

LET-LOK® TUBE FITTINGS

1/16" through 1" - Inch, 2 mm through 25 mm - Metric



LET-LOK® fittings are supplied assembled, finger tight. Diassembly before use can allow the entry of dirt or other particles.

1. Insert the tubing into the LET-LOK® fitting.
Check that the tube rests firmly on the fitting shoulder and that the nut is finger tight.

2. Tighten the nut.
1 1/4 turns of the nut is required for 1/4" (6 mm) and higher. (See Figure A.) A3/4 turns of the nut is required for 3/16" (4 mm) and lower. (See Figure B.)

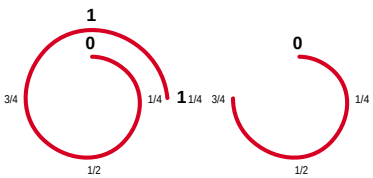


Figure A **Figure B**

Reassembly Instructions

LET-LOK® connections may be disconnected and remade repeatedly without loss of the leaktight seal.

1. Before disconnecting, mark the position of the nut in relation to the fitting body.
2. To reassemble, use a wrench to tighten the nut to original position.
3. Tighten slightly with a wrench until you feel a slight rise in torque.

Tube Cutting

There are two ways to cut tubes:

1. Tube cutter
2. Hacksaw

Tube Cutter

To attain a leak-free connection, cut the tubing squarely. Use a good quality tube cutter with the appropriate blade for the tubing. Do not try to reduce the time of cutting by taking deep cuts with each turn of the cutter. This will work harden the tube.
Deburr the end of the tube to avoid damage to the fitting and to ensure that the tube reaches the bottom of the fitting.

Hacksaw Cutting

In order to cut the tube with a hacksaw and get square ends, cut the tube with guide blocks.
If you use this method of cutting, you will need to deburr the tube ends.

Warning!

Do not hold the tube in a vise at the place where it will be inserted into the fitting (the vise will leave a mark on the tube that may cause leaks, and might cause ovality).

Tube Handling

Scratches on the tube might cause leaks. Therefore, use caution in handling the tube in order to reduce the possibility of leaks.

Some precautions to be taken:

1. Tubes must not be dragged on the floor.
2. Tubes must not be dragged out of a tubing rack, especially in case of large OD tubes.

Copper Tubing

If you use copper tubing on a rol, be sure to hold the end of the tube, then, move the tubing away from you, so that it can lie on a flat surface.