



**Do not attempt to install TruLink tubing and fittings without first reading and understanding this installation flyer and(or) watching the TruLink Installation video.**

**Compressed air is inherently dangerous and installation error can lead to serious injury or death.**

## WARRANTY INFORMATION

Applied System Technologies is proud to announce our Lifetime Warranty program, covering all pipe and fittings for the TruLink compressed air product line. This warranty is possible due to our long history of producing high quality piping systems, continuing our tradition of excellence and customer satisfaction. We are 100% committed to supplying the finest products available to our customers and always do our best to exceed their expectations.

This Lifetime Warranty is a testament to that commitment. Applied System Technologies will continue to be the leader and not the follower in our field. We will continue to develop new and innovative products that revolutionize the compressed air piping industry. The bottom line is that compressed air piping is what we do! That's our product. That's our focus. That's why we are the experts in our field.

To initiate a warranty claim, send an email to [customerservice@appliedsystemtech.com](mailto:customerservice@appliedsystemtech.com). Include contact name, phone number and PO used to purchase product. Please include brief description of product problem. All warranty claims are subject to approval and discretion by manufacturer. Under no circumstances should a warranty repair occur without the express written direction of manufacturer. Manufacturer is not responsible for any warranty costs that are incurred outside of written direction from manufacturer. For additional product information and warranty details, please see our O&M Manual:

(<https://appliedsystemtech.com/wp-content/uploads/2023/11/22-OM-Manual-1.2-.pdf>)



## Trulink 20mm – 63mm Assembly Instructions:



All Tubing 20mm-63mm must be Chamfered and burr-free prior to installation using our Drill Adapter Tool. This tool is designed for optimal Outside diameter Chamfer of the tubing 20mm – 63mm.



TRULINK DRILL ADAPTER TOOL  
(TP-Drill Adapter - DB)

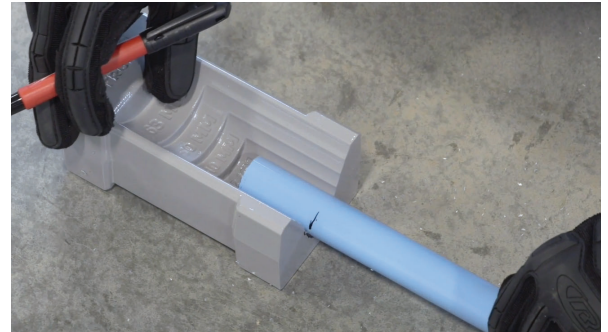
Do not use sandpaper, grinder, file or other devices for chamfering tubing.



Fitting nuts 20mm - 40mm are pre-torqued to factory specifications and should not be removed or additionally tightened. Fitting nuts 50mm and 63mm are shipped loosened for ease of installation and require tightening to complete connection.

Tubing should be marked to indicate full depth of insertion into the fitting prior to installation using our Tube ID / Depth Marking Gauge 20mm – 63mm (TP-Depth Gauge)

Insert the tubing into the fitting keeping the fitting and tubing in straight alignment. ensure tubing is inserted all the way to the Depth Gauge mark.



Drill Adapter Deburring Tool 20mm - 63mm	TP-Drill Adapter - DB
Tube ID/ Depth Marking Gauge 20mm -63mm	TP-Depth Gauge
Wrench set 20mm-63mm (10 Double Ended Wrenches)	TP-Wrench 20-63
Crows Foot Tool 20mm-63mm	TP-Crows Foot 20-63

Fitting nut torque engages the bite ring which ensures hold between fitting and tubing. Nut torque has no affect on sealing. Fitting nuts should be torqued to and not to exceed manufacturer torque specifications.

20mm	50inlbs
25mm	75inlbs
32mm	95inlbs
40mm	100inlbs
50mm	140inlbs
63mm	150inlbs

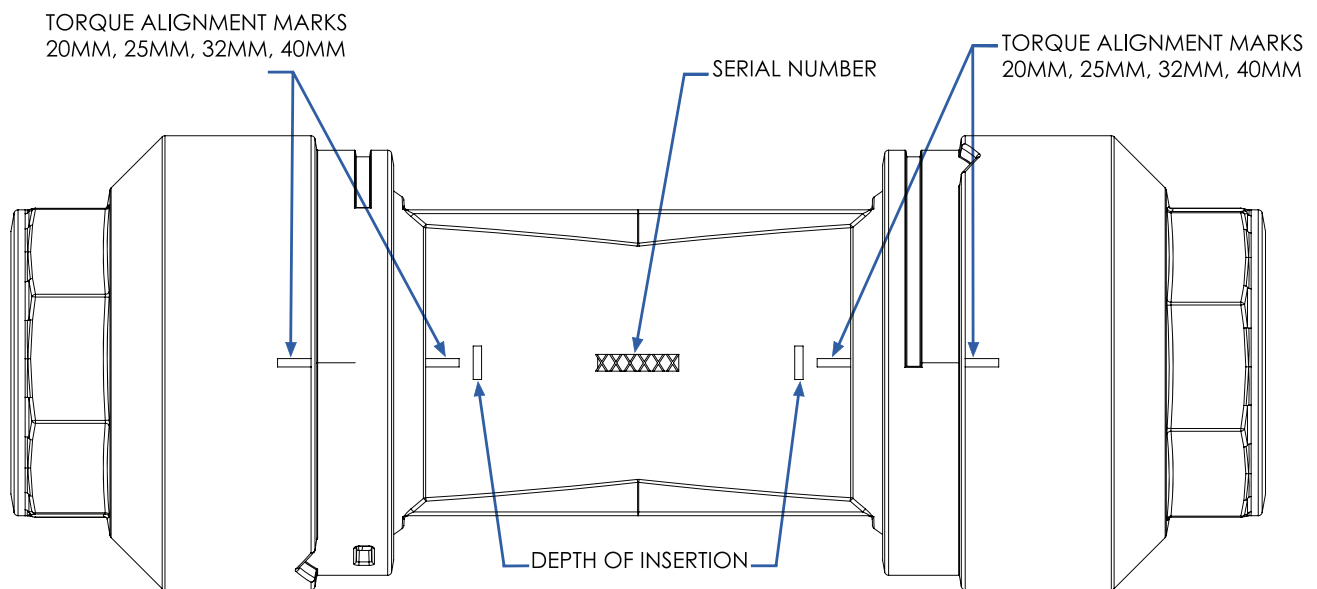
**SCAN HERE**  
to watch the complete  
installation video or visit  
[appliedsystemtech.com/trulink-installation](http://appliedsystemtech.com/trulink-installation)



## LASER MARKS

All pre-torqued fittings 20mm, 25mm, 32mm and 40mm sizes have **Torque Alignment Markings** these markings should align ensuring fitting and nuts are torqued properly. If any pre-torqued fittings are loosed for any reason, they should be retightened during installation making sure the marks on both nut and body are aligned. We do not recommend swapping nuts and bodies as the **Torque Alignment Markings** may no longer align properly.

All fittings 20mm, 25mm, 32mm, 40mm, 50mm and 63mm sizes include an **Insertion Depth Marking** each fitting body. This marking is recommended to be utilized to mark depth on the tubing to ensure full insertion and proper engagement. Additionally, the **Insertion Depth Marking** can be utilized to determine exact tubing lengths required between fittings.



## NPT Threaded Fitting Installation Instructions:

All Trulink piping threads are provided in National Pipe Taper (NPT). Fittings such as Point-of-use Manifolds and Threaded Adapters are the most common.

### *The following instructions will greatly increase your success in the installation of NPT fittings:*

Properly installing NPT fittings start with an application of a high quality liquid thread sealant such as our offered, Jomar White Stuff (Part Number: PC-TC-SEAL-FG), Henkle Loc-tite 567, Rector Seal 5, or any other quality anaerobic thread sealant.



Sealants such as Teflon (PTFE) tape are not recommended as it does not fill the small voids in the NPT connection as thoroughly as liquid Sealants and can become dislodged causing contamination within the air stream. Liquid Sealants also provide lubrication that makes metal thread installation more manageable, and they help prevent galling.



Apply a thin layer of liquid thread sealant to the male threads ensuring that the threads are filled completely. Smooth the sealant around the threads as to leave no voids.



Place manifolds and ball valve kits into a vice to create a solid work platform for tightening the connection without being overly tight which can cause fitting damage. Never put Trulink fitting nuts in a vice. Never tighten NPT connections using the fitting nut. Always use the wrench flats provided on the fitting body for tightening NPT connections.

**Reminder: We strongly recommend vice/bench building all manifolds and ball valve kits, prior to system installation to prevent damage at the final installation location.**

Finger or hand tighten the Male NPT connection then apply torque to complete wrench tight. Wrench tight will vary depending on the size of the connection. A simple rule of thumb for installing NPT thread is finger tight plus 2-3 turns with a wrench. Be cautious of over tightening NPT connections, especially in smaller sizes. Never back off an installed fitting to get the correct alignment. Loosening installed NPT fittings disrupts the sealant, which causes leaking.

NPT taper can also act as a wedge. It is relatively easy to over tighten and permanently distort threads or even split or crack a female connection. Instead of torque measurement, it is hand tight plus the proper wrench tight engagement that produces a good, leak-proof connection.

**Note: Do not use torque as a reference for installing NPT threaded components because there will always be variations in fitting manufacturers.**

## ***Reusing NPT threaded fittings:***

Thoroughly inspect NPT fitting threads for possible damage before reusing them. Reusing NPT threads is not generally recommended because of possible permanent thread deformation created by over tightening during installation. NPT threads can also be damaged from repeated assembly and disassembly, making their reuse impractical. A general guideline is to replace NPT threaded fittings after two to three uses. Aluminum, Brass and Stainless-Steel fittings are not recommended for use more than once as they are more susceptible to deformation.

## ***Finished NPT threaded connection leaking?***

Depressurize the system, remove the fitting, clean off thread sealant, inspect thread for damage and reapply new sealant. Return to finger tight and then complete to wrench tight. Continuing to tighten rarely increases the sealing properties once pressure has been applied. Additional tightening can cause damage.