Swagelok

Tube Fitting Installation and Reassembly Safety Instructions

Up to 1 in./25 mm

These instructions apply both to traditional fittings and to fittings with the advanced back-ferrule geometry.

Fully insert the tube into the fitting and against the shoulder, rotate the nut finger-tight. High-pressure applications

and high safety factor systems: further tighten the nut until the tube will not turn by hand or move aduly in the fitting.







Over 1 in./25 mm

- Preswage the ferrules onto the tube using a Swagetok multi-head hydraulic swaging unit (MHSU).
- Apply the lubricant packaged with the fitting lightly to the body threads and the rear surface of the back femule.
- Insert the tube with preswaged ferrules into the fitting until the front ferrule seats against the fitting body; rotate the nut finger-tight.
- 4. Mark the nut at the 6 o'clock position.
- While holding the fitting body steady, fighten the nut one-half turn to the IZ o'clock position.

Use the Swagelok MHSU gap inspection gauge to ensure that the fitting has been tightened sufficiently.

Gaugeobility

On initial installation, the Swagelok gap inspection gauge assures the installer or inspector that a fitting has been sufficiently tightened.

Position the Swegelok gap inspection gauge next to the gap between the nut and body.



If the gauge will not enter the gap, the fitting is sufficiently tightened. If the gauge will enter the gap, additional tightening is required.

Always depressurize a system before adjusting the tightness of a tube fitting connection.

Reassembly-All Sizes

You may disassemble and reassemble Swagelok tube fittings many times.

Always depressurize the system before disassembling a Swagelok tube fitting.

Prior to disassembly, mark the tube at the back of the nut mark a line along the nut and fitting body flats.

Us a these marks to ensure that you return the nut to the previously pulled-up position.



insert the tube with preswaged ferrules into the fitting until the front ferrule seats against the fitting body.

Over 1 in./28 mm sizes: if needed, reapply lubricant lightly to the body threads and the rear surface of the back famile.



While holding the fitting body steady, rotate the nut with a wrench to the previously pulled-up position, as indicated by the marks on the tube and flats. At this point, you will feel a significant increase in resistance. Tighten the nut slightly.



 Do not use the Swagelok gap inspection gauge with reassembled fittings.



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F. J. Callahan

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