

Installation instructions for Swagelok tube fittings

Safety Precautions

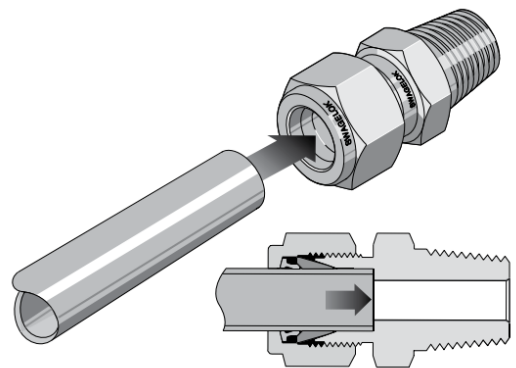
- Do not bleed system by loosening fitting nut or fitting plug.
- Do not assemble and tighten fittings when system is pressurized.
- Make sure that the tubing rests firmly on the shoulder of the tube fitting body before tightening the nut.
- Use the correct Swagelok gap inspection gauge to ensure sufficient pull-up upon initial installation.
- Always use proper thread sealants on tapered pipe threads.
- Do not mix materials or fitting components from various manufacturers – tubing, ferrules, nuts and fitting bodies.
- Never turn fitting body. Instead, hold fitting body and turn nut.
- Avoid unnecessary disassembly of unused fittings.
- Use long reducers in female Swagelok connections.

Up to 1 in./25mm

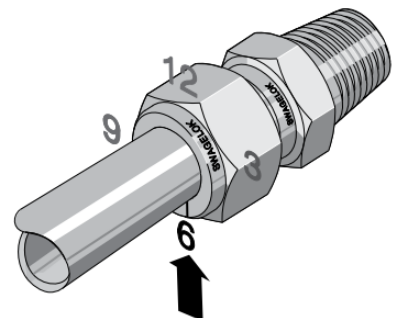
Fully insert the tube into the fitting and against the shoulder, rotate the nut finger-tight.

High-pressure applications and high safety-factor:

Further tighten the nut until the tube will not turn by hand or move axially in the fitting.

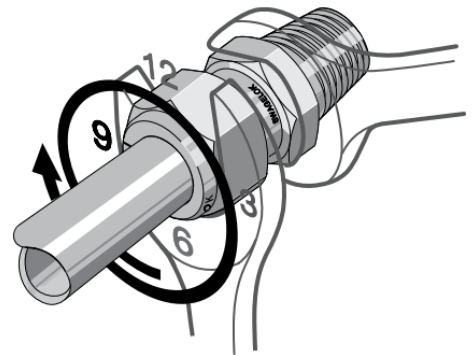


Mark the nut at the 6 o'clock position.



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.



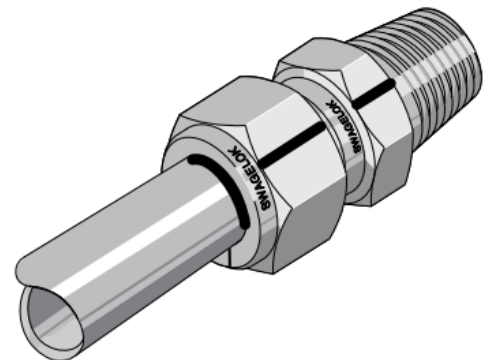
Reassembly – All Sizes

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.

