



FITTINGS – ASSEMBLY INSTRUCTIONS

Background

NR model series 2P and 3P chemically inert two and three piece fittings sets offer positive sealing without troubling dead space and are used with NR Teflon tubing.

The 2-piece fitting set incorporates a unique Kel-F nut and ferrule arrangement. The 3-piece fittings set is composed of a Teflon nut, Kel-F clamping ring and seal.

No flanging or heat tool/s required. These fittings are to be hand tightened only.

Table 1

Fitting set part number	For port size	Tubing part number	Tubing size (OD'XID')	No of sets per pack
102P109-10	#10-32	TBGM109	1/16X1/32	10
102P109-25				25
102P109-50				50
252P109-10	1/4-28	TBGM109	1/16x1/32	10
252P109-25				25
252P109-50				50

Procedure

1. Ensure Teflon tubing is of correct internal and external dimensions, as specified above.
2. Cut off Teflon tubing with a razor blade at an angle approximately 30 degrees from axis of tubing.
3. Insert angled end of tube, past an 1/8".
4. Square-cut off the angled-end of tube.
5. Tube is to extend 1/16" beyond the Kel-F ferrule.

Table 2

Fitting set part number	For port size	Tubing part number	Tubing size (OD'XID')	No of sets per pack
253P108-10	1/4-28	TBGM108	1/16X0.105	10
253P108-25				25
253P108-50				50
253P110-10	1/4-28	TBGM110	1/8x1/16	10
253P110-25				25
253P110-50				50

Procedure

1. Ensure Teflon tubing is of correct internal and external dimensions, as specified above.
2. Square-cut Teflon tubing with a razor blade.
3. Insert tubing through Teflon Nut.
4. Slip Kel-F clamping ring over assembly of Nut & tubing.
5. Push Kel-F insert until tubing bottoms barbed-end of Kel-F insert.
6. Compress the three pieces together to complete assembly procedure.

Tip:

To securely hold Teflon tubing without slipping, use a piece of sandpaper. Marginal or oversized Teflon tubing on the OD can be more easily pushed through nut by increasing the angle of cut as well as the length of cut.