

## END FEED ASSEMBLY INSTRUCTIONS:

### Tools required:

Tube cutter, deburring tool, blowlamp, abrasive cloth, wire brush, lead free solder, flux.

### Assembly

- Ensure the copper tube and fitting sizes are compatible. Cut the tube end square, and ensure it retains its shape.
- Deburr the tube, both inside and outside.
- Clean tube with an abrasive cloth, and fitting socket with a wire brush.
- Apply a thin layer of flux to the tube, and to the fitting socket.
- Insert the tube into the fitting until the tube stop is reached. Rotate the tube or fitting and remove any excess flux where possible.
- Light the blowlamp, and heat the fitting socket until the flux starts to boil. Keep the flame moving over the fitting and tube, do not provide excessive heat.
- Apply lead free solder to the tube-fitting interface until it fills the void.
- As a rule of thumb, a length of solder equivalent to the tube diameter will be adequate for a satisfactory joint.
- Remove the blowlamp, allow to cool and wipe the joint(s) with a damp cloth.
- Flush all residues out of the system.



### Demounting

- This fitting system is not demountable.