

How to Join Lawton Plastic Coated Copper Tube

Joining plastic coated copper tube.



Lawton Plastic Coated Copper Tube	Copper tube to BS EN 1057 with a solid PVC or PE covering (BS EN 13349) for corrosion protection. The covering is heat sensitive and must be drawn back and protected while the joint is made.
Joining	By soldering or brazing, in accordance with How to Solder Lawton Plumbing Capillary Fittings or How to Braze Lawton Plumbing Capillary Fittings. Soldering is the lower temperature process and is kinder to the covering.
Flux and Filler	See the Lawton Joining Solutions Data Sheet. The standards and the project specification take precedence over this guide.

Safety

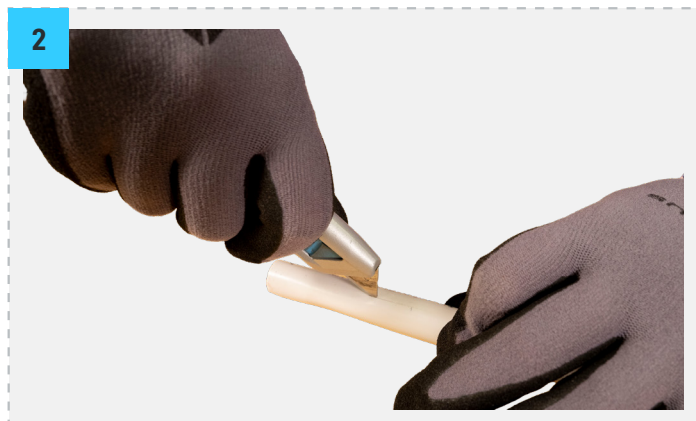
- Work shall be carried out in a well ventilated area. Heating the covering gives off fumes, which must not be breathed. The coating must not be burned or overheated.
- Eye protection and suitable gloves must be worn, and the blow lamp used with care.
- Hot work precautions shall be observed. Combustible materials must be cleared from the area, a fire extinguisher kept to hand and a fire watch maintained after the work. Particular care is needed when working near joists, floorboards and insulation.

These are general precautions. Site rules and any permit to work may differ and shall be followed.

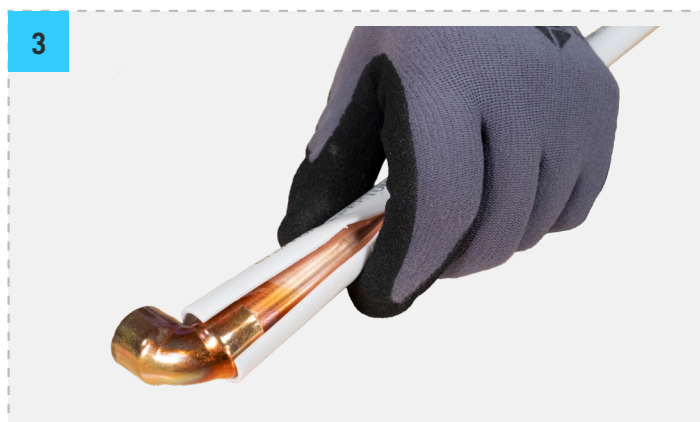
Procedure



1. Make a circular incision through the covering around the tube, at a distance from the end equal to the depth of the fitting socket.



2. Remove the cut length of covering from the end of the tube to expose the copper for jointing.



3. Make a lengthwise incision in the covering back from the cut so that it can be peeled clear of the joint.



4. Peel the covering back carefully to expose the tube around the joint.



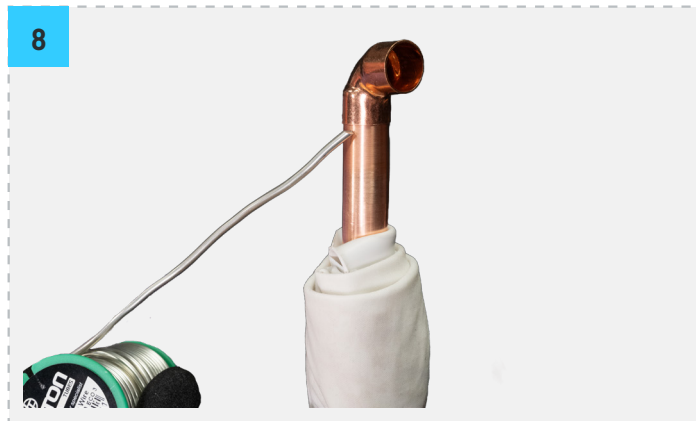
5. Secure the peeled covering clear of the joint with tape.



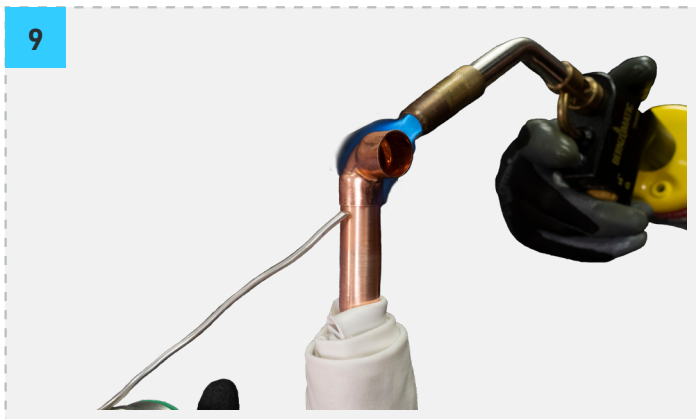
6. Clean the exposed tube and the fitting with a suitable abrasive pad.



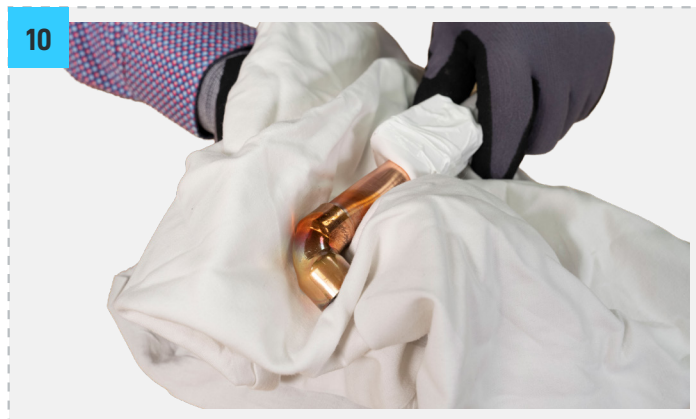
7. Flux and assemble the joint as described in the soldering or brazing guide.



8. Wrap the exposed covering next to the joint with a damp cloth to shield it from the heat.



9. Make the joint with the blow lamp, following the soldering or brazing guide. The flame must be kept off the covering and no more heat used than the joint needs.



10. Let the joint cool fully, then remove the damp cloth.



11. Re-position the covering over the joint and secure it with tape, ensuring any exposed edge is sealed by the tape. If and when required to apply covering or insulation over the fitting itself, apply it accordingly to the manufacturer's instructions. Some types of covering and insulation tape can be used to simultaneously secure and seal the edges of the covering and apply over the exposed fittings.

For more details, please refer to our website or contact us by e-mail at technical@lawtontubes.co.uk