

Plumber's Instructions For Using Pre-Soldered Fittings™

- 1. Inspect the fitting.** Inspect the fitting to make sure a complete ring of solder is present in each end.
- 2. Removing burrs resulting from pipe cutting and cleaning the mating surface.** Burrs left after cutting the pipe can make it difficult to place the fitting onto the pipe. Use a wire brush inside and outside of the pipe to remove the burr. avUsing a fine sand cloth, steel wool, or wire brush will provide a bright clean appearance, free from oxidation, dirt, corrosion, oil/grease, or foreign materials.
- 3. Applying flux.** Apply an adequate amount of lead-free flux to the mating surfaces. Push the pipe into the joint until it hits the stop.
- 4. Heating to complete the joint.** Heat two opposite sides at a 90 degree angle. **Heat the pipe more than the fitting to draw the solder out.**

Important: Stop immediately when solder appears. Joint is complete.

This will avoid dripping and burning. This process is the opposite of non pre-soldered fittings, where you direct most of the heat on the fitting and draw the solder into the joint.

- 5. Soldering in hard to reach areas.** Heating two sides is usually sufficient.

We recommend the use of a flame heat deflector shield placed around the joint. The shield helps to direct heating only where desired.

- 6. Completed joints that may need additional joining latter on.** Insert a pipe into the end or ends that are not to be soldered. Then, wrap a wet cloth around the pipe and the end of the fitting that is not to be soldered. Now, begin heating only the pipe on the end of fitting that you want to solder at this time. Make sure to keep the end not to be soldered cool at all times with a wet cloth.

** The solder used in the production of these fittings is a very unique patented solder. The solder is 9500 PSI lead free solder, nearly double the thickness and strength of normal solder. This solder will flow at 100 to 150 degrees less than normal solder, which results in less chance of burning the flux. When heated, this solder remains in a thicker state, fills in any voids, and provides a stronger leak proof joint.