

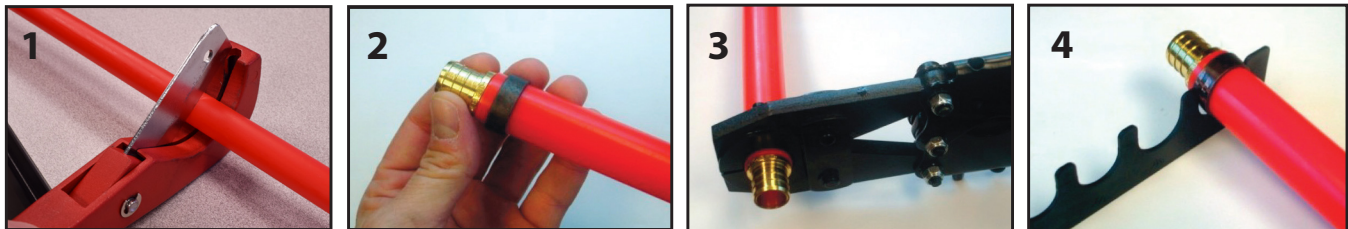
Legend Crimp Tool

Installation Guide

The Legend Crimp Tool is designed for use with copper crimp rings in combination with brass insert fittings, meeting the requirements of ASTM F1807 or plastic insert fittings meeting the requirements of ASTM F2098. The Legend Crimp Tool should only be used on crimp fittings and flexible plastic tubing meeting the requirements of ASTM F876 / 877 or ASTM F2769.

Making A Crimp Connection

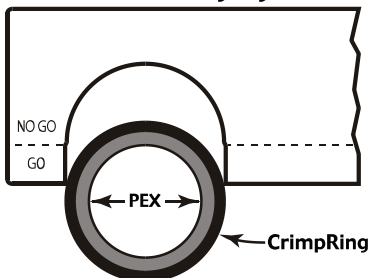
1. Cut tubing squarely. Remove any burrs.
2. Slide crimp ring over end of tubing. Insert fitting into end of tubing until it stops at shoulder, covering all three barbs. Position crimp ring 1/8" to 1/4" from end of tubing and fitting shoulder.
3. Place the crimping end of tool jaws around the center of the crimp ring and press the handles together. Be certain to fully close the jaws of the tool.
4. Check for proper crimp with the Go/ No-Go gauge.



Using GO/NO-Go Gauge

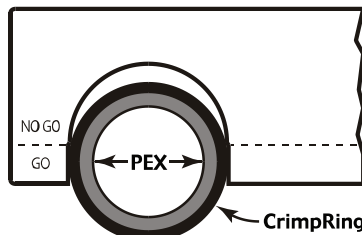
NO GO!

The CrimpRing is not compressed enough, and will not slide into the "GO" slot of the gauge.



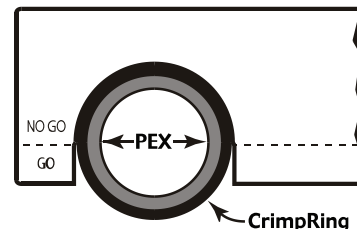
GO.

The CrimpRing slides into the "GO" slot, but stops at the shoulders in the "GO" slot.



NO GO!

The CrimpRing is compressed too small, and slides all the way into the "NO GO" slot.

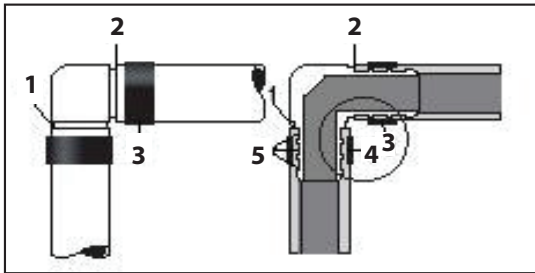


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Illustration Of A Good Connection

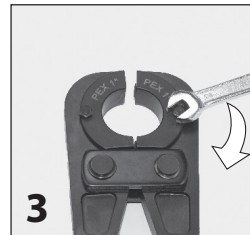
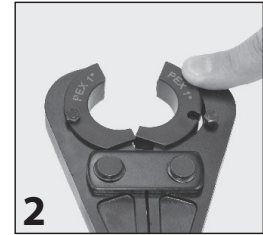
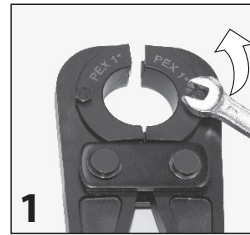
1. Fitting shoulder location.
2. Tube is cut square and stops at the fitting shoulder.
3. Crimp ring is positioned 1/8"-1/4" from end of tube, directly over ribs of fitting.
4. Crimp ring is evenly compressed over tube and show no evidence of uneven distortion.
5. The tube material is uniformly compressed between the brass ribs, resulting in a leak-free, quality joint.



Change the jaws to crimp different size fittings

1. Loosen jaw bolt by turning counter-clockwise 2-4 turns with wrench provided.
2. Remove jaw by sliding inwards.
3. Put new jaw into tool, tighten jaw screw by turning clockwise.

Repeat steps 1-3 to change both jaws in the set. Be sure both jaws installed match each other, the desired fitting size and tube to be crimped.



Tool Calibration

After repeated usage components on the tool may wear and not allow proper closing force, which in turn may cause an improper crimp connection. Always check each connection with the Go/No-Go gauge per enclosed directions. If more than one or two improper connections are found where the crimp ring was not compressed enough, perform the following adjustments on the tool:

1. Open the handle and loosen the nut as shown, counter-clockwise.
2. Push the bolt through **(2)** far enough so the head opposite side can be rotated clockwise to the higher number on the scale as shown. **(3)**
3. Push the bolt back in place and tighten the nut on the opposite side.
4. Check the next crimp connection with the Go/ No-Go gauge for proper compression and re-adjust as necessary. If compression is too small, repeat steps 1-3; except rotate the bolt head counter-clockwise to the next lower number. If adjustment is required higher than 3, or lower than 0, then replace the tool.

