



Zurn PEX Crimp Tools – QCRT2CM, QCRT3CM, QCRTJCM, QCRT4CM Operating Instructions

Operating Instructions

Use the crimp tool to install only manufacturer-approved pipe or tube used with copper crimp rings and brass, copper, or plastic fittings manufactured to appropriate ASTM standards for polyethylene and polybutylene pipe installation. **Always refer to the tube manufacturers' product assembly instructions when using the crimp tool.**

To Crimp with Tube, Fitting, and Ring in Place:

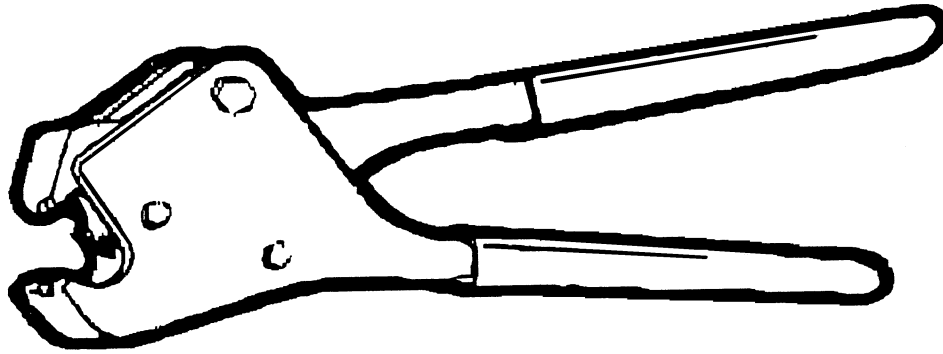
1. Pull back on the moving handle and open the jaws full.
The crimp tool does not work like pliers. Do not force the handles apart.
2. Position jaws squarely around the ring.
3. Gently open the handles to close jaws on the ring.
4. Squeeze handles together to complete the crimp.
One crimp per ring only!
5. Pull back on moving handle to release jaws from the crimped ring.

6. Measure the crimped ring with Zurn "Go-No Go" gage. See table below. Do not measure bumps on ring where jaws meet. If "Go" on gage does not fit, or if "No Go" does fit, then cut out connection, replace fitting and ring, adjust and calibrate the tool, and recrimp.

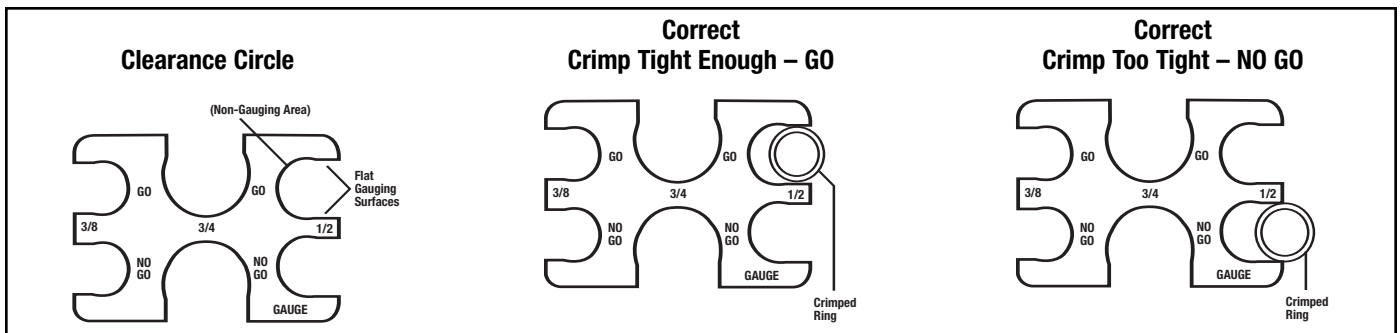
The following dimensions are the ASTM maximum and minimum crimped ring diameters for polyethylene (PEX) and polybutylene (PB) pipe installations.

Std. Tube Size >	3/8"	1/2"	5/8"	3/4"
Min. Diameter	0.580"	0.700"	0.815"	0.945"
Max. Diameter	0.595"	0.715"	0.830"	0.960"

Variation in ring diameter (out-of-round) should not exceed 0.006".



Using the Zurn PEX Crimp Gauge Properly: Crimp Gauge Instructions



1. The flat portion of the opening is the gauging area.
2. The "Go" opening should go freely across a crimped ring anywhere on its diameter with the possible exception of the upset area of the ring surface caused by the tool jaws closing. Do not force the gauge across the ring.
3. The "No Go" opening should not go across a crimped ring anywhere.
4. The gauge should always be pushed across the crimped ring from the side. **Do not** slide the gauge along the tube up to the crimped ring.

Note: Fitting and tube are not shown in illustrations for clarity. The Zurn PEX Crimp Gauge is to be used only on crimp rings that have been crimped onto tube and fittings.

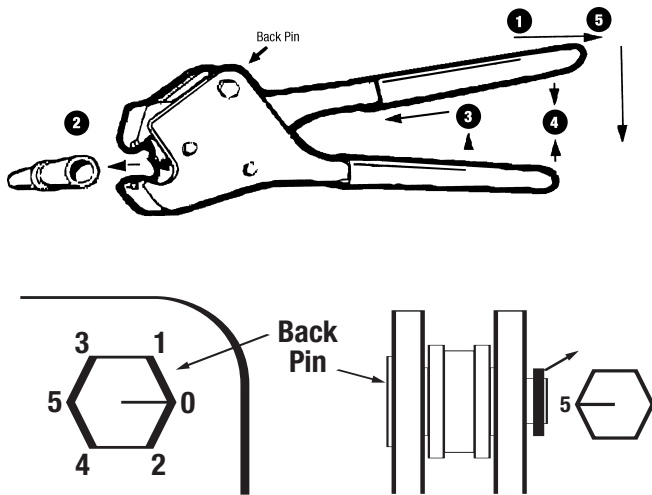
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Zurn PEX Crimp Tools – QCRT2CM, QCRT3CM, QCRTJCM, QCRT4CM Adjustment Instructions



Adjustment Instructions

All crimp tools wear, which increases the crimp diameter after many crimps. When the crimps start to approach the maximum ring diameter, then adjust the back pin (see the table, below right and the figure below). To adjust for a tighter crimp, remove the E-clip (for example, pop it off with a screwdriver), slide the back pin head out about 1/4 inch, rotate the back pin until the line on the hex head points to the next highest number on the tool body, push the pin back in, and refit the E-clip. Five adjustments are available.



For a tighter crimp, turn mark on pin to the next number:



Maintenance

For easier, better crimps and longer tool life, keep tool clean and rust-free inside and out. Lubricate all moving parts frequently with light oil.