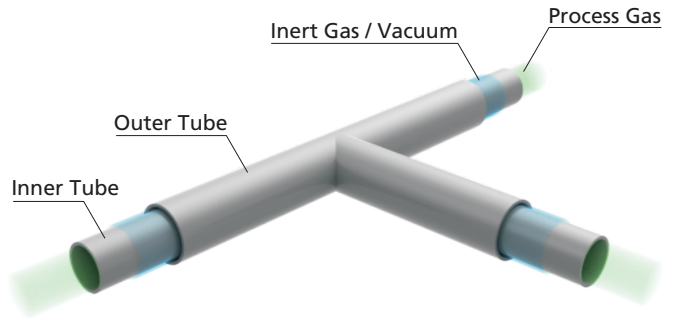


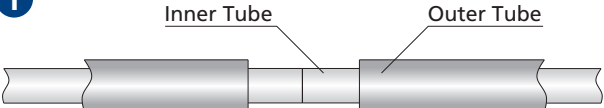
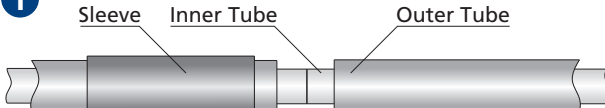
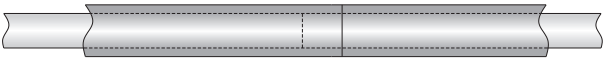
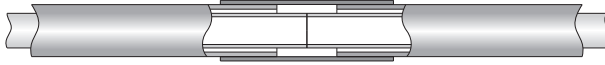
TCA Series Coaxial Tubing and Fittings

Introduction

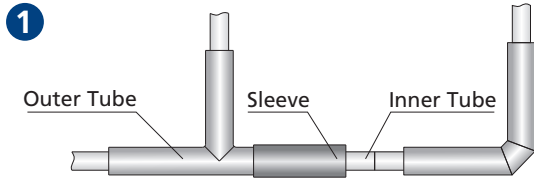
The inner process tube meets the high cleanliness and high performance requirements of ultra high purity fluid systems through strict specifications for raw materials, electropolishing, cleaning and packaging. The outer safety tube provides safe distribution of the overflow fluid in the unlikely event of a leak in the process tube. The double tube system is simple and easy to install with only orbital welding and can be integrated into existing systems and facilities.



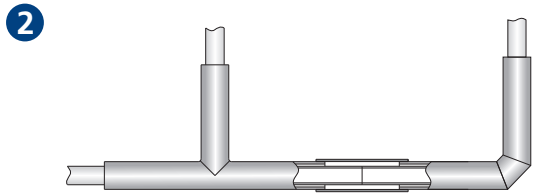
Connection Method

Tube to tube or tube to fitting connection method 1	Tube to tube or tube to fitting connection method 2
<p>1</p> 	<p>1</p> 
<p>Orbital weld the inner tubes together, then conduct helium leak test.</p>	<p>Install the sleeve on the outer tubes and orbital weld the inner tubes together, then conduct helium leak test.</p>
<p>2</p> 	<p>2</p> 
<p>Move the outer tubes to cover the inner tubes completely and connect them by orbital welding, then conduct helium leak test.</p>	<p>Move the sleeve to cover the gap between the two outer tubes completely and weld the sleeve to the outer tubes, then conduct helium leak test.</p>

Fitting to fitting connection

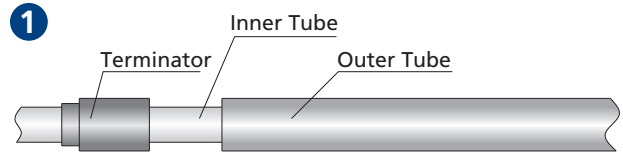


1 Install the sleeve on the outer tube of one fitting and connect the inner tubes together by orbital welding, then conduct helium leak test.



2 Move the sleeve to cover the gap between the two outer tubes completely and weld the sleeve to the outer tubes, then conduct helium leak test.

Seal the outer tubes



1 Install the terminator to the inner tubes.



2 Weld one end of the terminator to the outer tube and the other end to the outer wall of the inner tube, then conduct helium leak test.

Coaxial Tubing

Features

- ◎ Materials:
 - Inner tube: 316L, 316L VAR, 316L VIM-VAR
 - Outer tube: 316L, 304L
- ◎ Outside diameters:
 - Inner tube: 1/4" ~ 2"
 - Outer tube: 1/2" ~ 2 1/2"
- ◎ Process:
 - Inner tube: internal surface electropolished to roughness of $Ra \leq 5 \mu\text{in}$ (0.13 μm), $Ra \leq 7 \mu\text{in}$ (0.18 μm), $Ra \leq 10 \mu\text{in}$ (0.25 μm)
 - Outer tube: internal surface bright annealed or bright annealed after precision cold working to roughness of 15 μin (0.38 μm), $Ra \leq 20 \mu\text{in}$ (0.51 μm), $Ra \leq 32 \mu\text{in}$ (0.8 μm), $Ra \leq 63 \mu\text{in}$ (1.6 μm); external surface machine finished to roughness of $Ra \leq 63 \mu\text{in}$ (1.6 μm)
- ◎ Cleaning: ultrasonically cleaned, washed, rinsed, and purged and dried with high purity hot nitrogen in ISO 6 cleanroom
- ◎ Packaging: assembled in ISO 4 cleanroom, tubing ends are capped and tubing is packed in double polyethylene bags with inner bag filled with 99.999% nitrogen
- ◎ Marked with brand, inner tube grade, specification, heat number
- ◎ Standard length: 20 ft and 6 m

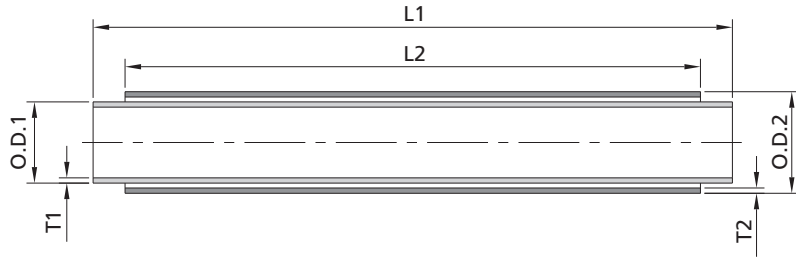


Materials

Grade	Standard	FITOK Designator	Composition/%							
			C	Mn	P	S	Si	Ni	Cr	Mo
316L	ASTM	6L	≤ 0.035 ^①	≤ 2.00	≤ 0.045	≤ 0.03	≤ 1.00	10.0~15.0	16.0~18.0	2.0~3.0
316L VAR		6LV	≤ 0.03	≤ 1.50		≤ 0.01				
316L VIM-VAR		6LW								

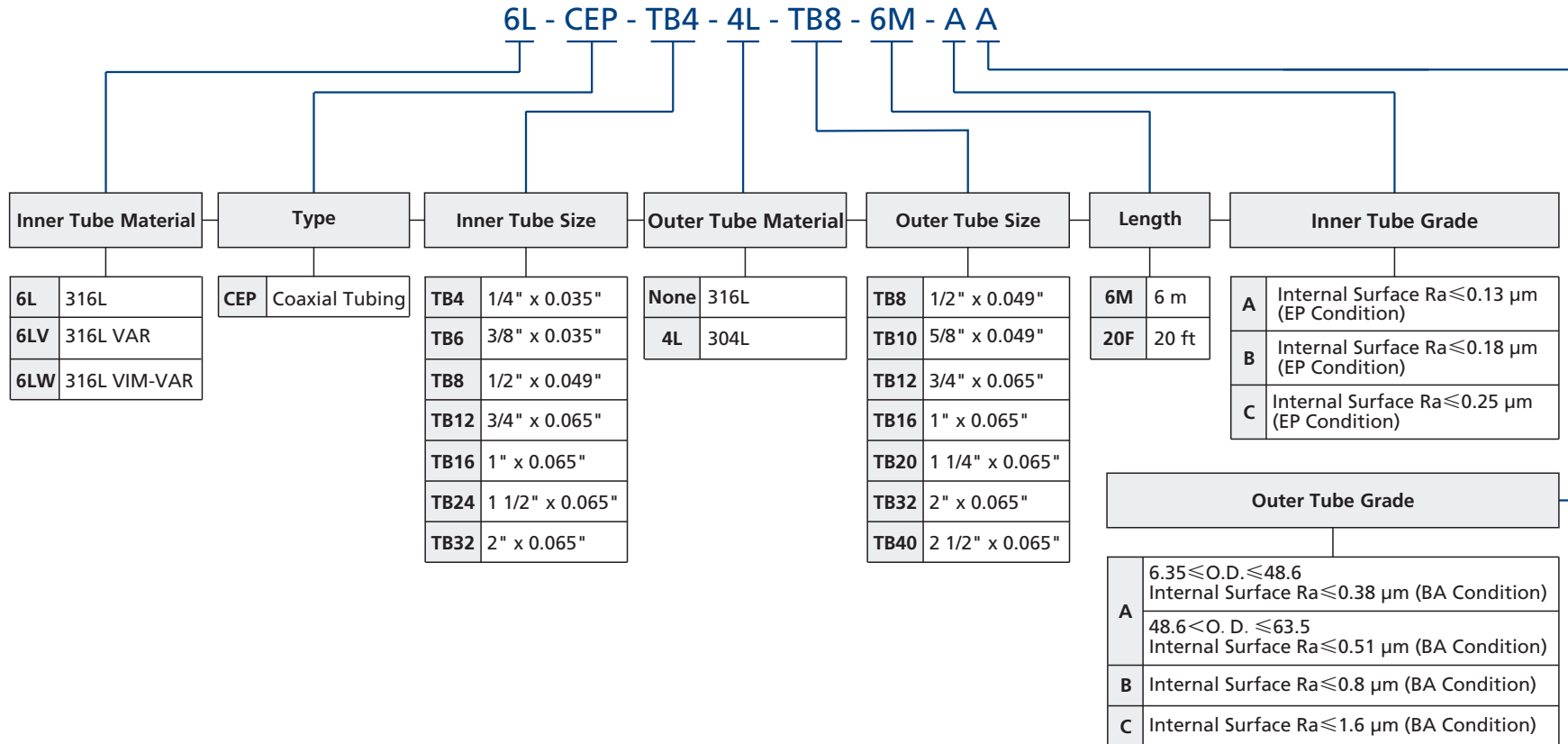
- ① The carbon content of tubing with outside diameter smaller than 1/2" or wall thickness smaller than 0.049" is allowed up to 0.04%

Ordering Information



Basic Ordering Number	Inner Tube O.D.1	Inner Tube Wall Thickness T1	Outer Tube O.D.2	Outer Tube Wall Thickness T2	Metric/m (recommended)		Fractional/ft		Inner Tube Working Pressure (-18~99 °F) psig
					Inner Tube Length L1	Outer Tube Length L2	Inner Tube Length L1	Outer Tube Length L2	
□□-CEP-TB4-TB8-□□-□□	1/4"	0.035"	1/2"	0.049"	6	5.95	20	19.83	5100
□□-CEP-TB6-TB10-□□-□□	3/8"	0.035"	5/8"	0.049"	6	5.95	20	19.83	3300
□□-CEP-TB8-TB12-□□-□□	1/2"	0.049"	3/4"	0.065"	6	5.95	20	19.83	3700
□□-CEP-TB12-TB16-□□-□□	3/4"	0.065"	1"	0.065"	6	5.91	20	19.71	3300
□□-CEP-TB16-TB20-□□-□□	1"	0.065"	1 1/4"	0.065"	6	5.91	20	19.71	2400
□□-CEP-TB24-TB32-□□-□□	1 1/2"	0.065"	2"	0.065"	6	5.9	20	19.67	1600
□□-CEP-TB32-TB40-□□-□□	2"	0.065"	2 1/2"	0.065"	6	5.9	20	19.67	1200

Ordering Number Description



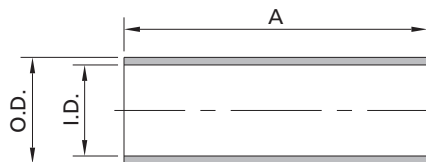
Note: "Ordering Number Description" is a reference to understand the combination rules of FITOK product part number.
 Not all combination are available.

Coaxial Sleeve

Features

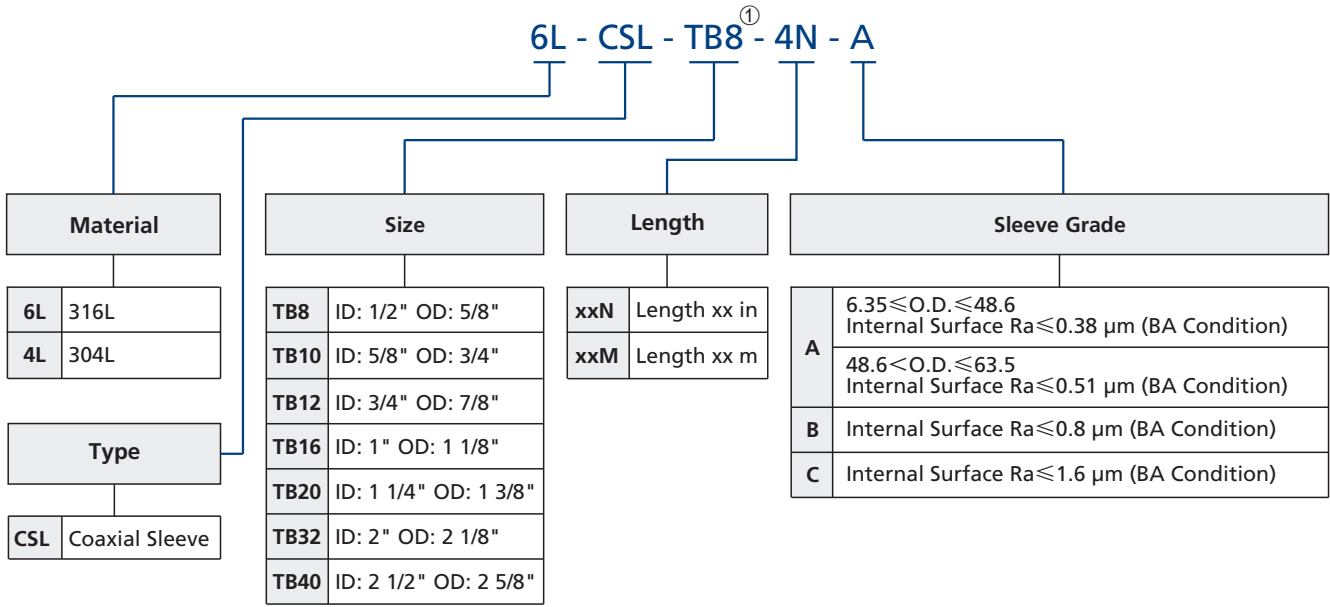
- ⦿ Materials: 316L, 304L
- ⦿ Inside diameter: 1/2" ~ 2 1/2"
- ⦿ Process: internal surface bright annealed or bright annealed after precision cold working to roughness of 15 μin (0.38 μm), $R_a \leq 20 \mu\text{in}$ (0.51 μm), $R_a \leq 32 \mu\text{in}$ (0.8 μm), $R_a \leq 63 \mu\text{in}$ (1.6 μm); external surface mechine finished to roughness of $R_a \leq 63 \mu\text{in}$ (1.6 μm)
- ⦿ Cleaning: ultrasonically cleaned, purged and dried
- ⦿ Packaging: tubing ends are capped and tubing is packed in individual polyethylene bag
- ⦿ Marked with brand, material grade and trace number
- ⦿ Standard length: 2.5 in, 4 in, 4.5 in, customized lengths are available upon request

Ordering Information



Part Number	I.D.	O.D.	Length A
6L-CSL-TB8-□□-□	1/2"	5/8"	2.5"
6L-CSL-TB10-□□-□	5/8"	3/4"	2.5"
6L-CSL-TB12-□□-□	3/4"	7/8"	2.5"
6L-CSL-TB16-□□-□	1"	1 1/8"	4"
6L-CSL-TB20-□□-□	1 1/4"	1 3/8"	4"
6L-CSL-TB32-□□-□	2"	2 1/8"	4.5"
6L-CSL-TB40-□□-□	2 1/2"	2 5/8"	4.5"

Ordering Number Description



① Refer to outer tube outside diameter for sleeve part number selection.

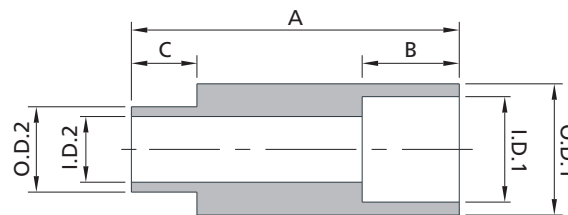
Note: "Ordering Number Description" is a reference to understand the combination rules of FITOK product part number.
Not all combinations are available.

Coaxial Terminator

Features

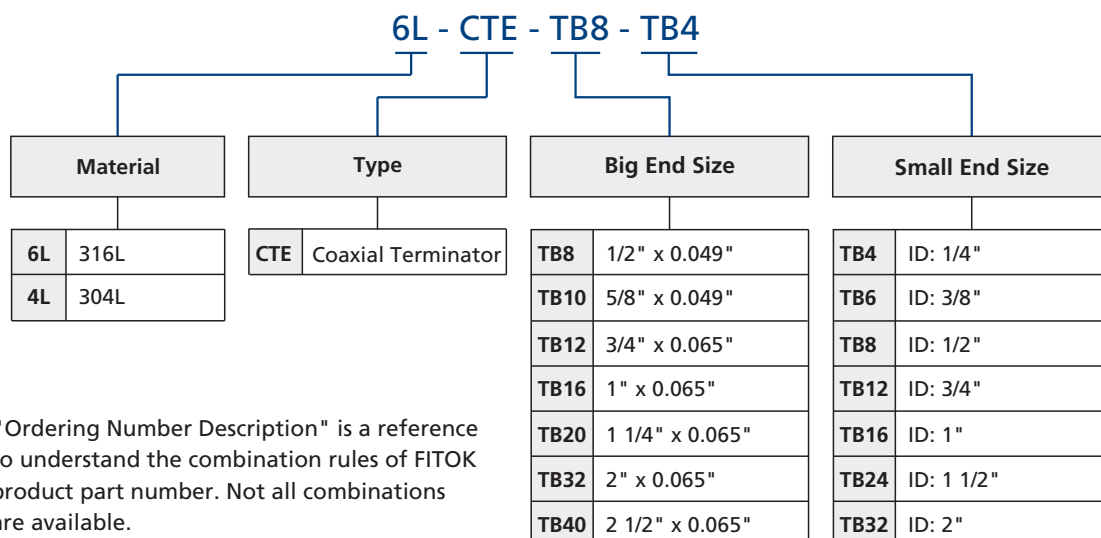
- Materials: 316L, 304L
- Big end: O.D. 1/2" ~ 2 1/2"
- Small end: I.D. 1/4" ~ 2"
- Marked with brand, material grade and trace number
- Standard length: 1.25 in, 2 in, 2.25 in

Ordering Information



Part Number	O.D.1	I.D.1	O.D.2	I.D.2	A	B	C
6L-CTE-TB8-TB4	1/2"	0.402"	0.325"	1/4"	1.25"	0.37"	0.25"
6L-CTE-TB10-TB6	5/8"	0.527"	0.450"	3/8"	1.25"	0.37"	0.25"
6L-CTE-TB12-TB8	3/4"	0.620"	0.603"	1/2"	1.25"	0.37"	0.25"
6L-CTE-TB16-TB12	1"	0.870"	0.885"	3/4"	2"	0.5"	0.25"
6L-CTE-TB20-TB16	1 1/4"	1.120"	1.135"	1"	2"	0.5"	0.25"
6L-CTE-TB32-TB24	2"	1.870"	1.635"	1 1/2"	2.25"	0.75"	0.25"
6L-CTE-TB40-TB32	2 1/2"	2.360"	2.135"	2"	2.25"	0.75"	0.25"

Ordering Number Description



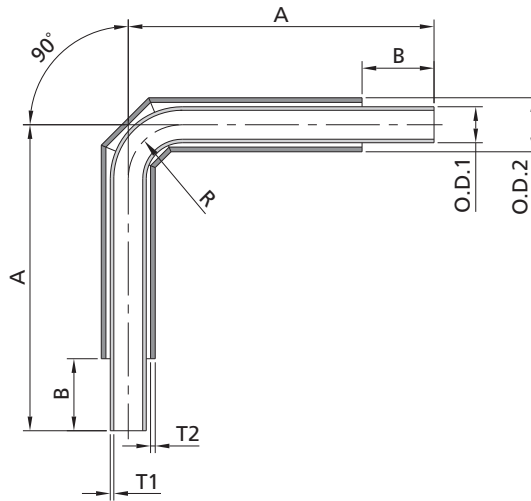
Coaxial Elbow

Features

- ⦿ **Materials:**
 Inner tube: 316L, 316L VAR, 316L VIM-VAR
 Outer tube: 316L, 304L
- ⦿ **Outside diameter:**
 Inner tube: 1/4" ~ 2"
 Outer tube: 1/2" ~ 2 1/2"
- ⦿ **Inner tube process:** internal surface electropolished to roughness of $Ra \leq 5 \mu\text{in}$ (0.13 μm), $Ra \leq 7 \mu\text{in}$ (0.18 μm), $Ra \leq 10 \mu\text{in}$ (0.25 μm)
- ⦿ **Cleaning:** ultrasonically cleaned, washed, rinsed, and purged and dried with high purity hot nitrogen in ISO 6 cleanroom
- ⦿ **Packaging:** packaged in ISO 4 cleanroom, tubing ends are capped and tubing is packed in double polyethylene bags with inner bag filled with 99.999% nitrogen
- ⦿ **Marked with brand, material grade and trace number**

Ordering Information

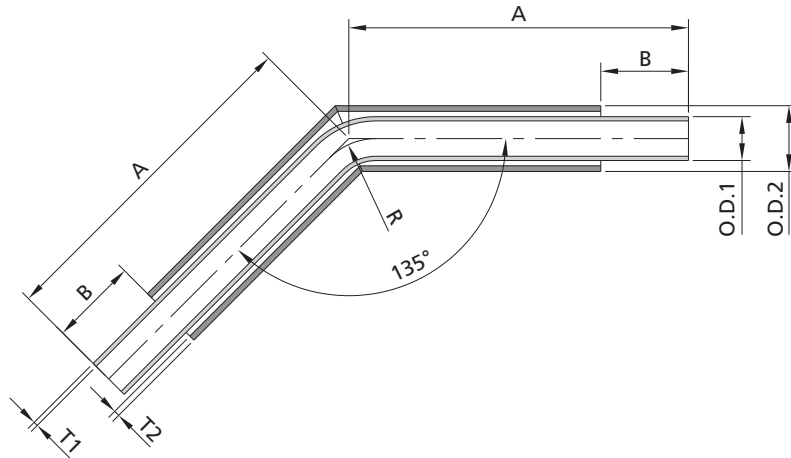
Coaxial 90° Elbow



Part Number	Inner Tube O.D.1	Inner Tube Wall Thickness T1	Outer Tube O.D.2	Outer Tube Wall Thickness T2	Bending Radius R	A	B
6L-CEL-TB4-TB8	0.25"	0.035"	0.5"	0.049"	0.56"	4.375"	1"
6L-CEL-TB6-TB10	0.375"	0.035"	0.625"	0.049"	0.56"	4.125"	1"
6L-CEL-TB8-TB12	0.5"	0.049"	0.75"	0.065"	0.75"	4.25"	1"
6L-CEL-TB12-TB16	0.75"	0.065"	1"	0.065"	1"	6.75"	1.75"
6L-CEL-TB16-TB20	1"	0.065"	1.25"	0.065"	1.18"	7.125"	1.75"
6L-CEL-TB24-TB32	1.5"	0.065"	2"	0.065"	2.25"	8.375"	2"
6L-CEL-TB32-TB40	2"	0.065"	2.5"	0.065"	3"	9"	2"

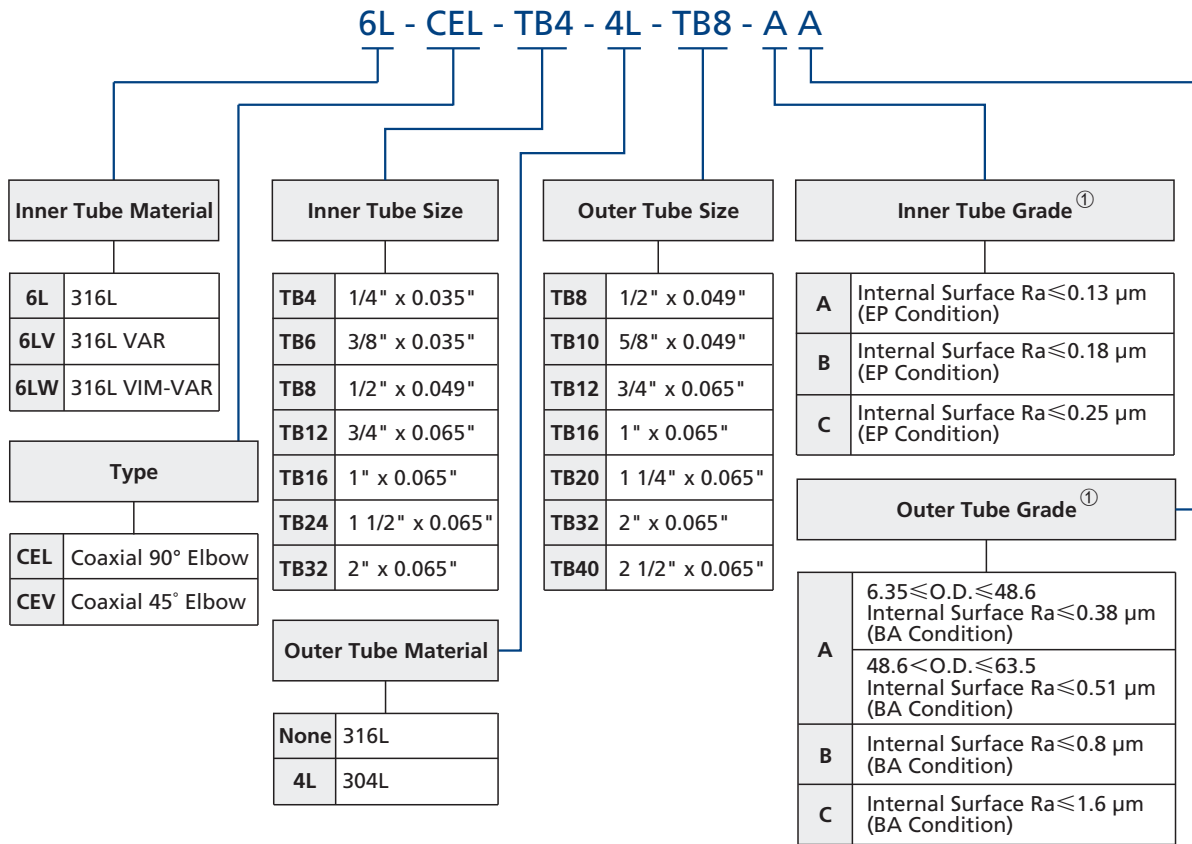
Ordering Information

Coaxial 45° Elbow



Part Number	Inner Tube O.D.1	Inner Tube Wall Thickness T1	Outer Tube O.D.2	Outer Tube Wall Thickness T2	Bending Radius R	A	B
6L-CEV-TB4-TB8	0.25"	0.035"	0.5"	0.049"	0.56"	4"	1"
6L-CEV-TB6-TB10	0.375"	0.035"	0.625"	0.049"	0.56"	3.875"	1"
6L-CEV-TB8-TB12	0.5"	0.049"	0.75"	0.065"	0.75"	3.875"	1"
6L-CEV-TB12-TB16	0.75"	0.065"	1"	0.065"	1"	6.125"	1.75"
6L-CEV-TB16-TB20	1"	0.065"	1.25"	0.065"	1.18"	6.25"	1.75"
6L-CEV-TB24-TB32	1.5"	0.065"	2"	0.065"	2.25"	7.12"	2"
6L-CEV-TB32-TB40	2"	0.065"	2.5"	0.065"	3"	8"	2"

Ordering Number Description



① Ra values for the internal and external surfaces of the cold working area of the fittings are not defined.

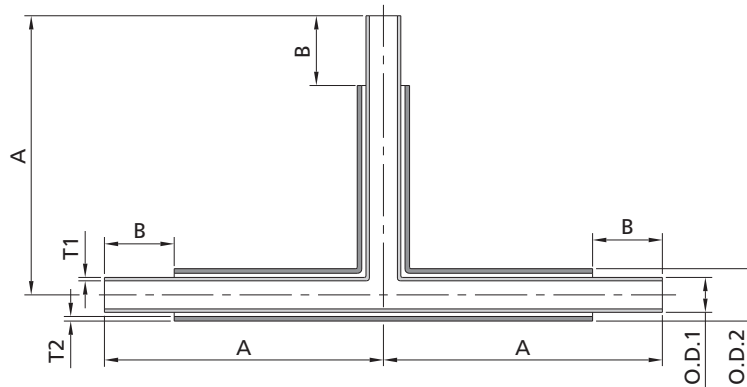
Note: "Ordering Number Description" is a reference to understand the combination rules of FITOK product part number.
Not all combinations are available.

Coaxial Equal Tee

Features

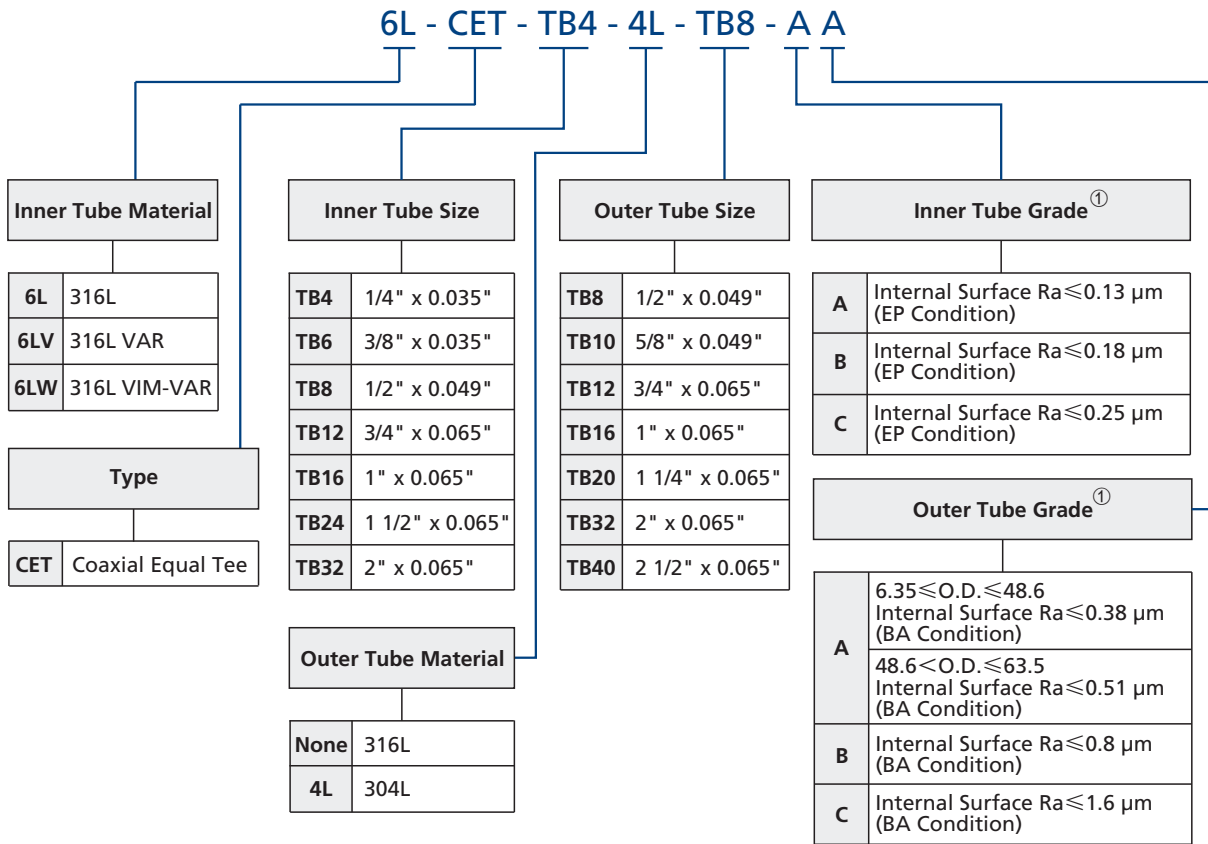
- ⦿ Materials:
 Inner tube: 316L, 316L VAR, 316L VIM-VAR
 Outer tube: 316L, 304L
- ⦿ Outside diameter:
 Inner tube: 1/4" ~ 2"
 Outer tube: 1/2" ~ 2 1/2"
- ⦿ Inner tube process: internal surface electropolished to roughness of $Ra \leq 5 \mu\text{in}$ (0.13 μm), $Ra \leq 7 \mu\text{in}$ (0.18 μm), $Ra \leq 10 \mu\text{in}$ (0.25 μm)
- ⦿ Cleaning: ultrasonically cleaned, washed, rinsed, and purged and dried with high purity hot nitrogen in ISO 6 cleanroom
- ⦿ Packaging: packaged in ISO 4 cleanroom, tubing ends are capped and tubing is packed in double polyethylene bags with inner bag filled with 99.999% nitrogen
- ⦿ Marked with brand, material grade and trace number

Ordering Information



Part Number	Inner Tube O.D.1	Inner Tube Wall Thickness T1	Outer Tube O.D.2	Outer Tube Wall Thickness T2	A	B
6L-CET-TB4-TB8	0.25"	0.035"	0.5"	0.049"	3.875"	1"
6L-CET-TB6-TB10	0.375"	0.035"	0.625"	0.049"	4"	1"
6L-CET-TB8-TB12	0.5"	0.049"	0.75"	0.065"	4"	1"
6L-CET-TB12-TB16	0.75"	0.065"	1"	0.065"	6.375"	1.75"
6L-CET-TB16-TB20	1"	0.065"	1.25"	0.065"	6.5"	1.75"
6L-CET-TB24-TB32	1.5"	0.065"	2"	0.065"	7.625"	2"
6L-CET-TB32-TB40	2"	0.065"	2.5"	0.065"	8"	2"

Ordering Number Description



① Ra values of the internal and external surfaces at tube circumferential weld area is undefined.

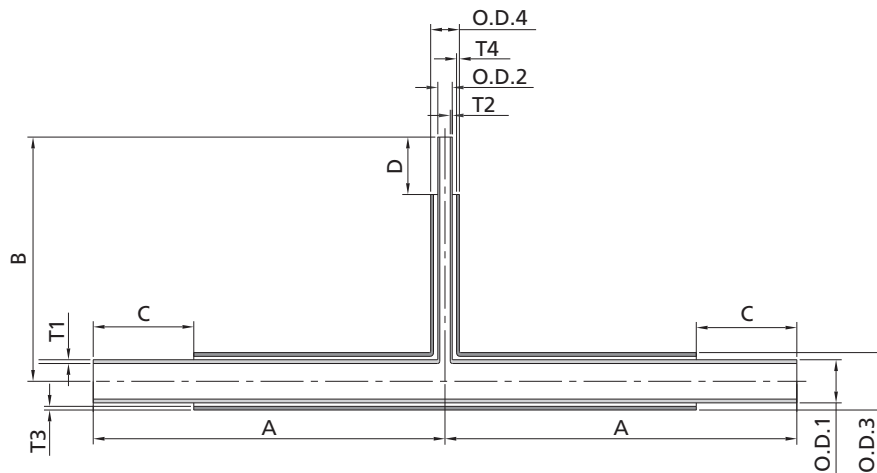
Note: "Ordering Number Description" is a reference to understand the combination rules of FITOK product part number.
Not all combinations are available.

Coaxial Reducing Tee

Features

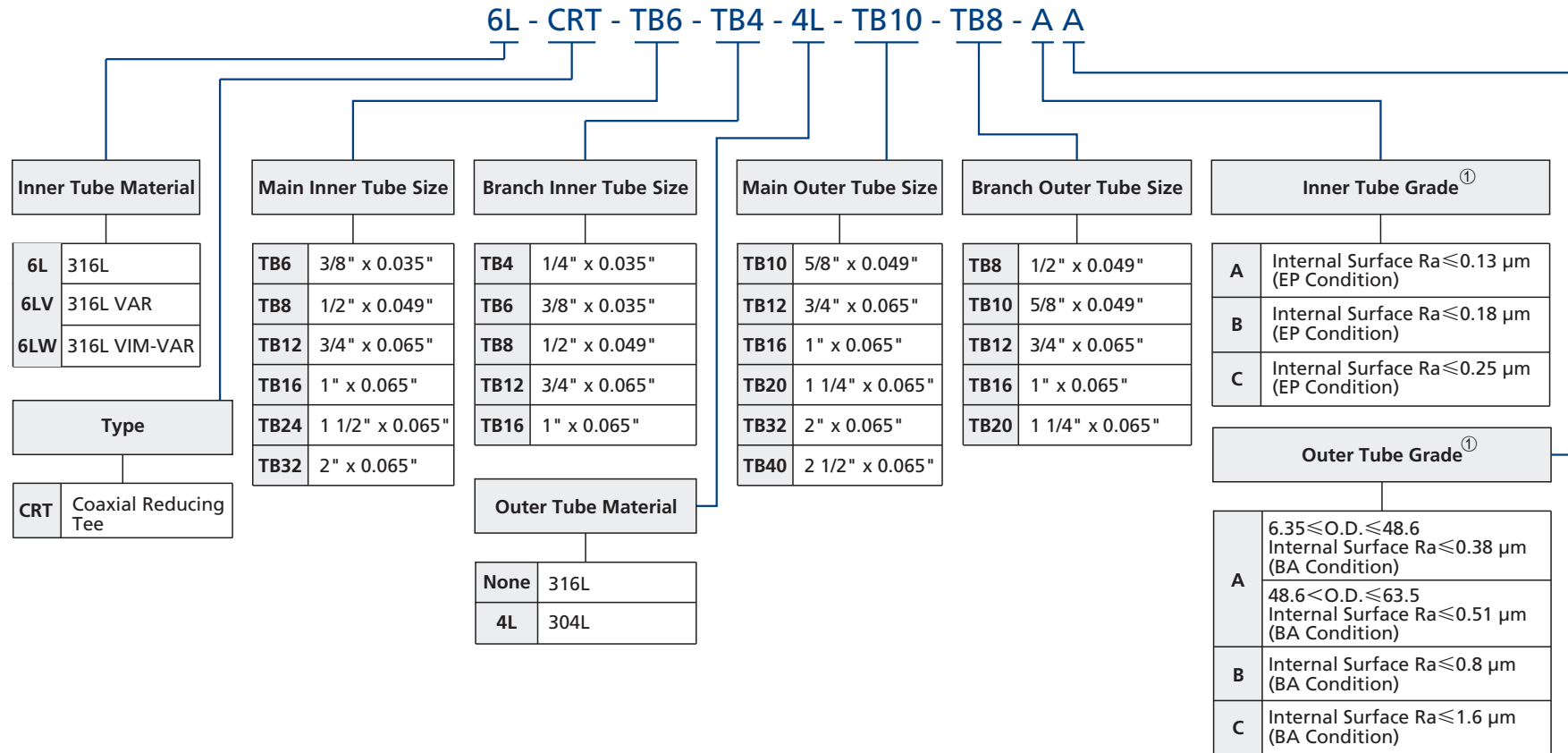
- ⦿ Materials:
 - Inner tube: 316L, 316L VAR, 316L VIM-VAR
 - Outer tube: 316L, 304L
- ⦿ Outside diameter:
 - Inner tube: main inner tube O.D. 3/8" ~ 2", branch inner tube O.D. 1/4" ~ 1"
 - Outer tube: main outer tube O.D. 5/8" ~ 2 1/2", branch outer tube O.D. 1/2" ~ 1 1/4"
- ⦿ Inner tube process: internal surface electropolished to roughness of $Ra \leq 5 \mu\text{in}$ (0.13 μm), $Ra \leq 7 \mu\text{in}$ (0.18 μm), $Ra \leq 10 \mu\text{in}$ (0.25 μm)
- ⦿ Cleaning: ultrasonically cleaned, washed, rinsed, and purged and dried with high purity hot nitrogen in ISO 6 cleanroom
- ⦿ Packaging: packaged in ISO 4 cleanroom, tubing ends are capped and tubing is packed in double polyethylene bags with inner bag filled with 99.999% nitrogen
- ⦿ Marked with brand, material grade and trace number

Ordering Information



Part Number	Inner Tube O.D.1	Inner Tube Wall Thickness T1	Inner Tube O.D.2	Inner Tube Wall Thickness T2	Outer Tube O.D.3	Outer Tube Wall Thickness T3	Outer Tube O.D.4	Outer Tube Wall Thickness T4	A	B	C	D
6L-CRT-TB6-TB4-TB10-TB8	0.375"	0.035"	0.25"	0.035"	0.625"	0.049"	0.5"	0.049"	3.875"	4.125"	1"	1"
6L-CRT-TB8-TB4-TB12-TB8	0.5"	0.049"	0.25"	0.035"	0.75"	0.065"	0.5"	0.049"	3.875"	4.125"	1"	1"
6L-CRT-TB8-TB6-TB12-TB10	0.5"	0.049"	0.375"	0.035"	0.75"	0.065"	0.625"	0.049"	4"	4.125"	1"	1"
6L-CRT-TB12-TB4-TB16-TB8	0.75"	0.065"	0.25"	0.035"	1"	0.065"	0.5"	0.049"	6.125"	4.25"	1.75"	1"
6L-CRT-TB12-TB6-TB16-TB10	0.75"	0.065"	0.375"	0.035"	1"	0.065"	0.625"	0.049"	6.25"	4.25"	1.75"	1"
6L-CRT-TB12-TB8-TB16-TB12	0.75"	0.065"	0.5"	0.049"	1"	0.065"	0.75"	0.065"	6.25"	4.25"	1.75"	1"
6L-CRT-TB16-TB4-TB20-TB8	1"	0.065"	0.25"	0.035"	1.25"	0.065"	0.5"	0.049"	6.125"	4.375"	1.75"	1"
6L-CRT-TB16-TB6-TB20-TB10	1"	0.065"	0.375"	0.035"	1.25"	0.065"	0.625"	0.049"	6.25"	4.375"	1.75"	1"
6L-CRT-TB16-TB8-TB20-TB12	1"	0.065"	0.5"	0.049"	1.25"	0.065"	0.75"	0.065"	6.25"	4.375"	1.75"	1"
6L-CRT-TB16-TB12-TB20-TB16	1"	0.065"	0.75"	0.065"	1.25"	0.065"	1"	0.065"	6.375"	6.625"	1.75"	1.75"
6L-CRT-TB24-TB8-TB32-TB12	1.5"	0.065"	0.5"	0.049"	2"	0.065"	0.75"	0.065"	7"	7"	2"	1.75"
6L-CRT-TB24-TB12-TB32-TB16	1.5"	0.065"	0.75"	0.065"	2"	0.065"	1"	0.065"	7.125"	7"	2"	1.75"
6L-CRT-TB24-TB16-TB32-TB20	1.5"	0.065"	1"	0.065"	2"	0.065"	1.25"	0.065"	7.25"	7"	2"	1.75"
6L-CRT-TB32-TB8-TB40-TB12	2"	0.065"	0.5"	0.049"	2.5"	0.065"	0.75"	0.065"	7.75"	9"	2"	1.75"
6L-CRT-TB32-TB16-TB40-TB20	2"	0.065"	1"	0.065"	2.5"	0.065"	1.25"	0.065"	8"	7.25"	2"	1.75"

Ordering Number Description



① Ra values of the internal and external surfaces at tube circumferential weld area is undefined.

Note: "Ordering Number Description" is a reference to understand the combination rules of FITOK product part number.

Not all combinations are available.