

LET-LOK FITTINGS INSTALLATION INSTRUCTIONS

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



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. At this point it is recommended that a scribe mark be drawn on the hex of the nut extending onto the fitting body. This mark will serve as an indicator for the starting point and proper pull-up.



Tighten the nut

1-1/4 turns of the nut are required for 1/4" (6 mm) and higher (see Fig. A). 3/4 turn of the nut is required for 3/16" (4 mm) and lower (see Fig. B).

Figure A

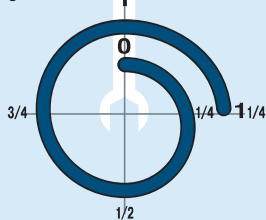
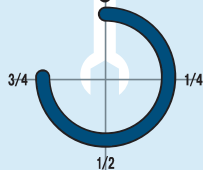


Figure B



REASSEMBLY INSTRUCTIONS

LET-LOK connections may be disconnected and remade repeatedly without the loss of the leak tight 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 the original position.
3. Tighten slightly with a wrench until a slight rise in torque is felt.

TUBE CUTTING

Two different methods can be used to cut tubes

1. Tube Cutter
2. Hacksaw

TUBE CUTTER

To attain a leak free connection, the tubing must be cut squarely. A good quality tube cutter with an appropriate blade for tubing material is recommended. 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. The end of the tube must be deburred 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 obtain square ends, the tube must be cut with guide blocks.

This method of cutting necessitates deburring of the tube ends.

Warning

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

TUBE HANDLING

Scratches on the tube might cause leaks. It is, therefore, important to handle the tube carefully to reduce the risk of leaks.

PRECAUTIONS

1. Tubes must not be dragged on the floor.
2. Do not drag tubes out of the tubing.

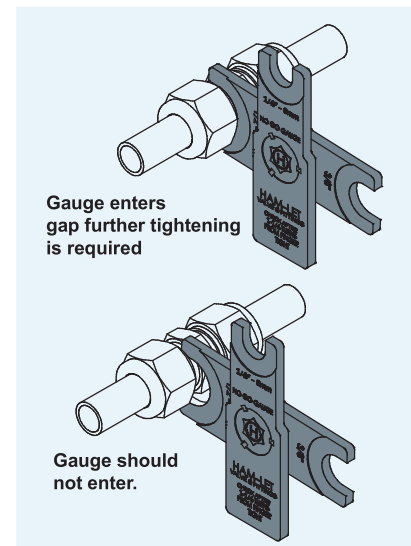
COPPER TUBING

If using copper tubing from a roll, hold the end of the tube and roll the roll outwards allowing the tubing to lie on a flat surface.

INSPECTION GAUGE

Use: This is a "No-Go" gauge and should be used as follows:

1. Make up the fitting according to the following instructions:
1/4 inch (6mm), 3/8 inch, 1/2 inch (12mm) make up 1-1/4 turns from the finger tight position.
2. Check gap between nut and body using the appropriate sized gauge.
If the gauge slides easily into the gap, tighten the nut further until gauge cannot enter the gap.



For Gauge Ordering Information, see page 102.

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PHYSICAL DIFFERENCES AND MARKINGS

LET-LOK® METRIC FITTINGS:

Tee & Elbow: (see Fig. 1)
Body marked: MM
Straight Connectors: (see Fig. 2)

Body: Stepped shoulder
Marked: LET-LOK 316 AV1(2)
Nut: (see Figs.1 & 2) Stepped shoulder
Marked: LET-LOK 316 6M(1) SD8(2)

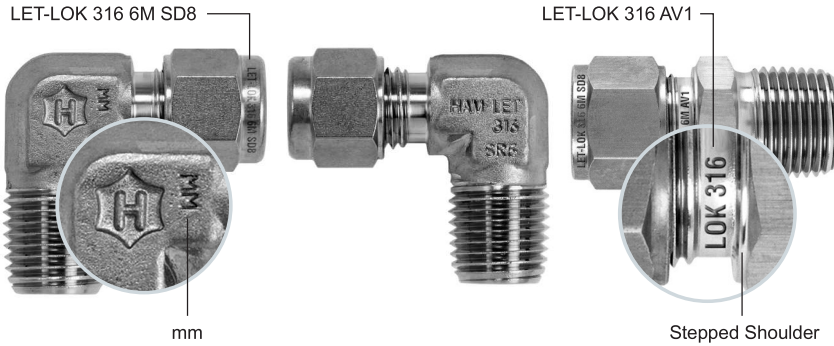


Fig. 1
Back side

1. Tube O.D. 2. Material Batch

Fig. 1
Front side

Fig. 2
Stepped Shoulder

LET-LOK® INCH FITTINGS:

Tee & Elbow: (See Fig. 3)
Straight Fittings: (see Fig. 4)
Body: Shoulder marked:
LET-LOK 316 AV2(2)

Nut: (See Fig. 3 & 4): Shoulder marked
LET-LOK 316 1/2(1) BU2(2)



Fig. 3
Back side

1. Tube O.D. 2. Material Batch

Fig. 3
Front side

Fig. 4

TUBING DATA FOR LET-LOK® FITTINGS

In order to assure maximum fitting reliability and performance, great care should be given when selecting the tubing for each application.

TUBE SELECTION

Four variables must be considered when ordering a tube for use with LET-LOK fittings:

1. Material
2. Tube wall thickness
3. Tube surface finish
4. Tube hardness

Tubing should comply with standard ASTM A213 or ASTM A269, be seamless and fully annealed. The tube must be free of scratches and suitable for bending and flaring.

TUBE O.D. TOLERANCES

1/16" - 1/8"	} ±	0.003"
2mm - 3 mm		0.076 mm
3/16" - 1 1/4"	} ±	0.005"
4mm - 25 mm		0.127 mm
1 1/2" - 2"	} ±	0.006"
38mm - 50 mm		0.152 mm

The ovality of twice the O.D. tolerance is not suitable for LET-LOK fittings. The tube must be reasonably round.

The ends of the tube must be free of burrs.

Tubing hardness: The hardness of the tube must be lower than the hardness of the fitting material.

The hardness must not exceed Rockwell 90 HRB (200HV).

HIGH SAFETY

In applications where severe conditions and high pressure exist, we recommend the following installation procedures:

1. Check that the nut is finger tight
2. Fully insert the tube (up to the shoulder)
3. Rotate the nut with a wrench until the tube does not rotate freely
4. Mark the position of the nut
5. Rotate the nut 1-1/4 turns

This method ensures that even if the tube O.D. is at the minimum tolerance, the ferrules will be in contact with the tube for the full 1-1/4 rotation