

# PrimeLock<sup>®</sup> Fitting

*Tube cut length and fitting assembly instructions for 1/4", 3/8", 1/2", 3/4", 1", 1 1/4", 1 1/2", and 40 mm sizes*

Follow this procedure to determine the proper tube cut length between PrimeLock<sup>®</sup> 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).

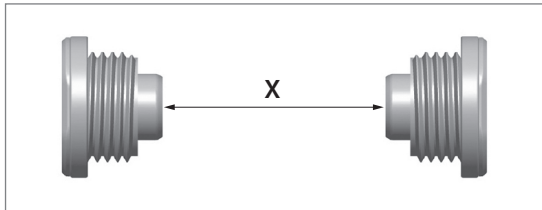


Figure 1.

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" and 40 mm	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.

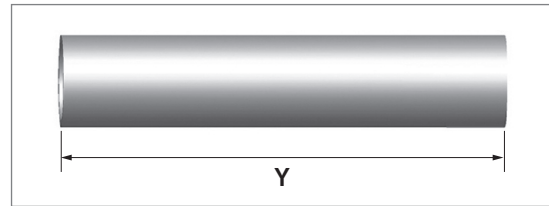


Figure 2.

## 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.

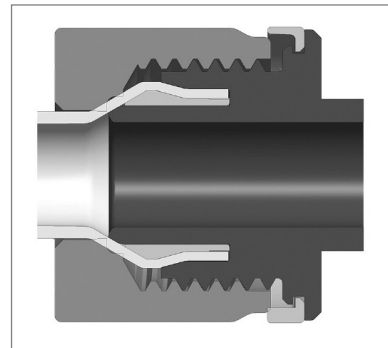


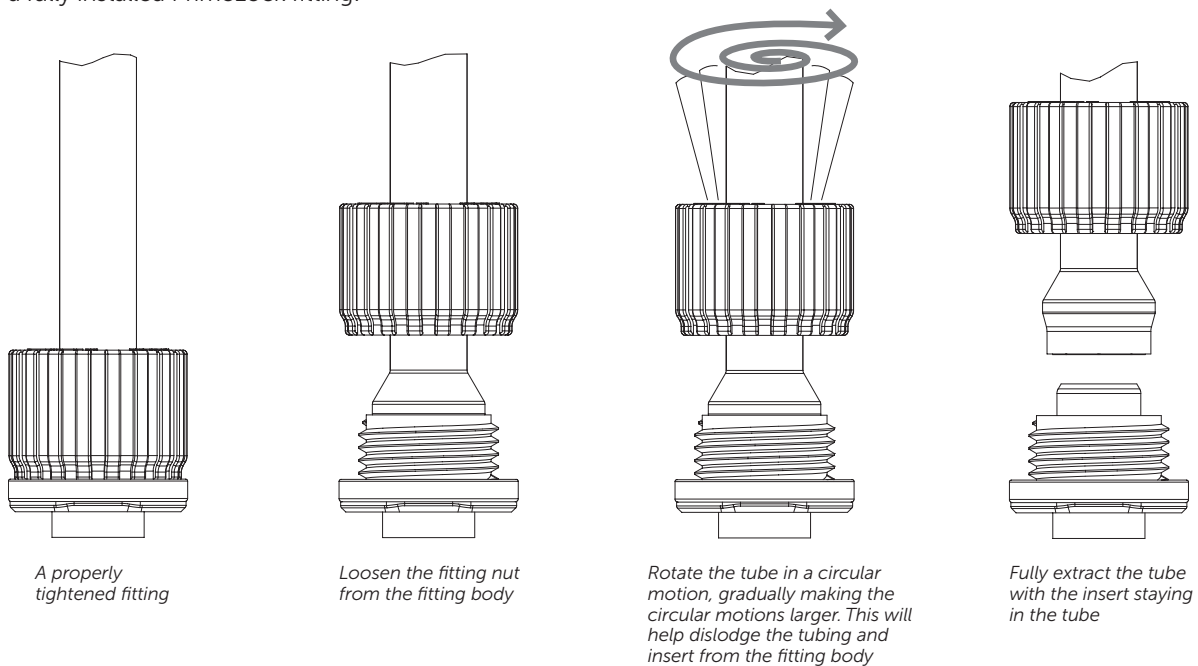
Figure 3.

## FITTING DISASSEMBLY

Care must be taken when disassembling PrimeLock fittings. Follow these instructions precisely to avoid fitting disassembly issues.

As shown in the example below, rotate the tube in a circular motion and slowly extract the tube with the insert from the nose of the PrimeLock fitting. If the tube is not rotated, the insert may disengage from the inside of the tubing and remain on the nose of the fitting.

Follow these steps to properly remove the tube from a fully installed PrimeLock fitting:



If the insert remains on the nose of the PrimeLock fitting, carefully remove the insert without damaging the fitting nose and discard. Install a new insert into the tube. Reusing a PrimeLock insert may cause sealing issues.

## PRIMELOCK INSERT INSTALLATION TOOLS

A complete set of tools is available on our website. Please visit PrimeLock Accessories on [www.entegris.com](http://www.entegris.com).

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