

ACR-L Straight Length Bendable Copper Tubing



SPECIAL FEATURES

Field Bendable: Typically eliminates factory made elbows and allows for field bent changes of direction.

Field Swageable: Typically eliminates purchased couplings and two brazes per coupling; requires only a single braze for each swaged joint.

Cleaned and Plugged: All straight lengths are cleaned, eddy current tested, and plugged per ASTM B 280.

Fewer Leak Opportunities: By eliminating one brazed joint per coupling and eliminating field brazed elbows, the potential number of leak points is greatly reduced.

Compatible on-site Storage: Straight Lengths are 19' long to allow complete closure of job site containers.

Availability: Reftekk offers availability of bendable straight length ACR as a standard offering instead of special order.

PRODUCT

ACR straight length bendable copper tube. Field bendable and swageable tubing requires approximately half the number of brazes, greatly reducing the number of potential leak points and reducing installation time and quantity of materials. All straight lengths are cleaned, eddy current tested, and plugged per ASTM B 280.

COPPER SPECS

Material: ACR UNS C12200 Copper Tube manufactured in compliance with ASTM B 280.

Specifications: Straight Length Bendable Copper Tube meets the dimensional, chemical, mechanical strength, cleanliness and eddy current testing requirements of ASTM B 280.

Mechanical Strength: Minimum 36 ksi tensile strength per ASTM B 280.

Temper: The maximum hardness is limited to be an H55 temper, creating a bendable quality tube.

Length: Tube is supplied in 19' straight lengths, sealed with plugs to maintain cleanliness.

Dimensions & Tolerances: Meets ACR-L standards.

⚠ CAUTION

▲ Use Reftekk approved swaging tool.

▲ Do not use Swing Benders or T-Benders.

▲ Do not flare.

▲ Use Reftekk approved bending tool.

▲ Do not swage 1/4" OD tubing.

NOTE: Quantities are estimates only. Contractor is responsible for quantities required on project.

Length (ft)	Product #	Tube OD	Wall Thickness	Tube Length (ea.)	Min. Recommended Bend Radius (in.)	Recommended Bender
	HHC02	1/4"	0.030"	19 ft	0.688	Imperial 370-FH
	HHC03	3/8"	0.030"	19 ft	1.125	
	HHC04	1/2"	0.035"	19 ft	1.500	
	HHC05	5/8"	0.040"	19 ft	2.188	Refftekk Digi-Bender
	HHC06	3/4"	0.042"	19 ft	2.625	
	HHC07	7/8"	0.045"	19 ft	3.063	
	HHC09	1-1/8"	0.050"	19 ft	3.938	
	HHC11	1-3/8"	0.055"	19 ft	4.813	
	HHC13	1-5/8"	0.060"	19 ft	5.688	TBD

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Important Installation Notes

GENERAL

- 1) Refer to Reftekk's website (<http://www.reftekk.com>) for additional information
- 2) Ensure piping is properly insulated and sealed to keep the piping system dry
- 3) Keep tubing plugged until final installation to maintain cleanliness
- 4) Store in clean dry environment and protect from mechanical damage
- 5) Do **NOT** store directly on concrete or bare metal
- 6) Do **NOT** flare
- 7) Do **NOT** direct bury (under concrete, earth, water, etc.)
- 8) Support intalled tubing per local code requirements and per authority having jurisdiction

BENDING

- 1) Use **ONLY** Reftekk recommended or approved tubing benders:

Recommended

- Imperial 370-FH for tube sizes 1/4" thru 1/2"
- Reftekk Digi-Bender for tube sizes 5/8" thru 1-3/8"

Approved

- REMS Curvo
- REMS Curvo 50
- Lever-style hand-benders designed for O.D. tubing and having bending radii greater than or equal to the minimum recommended values

Do **NOT** use

- Any "swing" or "T" style benders
- Any benders with bending radii less than the minimum recommended values
- Any benders not designed for O.D. tubing (including conduit benders)

- 2) Refer to Reftekk Digi-Bender Instruction manual for complete safety and operating instructions.
- 3) Do **NOT** attempt to un-bend or re-bend any previous bends

SWAGING

- 1) Use **ONLY** Reftekk SwageX swage expander for brazing applications
 - Refer to operations manual for complete safety and operating instructions.
 - SwageX socket depth is only for use on BRAZED joints
 - Do **NOT** use for soldered joints
- 2) Tubing **MUST** be cut square with sharp tubing cutter and properly de-burred
 - Do **NOT** expand (swage) tubing that has not been de-burred