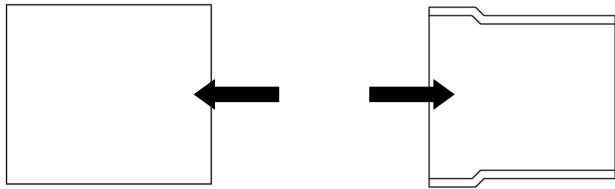


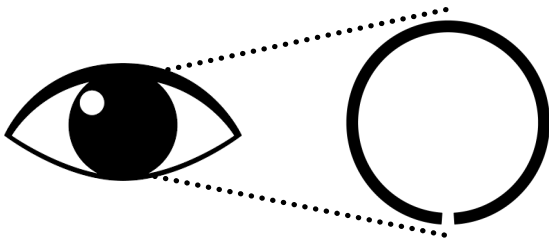
Brazing Ring Instructions

Please read and understand the following installation instructions when installing Reftekk Brazing Rings.



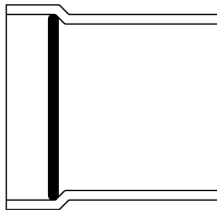
1 | Clean male tube-end and inside of female socket.

TIP: Reftekk recommends using Scotch-Brite Scouring Pads



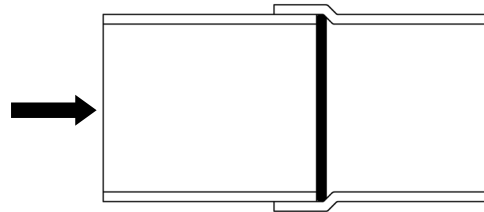
2 | Grab a properly sized brazing ring and inspect; it should have a shiny, **silver bronze** color. The ring should not have obvious defects or abnormalities.

- **DO NOT USE** if the brazing ring is miscolored or has any abnormalities.



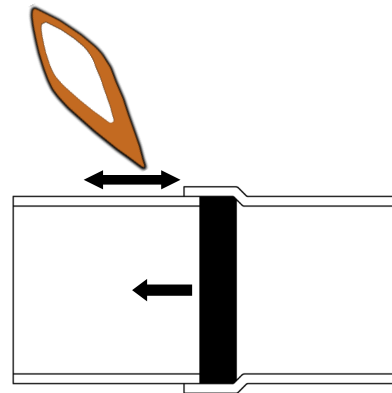
3 | Place the brazing ring inside of the socket. It should fit comfortably with slight compression.

- **DO NOT USE** if the brazing ring gap appears too large in socket.
- **DO NOT USE** if the brazing ring is too tight in the socket.
- **DO NOT USE** if the brazing ring fits too loosely in the socket.



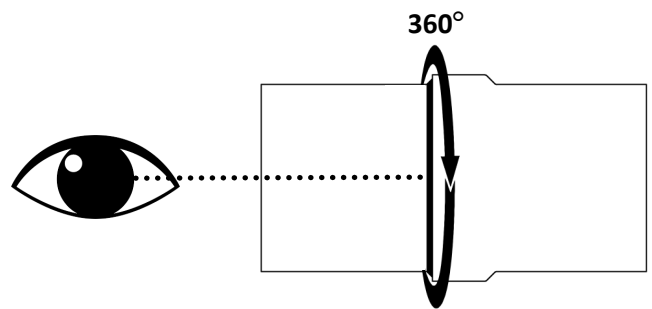
4) Insert the male tubing and push until the brazing ring and tubing are fully seated into the socket.

- **IMPORTANT:** Ensure the male tubing is in full contact with the brazing ring.



5) Begin brazing by concentrating heat on the male side of tubing, transitioning to applying heat all around the joint.

TIP: The brazing material will be drawn TOWARD the heat.



6) Braze is completed when molten braze alloy becomes visible around the full circumference of the joint.

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WARNING:

PROTECT yourself. Read and understand this information. FUMES AND GASES can be hazardous to your health. Before use, read and understand the Material Safety Data Sheet (MSDS). Keep your head out of fumes. Use enough ventilation, or exhaust at the flame, to keep fumes and gases from your breathing zone and the general area.

See American National Standard Z49.1, Safety in Welding, Cutting, and Allied Processes, published by the American Welding Society, OSHA Safety and Health Standards, available from the U.S. Government Printing Office, Superintendent of Documents, P.O. Box 371954, Pittsburgh, PA 15250-7954

MSDS: www.reftekk.com/BRGmsds

WARNING:

This product produces a chemical known to the State of California to cause cancer and birth defects (California Health & Safety Code § 25249.6). Wear appropriate safety gear and wash hands after use.

NOTES AND RECOMMENDATIONS

- A) No flux required for copper tubing.
- B) When brazing horizontally, recommended to orient the gap in the brazing ring downward.
- C) Recommended for use with half-hard (H55) copper and braze sockets created by the Reftekk SwageX handtool. Also work with conventional fittings, as well as hard and soft copper.