



## Gastite 17698 Python Pipe Cutter Installation Guide

[Home](#) » [Gastite](#) » Gastite 17698 Python Pipe Cutter Installation Guide 



### PYTHON LINE SETS Installation Guide

#### Contents

- [1 17698 Python Pipe Cutter](#)
- [2 SPLIT SYSTEM INSTALLATIONS USE PYTHON MALE FLARED FITTING](#)
- [3 DIMENSIONAL CHARACTERISTICS](#)
- [4 MINI-SPLIT INSTALLATIONS USE PYTHON FEMALE FLARED FITTING](#)
- [5 Documents / Resources](#)
- [6 Related Posts](#)

### 17698 Python Pipe Cutter

#### REQUIRED TOOLS

Python Pipe Cutter  
Python Chamfer Tools  
Torque Wrench  
OPTIONAL: Tube Bender

#### SPLIT SYSTEM INSTALLATIONS USE PYTHON MALE FLARED FITTING

1. Uncoil and straighten end of Python Line Set pipe to be installed. Using a Python pipe cutter, cut end of pipe creating a clean square cut.



2. Using the Python Chamfering tool that is size specific for the pipe being installed, fully insert the tool into end of pipe and rotate a minimum of 3 revolutions to properly open and chamfer the inner and outer pipe edge. Keep the tool aligned with the pipe while inserting, chamfering, and removing it, avoid rocking or bending the tool while it's inserted in the pipe.

**Note:** Keep Python fittings clear of any required brazing and do not make any brazed connections to components connected to Python fittings and Python pipe.



3. Mark the pipe, at the reference shoulder of the chamfer tool, before removing the tool and be sure the pipe chamfered debris is pulled away from the end of the pipe.



4. Slide the Python compression nut, then Python compression ring over the end of the pipe.

4



5. Insert the nipple of the fitting into the end of the pipe making sure that the pipe fully seats into the bottom pocket of the fitting adaptor and the mark is at the thread of the adaptor. Keep the fitting adaptor aligned with the pipe while inserting and avoid rocking, bending, or twisting the fitting adaptor while inserting into the pipe.

**Note:** The plastic washer and O-rings have been preinstalled onto the fitting adaptor. If these parts are missing, do not use the fitting.

5



6. Slide the compression ring until it fully meets the fitting adaptor.

6

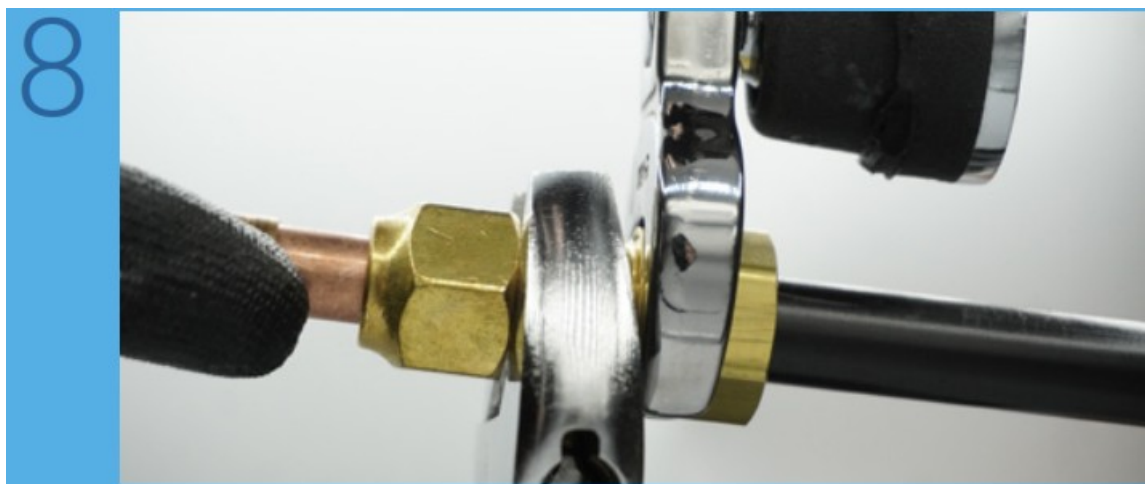


7. Slide the compression nut over the compression ring until it meets the adaptor threads.



8. Hand tighten the compression nut onto the compression fitting adaptor, then use a torque wrench to tighten to the specified torque.

**Note:** Python Line Set copper stub adaptors and flare nuts are offered to connect the Python male compression fitting to the HVAC equipment valve.



## DIMENSIONAL CHARACTERISTICS

Size	Nominal OD	Nominal ID	Torque Requirement*	Max Design Pressure
1/4"	.465"	.190"	25 lbs	700 psi
3/8"	.465"	.311"	25 lbs	700 psi
1/2"	.618"	.436"	30 lbs	700 psi
5/8"	.765"	.555"	50 lbs	700 psi

\*Torque Note: Do not over-torque the fitting, causing the nut to bottom out on the adaptor. Once the fitting is installed with the specified torque, there should be a gap between the nut and adaptor.

## MINI-SPLIT INSTALLATIONS USE PYTHON FEMALE FLARED FITTING

1. Uncoil and straighten end of Python Line Set pipe that fitting will be installed. Using a Python tubing cutter, cut end of pipe creating a clean square cut.



2. Using the Python Chamfering tool that is size specific for the pipe being installed, fully insert the tool into end of pipe and rotate a minimum of 3 revolutions to properly open and chamfer the inner and outer pipe edge. Keep the tool aligned with the pipe while inserting, chamfering, and removing it, avoid rocking or bending the tool while it's inserted in the pipe.

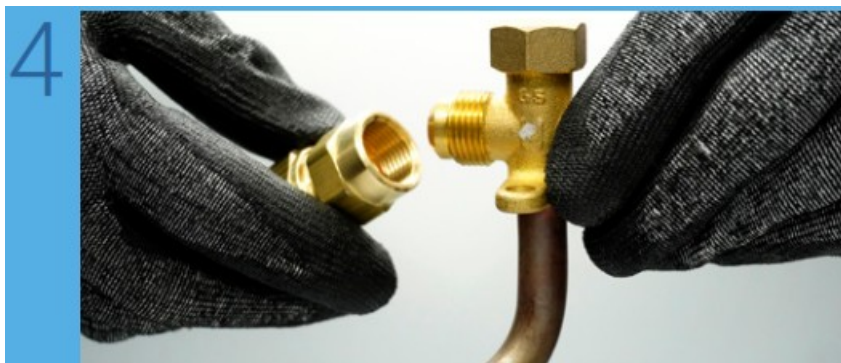
**Note:** Keep Python fittings clear of any required brazing and do not make any brazed connections to components connected to Python fittings and Python pipe.



3. Mark the pipe, at the reference shoulder of the chamfer tool, before removing the tool and be sure the pipe chamfered debris is pulled away from the end of the pipe.



4. Thread the fitting adaptor onto the king valve male connection point and tighten to required torque.



**Note:** A copper gasket is provided for this connection and fitting should not be used if copper gasket is missing.

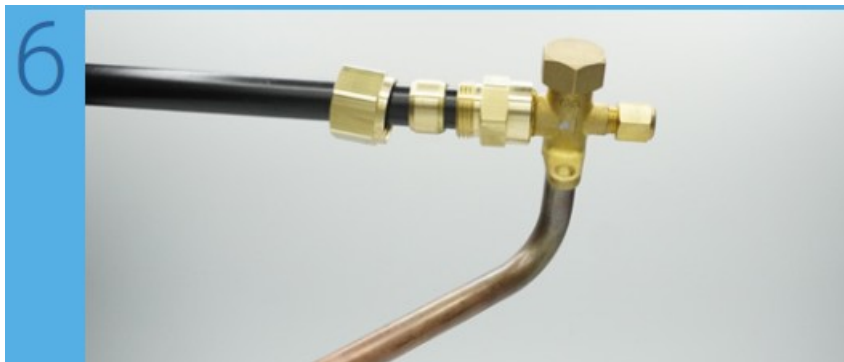
5. Slide the compression nut then compression ring over the end of the pipe.



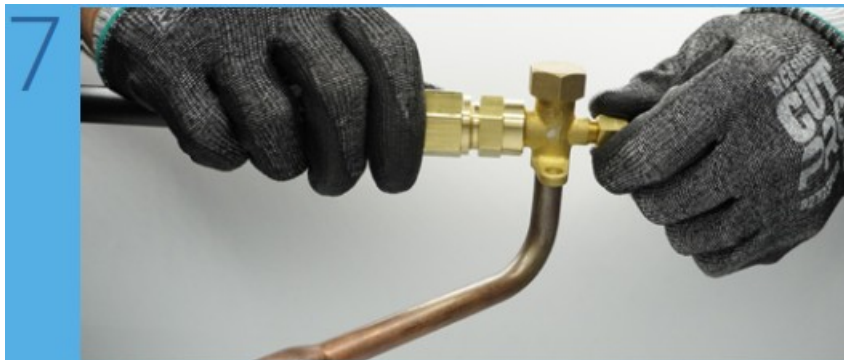
6. Insert the nipple of the fitting into the end of the pipe making sure that the pipe fully seats into the bottom pocket of the fitting adaptor and the mark is at the thread of the adaptor.

Keep the fitting adaptor aligned with the pipe while inserting and avoid rocking, bending, or twisting the fitting adaptor while inserting into the pipe.

**Note:** The plastic washer and O-rings have been preinstalled onto the fitting adaptor. If these parts are missing do not use the fitting.

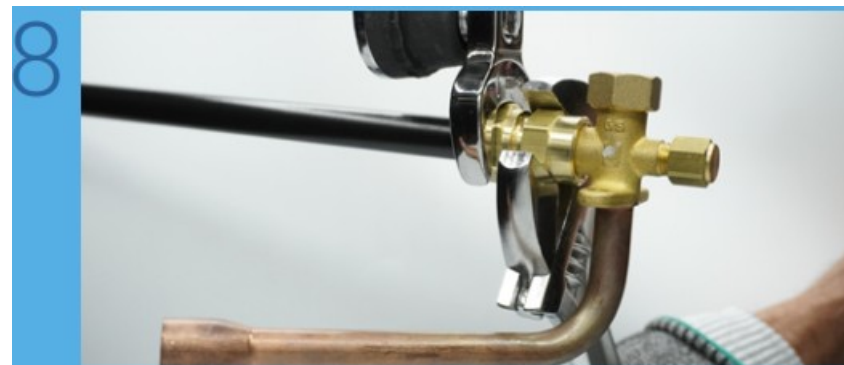


7. Slide the compression nut over the compression ring until it meets the adaptor threads.



8. Hand tighten the compression nut onto the compression fitting adaptor, then use a torque wrench to tighten to the specified torque.

**Note:** See table on reverse side for torque values.




**The Next Generation of Line Sets.**



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## Documents / Resources

	<p><a href="#">Gastite 17698 Python Pipe Cutter</a> [pdf] Installation Guide 17698, 17698 Python Pipe Cutter, Python Pipe Cutter, Pipe Cutter, Cutter</p>
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