

Fra.Bo Press-Fit Copper Installer Competences 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 to eradicate the risk of O-ring seal damage.
3. Select the required fitting and inspect it ensuring that all O-ring seals are in place and free from debris.
4. Insert the tube, with a twisting action, into the fitting until the full depth stop is reached.
5. Permanently mark the tube with a line, against the fitting mouth, recording the full socket dept insertion.
6. Remove the tube and apply a 'V' mark over the full-socket depth line to create an "A" mark then re-inset the tube back into the fitting to the full socket-depth, confirming the double depth check. The point of the "A" will be hidden in the fitting allowing process audit.
7. Select the correct sized 'M Profile' jaw for the fitting being installed and ensure it is correctly coated with 'Dri-Slide' Molybdenum lubricant.
8. Attach the jaw or sling to the fitting and crimp it at a right angle to the pipe until the full machine cycle is completed. Two crimps are required above 108mm.
9. Remove the jaw or sling and, after inspecting the fitting for obvious flaws, mark the fitting with your initials to record the identity of the installer.
10. Test the system following the BESA TR6 'Guide to Best Practice' for Site Pressure Testing of Pipework.