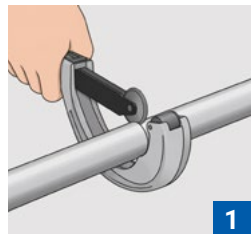


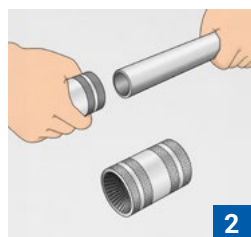
Compression Fittings Installation Guidelines

Installation of compression fittings

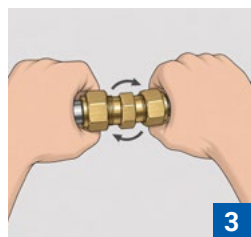
Only use tubes with the same nominal diameter as specified on the union nuts. Follow the installation steps below.



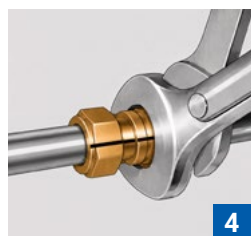
1. Cut the tube to length.
Suitable for the tube material.



2. Deburring the tube.
Deburr both the inside and outside of the tube. Check the tube end for scratches, dirt, or deformation.



3. Tube and fitting assembly.
Ensure the compression ring (olive) is correctly positioned within the fitting. Apply lubricant to the thread only. Insert the tube fully until it reaches the tube stop, then mark the tube at the back of the nut. Use this mark as a reference to ensure the tube remains fully inserted while making the permanent connection. The compression ring (olive) must sit on the tube as shown in the figure at the end of this document (pre-tightening position).



4. Tighten union nut
Tighten the union nut by hand until a firm fit is achieved (secure but

not fully tight). **At this point, place a clear alignment mark across both the nut and the body of the fitting as detailed in Image 4, this indicates the starting position.**

Using this mark as a reference, continue tightening the union nut according to the **number of turns specified in the table on the right**. The alignment mark allows you to accurately track the rotation and ensure the connection is fully tightened to specification.

Note: Excessive tightening of the union nut can cause leakage or rupture of the nut/olive. If lubrication is required to make tightening easier, apply lubricant to the thread only.

5. Check Connection

After installation, check the connection for leak tightness according to the guidelines for the applied media.

Prescribed Number of Tightening Turns

Tube Type (mm)	6 -12	15-22	28	35	42	54
Copper	1	¾	¾	¾	¾	¾
Steel (Thin-walled)	1	¾	¾	¾	-	-
Chromed Copper	¾	1¼	-	-	-	-
Stainless Steel	1	¾	¾	¾	-	-
Plastic (Pex with insert)	1¼	1¼	-	-	-	-

	Tube ∅	Compression	# of Tightening Turns
Thick-walled steel tube	3/8"	18mm	1*
	3/8"	22mm	1*
	1/2"	22mm	1*
	3/4"	28mm	1*
	1"	35mm	1*

* For thick-walled tubes, retighten the union nut by at least half a turn after the first heating cycle.

Lubrication Guidance

Only CRC Food Grade Silicone Grease is approved for use with brass compression fittings. This non-curing silicone grease provides effective lubrication and sealing support while remaining safe for use with rubber and plastic components, without degradation.

Use of alternative lubricants, particularly petroleum-based products, is not recommended as they may compromise sealing performance and material integrity.



Jointing Compounds / Sealants

Jointing compounds or sealants are not necessary. The use of these materials could impair the efficiency of the joint and may compromise local water regulations.

