

# HAM-LET PRECISION INSTRUMENTATION PIPE FITTINGS

## PIPELINE

To ensure a leak-tight seal, HAM-LET recommends that you use pipe-thread sealant on all NPT threads. The most effective sealing method is PTFE 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 the tape does not overhang the first thread. Otherwise, the tape could shred and enter the fluid system. Cut off excess tape.

The connection is now ready for proper makeup.

## HI-TECH COMPONENTS - HTC

### 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 bead-to-bead assembly compresses a soft metal gasket-to-seal. This assembly can be locked by the HAM-LET 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 the 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. spiral.
3. Make up instructions:  
Tighten the female nut to the male nut/body until it is finger tight.  
Tighten the female nut 1/8 of a turn past the finger-tight point.  
Always torque the female nut while keeping the male nut/body stationary.  
Face-seal connections are remarkable - please use a new gasket for each remake.

