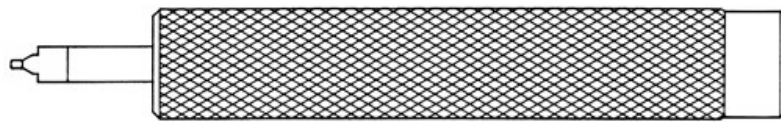
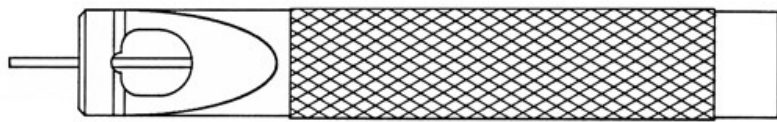


## 062 MINSTAC Tubing Preparation and Coupling Assembly

### Coupling Assembly Tools



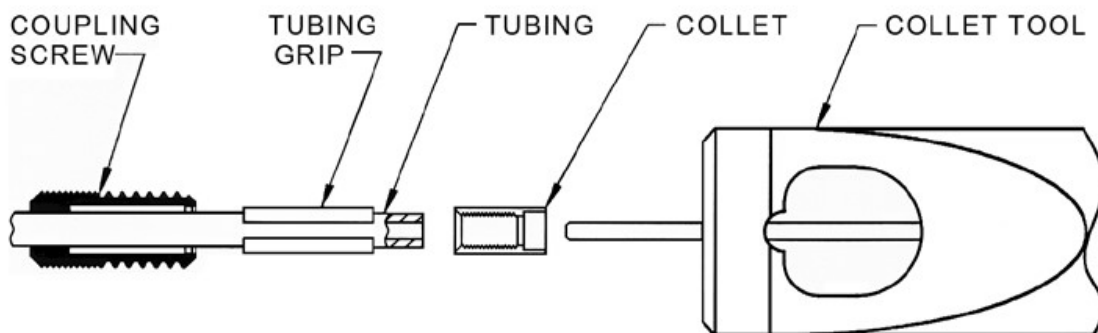
Chamfer Tool  
TTTA3201543A



Collet Tool\*  
TTTA3201443A

### Procedure:

1. Cut the tubing to the desired length. The cut should be reasonably square.
2. Slide the Coupling Screw (Part Number TMAA320207\_Z) over the end of the tubing, with the threaded end facing the tubing end. Place the collet into Tool\* (Part Number TTTA3201443A) counterbore end first.



\* The Lee Collet Tool (Part Number TTTA3201443A) is for use with 0.032" (0.81 mm) I.D. tubing. The following tools should be substituted for use with their respective sized tubing:

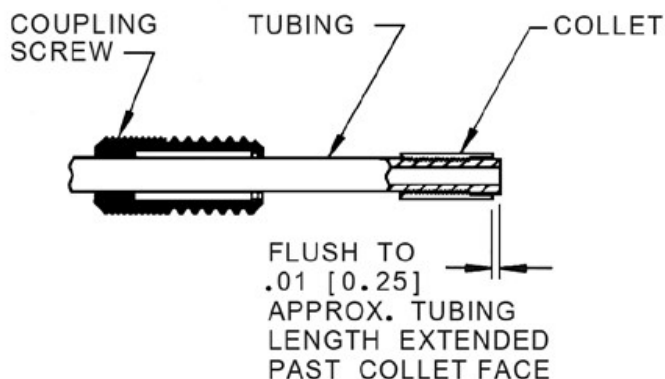
TTTA3201743A: 0.012" (0.30 mm) I.D. tubing

TTTA4000143A: 0.040" (1.02 mm) I.D. tubing

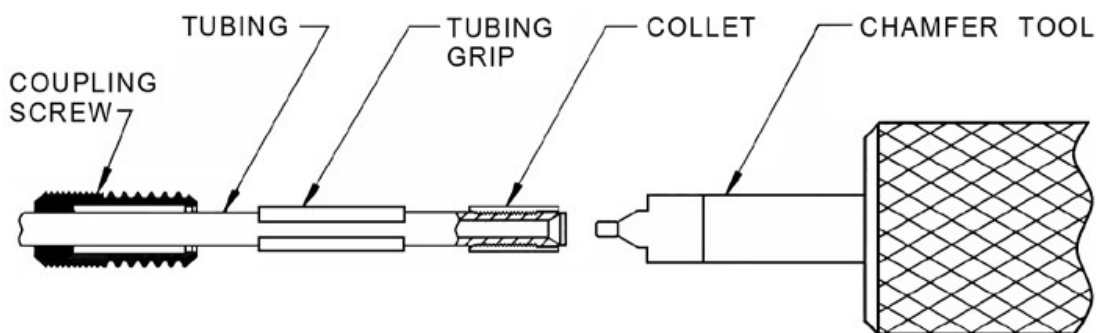
*Unless otherwise specified, dimensions are in inches [mm]. Drawings are not to scale.*

**Procedure continued:**

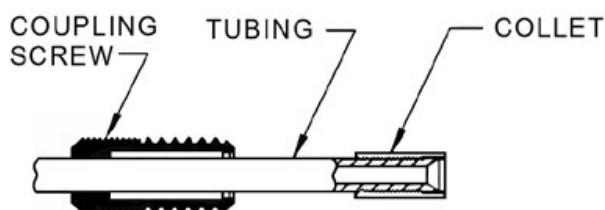
3. While holding the tubing with the rubber Tubing Grip (Part Number TTTX0500900A), screw the Collet onto the tubing end. This should require about 15-20 turns of the Collet Tool. Remove the tool from the coupling end and check that the tubing extends at least to the end of the collet.



4. Using the Lee Chamfering Tool\* (Part Number TTTA3201543A), place the pilot pin into the tubing assembly. Rotate the tool while applying a small axial force in a clockwise direction until it bottoms out against the Collet (already installed on the tubing).



\* The Chamfer Tool (Part Number TTTA3201543A) is for use with 0.032" (0.81 mm) I.D. tubing. The following tools should be substituted for use with their respective sized tubing:



TTTA3201643A: 0.012"  
(0.30 mm) I.D. tubing

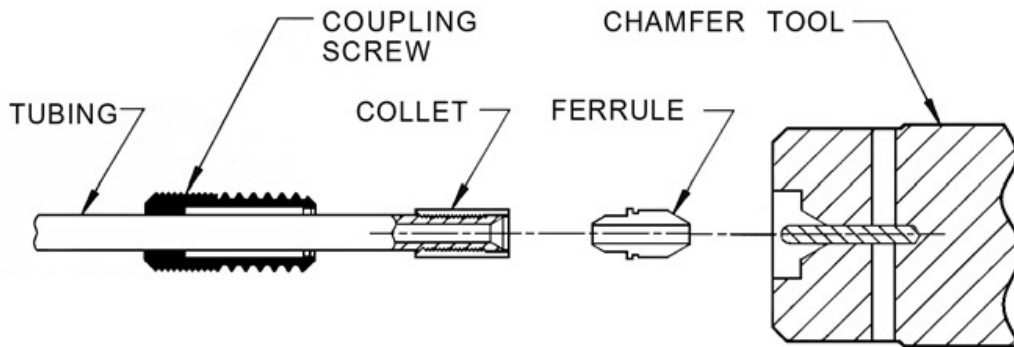
TTTA4000243A: 0.040"  
(1.02 mm) I.D. tubing

5. Slide the Coupling Screw over the Collet.

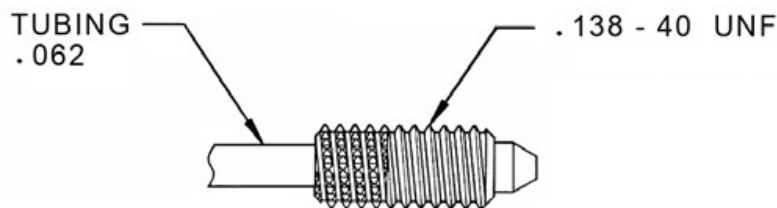
*Unless otherwise specified, dimensions are in inches [mm]. Drawings are not to scale.*

**Procedure continued:**

6. Push the Ferrule (Part Number TMBA3202910Z) onto the Ferrule installation end of the Lee Chamfer Tool (Part Number TTTA3201543A).



7. While holding the Coupling Screw, insert the Ferrule into the Coupling Screw (approx. 4 lbs. (1.8 kg.) force is required). The Ferrule will "snap" in place. The coupling assembly is now complete.



## 062 MINSTAC Coupling Installation

### Coupling Installation Tools



Torque Wrench  
TTTA3201243A

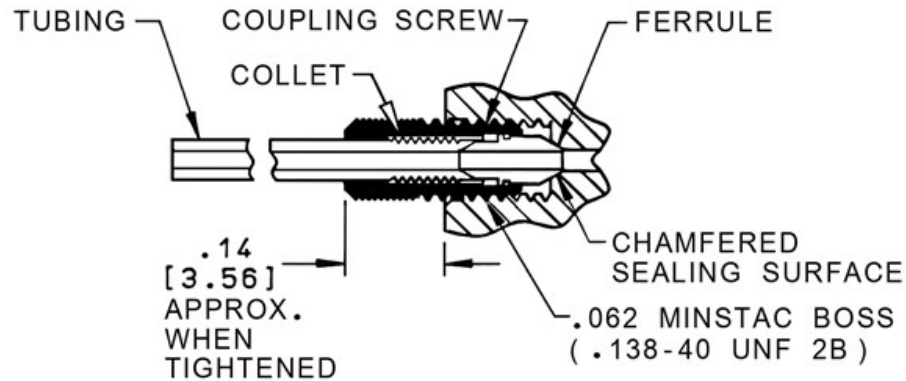


Wrench  
TTTA3200543C

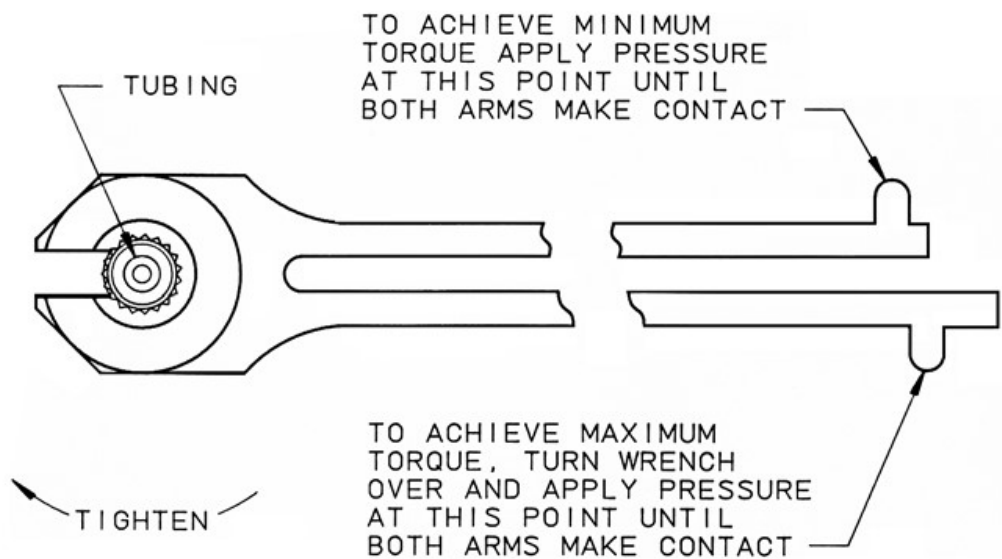
*Unless otherwise specified, dimensions are in inches [mm]. Drawings are not to scale.*

**Procedure:**

1. Start threading coupling assembly into the 062 MINSTAC fitting boss by hand.



2. Tighten the fitting between 5 to 10 ozf•in (0.035 to 0.07 N-m) by slipping the Lee Torque Wrench (Part Number TTTA3201243A) onto the knurled Coupling Screw. The minimum torque is achieved by pressing the shorter torque arm clockwise until it just contacts the longer arm. To check that maximum recommended torque is not exceeded, invert the Torque Wrench and press the longer torque arm clockwise until the Coupling Screw begins to move. This should occur before the torque arms make contact. After gaining a feel for the proper torque, use of the Torque Wrench may be discontinued.



NOTE: Minimum recommended torque: 5 ozf•in (0.035 N-m)

Maximum recommended torque: 10 ozf•in (0.07 N-m)

*Unless otherwise specified, dimensions are in inches [mm]. Drawings are not to scale.*