



4.0 INSTALLATION INSTRUCTIONS

TECTITE INSTALLATION INSTRUCTIONS

COPPER, CHROME PLATED COPPER, STAINLESS STEEL SYSTEM AND CARBON STEEL SYSTEM TUBES



1. Select the correct size of tube and fitting for the job. Ensure both are clean, in good condition and free from damage, scores and imperfections. Do not use any additional lubricant or sealing compounds. Cut the tube square using a rotary tube cutter wherever possible. Take care to ensure that the tube end is deburred and chamfered. If the tube is oval or damaged, use a re-rounding tool.



2. Remove any burrs or sharp edges from the external tube end using either the T110 (Tectite Classic and Tectite Pro) or the T115 (Tectite Sprint and Tectite Carbon) 3-in-1 Tectite deburring, scribe tool and socket depth marker or the S120 deburring tool from the XPress accessories range. Also, ensure the internal bore is deburred. For deburring stainless steel tube ends a fine toothed file should be used.

Then wipe clean the tube end to remove all swarf and debris - this helps to avoid damage to the 'O' ring when inserting the tube.

An alternative method of preparing copper tube ends 35-54mm before inserting into the fitting, is to use the appropriately-sized S122 percussion deburrer (not for carbon steel tube) featured in the XPress accessories range. Place the cup of the deburrer onto the end of the tube and strike it with a sharp blow from a copper-faced hammer. As well as removing burrs and sharp edges, this tool also creates a slight taper that aids insertion into the fitting. If 10mm R220 annealed copper tube is being used, ensure a T67 support liner is fully inserted into the tube.



3. To make a perfect joint, the tube must be fully inserted in the fitting until it meets the tube stop. To confirm that this is the case, mark the socket depth on the tube or pipe using the T111/T115 socket depth marker (Tectite Classic, Tectite Pro & Tectite 316) or a tape measure and a marker/pencil. For the socket depth of each size of fitting, see tables. The socket depth can occasionally be obscured by the collar of the fitting so we recommend adding a 'V' mark over the depth mark line as this will always be visible.

NOTE: The T111 Tool is designed for marking Tectite flexible metal tube as well as copper, PEX and PB. For 15 and 22mm tube you must ensure you are using the correct side of the tool as the depth mark is shorter for Tectite flexible metal tube to take into account of the depth of the TectSEAL™



4. When jointing chrome-plated copper tube with Tectite Classic, Tectite Pro and Sprint fittings, scribe the tube using the T110/T115 (Sprint) scribing tool to ensure positive grab ring location. This helps to accommodate any variance in chrome plate thickness. Note: The scribing function is not suitable for stainless steel tube.

