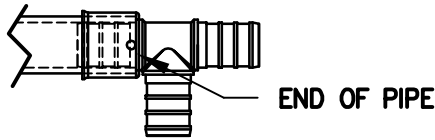
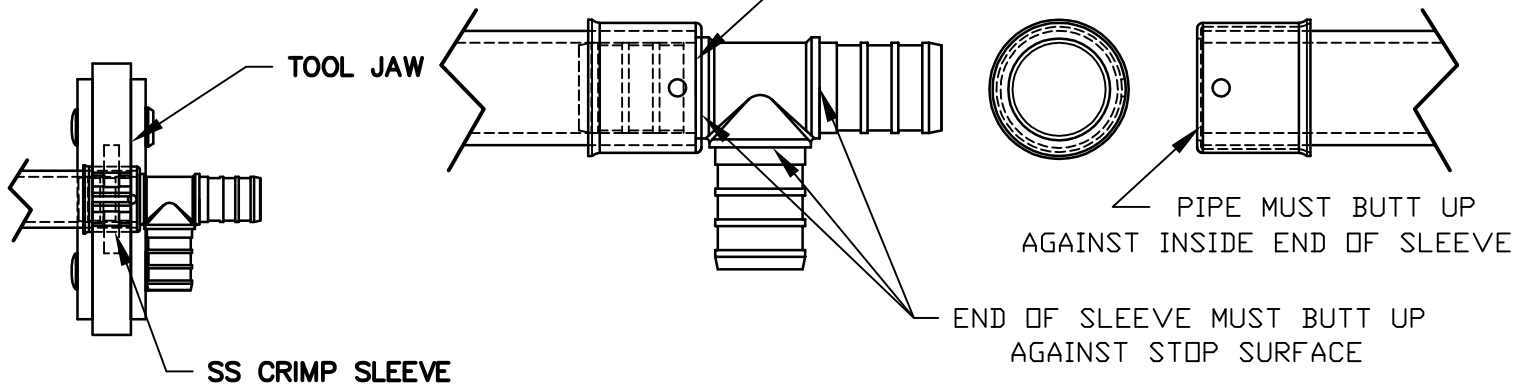


**SS SLEEVE  
ON BARBED FITTING**



END OF PIPE

**SS SLEEVE  
CRIMP GAGE INSTRUCTION**



TOOL JAW

PIPE MUST BE VISIBLE  
IN "SIGHT HOLE"

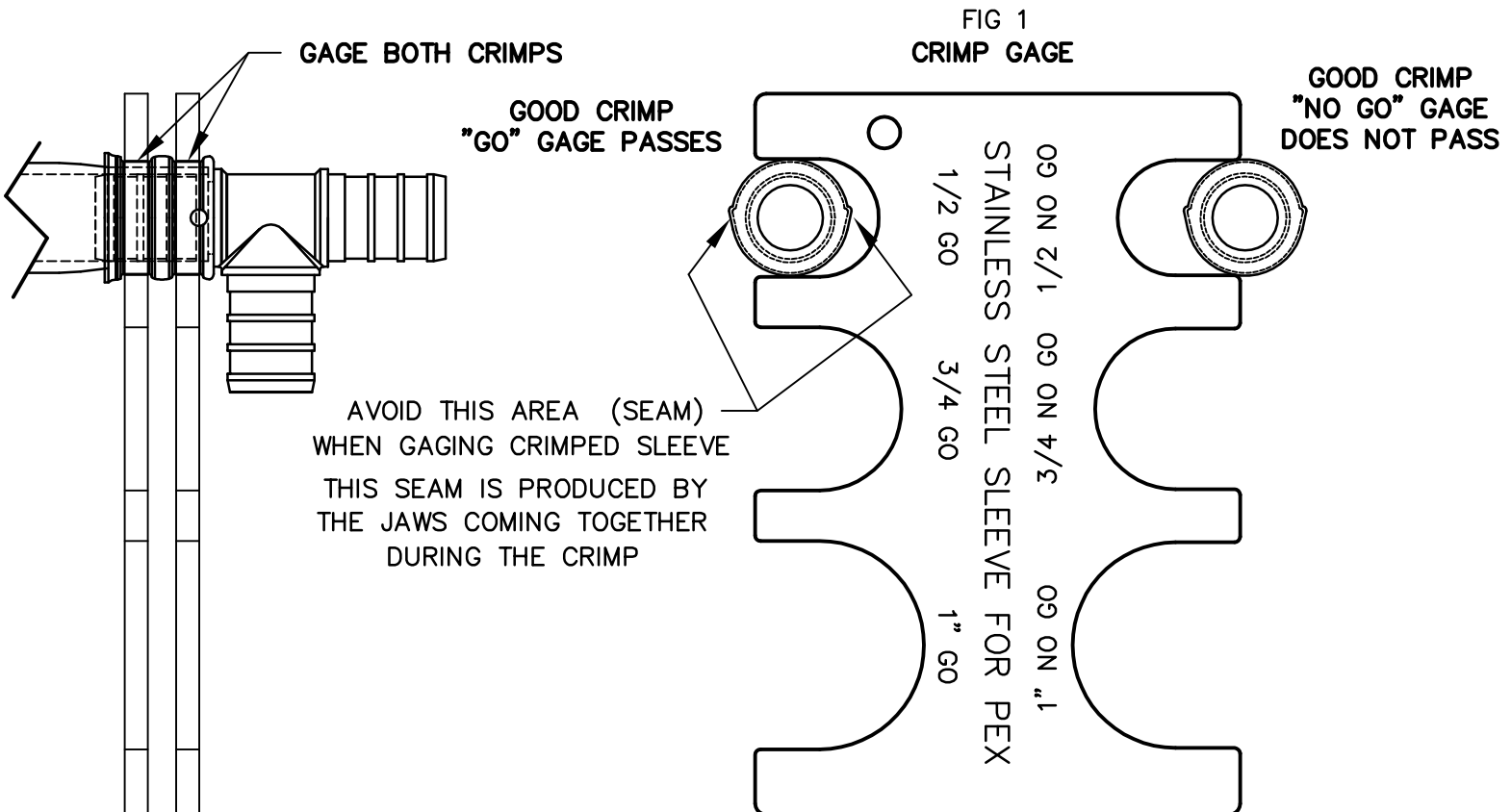
PIPE MUST BUTT UP  
AGAINST INSIDE END OF SLEEVE

END OF SLEEVE MUST BUTT UP  
AGAINST STOP SURFACE

SS CRIMP SLEEVE

CRIMPING/GAGING PROCEDURE

- 1) Place sleeve over end of pipe making sure it is pushed on all the way. The end of the pipe should be visible through the sight hole.
- 2) Open the jaws and position the sleeve so it is centered within the tools jaws.
- 3) Before squeezing the handles make sure the sleeve is centered and not over flaired portion on the end of the sleeve.
- 4) Squeeze the handles closed until they toggle and the handle stops butt. CRIMP EACH SLEEVE ONCE ONLY!
- 5) 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. Check both crimped areas.



GOOD CRIMP  
"GO" GAGE PASSES

GOOD CRIMP  
"NO GO" GAGE  
DOES NOT PASS

AVOID THIS AREA (SEAM)  
WHEN GAGING CRIMPED SLEEVE  
THIS SEAM IS PRODUCED BY  
THE JAWS COMING TOGETHER  
DURING THE CRIMP