



Reliable Connections



- Oetiker StepLess® PEXGrip® Pro Clamps 263
- Hand Installation Pincers (HIP)
- Hand Tube Cutters (HTC)
- Hand Clamp Cutters (HCC)

Instruction Manual

Original Manual Issued: 06.2025

- Clamp Installation Instruction Guide
- Tool Calibration Procedures
- Hand Tubing Cutter Instruction Guide
- Clamp Removal Instruction Guide

Item No. 08907248

Oetiker, Inc. | Marlette, MI


1 Information About this Manual

1.1 Symbols and Means of Depiction

Safety notices are used in this manual to warn of the risk of personal injury or property damage.

- ▶ Always read and observe these safety notices.
- ▶ Observe all notices that are flagged with a safety alert symbol and text.

The following symbols are used in this instruction manual:

Symbol	Meaning
 WARNING	Failure to observe this notice may lead to property damage.
NOTICE	Information for proper use.
1. ... 2. ... 3. ...	Multi-step instructions ▶ Carry out the steps in the order shown.

1.2 Scope

This instruction manual is intended for Oetiker StepLess® PEXGrip® Pro Clamps 263, manufactured to meet ASTM F2098 for use in conjunction with:

- PEX or PE-RT Tube per ASTM F877
- PEX Insert fittings per ASTM F1807 or F2159
- PEX connecting solutions for markets compliant with Standard ASTM F877/F2098

The specified clamps are suitable for fast and secure connections for PEX tubing in the plumbing field. The clamp design is tamper evident.

2 Basic Instructions

2.1 Recommended Installation

The products may only be used for the intended purpose and under safe and fault-free conditions.

- Correct usage also covers observance of this instruction manual.
- Any use not in accordance with the prescribed usage shall be regarded as incorrect usage and may lead to product failure.
- For proper installation of Oetiker StepLess® PEXGrip® Pro Clamps 263, use calibrated genuine Oetiker installation tools.
- For ratchet pincer maintenance, care, and calibration, reference the complete calibration instruction sheet supplied with the tool (Item Nos. 14100280 and 14100069) or reference sections 3.1, 3.2 and 3.3 of this instruction manual.

3-Handle Ratchet Pincer

Oetiker HIP 7000 | 280

Item No. 14100280 (Fig. 1)

- Includes GO/NO-GO gauge
- Can be calibrated
- Lightweight for easy handling
- Heavy-duty professional grade tool
- Single handed installation



Fig. 1:
Item No. 14100280

2-Handle Ratchet Pincer

Oetiker HIP 7000 | 069

Item No. 14100069 (Fig. 2)

- Includes GO/NO-GO gauge
- Can be calibrated
- Lightweight for easy handling
- Heavy-duty professional grade tool



Fig. 2:
Item No. 14100069

2.2 Clamp Installation Instruction Guide

1. Per ASTM F2098, insert fitting into tubing until shoulder or tube stop contacts end of tubing. Position clamp within 1/8" to 1/4" (3.2 to 6.4 mm) of tube end. **(Fig. 3)**

! **Note:** "Tube end" must be cut square. (Reference "Section 4" of this instruction manual for Oetiker recommended Hand Tube Cutters.)

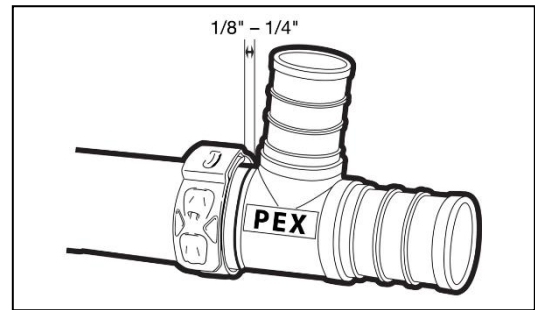


Fig. 3: Insert fitting and position clamp

2. Close clamp ear with tool, tool will not release until clamp is fully closed. **(Fig. 4)**

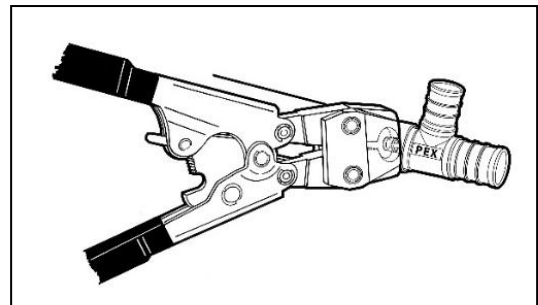


Fig. 4: Close clamp ear with tool

3. **IMPORTANT:** For proper installation of Oetiker StepLess® PEXGrip® Pro Clamps 263, full ear closure is required. Visually inspect clamp for correct closed ear form. **(Fig. 5)**

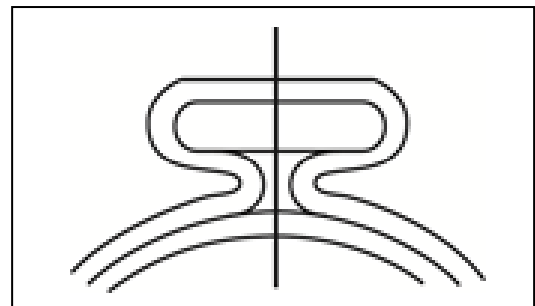


Fig. 5: Full ear closure required

2.2.1 Assembly Notice

NOTICE

- ▶ For the correct assembly of Oetiker StepLess® PEXGrip® Pro Clamps 263, the clamps must be completely closed.
- ▶ Genuine Oetiker Hand Installation Pincers with ratchet mechanism (HIP Item Nos. 14100280 and 14100069) will release only when clamp has fully closed.
- ▶ Tool information for HIP 7000 Ratchet Pincers can be found in section 2.1.

2.2.2 Warning Notice: Clamp Installation



WARNING

- ▶ In high chloride water conditions, use only plastic fittings.
- ▶ Do not install in contact with concrete.
- ▶ Use only ASTM F1807 or F2159 insert fittings with OETIKER clamps.
- ▶ Failure to observe the above warnings may result in property damage.
- ▶ Avoid contact with soldering flux.
- ▶ Failure to observe the above listed warnings may result in property damage.
- ▶ Oetiker declines any responsibility for improper use and/or incorrect installation of Oetiker products.

2.2.3 International Standards

- ASTM¹ F2098 for use with ASTM F1807 and F2159 insert fittings and ASTM F876 PEX², or F2769 PE-RT³ Tubing. For additional information, please refer to ASTM International Standards Worldwide.
- Conforms to ASTM F877
- Complies with NSF⁴ standards and has been approved to use the cNSFus-pw mark. For additional information, please refer to the NSF organization.

¹ ASTM = American Society for Testing and Materials

² PEX = Cross-linked Polyethylene

³ PE-RT = Polyethylene of Raised Temperature Resistance

⁴ NSF = National Sanitation Foundation

2.2.4 Canadian Standard

- Conforms to CSA⁵ B137.5

⁵ CSA = Canadian Standard Association

3 Ratchet Pincer Calibration Procedures

3.1 Checking the Tool Calibration for: Item Nos. 14100280 and 14100069

Calibration instructions on this page are specific for Ratchet Pincer Item Nos. 14100280 and 14100069

1. Close handles of manual pincer to stop point (Fig. 6)

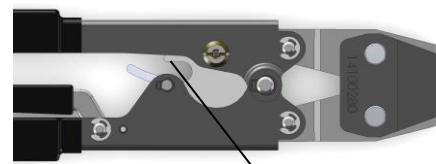


Fig. 6 Stop Point 6

2. Insert GO/NO-GO gauge into jaw gap (Fig. 7 and Fig. 8)

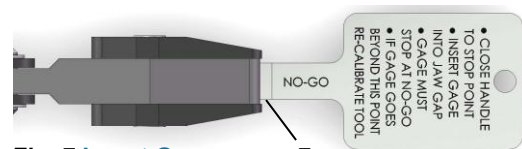


Fig. 7 Insert Gauge 7

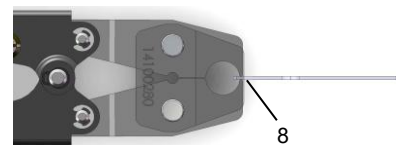


Fig. 8 Insert Gauge (side view) 8

3. GO/NO-GO gauge must stop at NO-GO
4. If GO/NO-GO gauge stops after the NO-GO point, then the tool must be "re-calibrated".
5. Check tool calibration daily.

3.2 Re-calibrating the Tool

The re-calibration instructions on this page are specific for Ratchet Pincer Item Nos. 14100280 and 14100069

1. Using a straight blade screwdriver, loosen the **Adjustment Nut (Fig. 9)**.

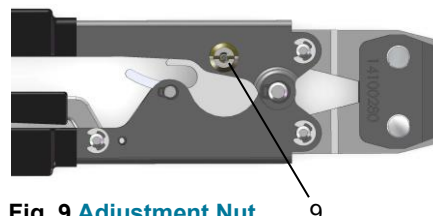


Fig. 9 Adjustment Nut 9

2. Close handles to stop point and place GO/NO-GO gauge into jaw gap.

3. Using a straight blade screwdriver, rotate the **Eccentric Stud (Fig. 10)** counterclockwise until jaws contact the GO/NO-GO gauge before the NO-GO area of the gauge.

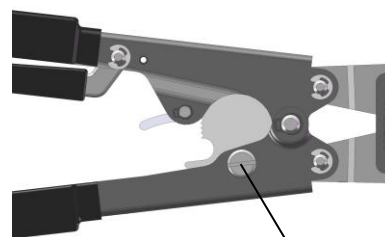


Fig. 10 Eccentric Stud 10

4. Using a straight blade screwdriver, tighten the **Adjustment Nut (Fig. 11)**.

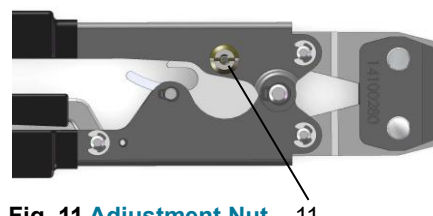


Fig. 11 Adjustment Nut 11

5. Check tool calibration daily.

3.3 Tool Maintenance

- Do not use the Ratchet Tools for any purpose other than to assemble clamps. Use other than intended may damage the tool and void warranty.
- Lubricate the tool head, spring and ratchet mechanism once per every 30 days with a light lubricating oil (if tool operation becomes sluggish at any time lubricate prior to further use).
- Clean tool periodically to remove rust and dirt. Rust or dirt build-up will interfere with tool operation and void warranty coverage. Lubricate all parts after cleaning to provide a light protective coating of oil.

3.4 Tool Warranty

NOTICE: When properly maintained and used as intended the Ratchet Tools are warranted against materials and manufacturing defects for a period of one year from date of purchase. This warranty does not cover defects or damage arising from improper storage or handling, ordinary wear and tear, misuse, abuse, accident or use with unauthorized product or parts. Liability is limited to repair or replacement of product or component part which is determined defective as covered by this warranty.

4 Hand Tube Cutters (HTC) for PEX or PE-RT Tubing

Recommended for cutting PEX or PE-RT tubing.

4.1 Pro Spec Hand Tube Cutter

Oetiker HTC 500 | 504

Item No. 14100504 (Fig. 12)

- Recommended for cutting of PEX, PE-RT, Poly tubing, HDPE up to 1"
- Blade safely stores in jaws when locked
- Replaceable V-shaped blade for straight cuts
- Replacement Blades (2 pack), **Item No. 14100506 (Fig. 13)**

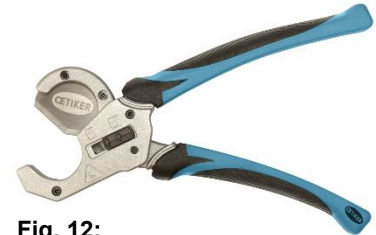


Fig. 12:
Item No. 14100504



Fig. 13:
Item No. 14100506

4.2 Radial Hand Tubing Cutter and Instruction Guide

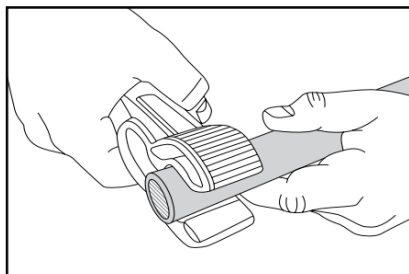
Oetiker HTC 500 | 418

Item no. 14100418 (Fig. 14)

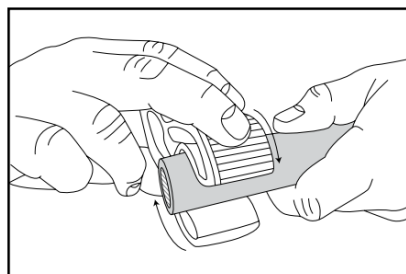
- For PEX tube, plastic conduit and gas pipe
- Cuts 1/2", 3/4" & 1" PEX tube, PEX type A, B & C
- Compact tool cuts pipe square, keeps it round
- Straight, circular cuts form tighter connections



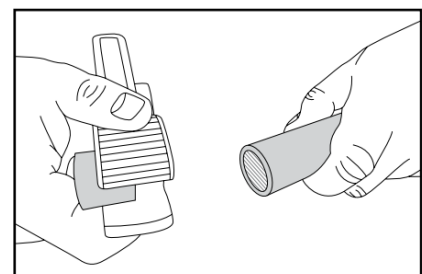
Fig. 14:
Item No. 14100418



1. Push tubing into cutting chamber.



2. Rotate cutter in direction of arrow.



3. Squeeze handles and remove tubing.

5 Hand Clamp Cutters (HCC) for Oetiker Ear Clamps

Safest method of clamp removal. Quick and easy clamp cutting.

5.1 Compound Action Hand Clamp Cutter

Oetiker HCC 2000 | 519

Item No. 14100519 (Fig. 15)

- For cutting Oetiker StepLess® PEXGrip® Pro Clamps 263
- Cuts clamp sizes 3/8" and 1/2"



Fig. 15:

Item No. 14100519

5.2 Compound Action Heavy-Duty Hand Clamp Cutter

Oetiker HCC 7000 | 609

Item No. 14100609 (Fig. 16)

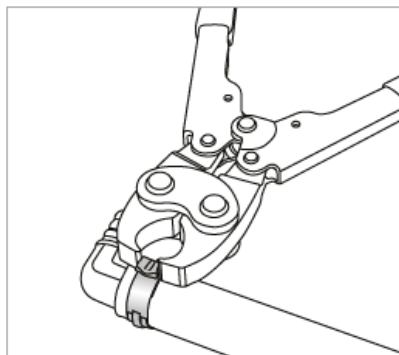
- For cutting Oetiker StepLess® PEXGrip® Pro Clamps 263
- Cuts clamp sizes up to 1"



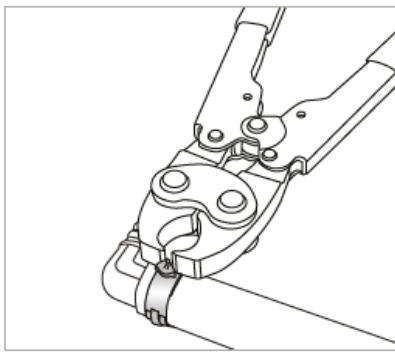
Fig. 16:

Item No. 14100609

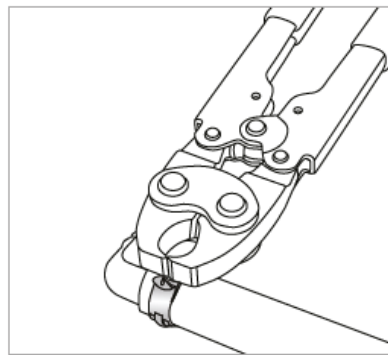
5.3 Hand Clamp Cutter Instruction Guide



1. Place jaw tips on each side of clamp ear or single leg.



2. Squeeze handles.



3. Cut through the ear and remove the clamp carefully.

NOTICE

- ▶ Clamp removal drawings shown on this page are for illustration purposes only, actual product may vary due to product enhancement.
- ▶ Caution must be observed with Hand Clamp Cutters; they can generate extreme forces.
- ▶ It is recommended that protective eye wear be worn when cutting clamps.
- ▶ Hand Clamp Cutter Item Nos. 14100519 and 14100609 are for **clamp removal only**.