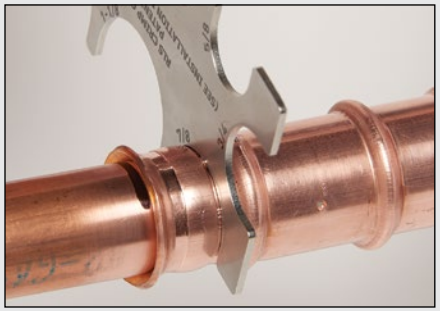
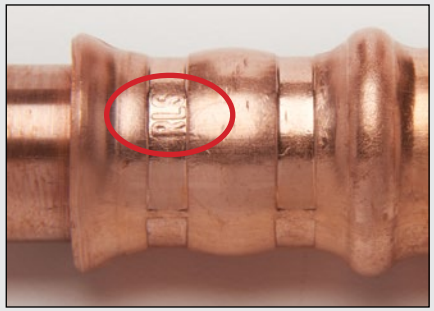
IMPORTANT!
After You Press...

1. Use the gauge.



Confirm the finished crimp band diameter by using the RLS crimp gauge. When properly crimped, the RLS crimp gauge allows the marked slot to fit snug on the crimp band. If it doesn't fit, it is under-crimped and will need to be re-crimped.

2. Look for the "RLS"



To verify the crimp cycle was completed properly, an RLS witness mark will appear within the crimp bands. Failure to create a witness mark means the crimping process was not made properly, and the fitting must be removed and the procedure repeated with a new fitting.

WARNING

FAILURE TO FOLLOW INSTALLATION INSTRUCTIONS, IMPROPER SELECTION OR IMPROPER USE OF RLS FITTINGS AND RELATED ACCESSORIES ("PRODUCTS") CAN CAUSE DEATH, PERSONAL INJURY AND PROPERTY DAMAGE. POSSIBLE CONSEQUENCES OF FAILURE, IMPROPER SELECTION OR IMPROPER USE OF THESE PRODUCTS INCLUDE BUT ARE NOT LIMITED TO:

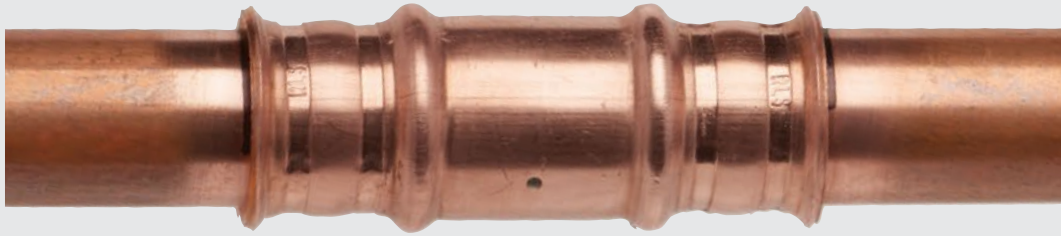
- Fittings thrown off at high speed.
- High velocity fluid discharge.
- Explosion or burning of the conveyed fluid.
- Electrocution from high voltage electric power lines.
- Contact with suddenly moving or falling objects that are controlled by the conveyed fluid.
- Injections by high-pressure fluid discharge.
- Dangerously whipping copper line.
- Contact with conveyed fluids that may be hot, cold, toxic or otherwise injurious.
- Sparking or explosion caused by static electricity buildup or other sources of electricity.
- Sparking or explosion from flammable liquids.

BEFORE SELECTING OR USING ANY OF THESE PRODUCTS, IT IS IMPORTANT THAT YOU READ AND FOLLOW THE INSTALLATION INSTRUCTIONS.

RLS® RAPID LOCKING SYSTEM

Original. Patented. Proven.

Prep Before You Press!



RLS® RAPID LOCKING SYSTEM

Original. Patented. Proven.

Follow the 6 simple steps inside to prep copper tube the right way to prevent leaks.

Sharp edges on copper tube ends may cause damage.
Remember these 6 key ways to prep before you press.

RLS® RAPID LOCKING SYSTEM
Original. Patented. Proven.

1. Inspect

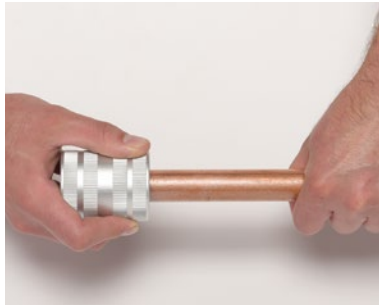
Before beginning, it is important to inspect the press fitting O-rings for obvious signs of damage, as well as the tube, especially within 1-1/2" from the tube end. Look for deep scratches (top photo), incise marks (bottom photo) or other defects, which might cause refrigerant leaks. If these are present, cut off the affected area, then proceed with prep.

2. Cut

Cut copper tube with the supplied tube cutter or a similar commercially available tube cutter. Do not use any type of saw to cut the tube – it will create sharp or jagged edges that can cut the press fitting's O-ring.

3. Deburr

Using the provided deburring tool, rotate the tool back and forth five to seven times to remove any residual burrs from the outside or inside of the tube.



4. Clean

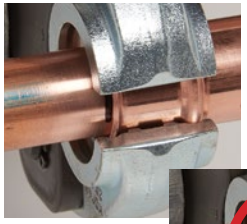
Use the included abrasive pad or adequate substitute (abrasive pad or 180 grit sandpaper) to clean the end of the tubes to be joined. Tube ends should be free and clear of oxidation, dirt and debris, and the surface should be shiny and bright.

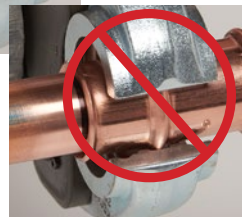
5. Mark

Use the supplied depth gauge to determine the insertion depth on every tube and mark it with a permanent marker. Every tube must be marked to the correct insertion depth every time.

6. Align

After inserting the tube into the fitting to the mark, place the jaws onto the fitting. Grooves in the jaw should line up and seat onto the groove on the fitting. Make certain the jaw is correctly seated between the groove and the flare (top photo) – NOT over the groove (bottom photo).





NOTE: These quick tips are a helpful start to using RLS press fittings. For complete instructions with added details, please see the *RLS Flame-Free Refrigerant Fittings Installation Instructions* guidebook.