

## SERVICE BULLETIN

**WARNING: Important service/installation information is contained in this bulletin. All installers and contractors must read, understand and follow these vital installation methods and steps. If you have any questions about this bulletin, contact Parker at 636-392-3906, or <http://sporlanonline.com/zoomlock/>. Failure to properly follow these warnings/instructions could lead to personal injury and/or system damage.**

**APPLICATION:** All 1-1/8" Elbows (90's and 45's) using 15 kN Klauke/RLS/Parker tool system

\*\*\*Note: RIGID compatible jaws and 19 kN Klauke/RLS/Parker tools and jaws are not affected by this

**REASON FOR RELEASE:** RLS has determined that the jaws as designed for the 15kN Klauke/RLS/Parker Tool may not completely crimp the 1-1/8" elbow fitting on the first attempt. This condition is readily detectable when using the RLS "go-no-go" gauge provided with the Tool as instructed (see instructions included with Tool <http://sporlanonline.com/zoomlock/>). Where the 15kN Klauke/RLS/Parker jaw has been used without the "go-no-go" gauge, a system leak may occur which could lead to **personal injury and/or system damage**. RLS has made the manufacturer of the tool aware of the issue and is working with its supplier to remedy the situation. A new jaw is being designed to resolve the issue.

**URGENCY:** Immediately and prior to any new 1-1/8" elbow installations all installers must read, understand and follow all warnings/instructions within this bulletin.

**LONG TERM RESOLUTION:** The manufacturer is in the process of designing a new jaw for the 15kN Klauke/RLS/Parker Tool System. The new jaw will provide a permanent solution for the crimp of the elbow, preventing any leak hazard.

**EXISTING INSTALLATIONS:** RLS recommends that, where possible, installers check any installations made using the 15kN Klauke/RLS/Parker Tool where the installer did not use the "go-no-go" gauge as instructed. If such an installation occurred, the system should be locked-out/locked off and reduce to atmospheric system pressure before inspecting with crimp gauge per installation steps below.

### **INSTALLATION STEPS:**

- 1). Prior to crimping, all proper installation steps leading up to crimping should be followed. These can be found on the documents in the toolkit or a <http://sporlanonline.com/zoomlock/>.
- 2). Lubricate the tool jaws prior to use.
- 3). Use tool 15 kN Klauke/RLS/Parker tool crimp the 1-1/8" elbow onto the piping system.
- 4). Once crimped onto the pipe use the "go-no-go" gauge (provided in tool kit) to determine if the crimp is complete. (If gauge has been lost or misplaced please contact RLS/Parker Sporlan for replacement). If gauge indicates a complete crimp, the process is done.
- 5). If the "go-no-go" gauge shows an incomplete crimp rotate 15 kN Klauke/RLS/Parker tool 30°-45°.
- 6). Re-crimp the elbow.
- 7). Use the "go-no-go" gauge to again determine if the crimp is complete. If gauge indicated a complete crimp, the process is done.
- 8). If the "go-no-go" gauge shows an incomplete crimp rotate tool 15 kN Klauke/RLS/Parker tool another 30°-45°.
- 9). Re-crimp the elbow.
- 10). Use the "go-no-go" gauge to again determine if the crimp is complete. If the gauge indicates a complete crimp, the process is done
- 11). **If the "go-no-go" gauge shows an incomplete crimp STOP THE PROCESS, GO NO FURTHER.**
- 12). De-energize system of all pressure, release all pressure (per code), evacuate all pressure, lock-out/lock-off the system so that no pressure can be added until a new elbow fitting can be installed.
- 13). Cut out and remove the old elbow fitting.
- 14). Install new pipe section(s) and elbow; begin process at step number one.

Note: All work must be performed by qualified personnel only. Use only authorized RLS fittings, supplies and tools, specified or supplied by RLS Group. All applicable OSHA safety standards, safe industry practices and local code/ordinances must be observed and followed. Observe all safety information contained in the RLS manuals and instructions. This bulletin, and all related technical information, must be made available to all personnel using RLS fittings and tools. 1