

## CORE Copper Press-Fit Installer Competencies Checklist

1. Cut the BS EN 1057 Copper tube, preferably with a wheel-type tube- cutter that produces no debris, keeps the tube end square, and produces minimal tube end burrs.
2. De-burr and chamfer the cut end of the tube, if required, to eradicate the risk of O-ring seal damage.
3. Inspect the tube surface looking for dints, scratches and bundle-tape residue. Reject if damage is found.
4. Select and unbag the required fitting and inspect it, ensuring that all O-ring seals are in place and free from debris.
5. Insert the tube, with a twisting action, into the fitting until the full depth stop is reached.
6. Permanently mark the tube with a line, against the fitting mouth, recording the full socket depth insertion.
7. Remove the tube from the fitting and check full socket depth externally, and then apply a “V” mark over the full-socket depth line to create an “A” mark, pointing to the cut end of the tube, and then re-insert the tube back into the fitting to the full socket depth. The point of the “A” will be hidden in the fitting, confirming the double-depth check, allowing process audit. (Just use the depth mark on potable water)
8. Select the correct size “M-Profile” jaw for the fitting being installed and ensure it is correctly coated with sufficient “Brunox” lubricant.
9. Attach the jaw or sling to the fitting at a right angle and, supporting the tool, crimp it until the full machine cycle is completed and the jaw/sling is fully closed. (Two crimps are required for 108mm with a COPPER ONLY collar)
10. Remove the jaw or sling (and the used CORE press-indicator foil) and, after inspecting the fitting for obvious flaws, mark the fitting with your initials to record completion and to record the identity of the installer.
11. Finally, test the system following the BESA TR6 “Guide to Best Practice” for Site Pressure Testing of Pipework.