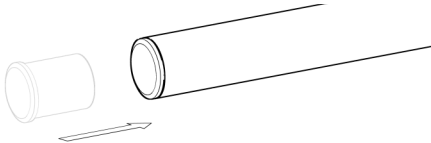




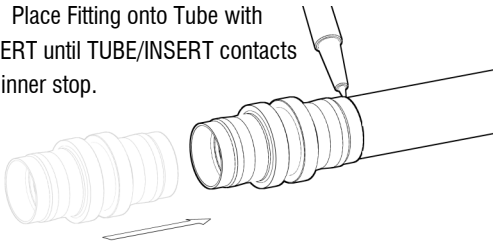
BEFORE SELECTING OR USING ANY OF RCS'S PRODUCTS, IT IS IMPORTANT THAT YOU READ AND FOLLOW THE INSTALLATION INSTRUCTIONS. FAILURE TO FOLLOW INSTALLATION INSTRUCTIONS, IMPROPER SELECTION OR IMPROPER USE OF THESE FITTINGS AND RELATED ACCESSORIES ("PRODUCTS") CAN CAUSE DEATH, PERSONAL INJURY AND PROPERTY DAMAGE. THE USER, THROUGH ITS OWN ANALYSIS AND TESTING, IS SOLELY RESPONSIBLE FOR MAKING THE FINAL SELECTION OF THE SYSTEM AND COMPONENTS AND ASSURING THAT ALL PERFORMANCE, ENDURANCE, MAINTENANCE, SAFETY AND WARNING REQUIREMENTS OF THE APPLICATION ARE MET.

## ASSEMBLY GUIDE

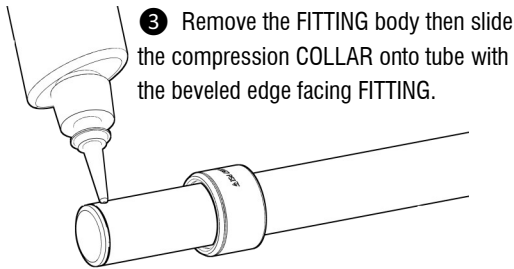
**1** Tube surface must be clean, free from scratches or any surface imperfections, and de-burred inside and out. Place tube support INSERT in to clean and de-burred tube.



**2** Place Fitting onto Tube with INSERT until TUBE/INSERT contacts the inner stop.



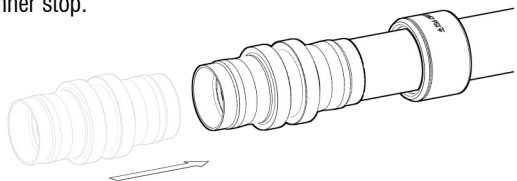
Mark Tube at end of FITTING with permanent felt tip marker.



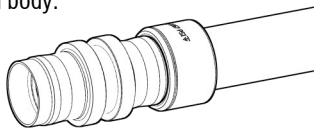
**3** Remove the FITTING body then slide the compression COLLAR onto tube with the beveled edge facing FITTING.

Apply LocTite® to full circumference of tube end.  
Keep LocTite® 1/8" from end of TUBE and INSERT.

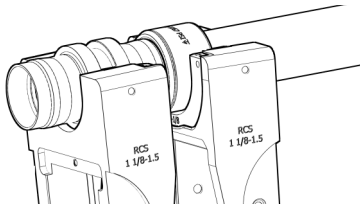
**4** Slide the FITTING body back onto the TUBE with INSERT in place until TUBE/INSERT contacts the fitting inner stop.



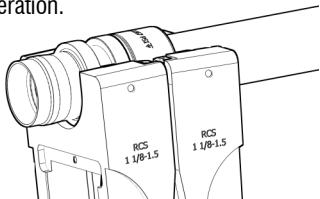
**5** Keeping the TUBE/INSERT against the FITTING inner stop, slide the COLLAR against the FITTING. Collar should overlap the FITTING body.



**6** Place the FITTING and COLLAR into correct size press clamps. The assembly MUST be fully seated on the lower circumference of the clamps. Do not change the insertion depth of the TUBE/INSERT and the connecting joint.



**7** Using the press tool, press the COLLAR onto the FITTING body until it is fully seated against FITTING stop. TUBE/INSERT must be maintained against the FITTING inner stop during the pressing operation.



That the tube insert depth reference mark is visible and closely aligned with the end of the FITTING body.

That the COLLAR is in the correct orientation, fully seated, and is flush against the shoulder of the FITTING body.

That any gap between the COLLAR and the FITTING shoulders are less than 1mm.

RCS Axial Swage Fitting Insertion Depth Chart									
<b>Tube Size (OD)</b>	1/4"	3/8"	1/2"	5/8"	3/4"	7/8"	1-1/8"	1-3/8"	1-5/8"
<b>Insertion Depth</b>	.47"	.47"	.54"	.70"	.76"	.84"	1.10"	1.15"	1.15"

Dimensions are the distance from the end of the copper tube to the depth mark. It does not include the insert. When the insert is put into the tube and the copper tube and insert are full depth into the fitting, the depth mark will align with the end of the fitting after pressing.