

Technical Note:

## COLD EXPANSION FITTINGS

### USE WITH PIPE & TUBING MADE FROM KAFRIT NA CROSS-LINKED POLYETHYLENE

Cold expansion fitting techniques have been successfully used with Kafrit NA cross-linked polyethylene for more than a decade in Europe. The most critical aspect of this technique is to ensure that the expansion of the pipe or tubing is uniform around the entire circumference of the pipe or tubing. To ensure the most uniform expansion and best quality connection, the following steps should be taken:

- Expand the pipe or tube at ambient temperatures greater than 5°C (41°F)
- Expand the pipe or tubing as slowly as possible
- Ensure that the pipe or tubing used has uniform wall thickness before attempting to use the pipe or tubing with cold expansion fittings

Special care should be taken when using cold expansion fittings with radiant heating tubing or pipe which has an oxygen barrier layer bonded to it. Depending on the oxygen barrier (EVOH) and adhesive that is used to bond it to the cross-linked polyethylene, problems may be observed. Check the integrity of the barrier layer and carefully check for leaks when making cold expansion connections on heating pipe or tubing.

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Revised & Reviewed: October 18, 2022