



# Standard Specification for Cold Expansion Fittings with PEX Reinforcing Rings for Use with Cross-linked Polyethylene (PEX) and Polyethylene of Raised Temperature (PE-RT) Tubing<sup>1</sup>

This standard is issued under the fixed designation F1960; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon ( $\epsilon$ ) indicates an editorial change since the last revision or reapproval.

## 1. Scope\*

1.1 This specification covers cold expansion fittings and cross-linked (PEX) reinforcing rings for use with cross-linked polyethylene (PEX) plastic tubing in nominal tubing sizes of  $\frac{3}{8}$ ,  $\frac{1}{2}$ ,  $\frac{5}{8}$ ,  $\frac{3}{4}$ , 1,  $1\frac{1}{4}$ ,  $1\frac{1}{2}$ , 2,  $2\frac{1}{2}$ , and 3 in. that meet the requirements of Specification **F876** or **F3253** and for use with Polyethylene of Raised Temperature (PE-RT) pipe in nominal tubing sizes of  $\frac{3}{8}$ ,  $\frac{1}{2}$ ,  $\frac{5}{8}$ ,  $\frac{3}{4}$ , 1,  $1\frac{1}{4}$ ,  $1\frac{1}{2}$ , 2,  $2\frac{1}{2}$ , and 3 that meet the requirements of Specification **F2769**. These fittings are intended for use in 100 psi (690 kPa) cold- and hot-water distribution systems operating at temperatures up to and including 180 °F (82 °C). The system is comprised of a PEX reinforcing ring and a cold expansion fitting. Included are the requirements for materials, workmanship, dimensions, and markings to be used on the fitting components. The components covered by this specification are intended for use in residential and commercial, hot and cold, potable water distribution systems as well as sealed central heating, including under-floor-heating systems.

1.2 The values stated in inch-pound units are to be regarded as standard. The values given in parentheses are mathematical conversions to SI units that are provided for information only and are not considered standard.

1.3 *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety, health, and environmental practices and determine the applicability of regulatory limitations prior to use.*

1.4 *This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.*

## 2. Referenced Documents

### 2.1 ASTM Standards:<sup>2</sup>

**A351/A351M** Specification for Castings, Austenitic, for Pressure-Containing Parts

**B16/B16M** Specification for Free-Cutting Brass Rod, Bar and Shapes for Use in Screw Machines

**B140/B140M** Specification for Copper-Zinc-Lead (Red Brass or Hardware Bronze) Rod, Bar, and Shapes

**B62** Specification for Composition Bronze or Ounce Metal Castings

**B75/B75M** Specification for Seamless Copper Tube

**B283/B283M** Specification for Copper and Copper-Alloy Die Forgings (Hot-Pressed)

**B371/B371M** Specification for Copper-Zinc-Silicon Alloy Rod

<sup>1</sup> This specification is under the jurisdiction of ASTM Committee **F17** on Plastic Piping Systems and is the direct responsibility of Subcommittee **F17.10** on Fittings. Current edition approved Nov. 1, 2020/May 1, 2021. Published December 2020/May 2021. Originally approved in 1999. Last previous edition approved in 2019/2020 as **F1960—19a**/F1960 – 20. DOI: 10.1520/F1960-20.10.1520/F1960-21.

<sup>2</sup> For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

- [B453/B453M](#) Specification for Copper-Zinc-Lead Alloy (Leaded-Brass) Rod, Bar, and Shapes  
[B584](#) Specification for Copper Alloy Sand Castings for General Applications  
[B927/B927M](#) Specification for Brass Rod, Bar, and Shapes  
[B967/B967M](#) Specification for Copper-Zinc-Tin-Bismuth Alloy Rod, Bar and Wire  
[D792](#) Test Methods for Density and Specific Gravity (Relative Density) of Plastics by Displacement  
[D1505](#) Test Method for Density of Plastics by the Density-Gradient Technique  
[D1600](#) Terminology for Abbreviated Terms Relating to Plastics  
[D2122](#) Test Method for Determining Dimensions of Thermoplastic Pipe and Fittings  
[D2765](#) Test Methods for Determination of Gel Content and Swell Ratio of Crosslinked Ethylene Plastics  
[D2837](#) Test Method for Obtaining Hydrostatic Design Basis for Thermoplastic Pipe Materials or Pressure Design Basis for Thermoplastic Pipe Products  
[D6394](#) Classification System for and Basis for Specification for Sulfone Plastics (SP)  
[F412](#) Terminology Relating to Plastic Piping Systems  
[F876](#) Specification for Crosslinked Polyethylene (PEX) Tubing  
[F877](#) Specification for Crosslinked Polyethylene (PEX) Hot- and Cold-Water Distribution Systems  
[F2159](#) Specification for Plastic Insert Fittings Utilizing a Copper Crimp Ring, or Alternate Stainless Steel Clamps for SDR9 Crosslinked Polyethylene (PEX) Tubing and SDR9 Polyethylene of Raised Temperature (PE-RT) Tubing  
[F2735](#) Specification for Plastic Insert Fittings For SDR9 Cross-linked Polyethylene (PEX) and Polyethylene of Raised Temperature (PE-RT) Tubing  
[F2769](#) Specification for Polyethylene of Raised Temperature (PE-RT) Plastic Hot and Cold-Water Tubing and Distribution Systems  
[F3253](#) Specification for Crosslinked Polyethylene (PEX) Tubing with Oxygen Barrier for Hot- and Cold-Water Hydronic Distribution Systems  
[F3348](#) Specification for Plastic Press Insert Fittings with Factory Assembled Stainless Steel Press Sleeve for SDR9 Cross-linked Polyethylene (PEX) Tubing and SDR9 Polyethylene of Raised Temperature (PE-RT) Tubing

## 2.2 ANSI Standard:

- [B1.20](#) Pipe Threads General Purpose<sup>3</sup>  
[B16.18](#) Cast Copper Alloy Solder Joint Pressure Fittings  
[B16.22](#) Wrought Copper and Copper Alloy Solder Joint Pressure Fittings

## 2.3 NSF Standards:

- [NSF 14](#) for Plastic Piping Components and Related Materials<sup>4</sup>  
[NSF 61](#) for Drinking Water System Components-Health Effects<sup>4</sup>

## 2.4 Manufacturers' Standardization Society Standards:

- [SP-104](#) Wrought Copper Solder Joint Pressure Fittings<sup>5</sup>

## 2.5 ISO Standards:<sup>6</sup>

- [ISO 9080](#) Plastics piping and ducting systems -- Determination of the long-term hydrostatic strength of thermoplastics materials in pipe form by extrapolation  
[ISO 12162](#) Thermoplastics materials for pipes and fittings for pressure applications –Classification, designation and design coefficient

## 3. Terminology

### 3.1 Definitions:

- 3.1.1 Definitions are in accordance with Terminology [F412](#) and abbreviations are in accordance with Terminology [D1600](#), unless otherwise indicated.
- 3.1.2 *PEX reinforcing rings*—cross-linked polyethylene rings used to add contraction force around the cold expansion fittings.

## 4. Classification

- 4.1 This specification covers one class of cold expansion fittings with PEX reinforcing rings suitable for use with PEX tubing that meets the requirements of Specification [F876](#) or [F3253](#) and with PE-RT tubing that meets the requirements of Specification [F2769](#).

<sup>3</sup> Available from American National Standards Institute (ANSI), 25 W. 43rd St., 4th Floor, New York, NY 10036, <http://www.ansi.org>

<sup>4</sup> Available from NSF International, P.O. Box 130140, 789 N. Dixboro Rd., Ann Arbor, MI 48113-0140, <http://www.nsf.org>.

<sup>5</sup> Available from Manufacturers Standardization Society of the Valve and Fittings Industry (MSS), 127 Park St., NE, Vienna, VA 22180-4602, <http://www.mss-hq.com>.

<sup>6</sup> Available from International Organization for Standardization (ISO), ISO Central Secretariat, BIBC II, Chemin de Blandonnet 8, CP 401, 1214 Vernier, Geneva, Switzerland, <http://www.iso.org>.

## 5. Materials and Manufacture

5.1 Cold expansion fittings shall be made from one of the following materials:

5.1.1 Brass:

5.1.1.1 *Machined Brass*—Machined brass fittings shall be made from material meeting the requirements of one of the following listed below:

Specification	Alloy
ASTM <b>B16/B16M</b>	UNS C36000
ASTM <b>B140/B140M</b>	UNS C31400
ASTM <b>B371/B371M</b>	UNS C69300, C69850
Standard EN 12164	CW614N
ASTM <b>B453/B453M</b>	UNS C35300
ASTM <b>B927/B927M</b>	UNS C27450, C27451
ASTM <b>B967/B967M</b>	UNS C49260, C49340

5.1.1.2 *Forged Brass*—Forged brass fittings shall be made from material meeting the requirements of Specification **B283/B283M**, Copper Alloy UNS Nos. C27450, C27451, C27453, C35330, C36500, C37700, C46400, C46500, C48600, C49260, C49340, C69300, or C69850.

5.1.1.3 *Cast Copper Alloys*—Cast copper alloy fittings shall be made from material meeting the requirements of Specification **B584**, Copper Alloy UNS Nos. C84400, C83800, C87850 or C89844 or C89836 or Specification **B62**, Copper Alloy UNS No. C83600, or Standard EN 1982, copper alloy EN Symbol CuSn4Zn6Pb3–C.

5.1.2 *Sulfone*:

5.1.2.1 *20 % Glass-Filled Polysulfone*—Polysulfone fittings produced using glass reinforcement shall be molded from polysulfone materials as specified in Specification **D6394**. The polymers shall consist of polysulfone and glass fiber and meet the following line call out for additional properties (SP0110G20A30430).

5.1.2.2 *Unreinforced Sulfone Plastic (SP)*—Fittings shall be molded from sulfone plastic (SP) as specified in Specification **D6394**. The material shall be unreinforced polysulfone (group 01, class 1, grade 2), or polyphenylsulfone (group 3, class 1, grade 2.) or unreinforced polyphenylsulfone/polysulfone blends (group 04, class 1, grade 2) or reworked plastic in accordance with **5.1.2.3**.

NOTE 1—Since fittings specified by this specification will be used in hot-and-cold water plumbing systems (also noted for Specifications **F2159**, **F2735**, and **F3348**), a material used to manufacture fittings in accordance with this specification must demonstrate qualities consistent with that application in addition to the performance requirements of this specification. Those qualifying characteristics include, but are not limited to, an established stresshydrostatic design basis (SDB)(HDB) in accordance with Test Method **D2837** ~~pressure design basis (PDB)~~ or ISO 9080/ ISO 12162 compliant minimum required stress (MRS) and a demonstration of resistance to the long-term effects of those chemicals normally found in potable water at the maximum temperature stated in this specification.

5.1.2.3 Clean rework material of the same commercial designation, generated for the manufacturer's own production may be used by the same manufacturer, provided the fittings meet all of the requirements of this specification. Rework material shall not be introduced at a ratio exceeding 25%.

5.2 Reinforcing rings shall be made from PEX material meeting the performance requirements of **6.1**.

5.3 *Stainless Steel*—fittings shall be made from material meeting the requirements of Specification **A351/A351M**, stainless steel UNS No. J92800.

5.4 *Wrought Copper*—Wrought copper fittings shall be made from material meeting the requirements of Specification **B75/B75M** for one of the following coppers: copper UNS C10200, C10300, C10800, or C12200.

## 6. General Requirements

6.1 *General*—All performance tests shall be performed on assemblies of fittings, PEX reinforcing rings and PEX or PE-RT tubing.

Fittings and reinforcing rings shall meet the material and dimensional requirements of this specification. PEX tubing shall meet the requirements of Specification **F876** or **F3253**. PE-RT tubing shall meet the requirements of Specification **F2769**. Assembly of test specimens shall be in accordance with **10.1**. Each assembly shall contain at least two joints. Use separate sets of assemblies for each performance test requirement.

6.1.1 Fitting manufactured according to this specification and intended for use with PEX tubing meeting requirements of Specification **F876**, shall comply with the following performance requirements of Specification **F877**. When a section with an identical title appears in this specification, it contains additional requirements that supplement those found in Specification **F877**.

6.1.1.1 Requirements,

6.1.1.2 Test Methods, and

6.1.1.3 Retest and Rejection.

6.1.2 Fittings, manufactured according to this specification and intended for use with PE-RT tubing meeting the requirements of Specification **F2769**, shall comply with the following performance requirements of Specification **F2769**. When a section with an identical title appears in this Specification, it contains additional requirements that supplement those found in Specification **F2769**.

6.1.2.1 Requirements,

6.1.2.2 Test Methods, and

6.1.2.3 Retest and Rejection.

6.2 *Dimensions*—Any randomly selected fitting or fittings and PEX reinforcing rings shall be used to determine dimensions. Measurements shall be made in accordance with Test Method **D2122**, except determine diameter by making measurements at four locations spaced at approximately 45° apart around the circumference. Inspection and gauging of solder joint ends shall be accordance with ANSI B16.18, ANSI B16.22, or Manufacturers' Standardization Society SP-104.

## 7. Performance Requirements

7.1 *PEX Reinforcing Rings:*

[ASTM F1960-21](https://standards.iteh.ai/catalog/standards/sist/7605bd54-ceb3-485f897a-2626d449ae3b/astm-f1960-21)

<https://standards.iteh.ai/catalog/standards/sist/7605bd54-ceb3-485f897a-2626d449ae3b/astm-f1960-21>

7.1.1 *Density*—When determined in accordance with **11.1**, the PEX reinforcing rings shall have a density in the range from 926 to 940 kg/m<sup>3</sup>.

7.1.2 *Degree of Cross-linking*—When tested in accordance with **11.2**, the degree of cross-linking for PEX reinforcing rings shall be within the range from 70 to 89% inclusive.

7.1.3 *Stabilizer Functionality*—The material used to make the PEX rings shall meet the stabilizer functionality requirements of Specification **F876**.

## 8. Dimensions

8.1 *Dimensions and Tolerances*—The dimensions and tolerances of fittings and PEX reinforcing rings shall be as shown in **Figs. 1 and 2**, and **Fig. 4** when measured in accordance with **6.2**.

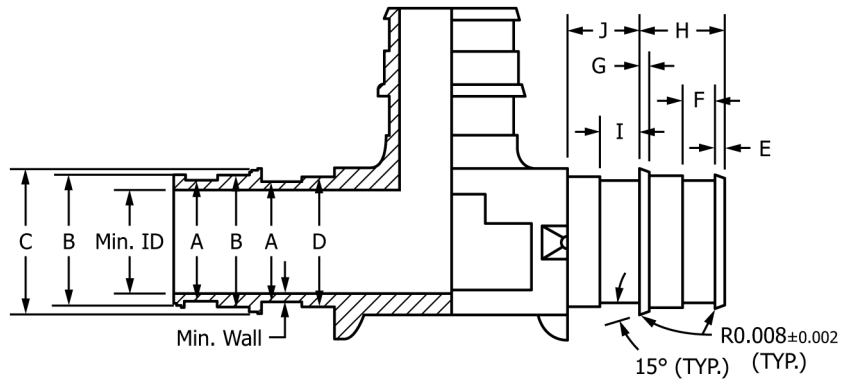
8.1.1 *Alignment*—The maximum angular variation of any opening shall not exceed 1° off the true centerline axis.

8.1.2 *Fittings with Solder Joint Ends*—Solder joint ends shall be in accordance with ANSI B16.22, ANSI B16.18 or MSS SP-104.

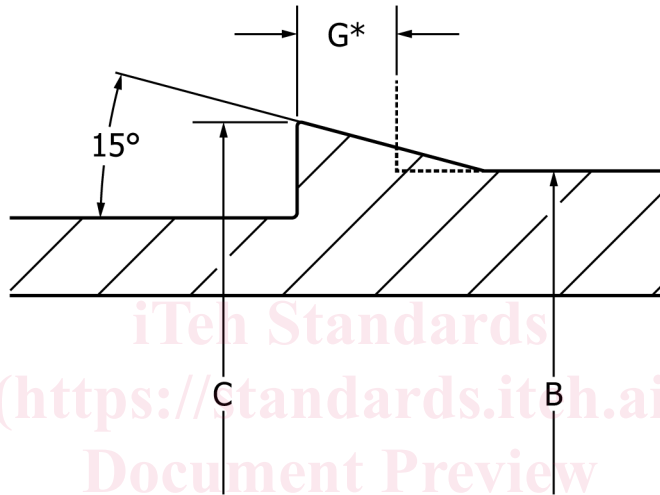
8.1.3 *Tapered Threaded Ends*—Fitting threads shall be right-hand conforming to ANSI B1.20.1. They shall be taper threads (NPT).

## 9. Workmanship, Finish, and Appearance

9.1 The fittings shall be made from compounds that are homogeneous throughout. The sealing surfaces of the insert shall be



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\*Maximum width of dimension "G" allowed to transition to surface of dimension "B"

Brass, Stainless Steel and Wrought Copper Dimensions

Nominal Tubing Sizes	Min. Wall	Min. ID	A max min	B max min	C max min	D max min	E max min	F max min	G min	H max min	I max min	J max min
3/8	0.047	0.260	0.395 0.375	0.441 0.433	0.480 0.472	0.427 0.407	0.067 0.051	0.128 0.108	0.051	0.325 0.305	0.127 0.107	0.286 0.266
1/2	0.057	0.378	0.533 0.513	0.579 0.571	0.618 0.610	0.565 0.545	0.067 0.051	0.128 0.108	0.051	0.404 0.384	0.167 0.147	0.325 0.305
5/8	0.057	0.500	0.655 0.635	0.697 0.689	0.748 0.740	0.683 0.663	0.067 0.051	0.167 0.147	0.051	0.482 0.462	0.207 0.187	0.404 0.384
3/4	0.057	0.595	0.748 0.728	0.795 0.787	0.874 0.866	0.782 0.762	0.067 0.051	0.207 0.187	0.051	0.522 0.502	0.246 0.226	0.443 0.423
1	0.072	0.795	0.985 0.965	1.032 1.024	1.110 1.102	0.998 0.978	0.067 0.051	0.246 0.226	0.051	0.640 0.620	0.285 0.265	0.561 0.541
1 1/4	0.075	0.960	1.159 1.139	1.276 1.266	1.362 1.352	1.237 1.217	0.080 0.064	0.299 0.279	0.064	0.781 0.761	0.348 0.328	0.684 0.664
1 1/2	0.095	1.084	1.324 1.304	1.382 1.374	1.494 1.486	1.349 1.329	0.093 0.077	0.351 0.331	0.077	0.919 0.899	0.408 0.388	0.805 0.785
2	0.095	1.550	1.800 1.780	1.958 1.950	2.079 2.071	1.891 1.871	0.093 0.077	0.467 0.447	0.077	1.137 1.117	0.521 0.501	1.030 1.010
2 1/2	0.105	1.990	2.280 2.260	2.430 2.410	2.585 2.565	2.430 2.410	0.155 0.135	0.610 0.590	0.160	1.520 1.480	0.610 0.590	1.350 1.310
3	0.115	2.410	2.720 2.700	2.910 2.890	3.080 3.060	2.910 2.890	0.180 0.160	0.710 0.690	0.190	1.810 1.770	0.720 0.700	1.610 1.570

**FIG. 1 Brass and Stainless Steel and Wrought Copper Insert Dimensions and Tolerances**

smooth and free of foreign material. The fitting walls shall be free of cracks, holes, blisters, voids, foreign inclusions, or other defects that are visible to the naked eye and that affect wall integrity.

## 10. Assembly

10.1 *Cold Expansion Joints*—Fittings shall be joined to PEX or PE-RT tubing by the contraction of the expanded tubing and reinforcing ring over the insert of the cold expansion fitting. Fittings and PEX reinforcing rings shall meet the dimensional and material requirements of this standard. PEX tubing shall meet the requirements of Specification **F876** or **F3253**. PE-RT tubing shall meet the requirements of Specification **F2769**.

10.2 *Expansion Tool*—The expansion tool shall expand the PEX tubing and reinforcing ring to a maximum inside diameter as listed in **Table 1**. The expanded tubing shall be round to ensure uniform contraction of the tubing around the cold expansion fitting. The expansion tool shall be inspected for wear according to the manufacturer’s instructions.

10.3 *Procedure:*

10.3.1 *Assembly of Connections*—Refer to manufacturers written installation instructions.

## 11. Reinforcing Ring Testing Methods

11.1 *Density*—Determine the density of the reinforcing ring material in accordance with Test Method **D1505**, or Test Method **D792**, using three specimens.

11.2 *Degree of Cross-Linking*—Determine the degree of cross-linking in accordance with Test Method **D2765**, Method B except for the following: during sample preparation, place a reinforcing ring in a lathe with automatic feeding. Shave a strip approximately 0.004 in.-thick that consists of the full thickness of the ring. For the purpose of this specification, the degree of cross-linking ( $V$ ) is defined as 100 % minus the extract percent =  $V$ .

## 12. Product Marking

12.1 *Cold Expansion Fitting:*

12.1.1 *Quality of Marking*—The marking shall be applied to the fittings in such a manner that it remains legible after installation and inspection.

12.1.2 *Content of Marking:*

12.1.2.1 Manufacturer’s name or trademark, or both,

12.1.2.2 This designation, F1960,

12.1.2.3 Certification mark or seal of the laboratory making the evaluation for this purpose, and

12.1.2.4 Nominal size.

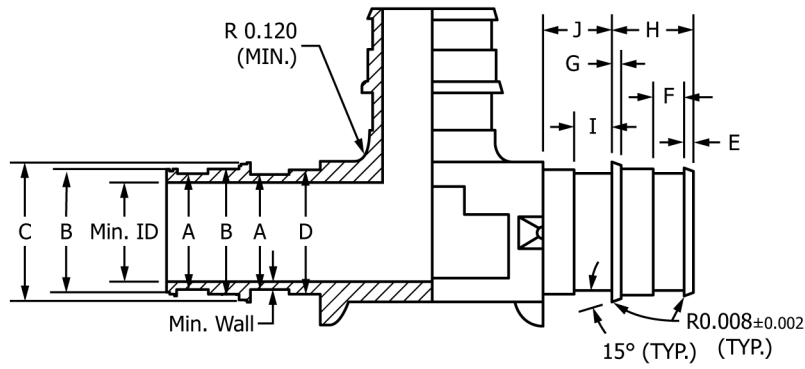
12.1.3 Where recessed marking is used on the fittings, in no case shall the marking cause cracks or reduce the wall thickness below the minimum specified.

12.2 *PEX Reinforcing Rings*—The product shall be marked with the following information:

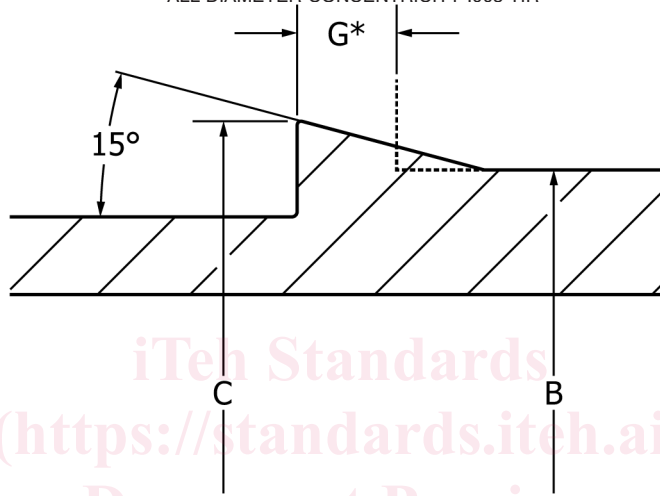
12.2.1 Manufacturer’s name or trademark, or both,

12.2.2 Nominal size,

12.2.3 Certification mark or seal of the laboratory making the evaluation for this purpose, and



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\*Maximum width of dimension "G" allowed to transition to surface of dimension "B"

Sulfone Dimensions

Nominal Tubing Sizes	Min. Wall	Min. ID	A max min	B max min	C max min	D max min	E max min	F max min	G min	H max min	I max min	J max min	Max Flash and Mismatch
3/8	0.047	0.268	0.402 0.382	0.441 0.433	0.480 0.472	0.427 0.407	0.067 0.051	0.128 0.108	0.051	0.325 0.305	0.128 0.108	0.306 0.266	0.005
1/2	0.057	0.385	0.540 0.520	0.579 0.571	0.618 0.610	0.565 0.545	0.067 0.051	0.128 0.108	0.051	0.404 0.384	0.167 0.147	0.345 0.305	0.005
5/8	0.057	0.494	0.648 0.628	0.697 0.689	0.748 0.740	0.683 0.663	0.067 0.051	0.167 0.147	0.051	0.482 0.462	0.207 0.187	0.424 0.384	0.005
3/4	0.057	0.590	0.755 0.735	0.795 0.787	0.874 0.866	0.782 0.762	0.067 0.051	0.207 0.187	0.051	0.522 0.502	0.246 0.226	0.463 0.423	0.005
1	0.072	0.788	0.992 0.972	1.032 1.024	1.110 1.102	0.998 0.978	0.067 0.051	0.246 0.226	0.051	0.640 0.620	0.286 0.266	0.581 0.541	0.005
1 1/4	0.075	0.970	1.159 1.139	1.276 1.266	1.362 1.352	1.237 1.217	0.080 0.064	0.299 0.279	0.064	0.781 0.761	0.348 0.328	0.704 0.664	0.005
1 1/2	0.095	1.084	1.328 1.308	1.382 1.374	1.494 1.486	1.349 1.329	0.093 0.077	0.351 0.331	0.077	0.919 0.899	0.408 0.388	0.825 0.785	0.005
2	0.128	1.484	1.800 1.780	1.958 1.950	2.079 2.071	1.891 1.871	0.093 0.077	0.467 0.447	0.077	1.137 1.117	0.521 0.501	1.050 1.010	0.005
2 1/2	0.175	1.850	2.280 2.260	2.430 2.410	2.585 2.565	2.430 2.410	0.155 0.135	0.610 0.590	0.160	1.520 1.480	0.610 0.590	1.350 1.310	0.005
3	0.210	2.220	2.720 2.700	2.910 2.890	3.080 3.060	2.910 2.890	0.180 0.160	0.710 0.690	0.190	1.810 1.770	0.720 0.700	1.610 1.570	0.005

FIG. 2 Sulfone Insert Dimensions and Tolerances