



PIPELINE

HAM-LET PRECISION INSTRUMENT PIPE FITTINGS

To ensure a leak-tight seal, HAM-LET recommends that you use a pipe-thread sealant on all NPT threads. The most effective sealing method is teflon tape. Tape should be used only on male tapered pipe threads.

Do not use tape on flared, coned or tube fitting ends!

Clean both male and female tapered threads. Wrap tape in the direction of the male tapered thread spiral.

Note: We suggest two wraps for stainless-steel tapered pipe threads. Make sure tape does not overhang the first thread otherwise, tape could shred and enter into the fluid system.

Cut off excess tape.

The connection is now ready for proper makeup.



HTC

HIGH-TECH COMPONENTS

MAKE UP OF GLANDS

- Glands offer a high-purity metal to metal seal for leak-free service in high-vacuum or high-pressure assemblies.
- The gasket is compressed by two highly polished beads when the male and female nuts are engaged.
- The gland's bead-to-bead assembly compresses a soft-metal gasket-to-seal. This assembly can be locked by HAM-LET's Grip-Kit (See A below).
- Visual test and leak testing are performed through two test ports in opposite locations from the female nut.

ASSEMBLY INSTRUCTIONS

1. Be sure to protect all HTC face-seal fittings until assembly and make up. Exercise great care that the sealing surfaces are not scratched, damaged or contaminated in any way during handling and assembly.
2. Always use a clean environment, and always employ proper clean-room protocol for make up and assembly of high-purity fittings and applications.

3. Make up instructions:

Tighten the female nut to the male nut/body finger tight.

Tighten the female nut 1/8 turn past finger tight.

Always torque the female nut while keeping the male nut/body stationary.

Face seal connections are remakable - please use a new gasket for each remake.

