



# Pneumatic Fitting Instructions and Caution Information

## Assembly Instructions

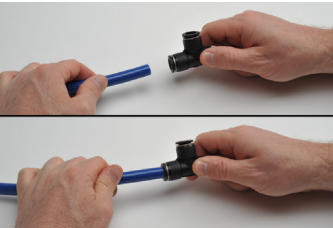


Prepare the **NITRA** tubing for cutting and make sure to have the proper tubing cutters like the **NITRA** TC-12 or TC-20.

(If cutting bonded tubing, carefully split the tubes with a knife and then pull apart as needed.)

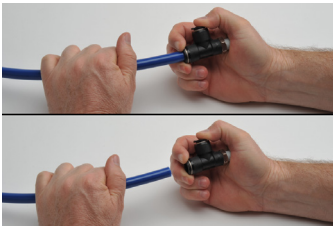


Cut the **NITRA** tubing at a right angle with the axis using a standard tube cutter. After cutting the tubing, make sure to check the cut end for an even cut with no debris.



Insertion of the **NITRA** tubing into fittings

- Make sure the tube is inserted fully into the fitting.
- Pull the tube gently to make sure it does not release.
- If the tube end is damaged or deformed, leakage or unexpected tube release may occur. Make sure to check tubing end thoroughly.



Removing the **NITRA** tubing from fittings

- Make sure the pressure in the tube is zero before releasing the tube from the fittings.
- To release the tubing, press the release ring at the end of the fitting and pull the tube with one hand.
- Inspect the released tube end and make a clean cut if it is damaged or deformed.

## Common Precautions for Tubing and Fitting Products

### Warnings:

- Do not use fittings with media other than air.
- Avoid installing with tubing under tension or with excessive bends.
- Do not use the product where weld spatters occur as fire may occur.
- Product damage or air leakage may occur at places where there is excessive rotation or vibration of the fittings.
- Use caution in water as the product may be damaged by surge pressure.
- Do not use the product where it is directly exposed to fluids such as cutting oil, lubricating oil, and coolant oil.

### Cautions:

- Assemble the tubing only after cleaning away impurities such as dust and excess debris.
- Fitting products are recommended for air systems only. Avoid using for other purposes.
- When using tubing other than NITRA brand with NITRA fittings, be sure the tubing OD conforms to the tolerances in Table 1 below.

**Table 1 - Tolerance of the Outer Diameter of the Tube**

Tube Specifications	ø5/32 [ø4]	ø1/4 [ø6]	ø5/16 [ø8]	ø3/8 [ø10]	ø1/2 [ø12]
Permissible tolerance	+ 0.005 [+/- 0.13]				

### Pneumatic Tubing Cutter

Part Number	Description	Pcs/Pkg	Wt (lb)	Price
TC-12	NITRA pneumatic tubing cutter for use with 1/8 to 1/2 inch and 4 to 12 mm outside diameter flexible plastic tubing.	1	0.1	\$4.25
TC-20	NITRA pneumatic heavy duty tubing cutter for use with polyurethane, nylon and other flexible tubing up to 2 inch [50mm] outside diameter.	1	0.2	\$7.25



TC-12



TC-20