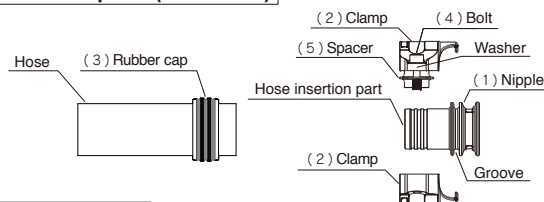


**Be sure to read this manual before using the connector.**

**Warning:** A potentially hazardous situation which could result in death or serious injury.

This is an explanation of the "correct use" of TOYOCONNECTOR. Similar to individually sold hoses, please be aware of the restriction on use and follow the warnings below. Failure to observe these could result in injury or property damage.

**Names of parts ( materials )**



- Materials**
- ( 1 ) Nipple : SCS16 ( SUS316L equivalent )
  - ( 2 ) Clamp : SCS14 ( SUS316 equivalent )
  - ( 3 ) Rubber cap : EPDM
  - ( 4 ) Bolt : SUSXM7 ( SUS304 equivalent )
  - ( 5 ) Spacer : Polyacetal
- Washer ( TC6-F50 only ) : Polyacetal  
 Lubricant of the bolt screw portion : NSF " H1 " registered grease

**Before fitting**

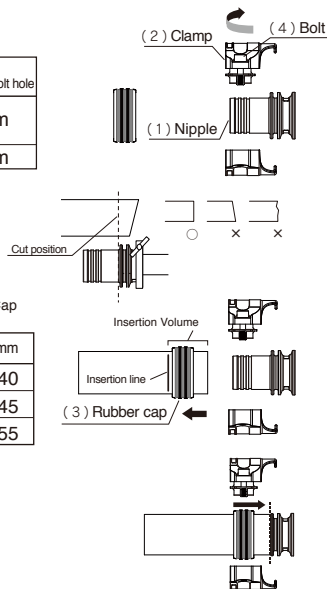
- Note** This connector should not be disassembled for cleaning on a daily basis.
  - Warning** When replacing a hose or disassembling a joint, wait until the joint is cooled down to the room temperature. If not, you may get burned or the joint may get damaged.
1. When cutting a hose, please make sure that the edge face of the hose will become square-on.
  2. If there are any loose strings or hard wires coming out from the end of the hose, be sure to remove such with nippers, etc. Take care such that the hose scraps, loose strings, or hard wires do not enter the hose.
  3. Be sure to have a sufficient hose length so as not to apply a hose bending stress around a coupling.
  4. Make sure that the hose is inserted completely into the root of the hose insertion part.
  5. **Warning** When inserting hoses into TOYOCONNECTOR, never put grease on the surface of the hose insertion part. It would be a cause of hose being pulled out.
  6. Fasten the clamp after confirming the direction of each component.
  7. Be careful of injuries caused by tools slipping during the fastening process.
  8. Be sure to use a " hex wrench " that is at least 180mm long to fasten the bolts ( at least 200mm long for TC6-F50 ). Fasten the 2 bolts evenly while alternating and fasten these until there are no gaps. When used in a state where there are gaps, trouble due to leaked fluids and detached hoses will occur. Refrain from using an impact driver when fastening the bolts. Doing so may damage the screws of the clamp.
  9. **Note** Complete fastening cannot be achieved with uneven fastening.
  9. **Note** A lubricant ( Extreme pressure grease ) registered with NSF " H1 " approved for use in areas that may accidentally come into contact with food " is applied to the screw portion of the clamp of TC6-F.
  10. **Note** When fastening the unit, there rarely may be cases when resin or metal dust ( or stringy shavings ) is generated. Be sure to remove such prior to use.

**How to attach a hose** ※ The same mounting instruction applies to all hoses.

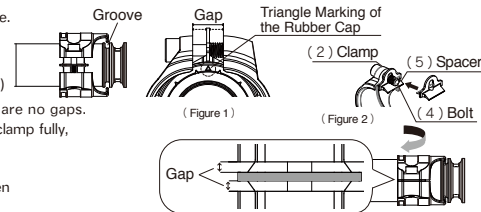
1. Loosen the ( 4 ) bolt and remove the ( 2 ) clamp from the ( 1 ) nipple.
2. Fix the ( 1 ) nipple onto the pipe to which it will be attached. Next, while adjusting the length of the hose, cut the end of the hose vertically. Take care such that the tensile element of the hose is not applied.
3. Remove the ( 1 ) nipple from the pipe and perform the assembly. Place the ( 3 ) rubber cap over the hose. By marking a line in advance on the hose according to the " Appropriate Rubber Cap Insertion Volume " table on the right, it will be possible to appropriately align the position of the rubber cap.
4. Insert the hose equipped with the ( 3 ) rubber cap into the base of the hose opening of the hose insertion part.

TOYOCONNECTOR Code	Size of hexagonal bolt hole
TC6-F32	6mm
TC6-F38	
TC6-F50	8mm

TOYOCONNECTOR Code	mm
TC6-F32	40
TC6-F38	45
TC6-F50	55



5. Provisionally assemble the ( 2 ) clamp in line with the grooves on the ( 1 ) nipple. Adjust the triangle marking of the rubber cap to be positioned in the center of the gap. ( Figure 1 )  
 ※ If the spacer has fallen off of the ( 4 ) bolt, provisionally assemble the ( 2 ) clamp after attaching the ( 5 ) spacer onto the ( 4 ) bolt. ( Figure 2 )
6. Fasten the 2 ( 4 ) bolts evenly while alternating and fasten these until there are no gaps. If there is any gap between the clamp components and you cannot fasten the clamp fully, leave the unit for a while and tighten the clamp again until there is no gap left.



**Notes for use**

- Note** Complete fastening cannot be achieved with uneven fastening.
  - Note** Be sure to use a " hex wrench " that is at least 180mm long to fasten the bolts ( at least 200mm long for TC6-F50 ).
  - Note** When fastening the unit, there rarely may be cases when resin or metal dust ( or stringy shavings ) is generated.
7. Fasten the hose to the pipe using a commercially available sanitary clamp. Mount the hose onto the pipe, making sure that the hose is not twisted.
  8. **Note** Clean the inside of the pipe without a failure ( every time after a pipe is connected. )

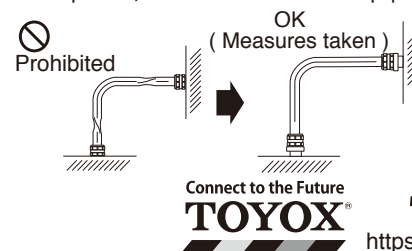
**Notes for Connector Reuse and Hose Replacement**

1. When reusing a TOYOCONNECTOR product, make sure that each of its components are not damaged prior to use. Be sure to replace the rubber cap. Please be sure to fasten the bolts after applying a commercially available lubricant ( Extreme pressure grease ) to the screw portions of the bolts and the clamp. Use of a lubricant ( Extreme pressure grease ) registered with NSF " H1 " approved for use in areas that may accidentally come into contact with food " is recommended.
2. Before replacing a hose, always make sure to remove the fluid and dirt on the connector surface. Fluid and dirt remaining on connector may possibly cause fluid leakage and hose loosening.
3. Please make sure to use a brand-new hose.
4. Although this may differ depending on conditions of use, replace the unit with components or a new clamp set after it has been removed approximately 5 times.
5. Do not hit the joint with a hammer or some other tools.

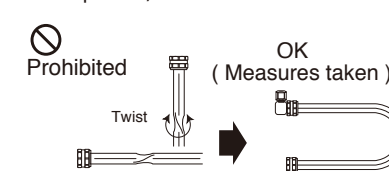
**Warning**

1. The material used for the TOYOCONNECTOR flow pass ( inner surface ) is SCS16 ( SUS316L equivalent ) . Phenomena such as corrosion or fluid leaks may occur depending on the type of fluid. Before use, be sure to check data ( refer to data on chemical resistance on the homepage ) . Please also make similar checks for fluid contact with the outer surface of joints.
2. Do not use hoses when they are twisted. Partially twisted hoses are also a danger as they may cause internal structural damage leading to a " Burst ". Follow the examples below to take preventative measures.

**Example 1 ) Twisted hose while piping**



**Example 2 ) Twist when bent**



**TOYOX CO., LTD.**

<https://www.toyox.co.jp> ISO 14001 certified