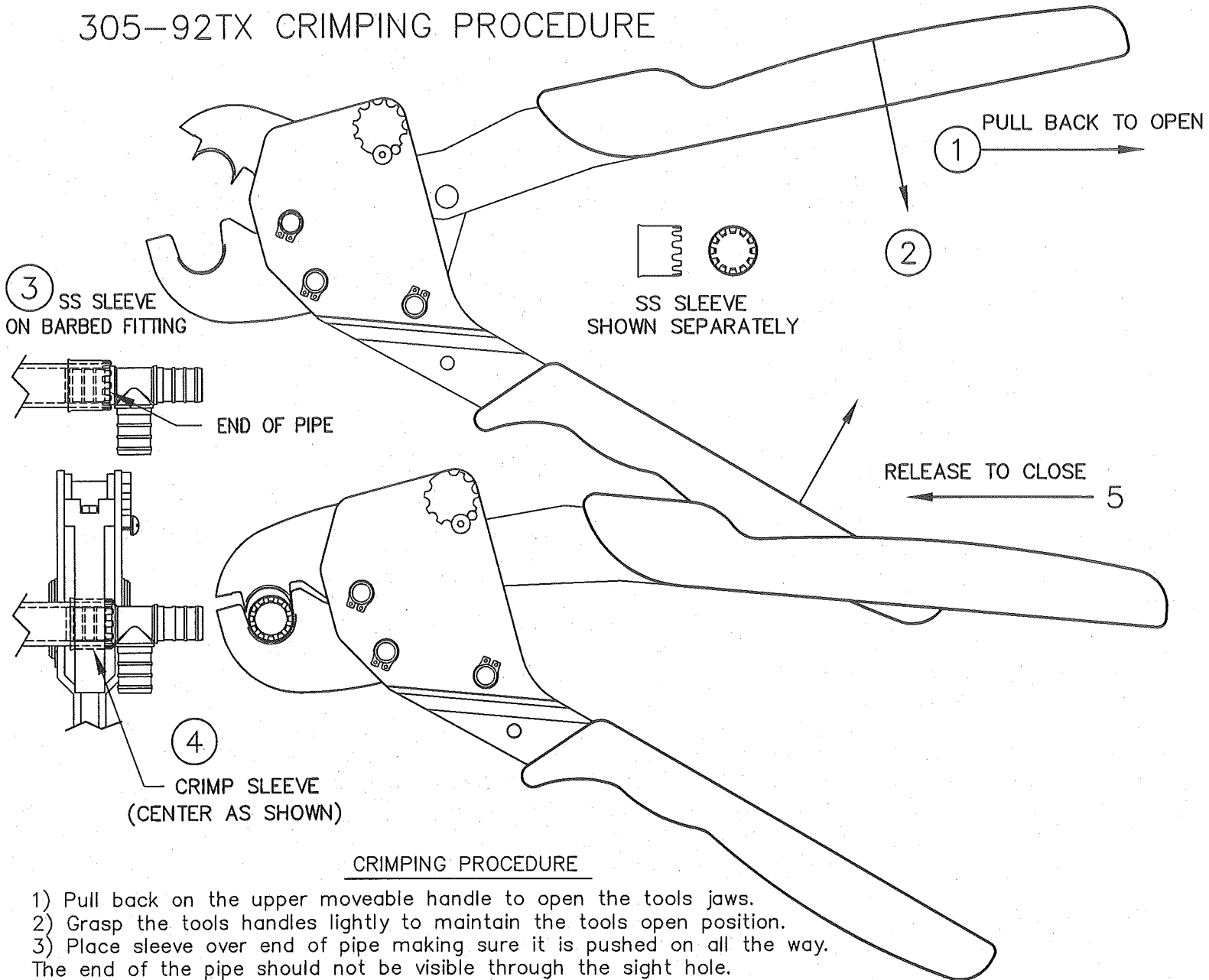


# 305-92TX CRIMPING PROCEDURE



## CRIMPING PROCEDURE

- 1) Pull back on the upper moveable handle to open the tools jaws.
- 2) Grasp the tools handles lightly to maintain the tools open position.
- 3) Place sleeve over end of pipe making sure it is pushed on all the way. The end of the pipe should not be visible through the sight hole.
- 4) Position the jaws so that the sleeve is centered within the tools jaws.
- 5) Loosen your grip to allow the spring pressure to close the jaws around the sleeve to be crimped. Before squeezing the handles make sure the sleeve is centered.
- 6) Squeeze the handles closed until the ends butt as shown below. CRIMP EACH SLEEVE ONCE ONLY!
- 7) Pull back on the upper handle to remove from the crimped sleeve, pipe and fitting.
- 8) Check the crimp with the gage provided. Measure the crimped fitting perpendicular to the seams of the crimp as shown in Fig 1. A properly crimped sleeve should pass the GO side of the gage and not pass the NO GO gage. If the sleeve does not pass the GO gage the tool is probably worn and needs to be adjusted as instructed in the Handle Pre-Load Adjustment Procedure.

