

# Swage Copper Installation Guide

## REQUIRED TOOLS

Pipe Cutter

Swaging Tool

Two Wrenches

OPTIONAL: Tube Bender

### SPLIT SYSTEM INSTALLATIONS USE PYTHON-SWAGE (NO-BRAZE) FITTINGS

- 1 It is acceptable to pre-install either the Python or the swage end first so long as you tighten the respective end by properly holding the adapter in a fixed orientation while the nut is tightened in order to prevent damage to the barb or pipe interior.

Note: Follow steps 1-8 of the Python Installation Guide for Python side prep and install.

- 2 Start by ensuring the swaged bell coming from your unit is clean and free of debris, burrs, cracks or dents that would otherwise cause a misshaped or unusable swaged end.

Note: Fitting not to be used with pre-brazed connections.

- 3 If copper stub is badly damaged and has enough copper pipe to be re-swaged, then do so using a pipe cutter and swaging tool or swaging spin bit as a recommended method of swaging. If swaged end has only

minor dents, then quick pass of the spin bit swaging tool will bring the swage bell back to round.

Note: Be sure Swaged end is cut perpendicular to the pipe for optimal sealing conditions. Any misaligned cut could result in failure to system sealing and leaks.


- 4 Fully seat fitting onto copper swaged end until it is bottomed onto the swaged rim and is not misaligned or caught on any edges or internal rims of the fitting or its compression ring.

- 5 Use one wrench to hold the fitting adaptor while tightening the nut with a second wrench until the nut and fitting adaptor meet. Do not over tighten.

### DIMENSIONAL CHARACTERISTICS—SWAGE BELL

Size	Nominal OD	Nominal ID	Max Design Pressure	Torque Specification
3/8"	.443"	.379"	700 psi	30 ft-lbs
1/2"	.568"	.504"	700 psi	50 ft-lbs
5/8"	.699"	.629"	700 psi	50 ft-lbs
3/4"	.824"	.754"	700 psi	80–85 ft-lbs
7/8"	.969"	.879"	650 psi	100–110 ft-lbs

NOTE: Torque Specification for reference only, as fittings are to bottom out.

 WARNING: This product can expose you to chemicals including lead which are known to the State of California to cause cancer and birth defects or other reproductive harm. For more information go to [www.P65Warnings.ca.gov](http://www.P65Warnings.ca.gov)

