NIBCO® PressACR®
Installation Instructions

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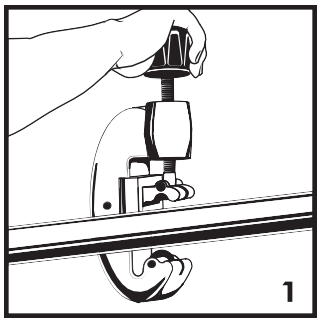
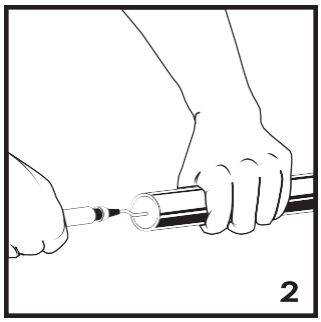
Fittings Installation Instructions

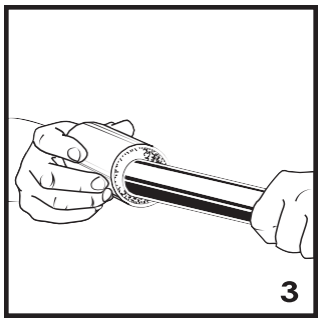
For hard or annealed ACR copper tubing



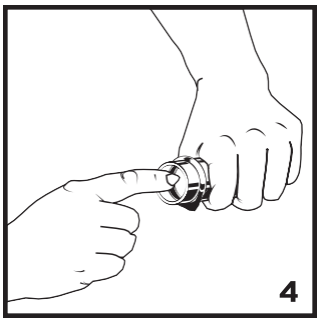
1. Select clean, undamaged copper tube and cut to desired length. Cut tube end square using a pipe cutter or fine-toothed steel saw. Do not crimp over etched print on tube.



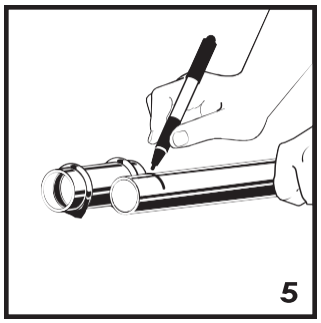
2. Deburr the tube inside diameter using a rounded file or a deburring tool.



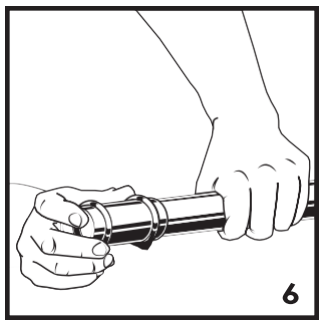
3. Deburr the tube outside diameter using a rounded file or a deburring tool. Radially sand the end of the tube with a very fine grit abrasive hand pad. Clean the tube end of all dirt, oil and grease as well as copper dust and chips from sawing.



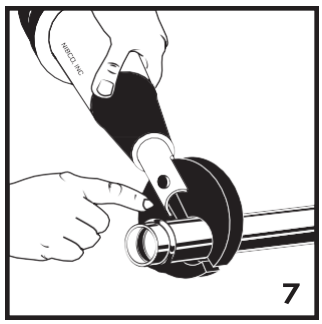
4. Check the fitting to make sure that the seal is in place, clean and free of contaminants. Only original NIBCO gray HNBR seals are to be used. Use only approved lubricants.



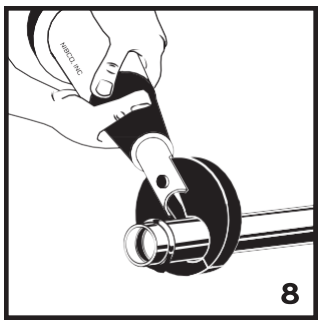
5. Mark the tube with the proper insertion depth using a permanent marker as indicated by the Insertion Depth Chart. Improper insertion depth may result in an improper seal.



6. Insert the tube into the fitting using a twisting motion to the marked depth. NOTE: End of tubing must contact stop.



7. Ensure that the proper pressing jaws are installed in the pressing tool and squeeze jaw arms to open jaw set. Place open jaws around the fitting end and ensure that the jaw is properly aligned with the contour of the fitting. For sizes 1-1/8" OD and above, the jaw has a pipe side and bead side orientation.



8. Make sure the tube is inserted to the proper depth in fitting and with the tool at a right angle to the tube, start pressing procedure.

Tube Insertion Depth Chart

Tube Size (In. OD)	Insertion Depth (In.)
1/4 – 3/4	11/16
7/8 – 1-1/8	7/8
1-3/8	1

WARNING	MISE EN GARDE !	ADVERTENCIA
Read press tool operator's manual and fitting manufacturer's installation instructions before using. Failure to follow all instructions may result in extensive property damage and/or serious personal injury. Call the NIBCO Technical Service Department at 1.888.446.4226 if you have any questions or need assistance.	Familiarisez-vous avec le mode d'emploi de la presse et les instructions du fabrint des raccords avant d'utiliser l'appareil. Le non-respect de leurs consignes risquerait d'augmenter les risques de dégâts matériels importants et/ou de graves blessures corporelles. Veuillez adresser toutes questions éventuelles ou demandes de mode d'emploi à la NIBCO en composant le 1.888.446.4226.	Antes de usar, lea el Manual del Operario de esta herramienta de presión y las instrucciones de instalación del acopliamiento proporcionadas por su fabricante. Pueden ocurrir daños materiales de gran envergadura y lesiones corporales de gravedad si no se respetan todas las instrucciones. Si tiene alguna pregunta o desea pedir un manual, llame al Departamento de Servicio Técnico de NIBCO al 1.888.446.4226.

NOTE: PressACR fittings can only be installed with NIBCO PressACR jaws. Use of any other jaw will void the product warranty

Not suitable for use with ammonia (R717)

Visit www.NIBCO.com for approved list of refrigerants

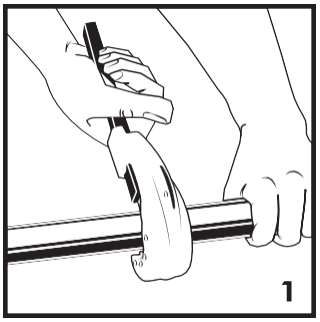
Leak Testing: Once all fittings are installed and pressed, the system may be tested for leaks. Testing for leaks should consist of pressurizing the system with nitrogen and using soapy water or tracer gas to detect leaks. Pressurize system to a minimum of 50% of the maximum rated pressure of the system, but no more than 700 PSI. Check the system for leaks and make repairs/replacements where necessary, and verify.

NIBCO® PressACR®

Fittings Installation Instructions - Tube Prep

For hard or annealed ACR copper tubing

Preparing the Copper Tube

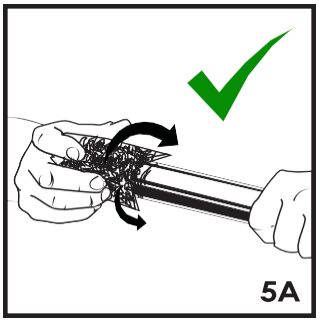


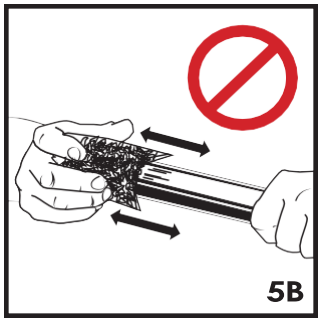
1. Select clean, undamaged copper tube and cut to desired length. Cut tube end square using a tube cutter or fine-toothed saw. Do not crimp over damaged, scratched, gouged, or otherwise damaged tubing ends. Do not crimp over etch print streams on tubing.

2. When using annealed ACR tube, ensure roundness meets the requirements of ASTM B280. Use a re-rounding tool if necessary.

3. Deburr the tube inside and outside diameter using a half-round file or a deburring tool.

4. Clean the tube end of all dirt, oil and grease.





5. Very fine grit emery cloth should be used to radially sand the end of the tube.

Scan for the Installation Video

Visit our website for the most current information.