

Fig. 1

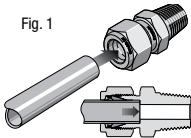


Fig. 2

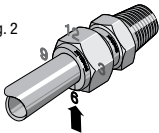


Fig. 3



Installation Instructions

1 in. (25 mm) and smaller

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

1. Fully insert the tube into the fitting and against the shoulder; rotate the nut finger-tight. *Fig. 1.*

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.

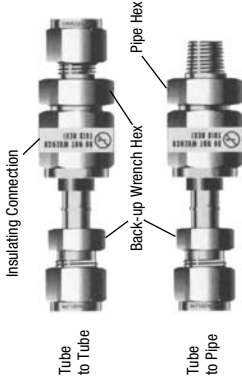
2. Mark the nut at the 6 o'clock position. *Fig. 2.*
3. While holding the fitting body steady, tighten the nut one and one-quarter turns to the 9 o'clock position. *Fig. 3.*

Note: 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.

Gaugeability

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

Swagelok® Dielectric Fittings



Installation Instructions Tube Connections

Follow the Swagelok tube fitting installation instructions on reverse side. A back-up wrench must be used on the wrench hex nearest the connection being installed. Keep the back-up wrench stationary.

Tube to Pipe

Apply pipe sealant to male threads and *install pipe thread end first*. Use the *pipe hex* to tighten pipe connection. Install the tube connection following the tube fitting installation instructions on reverse side.

⚠ CAUTION

The insulating connection must not be loosened or used as a disconnection point. All connections must be done as stated in the installation instructions.