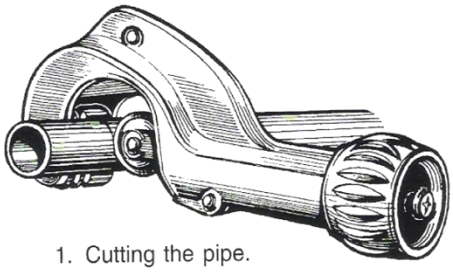
KK BRANCHFORMING INSTRUCTION

"The Plumbing Tool Specialists"

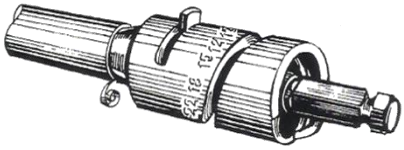
PREPARING THE BRANCHED TUBE

1. Cut tube to required length



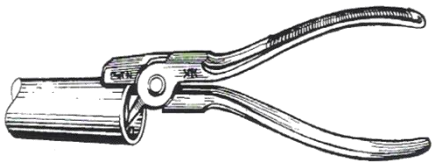
1. Cutting the pipe.

2. Scrap the burr



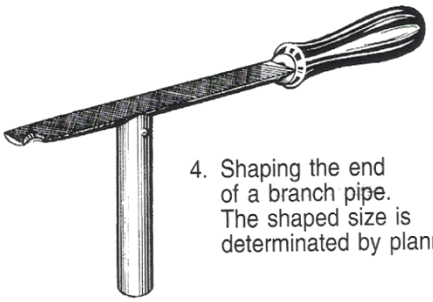
2. Scraping the burr.

3. Notch tube*



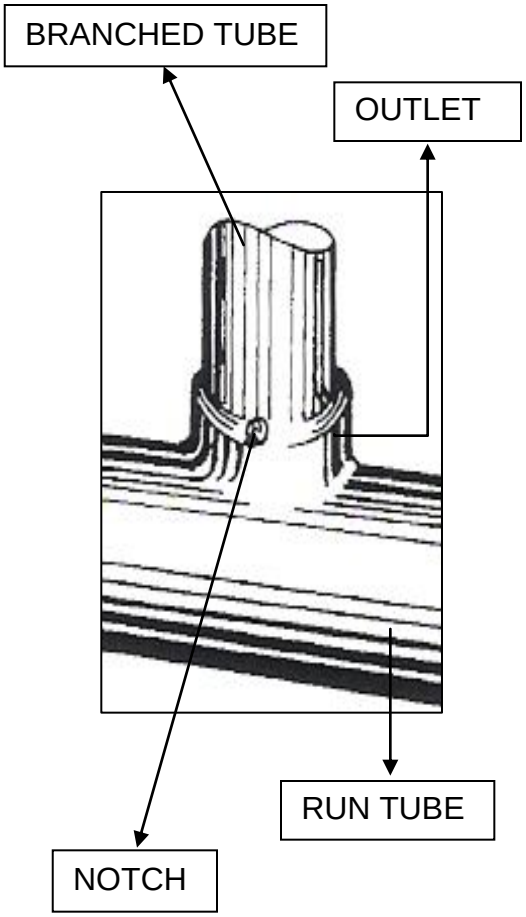
3. Making dimpled markings.

4. Shape end of Branch Tube

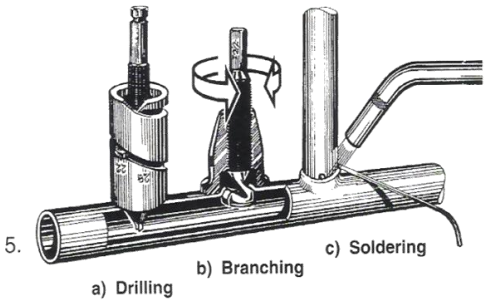


4. Shaping the end of a branch pipe. The shaped size is determinated by planner.

*When the notch is on the side of branch tube, the end of the branch tube has been shaped. When the notch is along the run tube, the end of the branch tube is not shaped.



PREPARING THE RUN TUBE



5a. Drill appropriate sized hole according to size of branch tube.

5b. Dress out branch. *If required, heat can be applied to soften metal around the hole during dressing out. Copper must not be over-heated past dull red, whereas brass is not to be worked in the 250°C – 550°C range to avoid embrittlement.*

5c. Solder branch tube to run tube. *Branch formed joints must be silver soldered. The inserted branch tube must not penetrate or obstruct the run pipe bore.*

HOLE SIZES FOR RUN TUBE

BRANCH TUBE	HOLE SIZE
½"	9.22mm
¾"	10.92mm
1"	14.62mm
1 ¼"	18.60mm
1 ½"	24.10mm
2"	32.77mm

FREQUENTLY ASKED QUESTIONS

1. **DOES BRANCHING WEAKEN COPPER?**
   No. Consider that after branching your run tube, a branch tube is than placed within the outlet. By doing this you have in effect doubled the wall thickness of the outlet.
2. **IS BRANCHING MORE EFFICIENT THAN 'T' PIECES**
   This practice reduces the need for fittings and the number of brazed joints. This means less chance of leakage or call-backs and improved flow characteristics.

Cut Costs – Improve Quality – Increase Profit

- *No T-fittings*
- *Only one soldered joint*
- *Improved flow characteristics*
- *Less chance for leakage or call backs.*