

CCH 2004-02 ed2 part 2 & 3

PART 2: IMPLEMENTATION OF COPPER CRIMP FITTINGS

In accordance with the provisions of article 7 - 6 ° of the amended decree of August 2, 1977, the crimp fittings can only be used in ventilated premises. This part specifies the successive operations which must be carried out at least when carrying out an assembly by crimping:

1. read the instructions for use specific to each manufacturer,
2. check the general appearance of the copper tube, that " it complies with the ATG B.524-1 specification and the manufacturer's recommendations (diameter, thickness, copper grade, etc.), and that its diameter complies with the specifications for assembly by crimping. Diameters of copper tubes on which crimping can be carried out:

DN ext. du tube (mm)	12	14	15	16	18	22	28	35	42	54
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3. cut the copper tube using a tube cutter, in order to obtain a clean, circular and perpendicular cut,
4. eliminate internal and external burrs. For existing pipes, in the presence of paint, oxidation, etc., the end piece must be mechanically exposed over the entire length of the socket,
5. take a fitting corresponding to the diameter of the copper tube and conforms to the specifications for the crimp assembly,
6. check that each crimping part of the fitting has its seal specified by the manufacturer,
7. mark the tube using the template provided or the connector used to identify the nesting depth,
8. press the connector onto the copper tube until it stops (except for the sliding sleeves),
9. take the jaw and the machine recommended and corresponding to the diameter of the part of the crimp fitting,
10. check the marking of the tube, readjust the fitting on the tube if necessary,
11. open the jaw and position it on the crimping part of the fitting,
12. check to again the position of the tube in the crimp fitting according to the marking carried out in 7,
13. start crimping, the course of the cycle must not be abandoned and must be carried through to its end (stops, auto stop matic ...),
14. remove the tooling once the crimping is finished,
15. check visually and tactile that the crimping has been correctly carried out.

NOTE: carry out a tightness test of the entire installation carried out in accordance with current regulatory and normative obligations.

PART 3: IMPLEMENTATION OF INSTALLATIONS INCLUDING CRIMPED COPPER FITTINGS

As a further reminder, in accordance with NF DTU 61.1 part 2, § 5.3.3.1.2.8, the gas piping must not include any mechanical and accessory connections inside a crawl space. According to NF DTU 61.1 part 1, § 3.76, a fitting is said to be mechanical when assembly and sealing are obtained separately, so this is the case for crimp fittings.

The following precautions must be observed when carrying out an installation comprising crimped copper fittings or when working on an existing installation that has been carried out with the copper crimping technique:

- crimped copper fittings must not be placed in the elements of the frame, whether by engraving, embedding or incorporation;
- no soldering must be carried out on the same installation within one meter of a crimping assembly;
- no hot bending should be carried out on a copper tube within one meter of a crimp assembly;
- no hot spot should be worn near a crimped copper fitting;
- the crimped copper fittings must not be etched using a thermal tool;
- the crimped copper fittings must not be pickled or cleaned with a chemical not intended for this application;
- when a copper fitting is to be crimped on an existing installation, the installer must verify the conformity of the tubes constituting the installation with the requirements of specification ATG B.524-1 on the one hand and the manufacturer's recommendations concerning the tube on the other hand (diameter, thickness, copper grade, etc.).