:

- The crimping tool has not been completely closed
- Crimping ring is pinched
- The pipe has been cut badly out of square
- The fitting has been double crimped



### Step 1

Ensure that the battery is fully charged and attach it to the tool.

### Step 2

Select the jaw size to suit the fitting to be crimped. The jaws must be examined in terms of possible damage or dirt in the compression area.

### Step 3

To change the jaw push the pin in and turn pin to unlock.

### Step 4

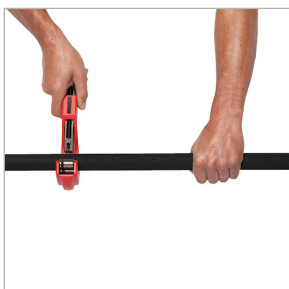
Insert the jaws and line up the holes in the tool with the hole in the jaw.

### Step 5

Push the pin through the hole in the jaw and turn pin to lock.

### Step 6

Cut the pipe to the required length with the recommended multi-layer pipe cutters.



### Step 7

Insert the approved calibrating/ deburring tool into the pipe, and then alternately turn in a clockwise and in a counter-clockwise direction. Ensure that a consistent, smooth chamfer is formed on the end of the pipe.

### Step 8

Insert the pipe into the fitting and under the stainless steel ring and push the pipe until it is visible in the slots of the plastic sight ring (witness hole). This ensures you have pushed the pipe home.



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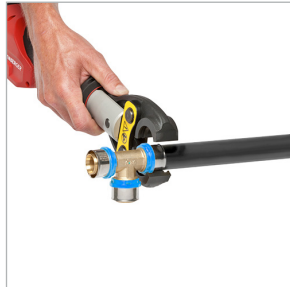
## Step 9

By squeezing the back of the jaw, the jaws will open. If you look at the machined profile on the inside of the jaws you will note a slot on each side of the profile.



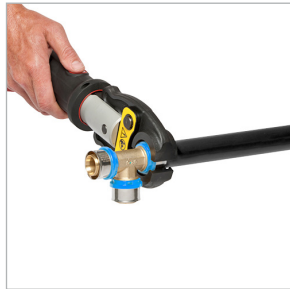
## Step 10

With the jaws open, place the fitting inside the jaws so that the raised section of the plastic sight ring fits into the slot in the jaws.



## Step 11

Release the jaws so they fit snugly over the fitting, ensuring that the raised section of the plastic sight ring is still located in the slots in the jaw.



## Step 12

Press the switch mechanism until the joint is completed and the piston has retracted back into the body of the tool.

Ensure that the tool jaws are fully closed and touch each other prior to tool retraction.



## Step 13

Press the back end of the jaws and remove the completed joint.



## Step 14

Visually inspect the crimped ring has been adequately pressed as illustrated.

