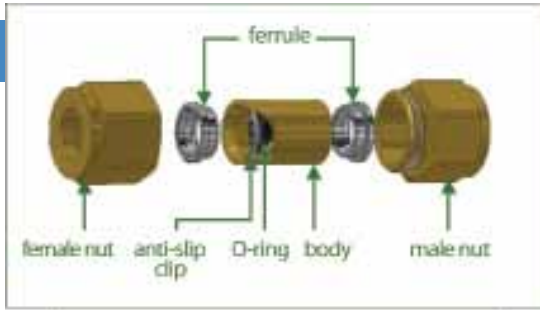


LOCUS Fittings Installation Guide



LOCUS Fittings Set

Body	x1
O-ring	x1
Anti-slip clip	x2
Ferrule	x2
Nut	x2

Parts pre-assembled for immediate use

Installation

- Select the correct tube size** (see Tables 1, 1.1, 1.2)
- Cut the aluminum or copper tube with a tube cutter**
 - Remove any burrs from end (end must be straight and even)
 - The end of the tube to be inserted must be straight (1.18"/30 mm)
- Fully insert the tube into the fitting**
 - Ensure the ferrule is in correct position. Fitting will not assemble if ferrule is in wrong position.
NOTE: Ferrule is not a reusable part. Replace if broken
 - Ensure tube is clean, free of debris, rust, scale, oil, grease, or excessive coating
 - Fully insert the tube (a minimum of 0.8" / 22 mm) through the grip ring until it adheres to the O-ring.
NOTE: To remove tube, **turn tube counter-clockwise** while pulling from fitting
- Tighten with wrench**
Tighten until there's no gap between male and female nuts (see torque value in Table 2)
- Check for leakage**
After the installation is complete, check for the leakage by spraying with soapy water or using a leakage detector

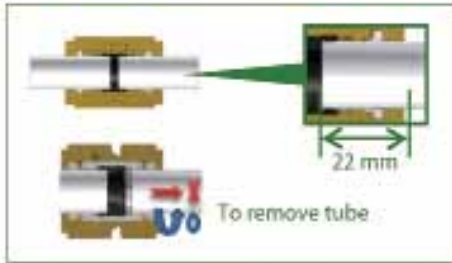
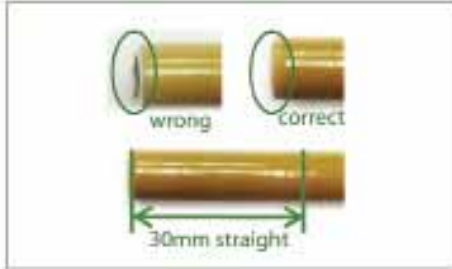


Table 1. Coated Aluminum Tube Dimensions

Size (inch)	Material	I.D. mm (inches)	Thickness mm (inches)	AL O.D. mm (inches)	Coating mm (inches)	Coating O.D. mm (inches)
1/4"	AL1060	∅ 4.35 (0.171)	1.00 (0.039)	∅ 6.02 (0.237)	0.167 (0.007)	∅ 6.35 (0.250)
3/8"	AL1070	∅ 7.52 (0.296)	1.00 (0.039)	∅ 9.19 (0.362)	0.167 (0.007)	∅ 9.52 (0.375)
1/2"	AL3003	∅ 10.30 (0.406)	1.20 (0.047)	∅ 12.37 (0.487)	0.167 (0.007)	∅ 12.70 (0.500)
5/8"	AL3004	∅ 12.88 (0.507)	1.50 (0.059)	∅ 15.55 (0.612)	0.167 (0.007)	∅ 15.88 (0.625)
3/4"		∅ 16.05 (0.632)	1.50 (0.059)	∅ 18.72 (0.737)	0.167 (0.007)	∅ 19.05 (0.750)

Table 2. Torque Needed

Size	O.D. mm (inches)	Torque – kg.f/cm (Lb.f/inches)
1/4"	6.35 (0.25)	180 ~ 230 (156~200)
3/8"	9.52 (0.37)	300 ~ 350 (260~304)
1/2"	12.70 (0.50)	350 ~ 400 (304~347)
5/8"	15.88 (0.63)	450 ~ 500 (370~434)
3/4"	19.05 (0.75)	600 ~ 650 (521~564)

Table 1.1 Conventional Aluminum Tube Dimensions

Size	O.D. mm (inches)	Thickness mm (inches)	I.D. mm (inches)	Material
1/4"	6.35±0.1 (0.25±0.004)	1.00 (0.039)	4.35 (0.171)	AL 10,30
3/8"	9.52±0.1 (0.37±0.004)	1.00 (0.039)	7.52 (0.296)	AL 10,30
1/2"	12.70±0.1 (0.50±0.004)	1.20 (0.047)	10.30 (0.405)	AL 10,30
5/8"	15.88±0.1 (0.63±0.004)	1.50 (0.059)	12.88 (0.507)	AL 10,30
3/4"	19.05±0.1 (0.75±0.004)	1.50 (0.059)	16.05 (0.632)	AL 10,30

Table 1.2 Conventional Copper Tube Dimensions

Size	O.D. mm (inches)	Thickness mm (inches)	I.D. mm (inches)	Material
1/4"	6.35±0.1 (0.25±0.004)	0.70 (0.028)	4.95 (0.195)	CU
3/8"	9.52±0.1 (0.37±0.004)	0.70 (0.028)	8.12 (0.320)	CU
1/2"	12.70±0.1 (0.50±0.004)	0.80 (0.031)	11.1 (0.437)	CU
5/8"	15.88±0.1 (0.63±0.004)	0.80 (0.031)	14.28 (0.562)	CU
3/4"	19.05±0.1 (0.75±0.004)	0.90 (0.035)	17.25 (0.679)	CU

