

# PrimeLock® Fitting

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

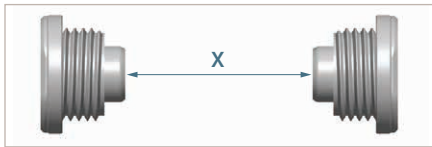


Figure 1.

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) | PrimeLock tubing size | Tube cut length (Y) |
|-----------------------|---------------------|-----------------------|---------------------|
| 1/4"                  | X + 1.30"           | 1"                    | X + 2.04"           |
| 3/8"                  | X + 1.50"           | 1 1/4"                | X + 2.61"           |
| 1/2"                  | X + 1.55"           | 1 1/2"                | X + 3.22"           |
| 3/4"                  | X + 1.88"           |                       |                     |

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

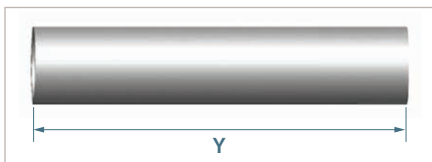


Figure 2.

## 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.

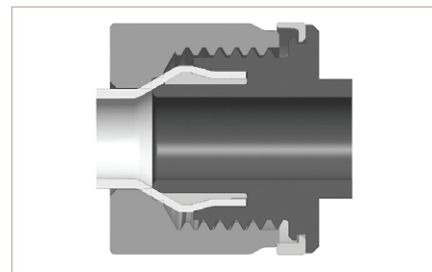


Figure 3.

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