

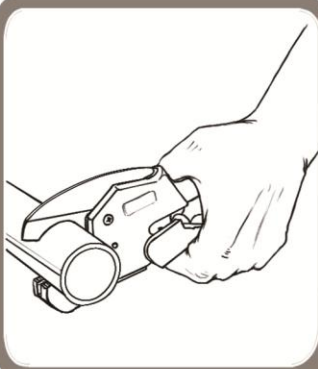
USER'S MANUAL

Super Tuff Poly Amide (STPA) tubing

We thank you for using STPA, a highly engineered polymer offering from DuPont. The manufacturer recommends that the user read this manual and keep the manual for future reference.

WARNING : STPA Tubing must be installed and serviced by a qualified installer or service agency. Improper installation, adjustment, alteration, service or maintenance can cause injury or property damage.

CUTTING

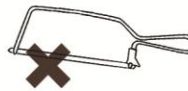


Cutting

The cut on a STPA tubing must be flat and without any burr.

This is best achieved with a sharp bladed cutting tool like a PVC pipe cutter, blade or pen-knife.

DO NOT use hacksaws.



DO NOT use round cutters.



Inacceptable cut:



Perfect cut:



FLARING

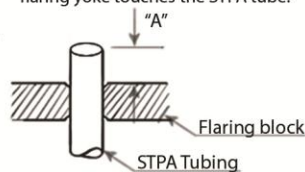
Flaring

Use ONLY The 45 degree screw-type flaring /swaging tool to flare / swage the STPA tubing.

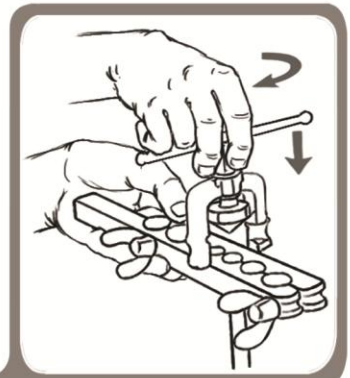
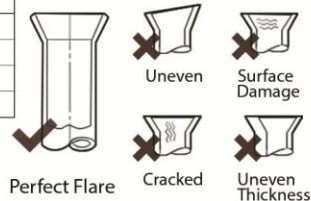
The flaring procedure is standard as for any other type of tubing.

Outside Diameter (OD) inch	"A" mm	Turns*
1/4	2.0-2.5	3-3.5
3/8	2.5-3.0	3-3.5
1/2	2.5-3.0	3-3.5
5/8	2.5-3.0	3-3.5

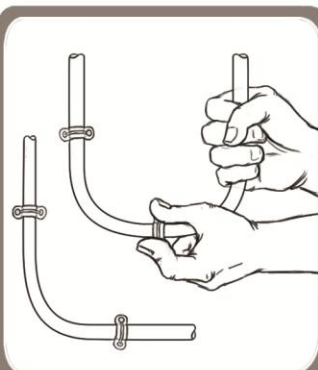
* Number of turns are counted after the flaring yoke touches the STPA tube.



Flare Check:



BENDING

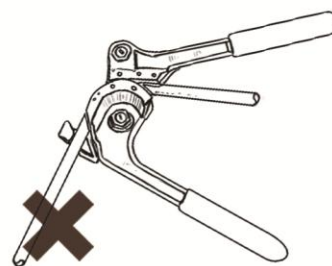


Bending

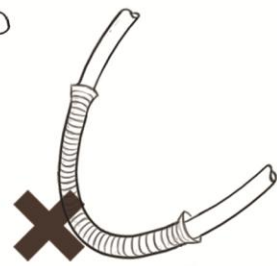
STPA tubing can be bent into Elbow & U turn bends by using hands.

They are then held in the required positions with the help of clamps.

STPA tubing does not require special bending tools:

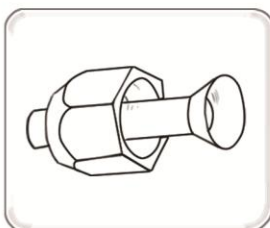


Mechanical Bender



Spring Bender

JOINING



Joining

Two STPA tubings are joined by flare and union nuts as shown in the series of illustrations.

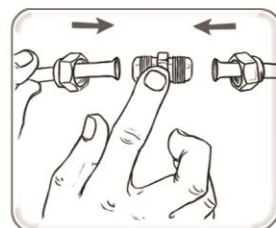
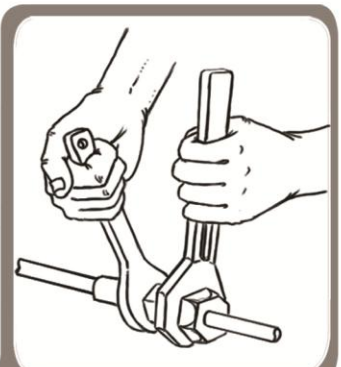


TABLE: No. of turns for tightening

Outside Diameter (OD) inch	Number of turns
1/4	1/2
3/8	3/4
1/2	1
5/8	1.5

When tightening the flare nut onto the union nut DO NOT tighten more than the amount specified in the above table.



Contact us by email at: marketing@okayindustries.co.in
Office Address: Okay Industries, A-35, Street No. 2, MIDC, Andheri (East), Mumbai - 400093
Tel No. +91-22-3088 9089 / 90

