PowerPEX®

PEX Expansion Ring Connection Guide For use with ASTM F1960 Fittings

1. Cut tube at 90-degrees. Do not crush OD of tubing with cutters. Hint: Slightly rotate cutter during blade engagement.

2. Install an approved PEX expansion sleeve onto OD of tubing.

3. Using expander tool, expand sleeve fully. If using a manual tool, expand ***slowly*** and repeat expansions, ***rotating expander*** 1/8-turn between expansions. Forcing the tube onto the expansion head and/or expanding too quickly can damage the tubing and sleeve, and require rework.

4. Insert fitting into expanded tube and sleeve. Hold fitting in place until tube/sleeve constricts annularly around the fitting.

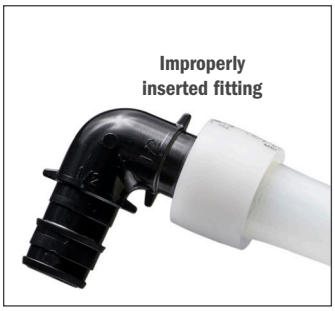
5. The installation is complete with a visibly secure connection. Remove defective connections. Test all completed joints.

Important: Sioux Chief requires all ASTM F1960 expansion joints using PowerPEX Type-B tubing be made with a self-rotating, power expansion tool to avoid improper expansion.

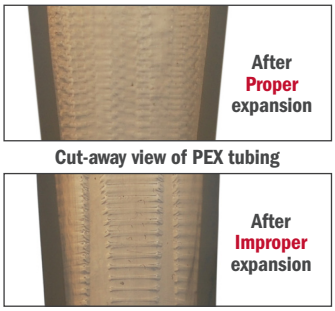
Special Considerations for Making Large-Diameter, or Low-Temperature F1960 PEX Expansion Joints:

When expanding large diameter tubing or in temperatures below 55°F, Do Not force the tubing onto the expansion head. Expand slowly and evenly at the prescribed rate of expansion. When using a manual tool, always rotate the tool. Keep tube/sleeves warm (Tip: store sleeves in pockets) to ensure uniform expansion and decrease the time needed to fully constrict around fitting. In colder temperatures, fewer expansions are needed. Use only enough tool expansions/rotations to allow full insertion of the fitting. Both lower temperatures and over-expansion of the tube/sleeve will increase the time needed to fully constrict and complete the joint. Do Not make connections in temperatures below 5°F. Do Not apply heat with a heat gun - Excessive heat may damage tube/sleeves/fittings.

Installation Problems: Take care to avoid the below issues when making joints with PEX expansion rings

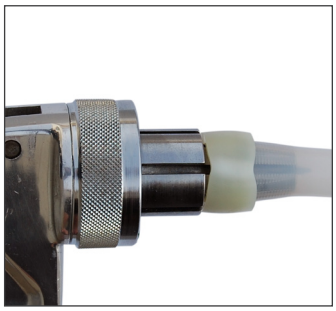


Be sure tubing is cut squarely, tube is inserted into sleeve completely and fitting is inserted fully into tube/sleeve.



No rotation between expansions, or defective expansion head leaving a groove as a potential leak path.

Damaged, cut or grooved barb on fitting.



Failure to rotate tool inside tubing may cause unequal expansion. Remove any rings with unequal expansion.