



## How to Service a Broken Toneable Duct Rod Female Fitting

Use appropriate fitting kit:

email: [info@gmptools.com](mailto:info@gmptools.com)

tele: +1.215.357.5500

3/8" Female End Fitting Toneable, # 88414    1/2" Female End Fitting Toneable, # 88416

**▲ IMPORTANT** - Avoid contact with skin and eyes. For skin, wash affected area with soap and water. Do not take internally. If taken internally seek medical attention immediately. If in contact with eyes, flush, with plenty of water. Use with adequate ventilation. Consult Material Safety Data Sheet for more information at [http://www.gmptools.com/pdf/DB\\_AB.pdf](http://www.gmptools.com/pdf/DB_AB.pdf)

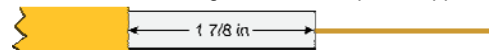
1. Cut-off, squarely, broken rod end with a fine tooth hacksaw.

2. Mark 4" from end of rod. Carefully cut cover circumferentially at mark and remove cover.



▲ Important: Do Not Cut into Surface of Fiberglass

3. Remove 2" of fiberglass core to expose copper wire, without damaging copper wire.



4. Create a flat on the fiberglass core approximately 1/32" deep (a little less than thickness of wire).



Fold back wire onto flat.

5. Test fitting. It must be snug with no play to maintain proper contact. If too loose, cut off and start over



Verify 2 - 15 ohm continuity between fittings.

6. Remove the ferrule and roughen fiberglass with sandpaper. Clean the rod end with cleaning solvent

7. Mix epoxy: **a)** fold **b)** cut **c)** squeeze **d)** mix thoroughly. Place 2/3 on rod and 1/3 in coupling

8. Insert rod into coupling and rotate. Remove excess epoxy. (working time is 3 - 5 minutes @ 70°)

9. Check continuity. If no continuity, remove ferrule, clean off adhesive and repeat the above steps

10. Full physical properties aren't developed for at least 24 hours at room temperature.

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