



HTC®
HI-TECH COMPONENTS

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.

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 remakable - please use a new gasket for each remake.

