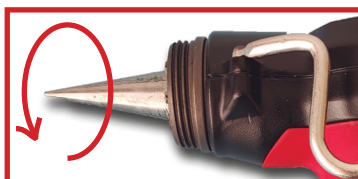


# INSTRUCTIONS

## SET ELECTRIC EXPANDER FOR PEX-A PIPES

(Expansion ring system)



Self-rotatory expanding head





## DESCRIPCIÓN

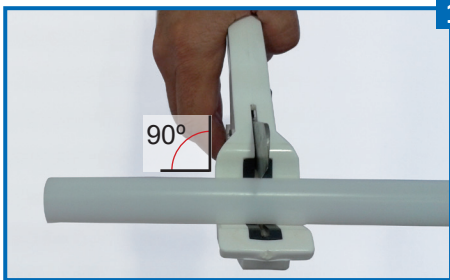
1. Expander cone
2. Trigger
3. Lock of trigger
4. 2 batteries: 12V 5,0Ah 60Wh
5. Expanding heads
6. Charger 220V 50Hz
7. Lubricant
8. Digital display screen (disabled)

## WARNINGS ⚠

- Remove the battery pack before starting any work on the machine.
- When the battery is charging, keep it away from the water and the humidity.
- Do not use the tool in an environment with flammable gases, explosive or dust.

# ASSEMBLY STEPS

The size of the used expansion head must be the one corresponding to the pipe.



1

To achieve a good result, it is essential to cut the pipe as clean and perpendicular as possible to its axis.

The pipe ends should be dry and without grease, so that the plastic ring will not slide on the pipe during expansion.



2

## PEX-a ring without stop edge

Fit the plastic ring onto the pipe so that a very small part of it (max. 1mm) is outside the pipe end. The plastic ring should be firmly fitted on the pipe. If the plastic ring fits loosely, expand the pipe end slightly without the plastic ring.

Then put the ring back on the end of the pipe sticking out a bit (max. 1 mm).



## PEX-a ring with stop edge or EVO-PLUS ring

Place the ring on the end of the pipe until the pipe reaches the stop edge of the ring.



3



Before pulling the trigger, make sure the trigger safety is unlocked. Press the button, on the side of the tool that has a picture of the open padlock.

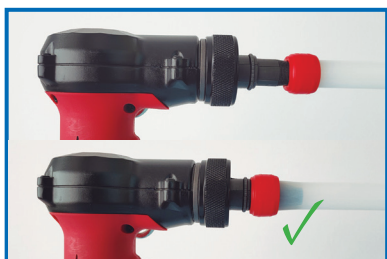
View image.

# ASSEMBLY STEPS

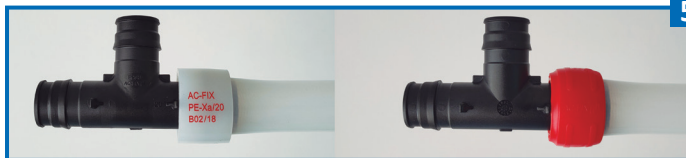
4



Screw in the expander head of the appropriate measure on the tool. Insert the expander head into the pipe, then push the trigger; the expander head will expand and retract continuously while the trigger is pressed. Each time the segments retract, repeatedly and gently push the pipe inward on the expander head several times (\*) until the pipe and ring are at level with the shoulder of the expansion head. The expander head must not be pushed inwardly of the pipe so as not to block the movement auto-rotation. Finally, remove the pipe when the segments retract and then release the trigger. Wipe off excess grease from inside the pipe.



5



Fully insert the fitting into the pipe. If you can not insert the fitting into the pipe, remove the fitting and expand once more.

6



Keep the head of expansion and the cone always clean and greased. If there is dust, dirt or debris, use a clean cloth that does not loose lint, then apply a thin layer of grease on it. Do not lubricate it too much.

(\*) The approximate number of expansions depends on the diameter of the pipe:

16 x 1,8: 4    16 x 2,2: 6    |    25 x 2,3: 8    25 x 3,5: 20

20 x 1,9: 6    20 x 2,8: 12    |    32 x 2,9: 12    **32 x 4,4: DO NOT USE**

**DO NOT USE WITH PIPES 32 x 4,4!**

## Leak test

The joint can be pressurized after 30 minutes with temperatures up to + 5 °. At lower temperatures, this time increases according to the table below. The maximum test pressure, which must not be exceeded, is 20 bar (2.0 MPa). At room temperature, after about 6 hours, the joint will be as strong as the tube.

Intervals of temperatures	Time to test pressure
+5°C — +1°C	1,5 hours
±0°C — -4°C	3 hours
-5°C — -9°C	4 hours
-10°C — -15°C	10 hours

Carry out the tightness test according to test procedure A of the standard UNE-CEN / TR 12108 IN: 2015