

# Instructions for Installing ASTM F1960 Expansion fittings for WaterPEXa Tubing

## ⚠ WARNING



Read this Manual BEFORE using this equipment.

Failure to read and follow all safety and use information can result in death, serious personal injury, property damage, or damage to the equipment.

Keep this Manual for future reference.

- F1960 compression rings are PEX.
- Connection is made by placing a compression ring onto tube, expanding tubing and ring, inserting a full-flow fitting, and holding in place until tube/ring memory secures the connection.
- Fittings are reusable if barb is undamaged.
- F1960 Expansion Fittings are designed for use with Watts WaterPEXa tubing and should not be used with any WaterPex product sold by Watts. Watts WaterPEXa is recognizable by the dashed stripe on its side



1. Cut tube at 90-degrees. Do not crush outside diameter of tubing with cutters. To achieve a clean cut, slightly rotate cutter during blade engagement.



2. Install PEX sleeve onto outside diameter of tubing.



3. Using an ASTM F1960 tube expander, expand sleeve fully. Repeat expansions, rotating expander 1/8-turn between expansions. Note: To limit the amount of time for tube compression onto fitting in cold environments, expand the tube/sleeve slowly and only enough to fully insert the fitting. Keeping sleeves warm will speed retraction and inhibit unequal expansion. Use Milwaukee Tools M12 or M18 Cordless ProPex® Expansion Tool for expanding tubing. Milwaukee tools are sold through Milwaukee distributors. Manual tools are NOT recommended and may result in poor connections.



4. Insert fitting into expanded tube and sleeve. Assure proper expansion so that fitting is touching tube and sleeve. Hold fitting in place until tube/sleeve memory constrict annularly around the fitting.



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

**CAUTION**

### F1960 Application Cautions



Tube not cut square – ring and tube need to be mated perfectly and installed fully over F1960 barb for a viable seal.

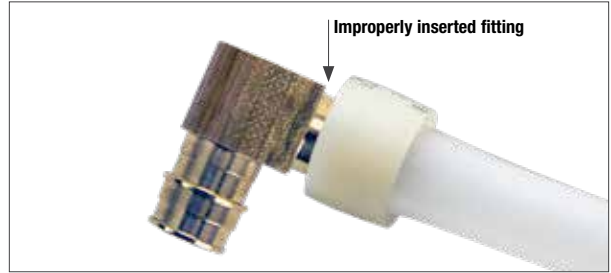
With a properly functioning expansion tool, the stretch on the tubing is even, with no path for water to leak through.



If the tool is defective or did not rotate properly, it could leave a path for leaks between the fitting and the tubing.



Ring must be kept around 55°F or greater to assure expansion is uniform. Remove any expanded ring that displays unequal expansion.



Fitting not inserted completely into expanded tube and ring.  
Ring not fully covering WaterPEXA tubing.



Damaged, cut or grooved sealing barb.

**WARNING:** This product contains chemicals known to the State of California to cause cancer and birth defects or other reproductive harm.  
**For more information: [Watts.com/prop65](http://Watts.com/prop65)**

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