



PRIMELOCK® FITTING

Tube cut length and fitting assembly instructions for
1/4", 3/8", 1/2", 3/4", 1", 1 1/4", 1 1/2" sizes

Follow this procedure to determine the proper tube cut length between PrimeLock® fittings. Proper tube cut length is important to ensure fitting seal performance.

1. Measure the distance between PrimeLock fitting nose ends (dimension X in Figure 1).

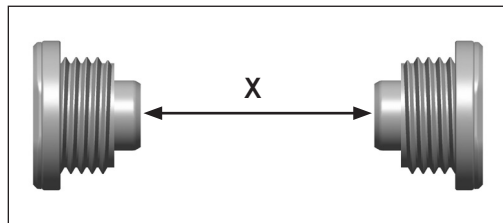


Figure 1.

2. Add additional tube length per Table 1.

NOTE: This tube cut length calculation includes the fitting-to-fitting distance plus the shrinkage of the tube length from installing the PrimeLock inserts.

TABLE 1

| PrimeLock Tubing Size | Tube Cut Length (Y) |
|-----------------------|---------------------|
| 1/4" | X + 1.30" |
| 3/8" | X + 1.50" |
| 1/2" | X + 1.55" |
| 3/4" | X + 1.88" |
| 1" | X + 2.04" |
| 1 1/4" | X + 2.61" |
| 1 1/2" | X + 3.22" |

3. Cut the tube to this calculated length Y (see Figure 2). The cut length must be no shorter than 1/8" from specification.

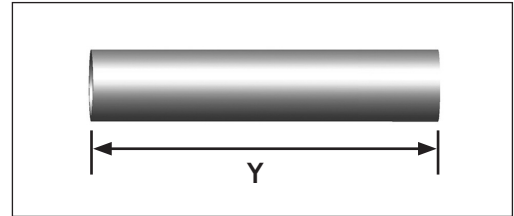


Figure 2.

FITTING ASSEMBLY INSTRUCTIONS

Proper seating of the tube in the fitting is very important to ensure leak free performance.

1. Fully install tube into the fitting body prior to tightening the fitting nut. Do not use the nut threads to pull the tube into the fitting.
2. A properly assembled fitting is shown in Figure 3.

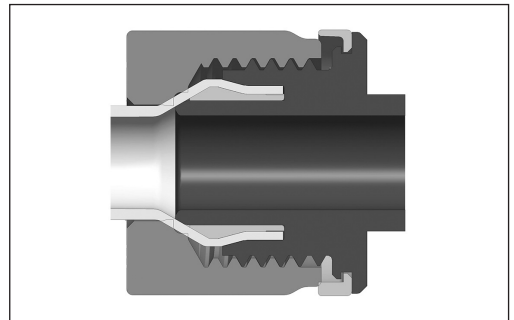


Figure 3.

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ENTEGRIS, INC.

Corporate Headquarters | 129 Concord Road | Billerica, MA 01821 USA
Customer Service Tel. +1 952 556 4181 | Customer Service Fax +1 952 556 8022
In North America 800 394 4083 | www.entegris.com