

HAM-LET PREASSEMBLY TOOL

In constrained installation areas, LET-LOK® fittings can be assembled with the preassembly tool and a second step on the system.

PART NO.	LET-LOK® SIZE
3902419	PREASSEMBLY TOOL 1/8
3901658	PREASSEMBLY TOOL 1/4
3901659	PREASSEMBLY TOOL 3/8
3901660	PREASSEMBLY TOOL 1/2
3902719	PREASSEMBLY TOOL 5/8
3902402	PREASSEMBLY TOOL 6MM
3902420	PREASSEMBLY TOOL 8MM
3902421	PREASSEMBLY TOOL 10MM
3902422	PREASSEMBLY TOOL 12MM
3902720	PREASSEMBLY TOOL 14MM
3902721	PREASSEMBLY TOOL 15MM
3902538	PREASSEMBLY TOOL 16MM

Instruction for using "Preassembly Tool" 6mm-16mm, 1/4"-5/8"

1. Assemble HAM-LET ferrules and nut on the Preassembly Tool, tighten the nut to finger tight position.
2. Insert the tube through the nut and ferrules until the tube touches the bottom (shoulder).
3. From the finger tight position, rotate the nut 1-1/4 turns (450°).
4. Release the nut from the Preassembly Tool; pull out the tube with the ferrules swaged into the tube.
5. Insert tube with swaged ferrules into the fitting body.
6. Tighten the nut to the finger tight position (mark the place).
7. To assemble on the fitting, use a wrench to tighten the nut to the original position. An increase of torque will be felt, from this point turn the wrench slightly.

Tightening to the original position depends on the tube size.

A large tube size will need more tightening than a small size, and the wall thickness has some effect on the tightening.

Note:

1. When using the Preassembly Tool, make sure the tool is free of damage and is clean prior to use.
2. Usage of the Preassembly Tool is limited, after permanent use please send tool to HAM-LET for evaluation.
3. Soft tubing and tubing at the maximum diameter tolerance can cause the tube to stick to Preassembly Tool.
In order to remove the stuck tube, please rock the tube back and forth until the tube gets released from the tool.



Instruction for using "Preassembly Tool" 1/8"-3/16", 2mm-4mm

1. Assemble HAM-LET ferrules and nut on the Preassembly Tool, tighten the nut to the finger tight position.
2. Insert the tube through the nut and ferrules until the tube touches the bottom (shoulder).
3. From the finger tight position, rotate the nut 3/4 of a turn (270°).
4. Release the nut from the Preassembly Tool; pull out the tube with the ferrules swaged into the tube.
5. Insert tube with swaged ferrules into the fitting body.
6. Tighten the nut to the finger tight position (mark the place).
7. To assemble on the fitting, use a wrench to tighten the nut to the original position. An increase of torque will be felt, from this point turn the wrench slightly.

Tightening to the original position depends on tube size.

A large tube size will need more tightening than a small size, and the wall thickness has some effect on the tightening.