

END FEED ASSEMBLY INSTRUCTIONS:

Tools required:

Tube cutter, deburring tool, blowlamp, abrasive cloth, wire brush, lead free solder, flux.

Assembly

- Ensure the copper tube and fitting sizes are compatible. Cut the tube end square, and ensure it retains its shape.
- Deburr the tube, both inside and outside.
- Clean tube with an abrasive cloth, and fitting socket with a wire brush.
- Apply a thin layer of flux to the tube, and to the fitting socket.
- Insert the tube into the fitting until the tube stop is reached. Rotate the tube or fitting and remove any excess flux where possible.
- Light the blowlamp, and heat the fitting socket until the flux starts to boil. Keep the flame moving over the fitting and tube, do not provide excessive heat or additional solder.
- Apply lead free solder to the tube-fitting interface until it fills the void.
- As a rule of thumb, a length of solder equivalent to the tube diameter will be adequate for a satisfactory joint.
- Remove the blowlamp, allow to cool and wipe the joint(s) with a damp cloth.
- Flush all residues out of the system.

Demounting

- This fitting system is not demountable.

