Jointing Techniques

For compression fittings with Copper Tube to BS EN 1057

1.	Ensure the tube conforms to BS EN 1057.
2.	Select the correct fitting for the size of the tube to be connected.
3.	Ends of the tube for jointing must be cut cleanly across the tube diameter and be free from contamination, surface damage or defects.
4.	Enter the tube through the thrust nut and compression ring full into the fitting until positive contact is made with the tube stop.
5.	Make sure the sealing faces of the joint and threads are clean and free from swarf and any contamination. A little light oil applied to the threads of the fittings is useful in reducing friction during tightening. With correctly madejoints, jointing compounds should not be required, although in certain circumstances these may offer practical advantages.
6.	Care should be taken that the compression olive is not placed over any identification mark or other indention on the tube.
7.	Hand tighten the thrust nuts until ALL slack in joint is taken up.
8.	Complete tightening should be made using a suitable spanner. Ensure the axial alignment of the tube and fittings during tightening operation and thereafter. Over-tightening should be avoided as this may destroy the watertight seal.

Male and Female Joints

1.	Taper Threads should be assembled using a WRAS Approved sealant or Tape E.G. PTFE

2.	Parallel threads should be assembled using washers WRAS Approved

Notes: Some authorities and System Specifications preclude the use of jointing compounds or require that only certain proprietary material may be used. Before utilising jointing compound it is the responsibility of the installer to ensure compliance.

Tightening Compression Fittings Guidance:

Size	Turns	Size	Turns
12mm	1 1/4 Turns	28mm	1 1/4 Turns
15mm	1 1/4 Turns	35mm	3/4 Turns
18mm	1 1/4 Turns	42mm	3/4 Turns
22mm	1 1/4 Turns	54mm	3/4 Turns