

The following is a summary of some of the key steps that must be followed when installing Flexpipe crimp fittings (Standard and EL). Refer to the Installation Guide for Installation details.

Safety

- Use required personal protective equipment - PPE
- Inspect equipment for damage prior to use
- Always follow proper lifting techniques
- Keep fingers out of pinch points at all times

6-Step Pipe Preparation

- 1 - Clean outside surface of pipe
- 2 - Cut pipe to length
- 3 - Check for moisture in fibers (moisture meter) / cords (visual)
- 4 - Bevel inside liner (**Note: If fibers or cords become exposed you will have to repeat steps 1 to 3**)
- 5 - Mark length of pipe to be inserted into fitting mandrel (**See dimension A/B in below table**)
- 6 - Apply Denso paste to exposed fibers/cords

Standard/EL Sleeve Outer Diameters (uncrimped)

Sleeve Type	2" O.D.	3" O.D.	4" O.D.
FP150/FP301	3.27	4.36	5.50
	83.1mm	110.7mm	139.7mm
FP300/FP601/FC901	3.35	4.55	5.68
	85.1mm	115.6mm	144.3mm

Note: Dimensions are approximate for fitting identification purposes

Fitting Preparation

- Confirm fitting sleeve O.D. and length
- Inspect O-rings for cuts, missing, or damage
- Check sleeve: no dents, centered, vent hole clear
- Check internal mandrel coating for chips
- Record fitting serial number
- Measure and mark appropriate crimp lines based on type of fittings being installed (Standard or EL table)
- Apply grease over mandrel nose and O-rings

Sleeve Length	2"	3"	4"
Standard Sleeve	4 3/4"	7 1/4"	9"
	121mm	184mm	230mm
EL Sleeve	7 1/2"	8 5/8"	11"
	191mm	219mm	280mm

Note: Dimensions are approximate for fitting identification purposes

Mandrel Insertion

- 1 - Use a crimp adaptor clamp for coupling and weld neck fittings and a press end adaptor for end flange fittings.



Coupling Fitting and Adaptor



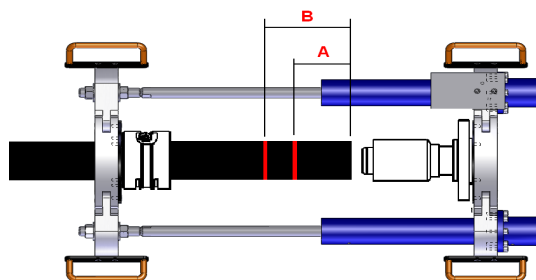
Flanged Fitting and Press End Adaptor



Use Correct Pipe Centering Tool for 2" and 3" Pipe

- 2 - Select correct pipe clamp to match pipe size (2", 3", 4") FP150, FP300, FP301, FP601, FC901

- 3 - Attach pipe clamp



A = Standard Fittings

B = EL Fittings

A		
2 IN	4-1/4" -	108mm
3 IN	6-7/8" -	175mm
4 IN	8-7/8" -	226mm
B		
2 IN	7" -	178mm
3 IN	8-1/4" -	210mm
4 IN	10-1/2" -	267mm

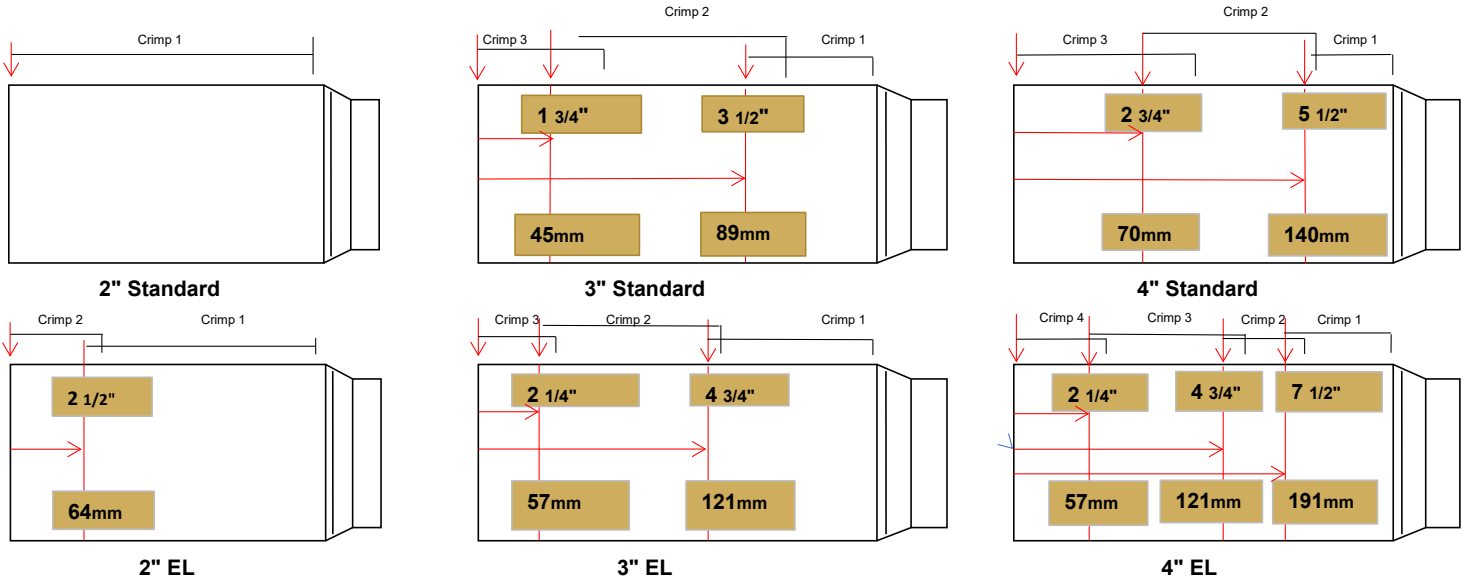
4 - Insert pipe into fitting up to marked line

NOTE: The 4" mandrel must be inserted in two steps for the EL fittings. The first step is to insert pipe halfway only, then open the press and move the clamp further back to complete fitting insertion. Clamp must never be closer than 4" from the end of the sleeve to avoid damaging the reinforcement fibers during installation.

Crimping

Ensure crimper has correct die set installed: 2" Yellow, 3" Blue, 4" Orange

Crimp all fittings starting from the first crimp line mark closest to the bell of the sleeve. Ensure the edge of the die is positioned flush with your marked line. Once crimp is done, re-position crimper die flush onto next marked line towards the pipe. Repeat as necessary. For your last crimp ensure die is flush with the end of the sleeve.



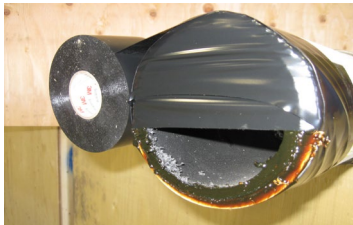
Energize the crimper to the following pressure and hold for 20 seconds for each crimp:

- FP150/FP301 with standard size fittings: 8500 PSI / 58,600 kPa
- FP601 w/ standard size fittings, and all classes of FP HT and FC products w/ EL fittings: 9000 PSI / 62,000 kPa

Completion

- Wrap fitting in Denso tape (Low Temp Denso LT on Flexpipe/FlexCord / High Temp Denso HT on High Temp pipe
- Wrap either Patco/3M or Polyken Pipeline Tape tightly over Denso tape on all fittings

Night Capping



Paste and tape all ends of exposed pipe to keep exposed fibers or steel cording dry
Examples:
Surface lines, Bell Holes, Partial Reels/Coils. **For long term storage, the use of a Flexpipe shrink cap is highly recommended.**

Maximum Allowable Pull Forces		
Pipe Size	(kgf)	(lbs)
2"	1000	2200
3"	2040	4500
4"	2720	6000