

## Soft Alloys: (90/10 & 70/30 Copper Nickel/ Brass/ Copper) Tube Preparation Instructions

Sealing a brass or copper nickel tube requires greater care in tube preparation than harder tube materials. A Tube Preparation Brush can remove 0.005" (0.13mm) of tube material in only 5 seconds. Secondly, a brush inserted at a 2" depth and rotated can create a larger ID than the ID at the tube end. (Fig. A)

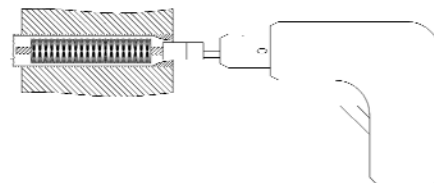


FIG. A

This can give you a false reading using the Go/No-Go Gage. (Fig. B)

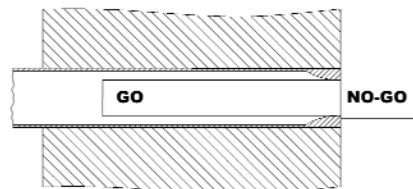


FIG. B.

Brushing technique for brass/ copper nickel tubes.

1. Insert Brush in the ID to a depth of 3/4" (19mm) or less. Brush for no longer than five (5) seconds. If pits have been removed, measure with Go/No Go Gage. (Fig. C).
2. Insert brush to 1-3/4" (43mm) and brush for less than five (5) seconds. Measure with Go/No Go gage and continue installation as described in Step 5 of EST Document DC4010 for P2 Pop-A-Plugs and Step 5 of DC1220 for CPI / Perma Plugs.

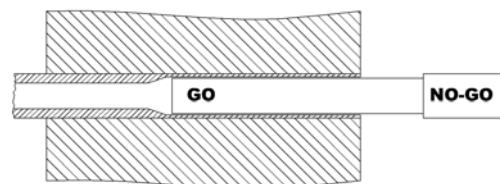


FIG. C

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