



**CLEAN ROOM DEVICES, LLC**  
"WHERE TUBING AND FITTINGS COME TOGETHER"

**CRD 410**  
**MANUAL FITTING INSERTER**  
**OPERATIONS MANUAL**



VERSION 1.1  
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[cleanroomdevices.com](http://cleanroomdevices.com)

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## 1.0 General Product & Safety Information

### 1.1 Product Information

- The Fitting Inserter is designed to hold and locate soft tubing and push it onto fittings.
- The minimum/maximum outside tube diameter is 1/16" to 3/8"

### 1.2 Safety Information

- This product uses a geared lever action to insert fitting into tubing. Avoid placing hands or fingers between jaws and nest.

## 2.0 Installation

Ensure all four (4) rubber suction feet are completely stabilized on your work surface prior to using the unit.

### 2.1 Jaw Installation

- Select the jaw set that corresponds to the tube OD being used.
- Assemble jaw halves using 2 .250 x 1-1/2" dowel pins and compression spring. (Figure 1&2)



Figure 1

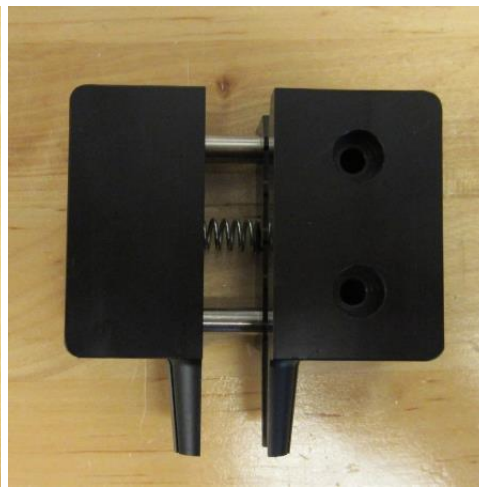


Figure 2

- Slightly squeeze jaws together and place on the 2 dowel pins extending from thrust plate. (Figure 3) Attach jaws using 2 10-24 x 1-3/8" socket head cap screws. (Figure 4)

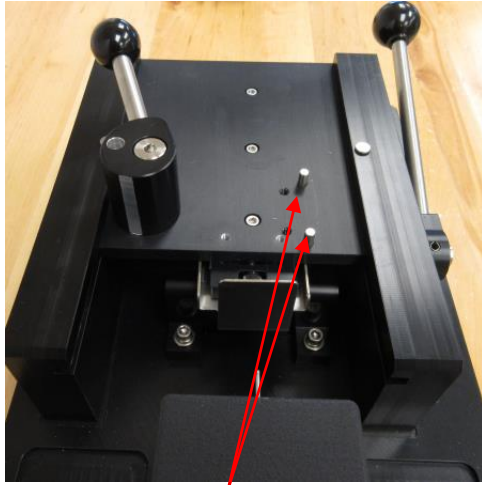


Figure 3

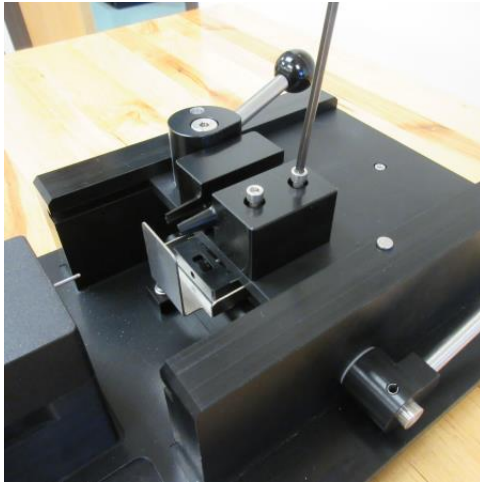


Figure 4

## 2.2 Nest Installation

- Select the nest set that corresponds to the fitting being used.
- Rotate nest to fitting position desired and simply place on the four dowel pins.
- Magnet holds nest in place. (figure 5)

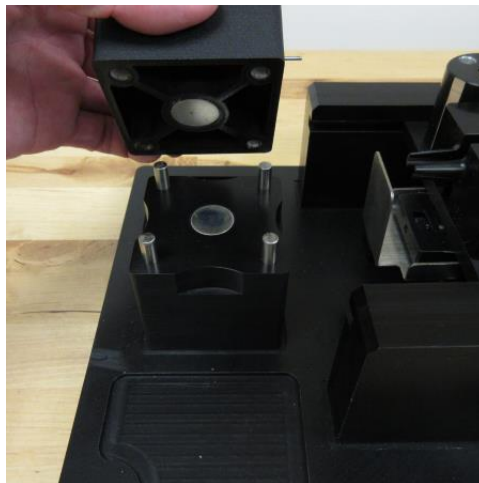


Figure 5

### 3.0 Operation

#### *Setting the Stop Gate*

- The stop gate allows for repeatable insertion of the tubing onto the fitting to a desired position on that fitting. (halfway on, fully on up to shoulder, etc.) The stop gate is adjusted via the thumb wheel. (Figure 6)

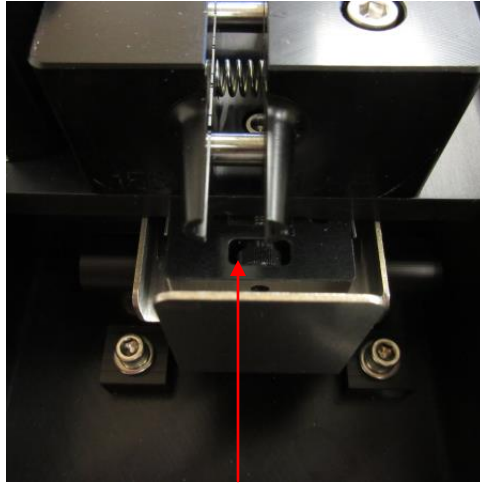


Figure 6

#### *Loading Nest and Jaws*

- Ensure that the thrust lever is all the way back and the stop gate is in the upright position.
- Lock fitting into nest, ensuring the fitting is properly seated. (Figure 6)

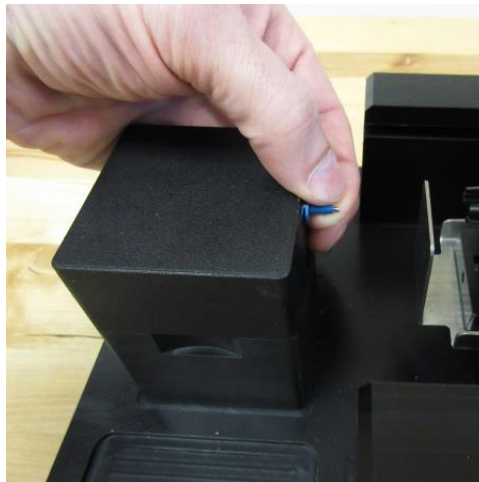


Figure 6

- Open jaws to the semi open position by rotating cam until the flat is resting on the jaw (Figure 7)
- With jaws in the semi open position, insert tubing into jaws up to the stop gate and lock in position with locking lever. (Figures 7&8)

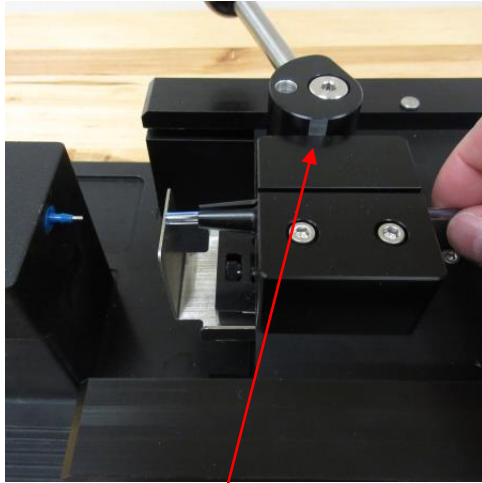


Figure 7

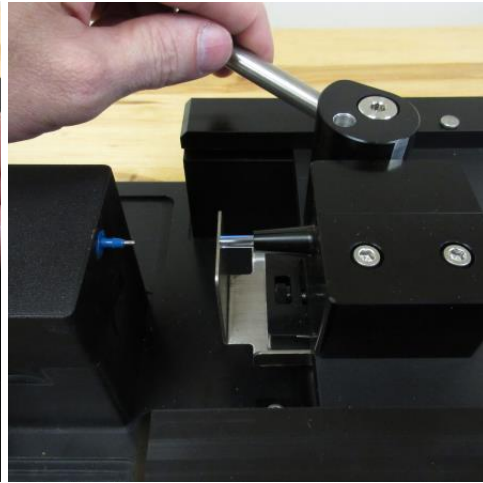


Figure 8

- Pull thrust lever back until fitting is inserted to desired position. (Figure 9)
- Open jaws and then push thrust lever partway forward so as to clear the stop gate. (Figure 10)
- Remove fitting from nest.

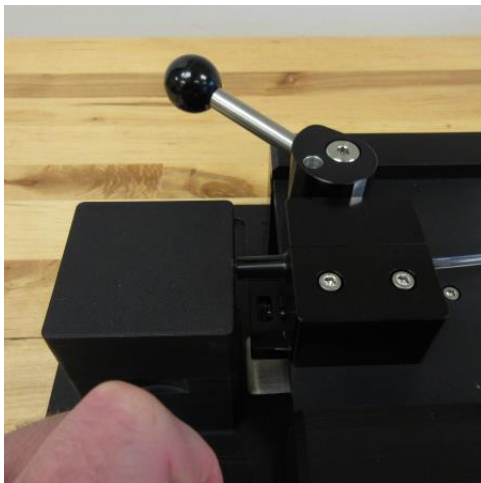


Figure 9

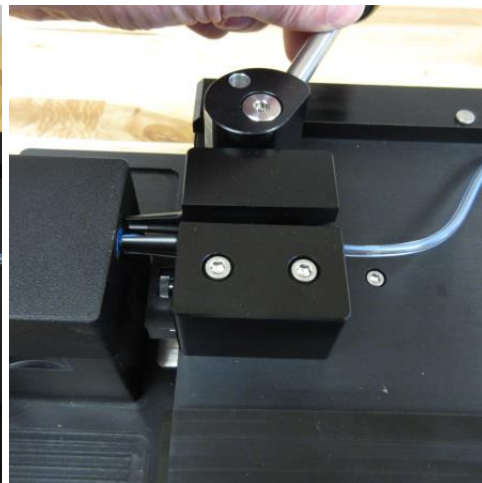


Figure 10

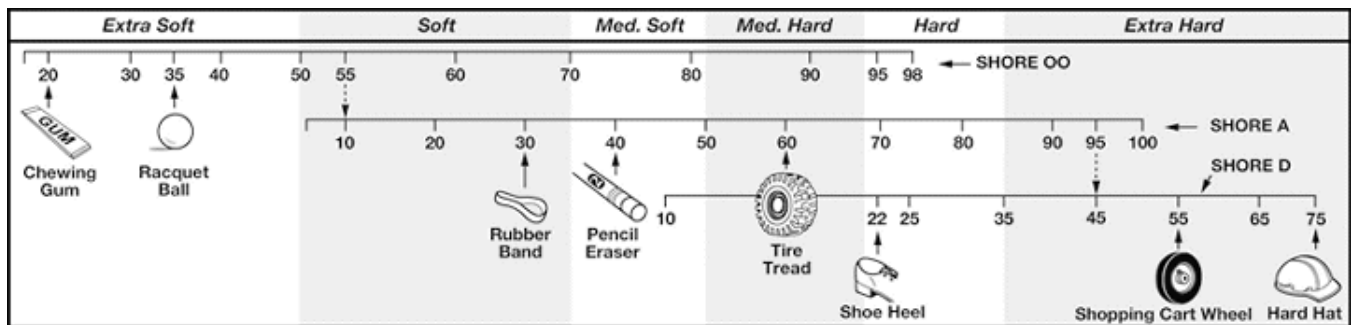
## 4.0 Maintenance

- Wipe down outer surfaces with alcohol, septihol or mild detergents as required.
- Once every three months check screws for tightness.

## 5.0 Product Specifications

Unit Weight	11 LBS / 4.99 KG
Overall Dimensions	14 in. lg. x 9 in. w. x 8.5 in. ht.

## 6.0 Durometer Scale



## 7.0 Warranty

### 7.1 Warranty

The manufacturer warrants the product manufactured by it, when properly installed, operated, applied and maintained in accordance with the procedures and recommendations outlined in the manufacturer's operation manual, to be free from defects in material or workmanship for a period as specified below, provided such defect is discovered and brought to the manufacturer's attention within the aforesaid warranty period.

The manufacturer will repair or replace any product or part determined to be defective by the manufacturer within the warranty period, provided such defect occurred in the normal service and not as a result of misuse, abuse, neglect or accident. Normal maintenance items requiring routine replacement are not warranted. The warranty covers parts and labor for the warranty period unless otherwise specified. Repair or replacement shall be made at the factory or the installation site, at the sole discretion of the manufacturer. Any service performed on the product by anyone other than the manufacturer must first be authorized by the manufacturer.

Unauthorized service voids the warranty and any resulting charge or subsequent claim will not be paid. Products repaired or replaced under warranty shall be warranted for the unexpired portion of the warranty applying to the original product.

The foregoing is the exclusive remedy of any buyer of the manufacturer's product. The maximum damages liability for the manufacturer is the original purchase price of the product or part.

THE FORGOING WARRANTY IS EXCLUSIVE AND IN LIEU OF ALL OTHER WARRANTIES, WHETHER WRITTEN, ORAL, OR STATUTORY, AND IS EXPRESSLY IN LIEU OF THE IMPLIED WARRANTY OF MERCHANTABILITY AND THE IMPLIED WARRANTY OF FITNESS FOR A PARTICULAR PURPOSE. THE MANUFACTURER SHALL NOT BE LIABLE FOR LOSS OR DAMAGE BY REASON OF STRICT LIABILITY IN TORT OR ITS NEGLIGENCE IN WHATEVER MANNER INCLUDING DESIGN, MANUFACTURE OR INSPECTION OR THE EQUIPMENT OR ITS FAILURE TO DISCOVER, REPORT, REPAIR, OR MODIFY LATENT DEFECTS INHERENT THEREIN.

THE MANUFACTURER, HIS REPRESENTATIVE OR DISTRIBUTOR SHALL NOT BE LIABLE FOR LOSS OF USE OF THE PRODUCT OR OTHER INCIDENTAL OR CONSEQUENTIAL COSTS, EXPENSES, OR DAMAGES INCURRED BY THE BUYER, WHETHER ARISING FROM BREACH OF WARRANTY, NEGLIGENCE OR STRICT LIABILITY IN TORT.

The manufacturer does not warrant any product, part, material, component, or accessory manufactured by others and sold or supplied in connection with the sale or manufacturer's products.

### 7.2 Warranty Period

Parts and labor are for ninety (90) days from the date of shipment from the factory. Freight to the factory on units that the manufacturer requests to be returned shall be paid by the purchaser, all return freight to be paid by the manufacturer; means of transportation to be specified by the manufacturer.

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