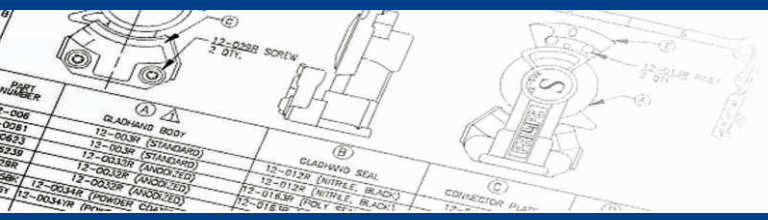
PHILLIPS



QWIK TECH TIPS

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Tips for Composite Fitting Installations

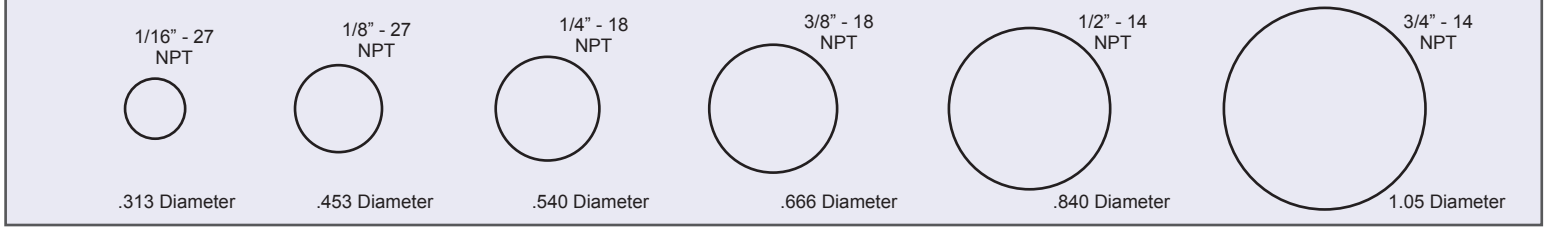
While traditional brass fittings are no less effective at getting the job done, there are definite benefits to using composite fittings instead. In a study done by a major manufacturer, the estimated labor savings, which took into consideration time and cost, was up to 42%! And in that same study it was also concluded that it took about 80% less time to install tubing to a composite fitting, than it did to a brass fitting. Just in that alone there are clear benefits to using a composite fitting over brass. However, a fitting must be properly installed to do its job right. The following are tips to remember when installing composite fittings.

- **ALWAYS** tighten the fitting by hand and then apply final torque with a wrench at the hex.
- **NEVER** use a wrench on the composite non-threaded end.
- **ALWAYS** cut tubing square with a clean edge. Cutting tubing at an angle can lead to improper sealing.
- **ALWAYS** use tube cutters to cut tubing. **NEVER** use dikes, a knife, a saw or a dull tool to cut the tubing. Avoid burrs, dirt and anything that can cause improper sealing.
- **ALWAYS** allow adequate bend radius of the tubing. Kinking the tubing and/or applying excessive side loads can cause leaks.
- **NEVER** allow contaminants to enter fitting and cartridges.
- **NEVER** attempt to disassemble tubing from the fitting with the vehicle air system under pressure.
- Using a dust boot on a composite fitting keeps dust and debris from getting into the release button. If this button becomes clogged, the fitting cannot be release, and therefore it cannot be removed. A small bristle brush (or tooth brush) can be used to remove any dust and debris build up.
- Using a plug provides a positive seal of protection for open fittings.

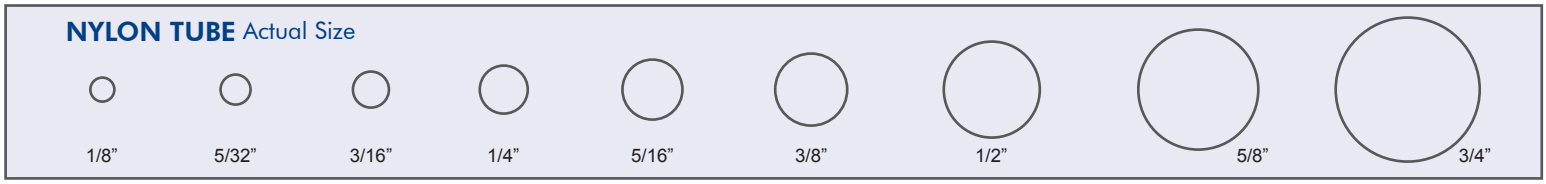
Since pipe thread isn't easily measured with a standard ruler, use the chart below to measure old fittings, and the nylon tube chart to measure air tubing to confirm the proper sized composite fitting needed before ordering/purchasing.

(Note: This article must be printed to actual size for the charts to reflect accurate sizing. As a quick reference, if a ruler is not available, a U.S. penny has a ¾" diameter and will fit perfectly inside the ¾" circle in the Nylon Tubing chart. If it does not, printing needs to be re-adjusted for accuracy.)

PIPE THREAD - OUTSIDE DIAMETER Actual Size



NYLON TUBE Actual Size



TIPS

Have technical questions? Get the latest tips from a skilled Phillips engineer!
Call:888-959-0995 OR e-mail:techtips@phillipsind.com

- ALWAYS tighten a composite air fitting by hand and then apply final torque with a wrench at the hex.
- NEVER use a wrench on the composite non-threaded end.
- ALWAYS cut tubing square with a clean edge. Cutting tubing at an angle can lead to improper sealing.

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