

## TS Series Sanitary Fitting Installation and Assembly Instructions

for use with 2 1/2 in. and larger PTFE Gaskets

**WELDING CAUTION:** Excess heat may alter the ferrule shape and affect seal integrity. Please contact your Swagelok representative for additional information on recommended welding practices.

Swagelok TS ferrules are recommended for use only with Swagelok TS gaskets.



1. If using two TS series ferrules...



2. Place TS series gasket in groove on either ferrule.



3. Press ferrules together so the gasket is seated in both ferrules.

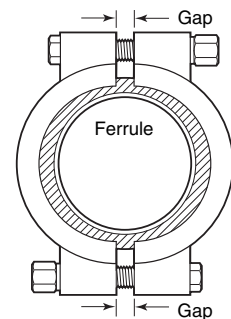


Fig. 1: End View

4. Install a high-pressure two-bolt clamp (AJC13HP) and finger-tighten both bolts (see Fig. 1).

**⚠ The gap must be greater than 0.25 in. (6.4 mm) on both sides when the bolts are finger-tight. Otherwise, leakage may occur after the bolts are fully tightened. Use another high-pressure clamp if this finger-tight gap is less than 0.25 in. (6.4 mm). See page 7 of the *Stainless Steel Components for the Liquid Flow Industries* catalog for the required torque values for the bolts.**

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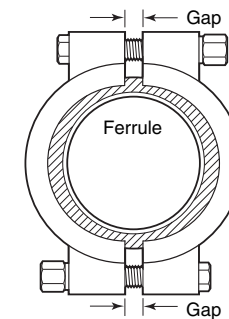


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