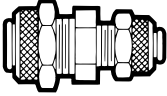
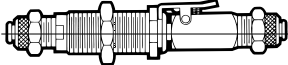
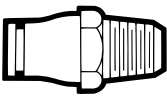
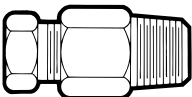
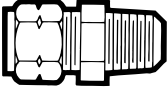
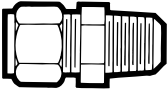
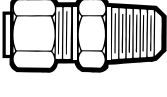




General Information

Fitting Descriptions

Style	Working Pressure		Construction	Application	Compatible Tubing
	Maximum	Nominal			
Poly-Flo® 	500 PSI	125 PSI	<ul style="list-style-type: none"> • Three-piece: body, nut sleeve • Shapes: brass, forged SAE CA377 or equal • Straights: brass, SAE CA360 or equal • Sleeves: Celcon® or Brass 	<ul style="list-style-type: none"> • Pneumatic instrumentation circuits • Fluid piping systems 	<ul style="list-style-type: none"> • Polyethylene • Polypropylene • Nylon • Polyvinyl chloride • Polyallomar • Soft metal • Poly-Flo® • Nylo-Seal® (SN, NF) • Impolene
Poly-Flo® Kwik-Connect 	500 PSI	125 PSI	<ul style="list-style-type: none"> • Body and nuts: Chrome-plated brass or Type 316 stainless steel • Sleeves: Celcon® • Springs: Stainless steel • O-Rings: Buna N on brass couplings, Viton® on stainless steel couplings 	<ul style="list-style-type: none"> • Low pressure instrumentation lines requiring frequent connecting and disconnecting • Medical and dental equipment 	<ul style="list-style-type: none"> • Polyethylene • Polypropylene • Nylon • Polyvinyl chloride • Polyallomar • Soft copper • Poly-Flo® • Nylo-Seal® • Impolene
OmegaFlo™ 	300 PSI	125 PSI	<ul style="list-style-type: none"> • One-piece unit • Shapes: brass, forged SAE CA377 or equal • Sleeves: SAE CA360 or equal • Straights: brass SAE CA360 or equal 	<ul style="list-style-type: none"> • Pneumatic instrumentation circuits • Fluid piping systems 	<ul style="list-style-type: none"> • Polyethylene • Nylon 11 • Soft copper • Poly-Flo® • Nylo-Seal® • Impolene
Hi-Duty® 	4,300 PSI ^A	800 PSI	<ul style="list-style-type: none"> • Two piece: body and nut/sleeve • Shapes: brass, forged SAE CA360 or equal • Flareless compression design 	<ul style="list-style-type: none"> • Instrumentation systems • Mobile farm and mobile construction equipment • Hydraulic and pneumatic controls • Process control systems • Laboratory equipment 	<ul style="list-style-type: none"> • Copper • Brass • Seamless steel • Thermoplastic
Flex® 	1,000 PSI ^A	200 PSI	<ul style="list-style-type: none"> • Three piece: body, nut and elastomeric sleeve • Shapes: brass, forged SAE CA377 or equal • Straights: brass, SAE CA360 or equal • Flareless • Special compound sleeves available to 450°F 	<ul style="list-style-type: none"> • High vibration and shock conditions • Diesel engine fuel lines • Lubrication systems • Gasoline, air and water lines 	<ul style="list-style-type: none"> • Copper • Brass • Aluminum • Steel • Glass • Thermoplastic
Compression 	400 PSI ^A	250 PSI	<ul style="list-style-type: none"> • Three-piece: body, nut and sleeve • Shapes: brass, forged SAE CA377 or equal • Straights: brass, SAE CA360 or equal 	<ul style="list-style-type: none"> • Low pressure air, oil, water and gas piping • Meets SAE J512 	<ul style="list-style-type: none"> • Copper • Brass • Aluminum • Thermoplastic
CompresaMatic™ 	4,500 PSI ^A	850 PSI	<ul style="list-style-type: none"> • Two-piece: body and nut/sleeve • Shapes: brass, forged SAE CA377 or equal • Straights: brass, SAE CA360 or equal • Nuts and sleeves interchangeable with standard compression bodies 	<ul style="list-style-type: none"> • Air, oil, water and gas piping • Meets SAE J512 Except for the nut and sleeve 	<ul style="list-style-type: none"> • Copper • Brass • Aluminum • Thermoplastic • Seamless steel

^AMaximum working pressure based on 1/8" O.D. dead soft copper tubing. Please consult Imperial Eastman for additional information.

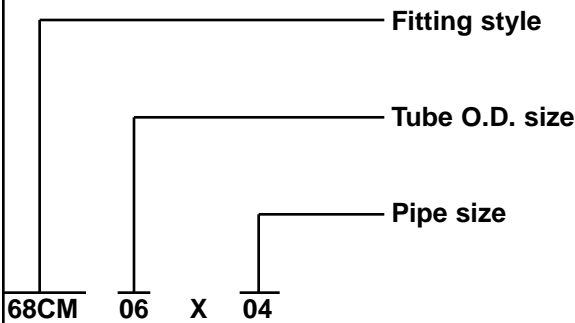
General Information

Part Number Designation Guide

Part Numbers for Tube Fittings

To order Dayco-Imperial tube fittings, use the diagram below as a guide.

Example: CompresaMatic® fittings with 3/8" tube connection and 1/4" male pipe thread.

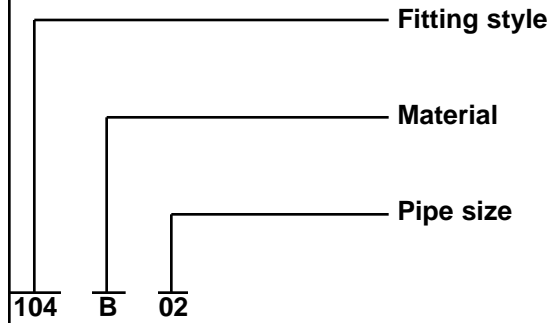


Part number = 68CM06X04

Part Numbers for Pipe Fittings

To order Dayco-Imperial brass pipe fittings, use the diagram below as a guide.

Example: Brass 1/8" NPTF female union.



Part number = 104B02

Fitting Selector Guide

FITTING STYLE	FITTING MATERIAL	MAXIMUM RECOMMENDED WORKING PRESSURE (PSI)									
		"Dash No."									
		- 02	- 03	- 04	- 05	- 06	- 08	- 10	- 12	- 14	
Hi-Duty ^{®1}	Brass	4,300	2,850	2,100	1,800	1,500	1,150	1,000	550	400	
45° Flare ¹	Brass		2,850	2,100	1,800	1,500	1,100	1,000	850	750	
CompresaMatic ^{™1}	Brass	4,500	2,500	1,750	1,800	1,150	950	750	1,000		
Compression ¹	Brass	400	400	300	300	200	200	150	100	75	
Flex [®] — Belled Tubing ¹	Brass	2,000	1,500	1,000	900	700	500	400	350	300	
Flex [®] — Non-Belled Tubing ¹	Brass	1,000	750	500	450	350	200				
OmegaFlo [™]	Brass	300 PSI MAXIMUM									
PolyFlo [®]	Brass	500 PSI MAXIMUM									
Brass Pipe Fittings	Brass	3,000 PSI MAXIMUM ²					2,000 PSI MAXIMUM ³				

Maximum working pressures depend on tubing material, tube O.D., wall thickness and fitting size. The pressures listed above reflect static pressures at 72°F with the following material and "Dash No." wall thickness.

¹TUBING MATERIAL: Copper dead soft seamless, ASTM B75, ANSI H23.3, -02/.030, -03/.030, -04/.030, -05/.032, -06/.032, -08/.032, -10/.035, -12/.035, -14/.035

²Exceptions: 101B = 2500 PSI; 102B = 2500 PSI; 104B = 1500 PSI

³Exceptions: 102B = 1000 PSI; 104B = 625 PSI; 108B = 1500 PSI; 116B = 1500 PSI; 122B = 1500 PSI

General Information

Thread Size Chart

Use this chart to determine fitting thread sizes per tube O.D. size.

For example: Thread sizes for a Hi-Duty® 1/8" fitting, with Part No. 88LB02X02 are: .5/16-24 tube thread size x 1/8-27 pipe thread size, as below:

PART NUMBER = 88LB02X02

TUBE SIZE (O.D.)

	"Dash" No.	- 02	- 03	- 04	- 05	- 06	- 07	- 08	- 10	- 12	- 14	- 16
FITTINGS	Size	1/8"	3/16"	1/4"	5/16"	3/8"	7/16"	1/2"	5/8"	3/4"	7/8"	1"

TUBE END THREADS

Hi-Duty®	5/16-24	3/8-24	7/16-24	1/2-20	9/16-20		11/16-16	7/8-18	1-18	1 1/4-18	
45° Flare	5/16-24	3/8-24	7/16-20	1/2-20	5/8-18	11/16-16	3/4-16	7/8-14	1 1/16-14	1 1/4-12	
CompresaMatic®	5/16-24	3/8-24	7/16-24	1/2-24	9/16-24	5/8-24	11/16-20	13/16-18	1-18		
Compression	5/16-24	3/8-24	7/16-24	1/2-24	9/16-24	5/8-24	11/16-20	13/16-18	1-18		
Flex®	3/8-24	7/16-24	1/2-24	9/16-24	5/8-24		13/16-18	1-18	1 1/8-18		
Poly-Flo® and Kwik-Connect	5/16-24	3/8-24	3/8-24	7/16-24	1/2-24		11/16-20				

PIPE END THREADS

Pipe Fittings	1/8-27		1/4-18		3/8-18		1/2-14		3/4-14		1-11 1/2
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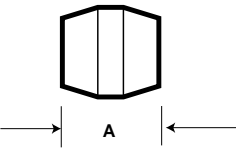
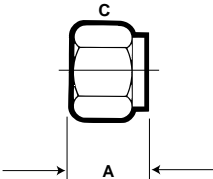
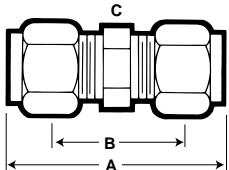
General Information

Assembly Instructions

Fitting	To Assemble	To Reconnect
Hi-Duty® Flareless Tube Fittings	<ol style="list-style-type: none">1. Using a tube cutter, cut tube squarely and cleanly, removing all burrs.2. Grasp fitting. Do not remove nut.3. Insert tube in fitting through nut until tube seats firmly against tube shoulder in body.4. Grip tube firmly to prevent turning and tighten nut until a slight “give” is felt. This “give” indicates the sleeve has been sheared from the nut.5. Continue tightening for one and one-half additional turns for a positive, leakproof seal. It is not necessary to tighten the nut all the way down.	<ol style="list-style-type: none">1. Reinsert tubing2. Tighten nut one eighth of a turn more than previous make-up. NOTE: The Hi-Duty® fitting can be disconnected and reconnected repeatedly and will always reconnect tightly.
45° Flare Tube Fittings	<ol style="list-style-type: none">1. Using a tube cutter, cut tubing squarely and cleanly, removing all burrs.2. Slide nut onto tubing with the open threaded end of the nut facing toward the end to be flared.3. Flare tubing end with a good quality flaring tool.4. Position the flare against the nose of the fitting body and align the tube with the fitting.5. Assemble nut to body, tightening finger tight.6. Tighten nut with a wrench one-quarter to one-half turn for a leakproof connection.	<ol style="list-style-type: none">1. Tighten to original make-up position, plus an additional one-sixth turn of the nut (one flat of the hex).
Compression Flareless Tube Fittings	<ol style="list-style-type: none">1. Using a tube cutter, cut tube squarely and cleanly, removing all burrs.2. Insert tubing into the fitting body until it rests against the shoulder.3. Move sleeve into position and tighten the nut. NOTE: No flaring, soldering or other special preparation of the tubing is necessary before assembly.	<ol style="list-style-type: none">1. Tighten to original make-up position, plus an additional one-sixth turn of the nut (one flat of the hex).
CompresaMatic™	<ol style="list-style-type: none">1. Using a tube cutter, cut tube squarely and cleanly, removing all burrs.2. Insert the tube into fitting. Be sure the tube “bottoms” on the fitting shoulder.3. Tighten (hand-tight), and complete the seal with one wrench turn on all sizes.	<ol style="list-style-type: none">1. Tighten to original make-up position, plus an additional one sixth turn of the nut (one flat of the hex).
Poly-Flo® Flareless Tube Fittings	<ol style="list-style-type: none">1. Using a tube cutter, cut tubing squarely and cleanly, removing all burrs.2. Push tubing into fitting and tighten the nut. NOTE: There is no need to disassemble the fitting before assembly. When used with Poly-Flo® or PVC tubing, fitting is assembled finger tight. No wrenches needed.	<ol style="list-style-type: none">1. Tighten nut to original make-up position, tightening finger tight.
Poly-Flo® Kwik-Connect Couplers	<ol style="list-style-type: none">1. Using a tube cutter, cut tubing squarely and cleanly, removing all burrs.2. Push tubing into fitting and tighten the nut. NOTE: There is no need to disassemble the fitting before assembly. When used with Poly-Flo® or PVC tubing, assembly is finger tight.	<ol style="list-style-type: none">1. Tighten nut to original make-up position, tightening finger tight.
OmegaFlo™ Push-to-Connect/ Push-to-Release Pneumatic Fittings	<ol style="list-style-type: none">1. Using a tube cutter, cut tubing cleanly and squarely.2. Firmly push the tubing into the fitting until it will enter no further. A properly assembled tube cannot be pulled out by hand.3. To disconnect, simply push back on the brass collet and release tubing.	<ol style="list-style-type: none">1. Firmly push tubing into the fitting until it will enter no further. A properly assembled tube cannot be pulled out by hand.

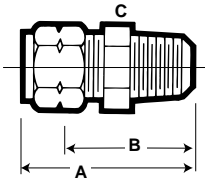
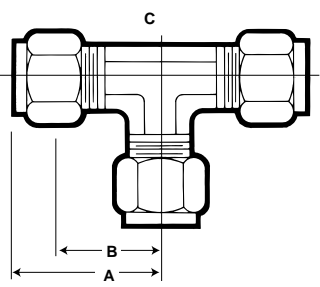
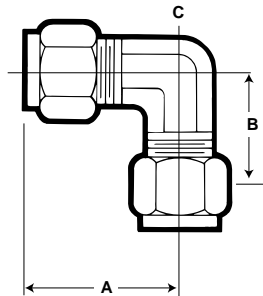
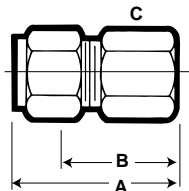
Tube Fittings

Compression Flareless Material: Brass

Style	Part No.	Tube O.D.	Pipe Thread	Min. Orifice Size	A	B	Wrench Pad/Hex C	
STYLE 60F Sleeve 	60F02	1/8			0.188			
	60F156	5/32			0.188			
	60F03	3/16			0.219			
	60F04	1/4			0.250			
	60F05	5/16			0.250			
	60F06	3/8			0.250			
	60F07	7/16			0.312			
	60F08	1/2			0.375			
	60F10	5/8			0.438			
	60F12	3/4			0.500			
	STYLE 61F Nut 	61F02	1/8			0.375		0.375
		61F156	5/32			0.344		0.375
		61F03	3/16			0.406		0.437
61F04		1/4			0.438		0.500	
61F05		5/16			0.438		0.562	
61F06		3/8			0.469		0.625	
61F07		7/16			0.500		0.688	
61F08		1/2			0.625		0.812	
61F10		5/8			0.770		0.938	
61F12		3/4			0.810		1.125	
STYLE 62F Union 		62F02	1/8		0.093	1.125	0.656	0.312
		62F156	5/32		0.109	1.125	0.656	0.312
		62F03	3/16		0.125	1.250	0.750	0.375
	62F04	1/4		0.188	1.438	0.812	0.437	
	62F05	5/16		0.250	1.469	0.875	0.500	
	62F06	3/8		0.312	1.578	0.984	0.562	
	62F08	1/2		0.406	1.938	1.093	0.688	
	62F10	5/8		0.531	2.359	1.450	0.812	
	62F12	3/4		0.656	2.562	1.620	1.000	

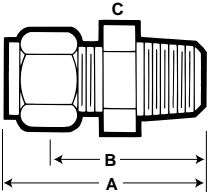
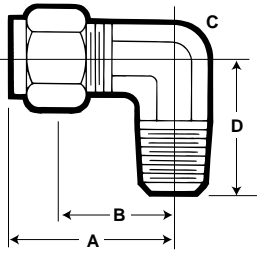
Tube Fittings

Compression Flareless Material: Brass

Style	Part No.	Tube O.D.	Pipe Thread	Min. Orifice Size	A	B	Wrench Pad/Hex C
STYLE 63F Ball Check 	63F02X02	1/8	1/8	0.093	1.015	0.781	0.437
	63F03X02	3/16	1/8	0.136	1.093	0.844	0.437
	63F04X02	1/4	1/8	0.136	1.188	0.875	0.437
STYLE 64F Union Tee 	64F02	1/8		0.093	0.859	0.625	0.312
	64F03	3/16		0.125	0.875	0.625	0.312
	64F04	1/4		0.188	0.938	0.671	0.437
	64F05	5/16		0.250	0.974	0.688	0.437
	64F06	3/8		0.312	1.078	0.781	0.500
	64F08	1/2		0.406	1.359	0.938	0.625
	64F10	5/8		0.531	1.594	1.130	0.812
STYLE 65F Union Elbow 	65F02	1/8		0.093	0.859	0.625	0.312
	65F03	3/16		0.125	0.875	0.625	0.375
	65F04	1/4		0.188	0.938	0.625	0.375
	65F05	5/16		0.250	0.984	0.688	0.437
	65F06	3/8		0.312	1.078	0.781	0.500
	65F08	1/2		0.406	1.359	0.938	0.625
	65F10	5/8		0.531	1.547	1.093	0.812
STYLE 66F Female Connector 	66F02X02	1/8	1/8	0.093	0.984	0.750	0.562
	66F03X02	3/16	1/8	0.125	1.031	0.781	0.562
	66F04X02	1/4	1/8	0.188	1.093	0.781	0.562
	66F04X04	1/4	1/4	0.188	1.344	1.031	0.688
	66F05X02	5/16	1/8	0.250	1.109	0.812	0.562
	66F05X04	5/16	1/4	0.250	1.328	1.031	0.688
	66F06X02	3/8	1/8	0.250	1.141	0.844	0.562
	66F06X04	3/8	1/4	0.312	1.359	1.062	0.688
	66F08X06	1/2	3/8	0.406	1.547	1.125	0.875
	66F08X08	1/2	1/2	0.406	1.766	1.344	1.000
	66F10X08	5/8	1/2	0.531	1.969	1.510	1.062

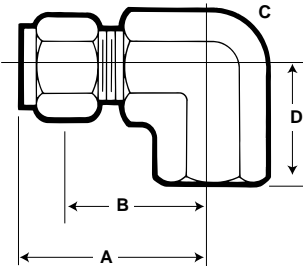
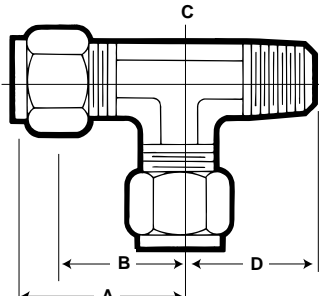
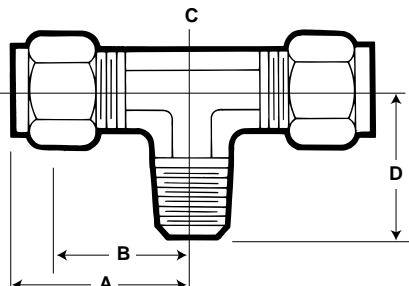
Tube Fittings

Compression Flareless Material: Brass

Style	Part No.	Tube O.D.	Pipe Thread	Min. Orifice Size	A	B	Wrench Pad/Hex C	D	
STYLE 68F Male Connector 	68F02X02	1/8	1/8	0.093	1.031	0.797	0.437		
	68F02X04	1/8	1/4	0.093	1.234	1.000	0.562		
	68F02X06	1/8	3/8	0.093	1.329	1.031	0.750		
	68F03X02	3/16	1/8	0.125	1.109	0.859	0.437		
	68F03X04	3/16	1/4	0.125	1.329	1.031	0.562		
	68F04X02	1/4	1/8	0.188	1.187	0.875	0.437		
	68F04X04	1/4	1/4	0.188	1.375	1.062	0.562		
	68F04X06	1/4	3/8	0.188	1.375	1.062	0.688		
	68F04X08	1/4	1/2	0.188	1.594	1.281	0.875		
	68F05X02	5/16	1/8	0.250	1.203	0.906	0.500		
	68F05X04	5/16	1/4	0.250	1.391	1.093	0.562		
	68F06X02	3/8	1/8	0.250	1.266	0.969	0.562		
	68F06X04	3/8	1/4	0.312	1.453	1.156	0.562		
	68F06X06	3/8	3/8	0.312	1.453	1.156	0.688		
	68F06X08	3/8	1/2	0.312	1.672	1.375	0.875		
	68F06X12	3/8	3/4	0.312	1.672	1.375	1.062		
	68F08X02	1/2	1/8	0.188	1.469	1.156	0.688		
	68F08X04	1/2	1/4	0.312	1.562	1.250	0.688		
	68F08X06	1/2	3/8	0.406	1.641	1.219	0.688		
	68F08X08	1/2	1/2	0.406	1.859	1.438	0.875		
	68F08X12	1/2	3/4	0.406	1.922	1.500	1.125		
	68F08X16	1/2	1	0.406	2.000	1.688	1.375		
	68F10X08	5/8	1/2	0.531	2.062	1.610	0.875		
	68F10X12	5/8	3/4	0.531	2.000	1.640	1.125		
	68F12X08	3/4	1/2	0.531	2.188	1.710	1.000		
	68F12X12	3/4	3/4	0.656	2.188	1.710	1.062		
	STYLE 69F Male Elbow 	69F02X02	1/8	1/8	0.093	0.859	0.625	0.312	0.688
		69F02X04	1/8	1/4	0.094	0.828	0.594	0.438	0.938
69F03X02		3/16	1/8	0.125	0.875	0.625	0.437	0.688	
69F03X04		3/16	1/4	0.125	0.895	0.641	0.437	0.922	
69F04X02		1/4	1/8	0.188	0.969	0.656	0.375	0.750	
69F04X04		1/4	1/4	0.188	1.031	0.719	0.438	0.938	
69F04X06		1/4	3/8	0.188	1.062	0.750	0.562	1.000	
69F04X08		1/4	1/2	0.188	1.188	0.875	0.688	1.250	
69F05X02		5/16	1/8	0.234	0.922	0.625	0.438	0.750	
69F05X04		5/16	1/4	0.250	1.046	0.750	0.438	0.938	
69F06X02		3/8	1/8	0.219	1.046	0.750	0.500	0.844	
69F06X04		3/8	1/4	0.312	1.078	0.781	0.500	0.938	
69F06X06		3/8	3/8	0.312	1.172	0.875	0.562	1.000	
69F06X08		3/8	1/2	0.312	1.234	0.938	0.688	1.250	
69F06X12		3/8	3/4	0.312	1.375	1.062	1.062	1.250	
69F08X02		1/2	1/8	0.188	1.219	0.844	0.688	1.000	
69F08X04		1/2	1/4	0.344	1.359	0.938	0.625	1.062	
69F08X06		1/2	3/8	0.406	1.359	0.938	0.625	1.125	
69F08X08		1/2	1/2	0.406	1.422	1.000	0.688	1.250	
69F08X12		1/2	3/4	0.406	1.437	1.125	0.750	1.281	
69F10X08		5/8	1/2	0.531	1.594	1.130	0.812	1.280	
69F10X12		5/8	3/4	0.531	1.719	1.260	0.938	1.500	
69F12X08	3/4	1/2	0.656	1.672	1.200	0.875	1.340		

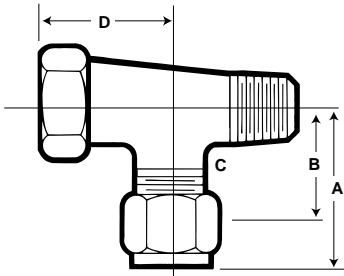
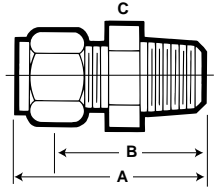
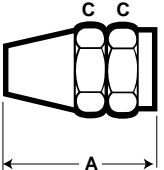
Tube Fittings

Compression Flareless Material: Brass

Style	Part No.	Tube O.D.	Pipe Thread	Min. Orifice Size	A	B	Wrench Pad/Hex C	D
STYLE 70F Female Elbow 	70F02X02	1/8	1/8	0.093	0.922	0.688	0.562	0.547
	70F03X02	3/16	1/8	0.125	0.969	0.719	0.562	0.547
	70F04X02	1/4	1/8	0.188	1.062	0.750	0.562	0.547
	70F04X04	1/4	1/4	0.188	1.188	0.875	0.688	0.719
	70F05X02	5/16	1/8	0.250	0.984	0.688	0.438	0.688
	70F06X04	3/8	1/4	0.312	1.141	0.844	0.500	0.875
	70F08X06	1/2	3/8	0.406	1.453	1.031	0.625	0.906
	70F08X08	1/2	1/2	0.406	1.547	1.125	0.688	1.188
STYLE 71F Male Run Tee 	71F04X02	1/4	1/8	0.188	1.000	0.688	0.375	0.750
	71F05X02	5/16	1/8	0.219	0.953	0.656	0.438	0.750
	71F06X04	3/8	1/4	0.312	1.078	0.781	0.500	0.938
	71F08X06	1/2	3/8	0.406	1.359	0.938	0.625	1.093
STYLE 72F Male Branch Tee 	72F02X02	1/8	1/8	0.093	0.859	0.625	0.312	0.688
	72F03X02	3/16	1/8	0.125	0.875	0.625	0.312	0.688
	72F04X02	1/4	1/8	0.188	1.000	0.688	0.375	0.750
	72F04X04	1/4	1/4	0.188	1.031	0.719	0.500	0.938
	72F05X02	5/16	1/8	0.234	0.953	0.656	0.438	0.750
	72F06X04	3/8	1/4	0.312	1.078	0.781	0.500	0.938
	72F08X06	1/2	3/8	0.406	1.359	0.938	0.625	1.093
	72F08X08	1/2	1/2	0.406	1.422	1.000	0.812	1.344

Tube Fittings

Compression Flareless Material: Brass

Style	Part No.	Tube O.D.	Pipe Thread	Min. Orifice Size	A	B	Wrench Pad/Hex C	D
STYLE 76F Tee 	76F02X02	1/8	1/8	0.093	0.953	0.719	0.562	0.531
	76F03X02	3/16	1/8	0.125	1.031	0.781	0.562	0.531
	76F04X02	1/4	1/8	0.188	1.093	0.781	0.562	0.531
	76F06X04	3/8	1/4	0.312	1.234	0.938	0.750	0.750
STYLE 80F Straight Through Tank Fitting 	80F04X04	1/4	1/4	0.257	1.375	1.062	0.562	
	80F06X06	3/8	3/8	0.382	1.453	1.156	0.688	
	80F08X08	1/2	1/2	0.516	1.859	1.438	0.875	
STYLE 161F Long Nut 	161F04	1/4			0.750		0.500	
	161F06	3/8			1.125		0.625	
	161F08	1/2			1.060		0.812	



INSTRUMENTATION & FILTRATION