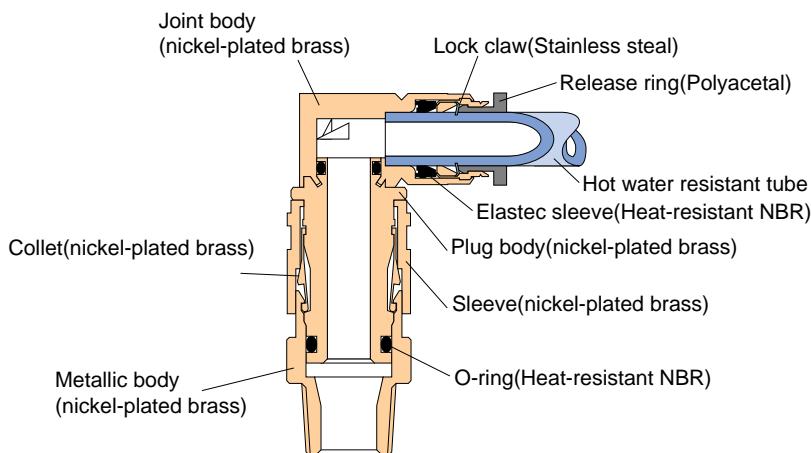


Quick-fitting Type Temperature Control Joint Die Temperature Control Fitting

Features

- The Die Temperature Control Fitting can be used with thermal oil, clear water or air.
- Prepare the molding die according to the thread size, bury the threaded part in the die, using an Allen wrench, and then just fit in the joint part.
- Push the release sleeve and remove the joint part, then you see no projection on the die.
- The built-in stop valve type will effectively prevent hot water from spilling out at connection or disconnection of the joint.

Construction



Specification

Fluid admitted	Air	Clean water (conditional)	Thermal oil
Service pressure range	0~150 psi (0~0.9MPa)	0~43 Psi (0~0.3MPa)	0~43 psi (0~0.3MPa)
Service temperature range	32~140°F (0~60°C)	32~210°F (0~99°C)	32~248°F (0~120°C)

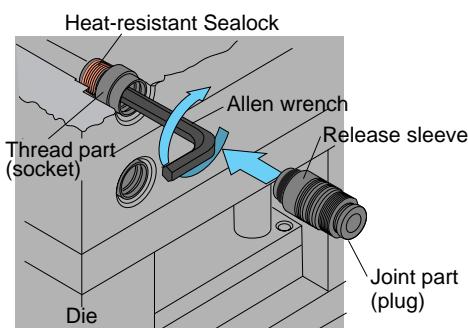
⚠ Warning

**Conditions of Water (when used) 1.No water hammer is allowed.

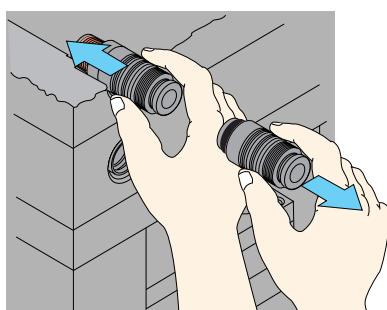
2.Be sure to install the insert ring.

**The above conditions apply to the case where a WA or WB tube is used.

Connection and Disconnection



Connection



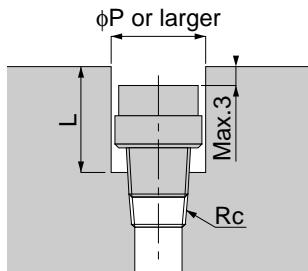
Disconnection

(1) Prepare a socket receiving hole in the molding die according to the thread size (see the socket mounting dimensions on page 97). Bury the threaded part(socket) in the die, using an Allen wrench.

(2) Simply insert the joint part(plug) in the socket for connection of the Fitting.

(3) For disconnection, pull out the joint part(plug) while pushing the release sleeve till it comes in contact with the support of the threaded part(socket). Without any projection on the die, you can handle the molding die with much ease. Also, the built-in stop valve assures safety in your operation by preventing hot water on the joint side from spilling when the Fitting is disconnected.

Socket Mounting Dimensions



Caution

See the values specified in the table below, and prepare a socket hole in the molding die as shown at left.

unit:mm

Model code	Rc	L	φP
AK 08-01S	Rc1/8	14.5	15
AK 08-02S	Rc1/4	14	
AK(S) 10-01S	Rc1/8		
AK(S) 10-02S	Rc1/4	17	18
AK(S) 10-03S	Rc3/8	16.5	
AK 10-04S	Rc1/2	18	22

**"S" represents the type with a built-in stop valve.

Model Disignation(Example)

AK C 08

(1)Type

AK : Die temperature Control fitting

AS : Die temperature Control fitting with built-in stop valve

(2)Type of Joint part

C : Straight

L : Elbow

*No code for threaded part only.

(3)Connection size

08 : 08 Series

10 : 10 Series

*08 series and 10 series are not interchangeable in connection.

(4)Thread size

(5)Joint Shape

F : Female

B : Hose barb

*No entry for quick-joint fitting

(6)Name of part(no Code for set) or thread size

P : Plug

S : socket

Taper pipe thread		
Code	01	02
Size	R1/8	R1/4
American standard Taper pipe thread		
Code	N1	N2
Size	NPT 1/8	NPT 1/4
Code	03	N3
Size	R3/8	NPT 3/8

(7)Hexagon flat-to-flat specification

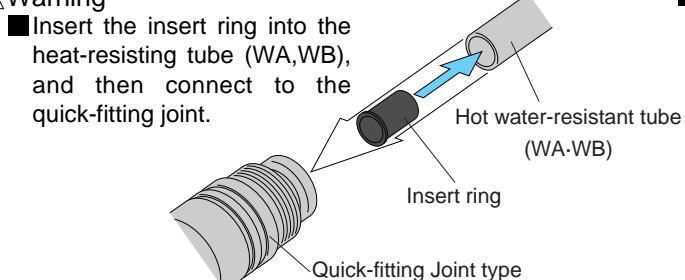
U: Hexagon flat-to-flat inch spec. (NPT)

No code: Hexagon flat-to-flat mm spec.

Usage

Quick-Fitting Joint Type

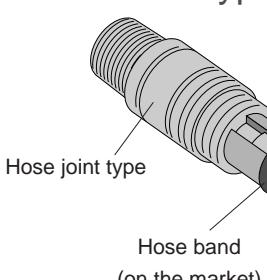
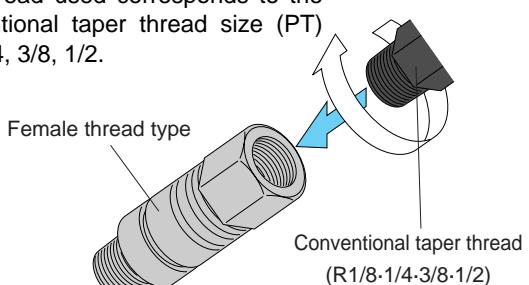
⚠ Warning



Hose barb type

Female thread type

■The thread used corresponds to the conventional taper thread size (PT) 1/8, 1/4, 3/8, 1/2.



⚠ Warning

■Use a heat-resistant tube of 6.8mm bore for ASC 10-ID06B □, and a heat-resistant tube of 9.5mm bore for ASC10-ID09B □. Also, use a hose band available on the market to prevent the tube from coming off.

Detailed safety Instructions

Before using the PISCO device, be sure to read the "Safety Instructions", "Common Safety Instructions for Products Listed in This Manual" on page 23~24 and "Common Safety Instructions for Quick-Fitting Joint" on pages 29~31.

Warning

1. Before releasing the plug, make certain that the pressure inside the tube is zero and that the temperature of water or thermal oil has dropped below 30°C(86°F). Releasing at pressures above zero or with the water or thermal oil hotter than 30°C(86°F) may cause the plug to fly out, thus inflicting injuries or burns on you.
2. Never touch the sleeve on the plug when it is under pressure. Touching may release the plug.
3. When fitting the plug to the threaded part, make sure that it is driven fully into the part. Imperfect fitting may result in the falling out of the plug. After installation, pull the plug lightly toward you to make certain that it does not come off.
4. Use the WB tube with water and the WA tube with water and thermal oil. Be sure to use an insert ring on WA and WB tubes. Failure to do so may result in the coming off of the tube or leakage.
5. With hose joints, use a heat-resistant hose of 6.3mm(0.25in.) inside diameter for ID06 size and one of 9.5mm(0.37in.) for ID09 size. Use of hoses of other sizes may result in the inability to connect, the coming off of the hose or leaks.

Insert the hose joint completely to the end of barb and fasten it with a commercially available hose band. Imperfect connection or failure to use the hose band may lead to the coming off of the hose or leaks.

Caution

1. When the threaded part is buried in the molding die, make sure that the top surface of the threaded part is a maximum of 3mm(0.12in.) from the face of the die. If the distance is allowed to be more than 3mm(0.12in.), it will sometimes be difficult or impossible to remove the plug.

**See the socket mounting dimensions.