

General Description: Parker UHP products are designed as leak-free components for applications where ultra-high pure applications are required. MiniButtweld™ fittings provide compact ultra-high pure designs for use with orbital weld equipment. Their unique machining and surface enhancement prevent outgassing and inhibit corrosion.

- Features:**
- 316L VIM/VAR Material
 - Permanently Heat Code marked; traceable to original mill certificate of test.
 - Electropolished components permanently marked with designator on cube (PE).
 - Critical surfaces are 100% visually inspected using magnification and lighting.
 - Material composition printed on bag.

MiniButtweld™ FITTINGS

SPECIFICATIONS:

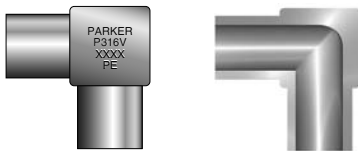
- **Pressure Ratings** will be governed by the tubing selected for a particular application. Working Pressures are calculated below for tubing using maximum allowable stress levels in accordance with ASME/ANSI B31.3, at ambient temperature.
- **Dimensions** are for reference only and are subject to change.

Tube O.D.	Pressure Rating (psig)	Normal Wall Thickness
1/8 in.	8500	.028 in.
1/4 in.	5100	.035 in.
3/8 in.	3300	.035 in.
1/2 in.	3500	.049 in.
6mm	6600	1mm

- **Internal Surface Finishes:** Standard finish MiniButtweld™ fittings have an internal Surface Roughness of 15 µinch Ra. Electropolished (PE) MiniButtweld™ fittings have an internal Surface Roughness of 5µinch Ra.
- **Cleaning and Packaging:** Ultra-High Purity 'OMEGA' cleaning and packaging in a Class 100 Clean Room environment validated per Federal Standard 209E, is standard for all electropolished components.

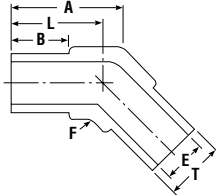
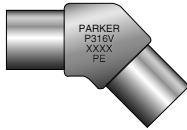
MATERIALS:

- 316L VIM/VAR Material complies with ASTM A276 and ASME SA479. Recommended tubing specifications include ASME SA213, ASTM A213, ASTM A249, ASTM A269, MIL T8504, and MIL T8506.



MiniButtweld™ FITTINGS

45° UNION ELBOW



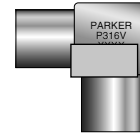
T Tube O.D.	Part No.	A (in.)	B (in.)	E (in.)	F Body Cube	L (in.)
1/4	4-4 MVM-SSV .035	0.47	0.25	0.18	5/16	0.41
3/8	6-6 MVM-SSV .035	0.56	0.25	0.31	7/16	0.47
1/2	8-8 MVM-SSV .049	0.64	0.25	0.40	9/16	0.53

HOW TO ORDER



Example: If your system requires an electropolished 90° Elbow orbital tube weld fitting connecting from 1/4" O.D. tubing to 1/4" O.D. tubing, .035" wall thickness, you would order the following part:

4 - 4 - MEM - SSV .035 - PE
Size **Type** **Material** **Wall Thickness** **Electropolished 5 µinch Ra**



Size: Tube sizes are designated by the number of sixteenths of an inch. (i.e. 1/4" O.D. tube=4/16"=4) Metric Tube O.D. is designated in millimeters and prefixed by "M". (i.e. 6M-6M MEM-SSV)

Type: Designates shape of component: H=Union, E=90° Elbow, V= 45° Elbow, J=Tee, K=Cross, OJ=Tribow.

Material: 316L VIM/VAR Stainless Steel. High-purity Nickel and Hastelloy C-22® available upon request.

Wall Thickness: Fittings must be specified to match tube wall thicknesses.

Hastelloy C-22® is a registered trademark of Haynes International, Inc.