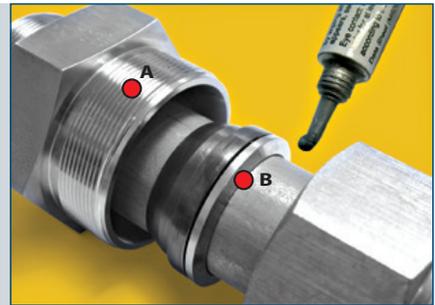


G-RAPID PLUS LOW FRICTION PASTE

INSTALLATION INSTRUCTIONS FOR LET-LOK FITTINGS
1 1/4"-2"
30mm-50mm



1. Close the nut and ferrules on the tube with a hydraulic tool
2. Open and release from the tool
3. Apply the G-Rapid paste on areas A and B
4. Tighten the nut on body 1/2 a turn with a wrench



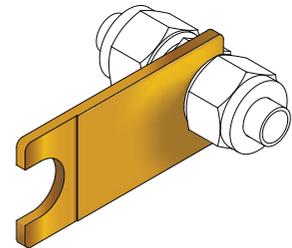
To order:
use part No. 3900753



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. Insert the tube (up to the shoulder)
3. Rotate the nut with a wrench until the tube does not rotate freely
4. Mark 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.

LET-LOK GAUGE

SIZE:

GAUGE	
PART NO.	Available only in
3900098	"1/4 (6 mm), 3/8", 1/2" (12 mm)

ADDITIONAL SIZES:

LET-LOK GAUGE	
PART NO.	LET-LOK SIZE
3901508	No-GO Gauge 1/16
3901509	No-GO Gauge 1/8"-2-3 mm
3901510	No-GO Gauge 3/16"- 4 mm
3901513	No-GO Gauge 5/16"- 8 mm
3902398	No-GO Gauge 8 mm
3901511	No-GO Gauge 10 mm
3901247	No-GO Gauge 5/8"-14-15-16 mm
3901246	No-GO Gauge 3/4"-18 mm
3901512	No-GO Gauge 7/8"-20-22 mm
3901245	No-GO Gauge 1"-25 mm

"D" - Dimension is minimum opening. Dimensions for reference only and subject to change without notice.

ACCESSORIES



STAINLESS STEEL TUBE CUTTER

Ordering Information	Capacity	
	inch	mm
Tube Cutter	3/16-1	5-25
Replacement Wheel	3/16-1	5-25



REAMERS, DEBURRING TOOLS

Ordering Information	Capacity
In.Out.Reamer 1/4"-1 1/4"	1/4" (5 mm) through 1 1/4" (36 mm)
In.Out.Reamer 1/2"-2"	1/2" (12 mm) through 2" (54 mm)



LEVER TUBE BENDERS

Ordering Information	Capacity	
	Tube Size	Bend Radius
Lever Bender 3/16	3/16"	5/ 8"
Lever Bender 1/4	1/4"	5/8"
Lever Bender 5/16	5/16"	15/16"
Lever Bender 3/8	3/8"	15/16"
Lever Bender 1/2	1/2"	1 1/2"
Lever Bender 6	6 mm	16 mm
Lever Bender 8	8 mm	24 mm
Lever Bender 10	10 mm	24 mm
Lever Bender 12	12 mm	38 mm

PREASSEMBLY TOOL

In constrained installation areas, LET-LOK® fittings can be assembled with the preassembly tool and another second step on the system.



PART NO.	LET-LOK SIZE
3902419	PREASSEMBLY TOOL 1/8
3901658	PREASSEMBLY TOOL 1/4
3901659	PREASSEMBLY TOOL 3/8
3901660	PREASSEMBLY TOOL 1/2
3902719	PREASSEMBLY TOOL 5/8
3902402	PREASSEMBLY TOOL 6MM
3902420	PREASSEMBLY TOOL 8MM
3902421	PREASSEMBLY TOOL 10MM
3902422	PREASSEMBLY TOOL 12MM
3902720	PREASSEMBLY TOOL 14MM
3902721	PREASSEMBLY TOOL 15MM
3902538	PREASSEMBLY TOOL 16MM



INSTRUCTIONS FOR USING PREASSEMBLY TOOL 6MM-25MM, 1/4"-1"

1. Assemble HAM-LET ferrules and nut on the Preassembly Tool. Tighten the nut to finger tight position.
2. Insert the tube through the nut and ferrules until the tube touches the bottom (shoulder).
3. From the finger tight position, rotate the nut 1-1/4 turns (450°).
4. Release the nut from the Preassembly Tool; pull out the tube with the ferrules swaged into the tube.
5. Insert tube with swaged ferrules into the fitting body.
6. Tighten the nut to the finger tight position.
7. To assemble on the fitting, use a wrench to tighten the nut to the original position. An increase of torque will be felt from this point turn the wrench slightly.
Tightening to the original position depends on the tube size. A large tube size will need more tightening than a small size, and the wall thickness has some effect on the tightening.

NOTE:

1. When using the Preassembly Tool, make sure the tool is free of damage and is clean prior to use.
2. Usage of the Preassembly Tool is limited, After permanent use please send tool to UCT Fluid Solutions for evaluation.
3. Soft tubing and tubing at the maximum diameter tolerance can cause the tube to stick to the Preassembly Tool.
In order to remove the stuck tube, please rock the tube back and forth until the tube is released from the tool.

INSTRUCTIONS FOR USING PREASSEMBLY TOOL 2MM-4MM, 1/8"-3/16"

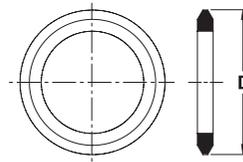
1. Assemble HAM-LET ferrules and nut on the Preassembly Tool, tighten the nut to the finger tight position.
2. Insert the tube through the nut and ferrules until the tube touches the bottom (shoulder).
3. From the finger tight position, rotate the nut 3/4 of a turn (270°).
4. Release the nut from the Preassembly Tool; pull out the tube with the ferrules swaged into the tube.
5. Insert tube with swaged ferrules into the fitting body.
6. Tighten the nut to the finger tight position.
7. To assemble on the fitting, use a wrench to tighten the nut to the original position. An increase of torque will be felt, from this point turn the wrench slightly.

STOP COLLAR

LET-LOK®		D	
inch	inch	mm	
1/4	.69	17.5	
3/8	.84	20.6	
1/2	1.10	27.0	
3/4	1.31	33.3	
1	1.68	42.7	

ASSEMBLY INSTRUCTIONS - STOP COLLAR

1. Remove the nut and ferrules from the fitting.
2. Insert the stop collar.
3. Assemble the nut and ferrules until finger tight.
4. Make up the fitting until the stop collar no longer rotates (feel with finger). At this stage it is guaranteed that the fitting is assembled correctly.



ORDERING INFORMATION FOR ASSEMBLED STOP COLLAR (WITH FITTING)

768L		SS		1/4		1/4		SC	
Fitting Type		SS Stainless Steel 316		Tube O.D.		1/4 NPT		Stop Collar	
Male LET-LOK® Connector Male End Connection		B Brass		The O.D. size is always the first to be described.		X			
		M Alloy 400							
		HC Alloy C-276							
Fitting Material									

ORDERING INFORMATION STOP COLLAR ONLY

STOP COLLAR		1/4	
Stop Collar		Tube O.D.	
		The O.D. size is always the first to be described.	