

Plumbing Inspector's Checklist for PEX Insert Crimp Systems

In the event there is a conflict between the contents of this list and the manufacturer's installation instructions or any applicable code, the code or the instructions, whichever is more restrictive, shall govern.

COMPONENTS

- **TUBING MARKINGS:** ASTM F 876/877/1807
- **CRIMP RINGS:** Copper Only (Black for PEX Systems) F 1807
- **INSERT FITTINGS:** Copper or Brass Only ASTM F 1807
- **MANIFOLD:** Recommended for PEX

JOINTS AND CONNECTIONS

- End cuts shall be cut square and free of burrs.
- Crimp rings shall be 1/8-inch to 1/4-inch from end of tubing.
- Crimp rings shall not have multiple crimps.
- Crimp ring shall be perpendicular to centerline of tubing.
- Check each crimp with GO/NO-GO GAUGE.
- Incorrectly crimped fittings shall be cut out and replaced.
- Contraction: allow 1/8-inch slack per foot of PEX tubing.
- PEX may be loosely bundled (NOT TAPED).
- Do not bend PEX tubing tighter than the recommended minimum bending radius.
- Install a minimum 18-inches of metallic or other approved material piping between water heater and PEX tubing.

GENERAL RECOMMENDATIONS

- PEX must be free of gouges, cuts, deep scratches, tar, kinks, grease, flux, and fading or discoloration.
- Protective sleeves or bushings shall be used with metal studs.
- Use clamps or straps at tubing bends directly from connections.
- Horizontal support shall be 32-inches minimum.
- Vertical tubing shall be supported at every floor, and at the mid-point between floors.
- Supports/clamps shall not restrict the movement of PEX tubing.
- Supports/clamps shall not pinch, cut, kink, or damage tubing.
- Use only hangers and straps recommended for plastic tubing.
- Tubing passing through slabs or foundations shall have a protective sleeve.

Continued on next page



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GENERAL RECOMMENDATIONS, CONTINUED

- Hose bibbs shall not be supported by PEX tubing. Hose bibbs shall be anchored to prevent strain on PEX tubing.
- Tubing shall be protected from nail damage.
- Transition connections shall be made with fittings approved for that purpose.
- PEX shall be located at least 6-inches horizontally and 12-inches vertically from sources of high heat.

TESTING

- Test pressure shall be at least equal to normal working pressure, but not less than 40 psi and not greater than 250 psi.
- Test duration shall not be less than 15 minutes.
- A slight drop in pressure after 2 hours is normal.

**CALL THE PEX TECHNOLOGY CENTER FOR
INFORMATION ABOUT PEX (800) 338-7732**



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