



## 316 Stainless Steel Push-In Fittings Operation Guide

### A. Installation of Pipe Fitting:

Apply an appropriate sealant onto the thread, tighten fitting by hand, then turn it 2 to 3 turns with a wrench until it reaches the desire torque listed below.

Recommended Torque		
Fitting Thread Size	Torque [lb-ft]	Torque [kgf/cm]
10-32, M5-M6	1.0 – 1.5	14 – 21
NPT1/8, R1/8	5.0 – 6.5	70 – 90
NPT1/4, R1/4	8.5 – 10.0	120 – 140
NPT3/8, R3/8	16.0 – 17.5	220 – 240
NPT1/2, R1/2	20.0 – 21.5	280 – 300

### B. Installation of Tubing into Fitting:

1. Slowly push a clean and perpendicularly cut piece of tubing into the fitting until it comes to a dead stop.
2. Pull the tubing back gently until the Collet of the fitting grips onto the tubing and has a good seal.
3. Use Polyethylene, Polypropylene, Polyurethane or Nylon Tubing designed for instant fittings. Hard metal tubing, such as Stainless Steel tubing as can be used if tubing is grooved first.

### C. Removal of Tubing from Fitting:

1. Push in evenly on both sides of the Release Button.
2. Pull out the tubing while keeping the Release Button depressed.
3. To reuse tubing, cut off the lodged portion of the used tubing evenly & perpendicularly.

Tubing Material	Specified Size	Hardness (Durometer)
Polyurethane	+/- 0.006" (+/- 0.15mm)	Shore A85 or Higher
Polyethylene	+/- 0.004" (+/- 0.10mm)	Shore D44 – D75
Polypropylene	+/- 0.004" (+/- 0.10mm)	Shore D44 – D75
Nylon	+/- 0.004" (+/- 0.10mm)	Shore D44 – D75
Pre-Grooved Metal Tubing	+/- 0.004" (+/- 0.10mm)	N/A

### D. Specifications:

Operating Pressure	0 – 250 psi	0 – 1650 kpa
Vacuum	0 – 29.5 inHg	750 mm HG
Operating Temperature	5 – 230 °F	-15 – 110 °C
Sterilization Temperature	280 °F	138 °C

## Stainless Steel (SS) Gripper-Style (W) Fitting Typical Materials of Construction

