

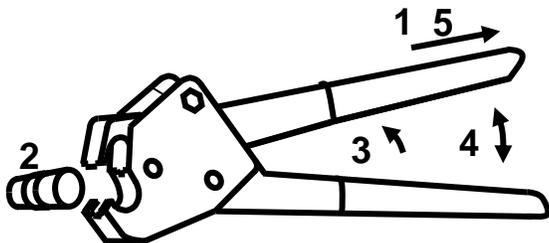


Mil3 Inc. 866-688-6453 email: mil3@nc.rr.com
Fax: 877-355-6453

OPERATION: Use the Crimpmaker to install only ASTM-approved pipe or tube used with a) copper crimp rings and b) brass, copper, or plastic fittings manufactured to appropriate ASTM standards for polyethylene and polybutylene pipe installation.

To crimp -- with pipe, fitting and ring in place:

- 1 Pull back on the moving handle and open the jaws fully (your Crimpmaker does not work like pliers... don't force the handles apart).
- 2 Position jaws squarely around the ring.
- 3 Gently let the handles open to close the jaw on the ring.
- 4 Squeeze handles together to complete the crimp. One crimp only!
- 5 Pull back on the moving handle to release jaws from the crimped ring.



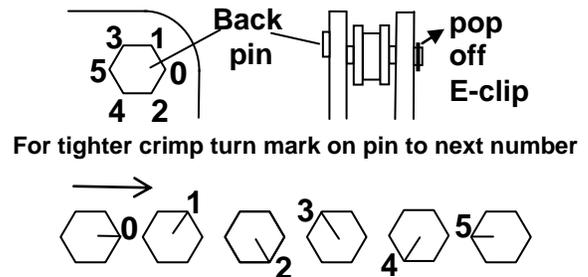
6 Measure the crimped ring with Mil3 Go-No Go gage or caliper. See table below. Do not measure bumps on the ring where the jaws meet. If GO on gage does not fit, or if NO GO does fit, the cut out the connection, replace the fitting and ring, adjust and calibrate the tool, and recrimp.

The following dimensions are the ASTM maximum and minimum crimped ring diameters for polyethylene (PEX) and polybutylene (PB) pipe installation:

Pipe Size →	3/8	1/2	3/4	1
Min. dia.	0.580"	0.700"	0.945"	1.175"
Max. dia.	0.595"	0.715"	0.960"	1.190"

Variation in ring diameter (out-of-round) should not exceed 0.006".

Adjustment: All crimp tools wear, which increases the crimp diameter after many crimps. When your crimps start to approach the maximum ring diameter, then adjust the back pin (see figure below). To adjust for a tighter crimp, remove the e-clip (for example, pop it off with a screwdriver), slide the back pin head out about 1/4 inch, rotate the back pin until the line on the hex head points to the next highest number on the tool body, push the pin back in, and refit the e-clip.



Maintenance: For easier, better crimps and longer tool life, keep tool clean and rust-free inside and out. Lubricate all moving parts frequently with CrimpLube™ from Mil3.

Mil3 Limited Warranty and Return Policy

MIL3 Inc. warrants the Crimpmaker will be free from failure caused by manufacture or design defect for ninety (90) days past user's proof of purchase date. This limited warranty does not apply to 1) abuse in handling, using, storing, or maintaining the tool; 2) use of the tool in non-recommended applications; 3) unauthorized tampering or repair to the tool. If warranty conditions are met, Mil3 will replace and return the tool free of charge. These are the exclusive remedies for breach of this limited warranty.

This limited warranty is in lieu of all other warranties, including implied warranties of merchantability. No person or firm can create for Mil3 any other liability, such as consequential damages based on breach of warranty, breach of contract, negligence or any legal theory. Such damages include damage to property and other economic loss.

After the expiration of the warranty period, repair or reconditioning of the tool is available at a modest cost. Customers should contact Mil3 by phone, fax or email to obtain a return merchandise authorization (RMA) and shipping instructions.

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