



# User Instructions for TDB Compression Fittings

## TDB Compression Fittings are Fully Certified with I.S EN1254-2

- 1** The tube dimensions to be joined must conform to EN 1057 and be approved by the National Standards Authority of Ireland.



- 2** Select the correct fitting in both size and for the connection required. We strongly recommend a tube cutter to ensure a clean, straight cut. If any other tool is used the cut should be thoroughly deburred and any swarf removed. A visual inspection should be carried out before assembly.



- 3** With the advent and popularity of pex and similar pipe, this needs to be cut with a plastic pipe cutter. An insert must be used to support the wall of the pipe when compressing.



- 4** Slide the nut and ring onto the tube and insert into the fitting as far as the raised pipe stop. The nut must now be hand tightened. Then using open ended spanners of the correct size the nut is tightened to the requisite number of turns. Take extra care, not to over tighten the fitting. Never use a Stillson or similar tool as this can distort the nut.



**BRASS PRODUCTS ARE NOT SUITABLE FOR UNDERGROUND USE**

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# Manufacturers Recommendations

- 1 The use of a light oil on the threads of larger sized compression fittings will aid the nut to turn and compress the ring with less force.
- 2 As stated previously on page 1 take extra care not to over tighten the fitting. Never use a stillson or any ill fitting tool to reduce the possibility of introducing stress corrosion into the fitting. There is no benefit only risk in over tightening a fitting.
- 3 The use of jointing compounds is neither necessary nor recommended. However, under certain circumstances or if a weep occurs it can be used on the jointing surfaces but not on the threads.
- 4 On soft coiled copper tubes depending on the manufacturers guidelines an insert may be mandatory.
- 5 When jointing male and female threads be careful not to over tighten and deform the female socket. Flax is not suitable as it is easy to over pack the threads. PTFE or a liquid/paste is recommended.
- 6 It is very important to keep joint clean and free from sand, soil, grit or other contaminants.

Compression fittings (Type A) 18mm and above require the use of internal support in the pipework when using R220 (annealed) tube and compression fittings below 18mm , may require internal support when used with annealed tube. The manufacturers/distributors advise should be sought where required.

Based on EN 1254-2, temperatures and pressures for Compression fittings from 6mm to 54mm are shown in below table.

