



PRIMELOCK® FITTING HOT-AIR GUN TECHNIQUE

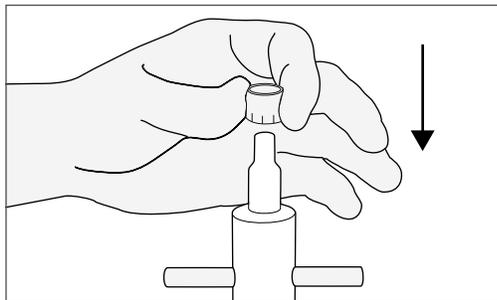
*Insert installation instructions
for 1/2", 3/4", 1" sizes*

INSTRUCTIONS FOR

PrimeLock® Fitting

The hot air gun installation technique is useful when space restrictions prevent the use of the handheld and benchtop insertion tools.

1. Slide the insert onto the mandrel as shown.



2. Verify the insert has been properly placed onto the mandrel. The installation indication lines on the insert are closest to the shoulder of the mandrel.

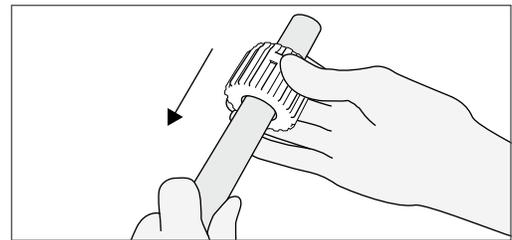


Correct installation of insert



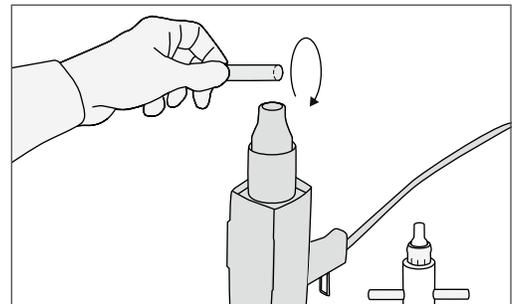
Incorrect installation of insert

3. Insert the cut end of the tubing through the PrimeLock nut.



4. If using an Entegris hot air gun, set the hot air gun on "high." Hold 1/2" to 3/4" of the PFA tubing 1/2" to 3/4" above the heater and continually rotate the tubing 360° for 25–60 seconds, depending on the heater.

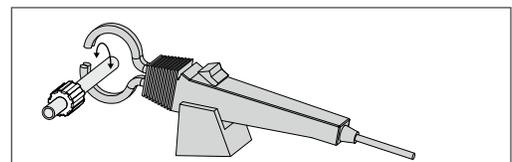
Note: It is very important to fully rotate the tubing over the heat source so all surface areas receive an equal amount of heat. Uniform heating is essential to correctly installing the insert.



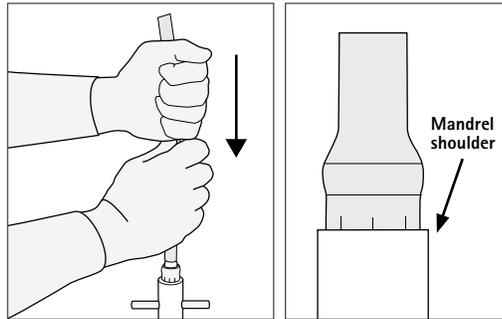
If using an Entegris infrared heating tool, turn on heating tool. Center 1/2" to 3/4" of the PFA tubing between the heat rings. While slowly rotating the PFA tubing back and forth between your forefinger and thumb, heat for 60–90 seconds, depending on the heater.

Note: To insert 1" tubing with an Entegris infrared heating tool, a larger heat ring (part number 213-91 or 213-92) is needed.

Note: It is very important to rotate the tubing through the heat source so all surface areas receive an equal amount of heat. Uniform heating is essential to correctly installing the insert.

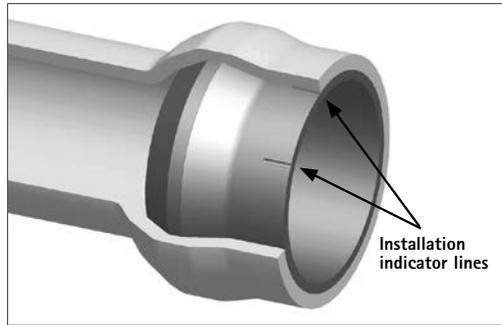


5. Immediately push the tube onto the mandrel until the tube contacts the mandrel shoulder.

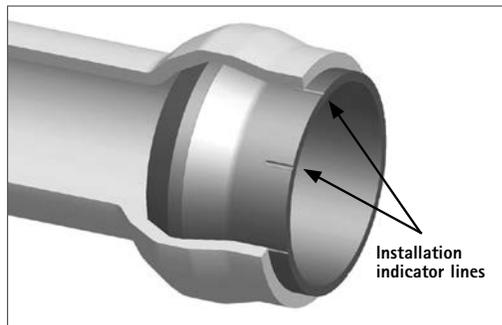


6. Wait 3–4 seconds, then remove the tubing assembly from the mandrel.

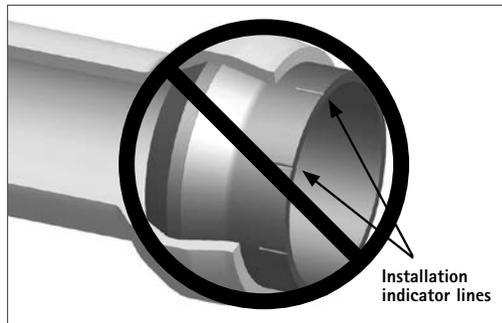
7. Verify the insert has been properly installed into the end of the tube. The insert has molded indication lines for gauging proper installation in the tube. For correct installation, the tubing will cover all or at least a portion of the indication lines. The insert does not need to be pushed fully into the tube.



Correct installation of insert

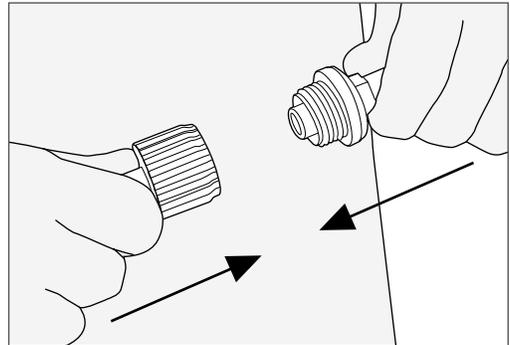


Correct installation of insert

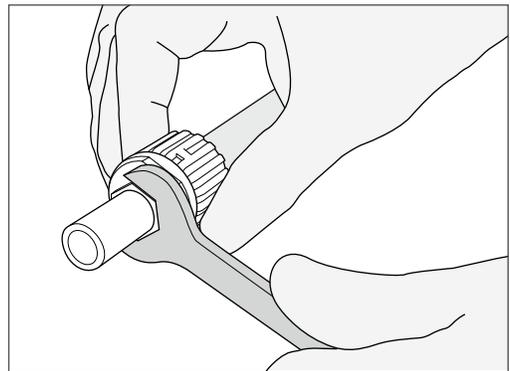


Incorrect installation of insert

8. Slide the assembly onto the fitting.

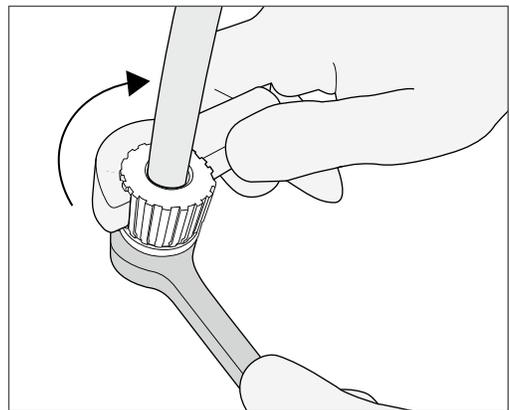


9. Start by hand-tightening the nut.

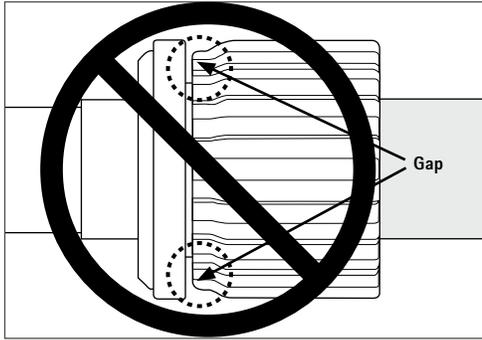


10. Place the PrimeLock wrench over the ribs of the fitting nut and rotate clockwise. Tighten the nut until the connection verification ring creates an audible click or the leading edge of the nut travels under the connection verification ring.

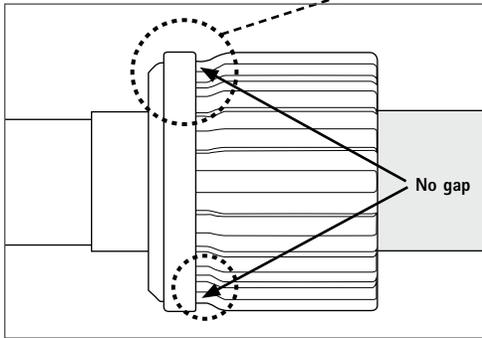
Note: Do not overtighten to the point where the nut bottoms out on the fitting body.



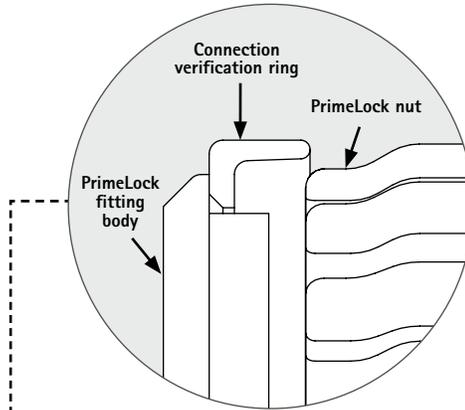
11. If there is excessive background noise, the connection can be verified by looking at the position of the connection verification ring relative to the nut.



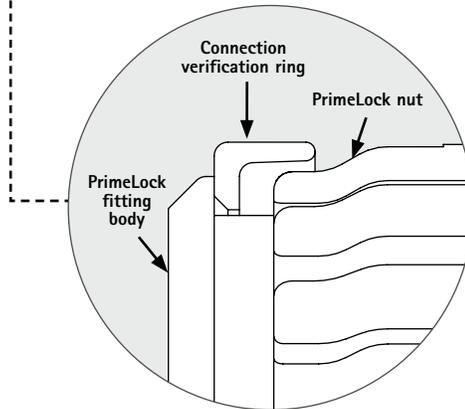
Incorrect tightening of the fitting – additional tightening required



Correct tightening of the fitting



Initial tightening of the fitting – nut travels underneath connection verification ring



Maximum tightening limit – nut bottoms out on the fitting body

12. CAUTION:



Do not retighten the fitting while the fitting assembly is above 30°C (86°F) or in a pressurized condition.

When reassembling the fitting, tighten the nut beyond the initial tightening position.

Part Number	Description	Tubing Size
PHMND-8	Hot-air mandrel	1/2"
PHMND-12	Hot-air mandrel	3/4"
PHMND-16	Hot-air mandrel	1"
PWR-8	Wrench	1/2"
PWR-12	Wrench	3/4"
PWR-16	Wrench	1"

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