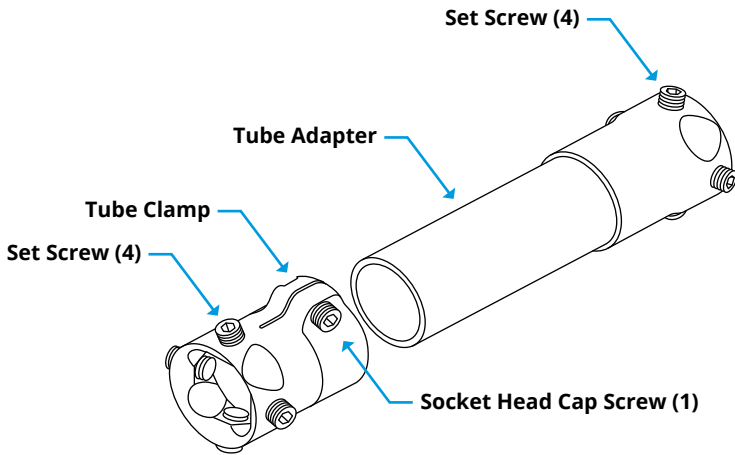


Tube Adapters & Tube Clamp



Tube Adapters

Tube and end fitting of the Tube Adapter are permanently assembled; disassembly should not be attempted. Length adjustments may be easily accomplished, but must adhere to the following procedures to insure the integrity of the system:

1. NEVER clamp tube in a vise; this may cause distortion
2. Use a standard tube cutter to make a straight cut. If the cutter does not reach through the wall, use a hacksaw to break through.
3. Deburr the outside of the cut edge so that it will contact the entire inside rim of the clamp. If the outside flares, carefully buff the O.D. to allow insertion into the clamp.
4. Loosen the Socket Head Cap Screw (**60249**) on the Tube Clamp (**60247** or **60400**). Insert the Tube into the Tube Clamp so that the tube stops on the rim inside the clamp. Do not force the tube into the clamp; if the tube will not slip into the clamp, try deburring the tube again.
5. Tighten the Socket Head Cap Screw (**60249**); torque to 10 N·m, do not overtighten. When alignment is finalized, apply Loctite Primer T and Loctite 242 to the screw threads and **torque to 10 N·m**.

Alignment

The fittings are attached to the pyramid modules and adjusted by means of four set screws. 12 mm long screws (**60248**) are supplied with the clamps and tube/Adapters. 16 mm Screws (**60271**) and 10 mm Screws (**60270**) are available if the alignment requires a different length.

Initial installation is simple and should begin with a neutral placement of the tube. Tighten all four screws evenly on the pyramid; then proceed with the required alignment.

To retain alignment when removing the component prior to final finishing (or when replacing a module), remove only two adjacent screws. Take out the two screws, which were installed to the greatest depth. Adjustment screws which are either too long (may damage the cosmetic cover), or too short (may affect stability), may be replaced with alternate sizes.

When alignment is finalized, apply Loctite Primer 'T' and Loctite 242 to each alignment screw thread and torque to 15 N-m.

Components

60245	Tube-Adapter, Ti, 400 mm
60429	Tube-Adapter, SS, 400 mm
60246	Tube-Adapter, Ti, 300 mm
60430	Tube-Adapter, SS, 300 mm
60247	Tube Clamp, Ti
60400	Tube Clamp, SS
60248	Set Screw, 12 mm long, option
60271	Set Screw, 16 mm long, standard
60270	Set Screw, 10 mm long, optional
60249	Socket Head Cap Screw



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