CRIMPING AND GAUGING INSTRUCTIONS

Large Diameter Qick Sert CR® Fittings

Large diameter (1-1/4" and above) Qick Sert CR (CR) polymer insert and crimp fittings require a different gauge than Zurn metal insert and crimp fittings. These instructions must be followed for 1-1/4", 1-1/2, and 2" CR fittings.

Zurn's large diameter CR fittings may be installed using copper crimp rings meeting the requirements of ASTM F1807 with tools that will give crimps that meet the requirements of ASTM F1807 on brass fittings.

Crimp Rings

Acceptable copper crimp rings include the standard copper crimp ring (QCR_X) and the QickCap® copper crimp ring with positioning end cap (QCR_XPC).

Tools

The QCRTLDM tool and QCRBTKIT56-14V battery powered tool with the standard jaws for brass fittings are used with the large diameter CR fittings.

Making a Crimp Connection

At room temperature, making a large diameter CR crimp is the same as making a large diameter brass crimp. The copper crimp ring is positioned in the same place and the tool is used in the same manner for both brass and CR fittings.

When making installations in cold temperatures, if you find that the crimps do not gauge properly, leave tool in the closed position on the fitting for approximately one minute. This typically brings the finished crimp into specification for the Zurn large diameter CR fittings.

Gauging a Large Diameter CR Crimp

The gauge for Zurn's large diameter CR fittings is called a Go-Go Gauge (QGA678CR). It gauges a finished crimp in two locations and both locations should go into the gauge. It is clearly marked as being suitable for our large diameter CR fittings only. It must not be used with brass fittings.

1. For each size of crimp (1-1/4", 1-1/2", 2") there are 2 gauging dimensions. The first and largest opening of each size is to check the crimp ring at 90° to where the tool jaws meet. The gauge 90° opening should go across the mid-point of the crimp ring.

Go-Go Gauge at 90° to tool Jaw Marks. A gap between the crimp ring and gauge is acceptable as long as the gauging flats cross the mid-point of the crimp ring. It is acceptable if the crimp ring goes all the way into the gauge at this location.

2. The second and slightly smaller opening is to check the crimp ring near the location where the tool jaws meet. At this location, the crimp ring should go completely into the gauge. There are actually 2 diameters near where the tool jaws meet. The crimp is acceptable as long as one of them goes into the gauge.

Go-Go Gauge near the Jaw Marks. Crimp ring fits all the way into the gauge.

3. If a crimp should not pass the Go-Go Gauge check, it may be re-crimped. We recommend that you try to place the tool as close to the original position as possible, and leaving the tool closed for 15-30 seconds before removing the tool.

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