



## 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 axially in the fitting.



Mark the nut at the 6 o'clock position.



While holding the fitting body steady, tighten the nut one and one-quarter turns to the 9 o'clock position. For 1/16, 1/8, and 3/16 in., 2, 3, and 4 mm tube fittings, tighten the nut three-quarters turn to the 3 o'clock position.



### Over 1 in./25 mm

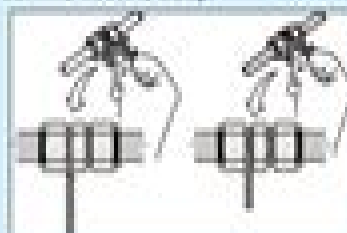
1. Preswage the ferrules onto the tube using a Swagelok multi-head hydraulic swaging unit (MHU).
2. Apply the lubricant packaged with the fitting lightly to the body threads and the rear surface of the back ferrule.
3. Insert the tube with preswaged ferrules into the fitting until the front ferrule seats against the fitting body; rotate the nut finger-tight.
4. Mark the nut at the 6 o'clock position.
5. While holding the fitting body steady, tighten the nut one-half turn to the 12 o'clock position.

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

### Gaugeability

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

Position the Swagelok 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.

Use 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./25 mm sizes:**

If needed, reapply lubricant lightly to the body threads and the rear surface of the back ferrule.



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.



# Swagelok Tube Fitting And Installation Manual

**United States. Food and Drug  
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