

Instructions for R-flex Connections

Used with All R-flex Pipe Configurations

R-flex connections are specifically designed and engineered for hydronic heating and cooling applications. They are available in PEX x NPT adapters. Tees and elbows can be constructed with the use of an NPT tee or elbow.

Assembly instructions

- 1 Cut the PEX pipe at a right angle with a pair of PEX cutters.
- 2 If the tubing is cut by a saw, deburr the pipe with an appropriate tool.
- 3 & 4 The compression fitting comes with a nut and steel plate. Use these to open the compression collar and allow the collar to slide off of the NPT base.
- 5 Slide the compression collar over the pipe. Ensure the notch on the inside of the clamping ring is facing the fitting.
- 6 Push the pipe COMPLETELY over the coupling.
- 7 Slide the clamping ring back to COMPLETELY cover the fitting.
- 8 Remove the bolt and the steel plate.
- 9 & 10 Assemble the bolt, washer and nut provided and tighten the compression collar in accordance with the following torque recommendations:

R-flex Diameter	Bolt Size	Torque
1" (USA / Canada)	M 8	8 Nm (5.9 ft-lbf)
32 mm	M 8	8 Nm (5.9 ft-lbf)
40 mm	M 8	10 Nm (7.38 ft-lbf)
50 mm	M 10	40 Nm (29.50 ft.lbf)
63 mm	M 12	70 Nm (51.63 ft-lbf)
75 mm	M 12	70 Nm (51.63 ft-lbf)
90 mm	M 16	110 Nm (81.13 ft-lbf)
110 mm	M 16	110 Nm (81.13 ft-lbf)

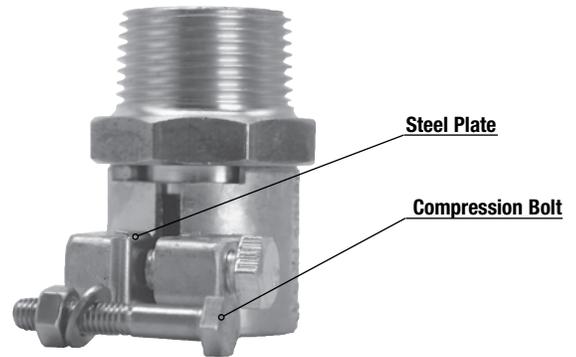
Test Connections:

1. Preliminary test

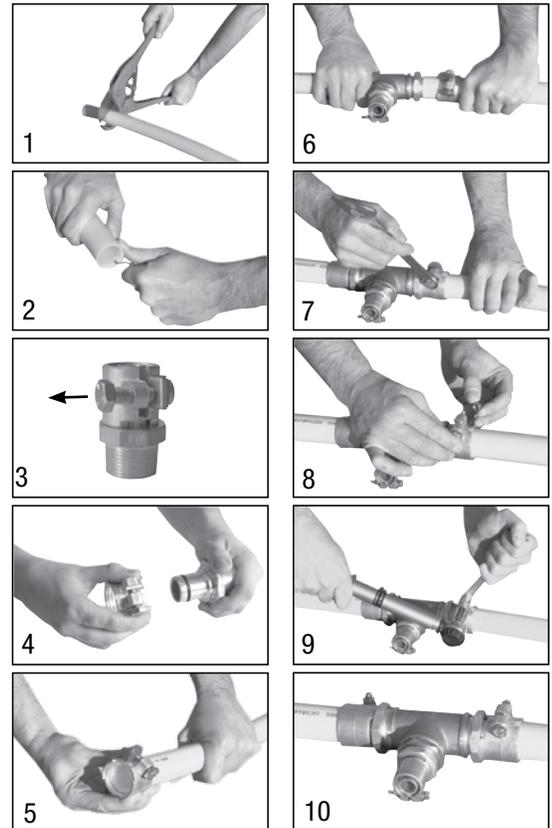
The preliminary test involves applying a test pressure equal to 1.5 times the admissible operating pressure. This pressure must be regenerated twice within the space of 30 minutes at intervals of 10 minutes. Following a test period of another 30 minutes, the test pressure must not have fallen by more than 9 psi. Leakages must not occur at any points in the system being tested.

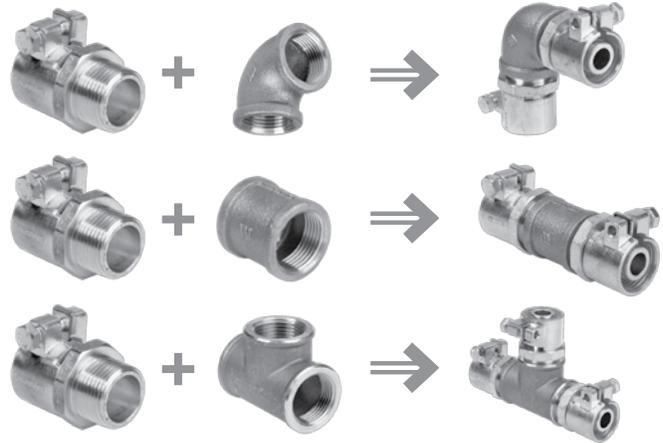
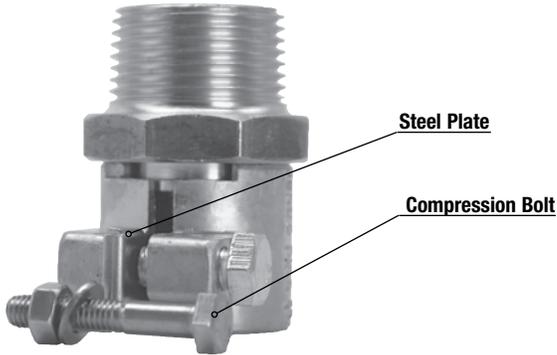
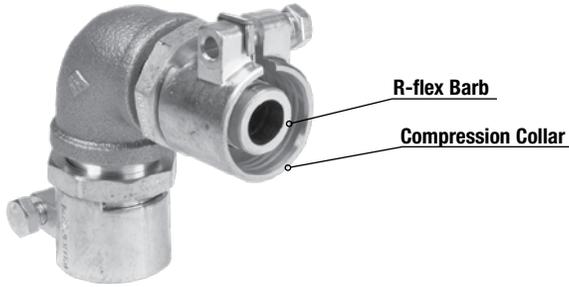
2. Main test

The main test has to be conducted immediately after the preliminary test. The test takes 2 hours. At the end of this period, the test pressure recorded after the preliminary test must not have fallen by more than 3 psi. Leakages must not occur at any point in the system being tested.



The R-flex connection is PEX x NPT. Elbows, Tees, and Couplings are created by the use of corresponding adapters.





Standard NPT Tees, Elbows, and Couplings are used with R-flex fittings to create a wide range of fitting configurations.

Qty	Description	Order #	Model #
1	1" R-flex x 1" MNPT	81012552	RFA-1X100MPT
1	32 mm R-flex x 1" MNPT	81012553	RFA-32X100MPT
1	40 mm R-flex x 1-1/4" MNPT	81012554	RFA-40X125MPT
1	50 mm R-flex x 1-1/2" MNPT	81012665	RFA-50X150MPT
1	63 mm R-flex x 2" MNPT	81012556	RFA-63X200MPT
1	75 mm R-flex x 2-1/2" MPNPT	81012589	RFA-75X250MPT
1	90 mm R-flex x 3" MNPT	81012558	RFA-90X300MPT
1	110 mm R-flex x 4" MNPT	81012590	RFA-110X400MPT

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