

# PowerPEX<sup>®</sup>

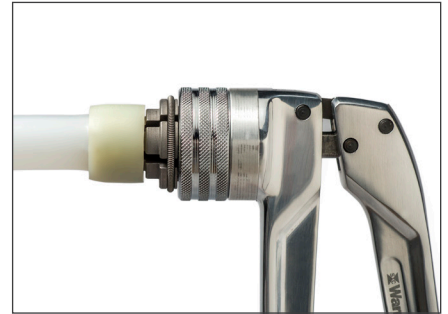
## PEX Expansion Ring Connection Guide For use with ASTM F1960 Fittings



1. Cut tube at 90-degrees. Do not crush OD of tubing with cutters. Hint: Slightly rotate cutter during blade engagement.



2. Install PEX sleeve onto OD of tubing.



3. Using expander tool, expand sleeve fully. Repeat expansions, rotating expander 1/8-turn between expansions.



4. Insert fitting into expanded tube and sleeve. Hold fitting in place until tube/sleeve constricts annularly around the fitting.



5. The installation is complete with a visibly secure connection. Remove defective connections. Test all completed joints.

Note: All ASTM F1960 PEX expansion joints made using PowerPEX Type-B tubing **MUST** be made with a self-rotating, power expansion tool to eliminate weak spots and avoid improper expansion rates.

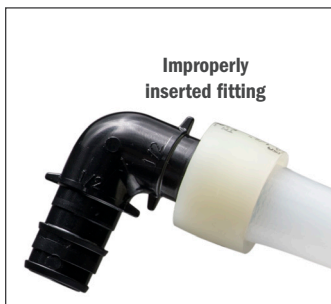


### Cold-Weather Installation: Special considerations for making F1960 PEX expansion joints in low temperatures

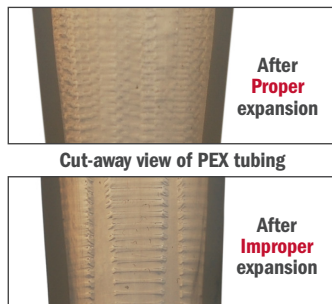
In temperatures below 55°F, keep tube/sleeves warm to ensure uniform expansion and decrease the time needed to fully constrict around fitting. Store sleeves in a warm area above 55°F (e.g. pockets). In colder temperatures, fewer expansions are needed. Use only enough tool expansions/rotations to allow full insertion of the fitting. Both lower temperatures and over-expansion of the tube/sleeve will increase the time needed to fully constrict and complete the joint.

**Do Not** make connections in temperatures below 5°F. **Do Not** apply heat with a heat gun - Excessive heat may damage tube/sleeves/fittings.

### Installation Problems: Take care to avoid the below issues when making joints with PEX expansion rings



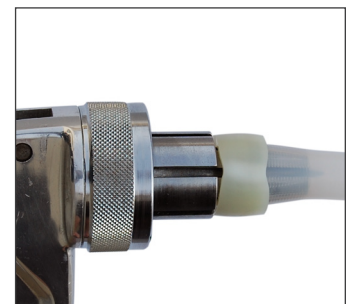
Be sure tubing is cut squarely, tube is inserted into sleeve completely and fitting is inserted fully into tube/sleeve



No rotation between expansions, or defective expansion head leaving a groove as a potential leak path.



Damaged, cut or grooved barb on fitting.



Failure to rotate tool inside tubing may cause unequal expansion. Remove any rings with unequal expansion.

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