

Gas Plus—Jointing Instructions



1. Cut pipe

Cut pipe to desired length. Cut should be square and free from any swarf or burrs. Use REMS pipe cutter or similar. Do not use a hacksaw as this creates excessive swarf.



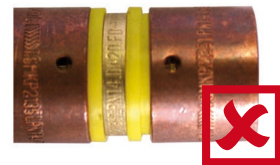
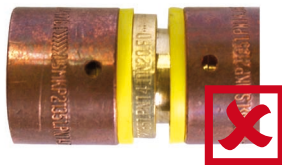
2. Round pipe

Insert rounding tool into cut pipe to correct any flattening that may have occurred during cutting.



3. Check fitting assembly

Ensure that the copper crimp ring and plastic ring retainer are assembled correctly onto the fitting. Both can be pushed on by hand if they have moved away from the fitting shoulder. Witness hole should be located toward the inwards end of each barb.



4. Insert pipe

Slide pipe onto fitting until it reaches the depth stop. Pipe should be fully visible through the witness holes on the crimp ring.



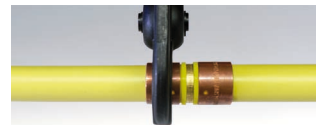
5. Crimp tool positioning

Position crimping tool evenly over the copper crimp ring. You should leave a similar distance between the outside of the jaw and the end of the crimp ring at both ends. Crimp tool should be placed at 90° to the pipework.



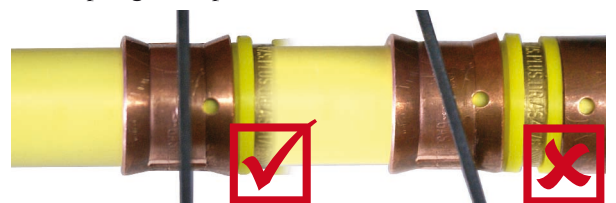
6. Crimp

Fully close jaws of the crimping tool to compress the copper crimp ring. Do not compress the plastic ring retainer.



7. Check crimp ring

Finally and most importantly, check the crimp ring dimension by placing the crimp gauge over the centre of the indented ring on the crimp sleeve. On a correctly crimped fitting the crimp gauge should pass freely over the crimp ring at this point.



8. Pressure test

At completion, carry out pressure testing as required per AS 5601–2004 and or any requirements specified by local authorities.