

PARTS AND ACCESSORIES FOR THE FLANGING TOOL

Two types of fittings are listed below: HV (Hamilton Valve) and IS (Industry Standard). The HV is used specifically when direct thread engagement into a Hamilton Valve is required. The IS is used in applications for general laboratory use and is not compatible with Hamilton Valves.

FEP Tubing (Fluorinated Ethylene-Propylene)	CTFE Tube Fittings and Washers IS
22AWG FEP Tubing, Pkg./10' 88906	Fittings and Washers for 22 or 18 AWG FEP Tubing, Package of 10 88806
18AWG FEP Tubing, Pkg./10' 88907	Fittings and Washers for 12 AWG FEP Tubing, Package of 10 88807
*22AWG FEP Tubing, Over 10' 20939	Washer for 22 or 18 AWG FEP Tubing
*18AWG FEP Tubing, Over 10' 20937	Package of 10 88882
*12AWG FEP Tubing, Over 10' 20938	Washer for 12 AWG FEP Tubing
*specify length when ordering	Package of 10 88883

CTFE Tube Fittings and Washers HV	Flanging Tool Kit
Fittings and Washers for 22 or 18 AWG FEP Tubing, Package of 5 88842	Flanging Tool Kit complete with heating iron, tubing holder and 3 flanging tips 88821
Fittings and Washers for 12 AWG FEP Tubing, Package of 5 88843	Heating Iron, 120 VAC 60227
Washer for 22 or 18 AWG FEP Tubing	Flanging Tip for 22 AWG FEP Tubing 32905
Package of 10 88882	Flanging Tip for 18 AWG FEP Tubing 32906
Washer for 12 AWG FEP Tubing	Flanging Tip for 12 AWG FEP Tubing 32907
Package of 10 88883	Flanging Tube Holder 32903

Please reference Hamilton Company's general Product Catalog for additional items.

RETURN OF GOODS

Hamilton Company's return and repair policy is written to protect its employees from potentially hazardous materials (e.g., serum, radioactive materials, carcinogenic chemicals, etc.) or any substance that may cause them partial or permanent disability during the inspection or repair process. In returning a product, the customer acknowledges that the product is free from any hazardous materials. Furthermore, the customer assumes responsibility should the returned product be determined to be hazardous.



THE MEASURE OF EXCELLENCESM

Hamilton Company manufactures products for precision fluid measuring: syringes, valves, diluter/dispensers, and robotic sample processors, as well as polymeric HPLC columns and resin. For additional information any of these product lines, please contact Hamilton Company or your local Hamilton representative.

<http://www.hamiltoncompany.com> **ISO 9001**

Hamilton Company 1970 Energy Way Riverside, CA 92507 USA Toll Free 800-648-5950 Fax +1-775-856-7259 Telephone +1-775-858-3000 e-mail: sales@hamiltoncompany.com	Hamilton Bonaduz AG CH-3000 Bonaduz/Schwarzenried Fax +41-81-666-60-70 Telephone +41-81-660-60-60 e-mail: hamopt@bonaduz.hamilton.ch	Hamilton Deutschland GmbH D-42299 Ottum Fax +49-6151-89-17-33 Telephone +49-6151-89-17-33	Hamilton GB Ltd. 1 Lyne Ridge Estate Lymington, Hampshire, UK Fax +44-1524-72-0651 Telephone +44-1524-72-0650
---	--	--	--



THE MEASURE OF EXCELLENCESM

FLANGING TOOL KIT

Congratulations! You have purchased the finest quality flanging tool available today. We at Hamilton Company combine top quality materials with skilled workmanship, ensuring the highest possible performance level of every device we manufacture. With proper care and handling, this flanging tool will provide unsurpassed performance year after year.

The Hamilton Flanging Tool Kit was designed to make precise flanges on 22, 18 and 12 AWG FEP (Fluorinated Ethylene-Propylene) tubing. The Flanging Tool Kit may not be suitable for other types of tubing or tubing with different outer or inner diameters. For best results, use only Hamilton premium quality CTFE (chlorotrifluorethylene) fittings, FEP tubing, and washers.

WARRANTY STATEMENT

Hamilton Company unconditionally guarantees its products to be free of defects in materials and workmanship. Any product which fails due to such defects will be repaired or replaced at our discretion without cost, provided the device is returned with an explanation. It is the responsibility of the purchaser to determine the suitability of application and material compatibility of the products based on the published specifications of the products.

TOOLS NEEDED

In addition to the Flanging Tool Kit, you will need a clean working surface, 120V/AC power source, a sharp razor blade, a suitable container of cool tap water approximately 1" deep, and an adequate supply of tubing, fittings, and washers of the sizes required.

INSTALLATION OF THE FLANGING TIP

To install a flanging tip onto the flanging tool, follow these steps:

1. Prior to heating, unscrew the metal cap on the end of the flanging tool (Figure 1).
2. Select the flanging tip for the size tubing you have selected (12, 18, or 22 gauge) and insert it into the flanging tool.
3. Replace the metal cap over the flanging tip and screw it firmly into place.

HEATING THE FLANGING TOOL

To heat the flanging tool, simply plug it into a grounded 120 VAC wall outlet and allow the unit to heat for about 15 minutes.

CAUTION: The flanging tool will reach a temperature of about 750 °F at the tip. Do not touch the tip or allow it to come into contact with other materials that may be on the bench top.

TO FLANGE FEP TUBING

1. Select the length of tubing you intend to flange. With a sharp razor blade cut the end to produce a clean right angle cut.
2. Place the cut end of the tubing into the tubing holder allowing for a length of approximately 1.5 times the outside diameter to protrude (Figure 2).
3. Firmly pinch the tubing holder between the fingers with one hand and with the other, engage the heating iron tip with a slight orbital movement at first, and then squarely into the tubing (Figure 3).
4. Remove the heating iron and tip from the tubing. As the flange cools, it will form the shape of a funnel (Figure 4).

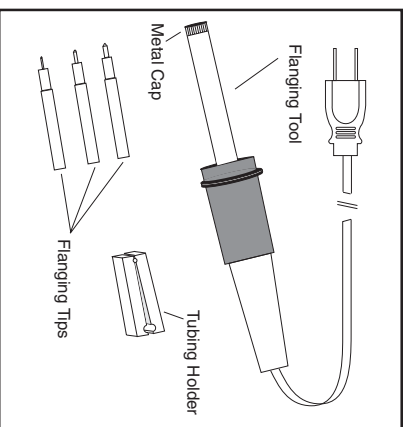


Figure 1

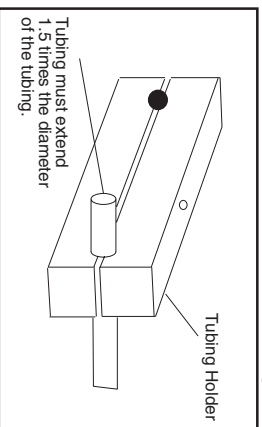


Figure 2

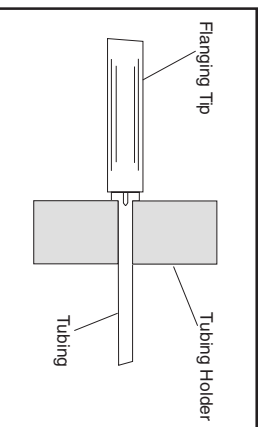


Figure 3

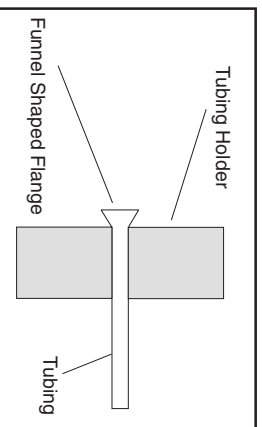


Figure 4

5. Again holding the tube holder firmly, push the heating iron tip into the tubing and firmly butt into the tube holder. Immediately quench, with the heated tip still in place, into a container of cool water.

6. While the parts are still in the water, remove the heating iron tip from the tubing. Then remove the tubing.

7. Your finished flange should look like Figure 5.

For single flanged tube assemblies, install a back-up washer and fitting onto the freshly formed flange (Figure 6). Cut the free tubing end to the desired length.

For double flanged tubing assemblies, first install the back-up washer and fitting to the freshly formed flange. Cut the tubing to the finished length allowing for the flange. Next, install the fitting and back-up washer for the second end of tubing. Proceed to flange the tube as previously instructed. Your finished product should look like Figure 7.

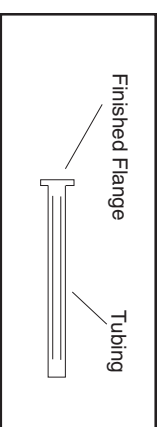


Figure 5

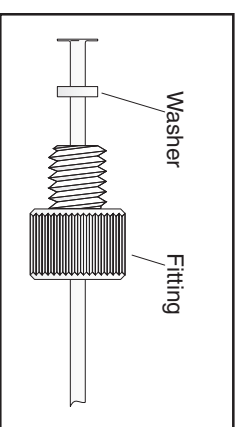


Figure 6

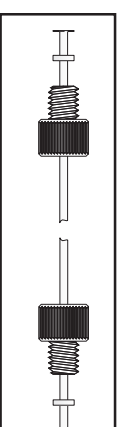


Figure 7