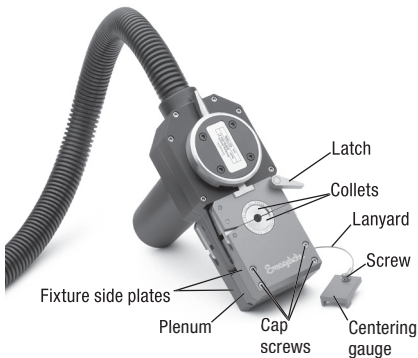


Swagelok

Series 5, 10, and 20 Weld Head Tube Fixture Block

Attaching Centering Gauge to Plenum

1. Attach a **screw** (#4-40 UNC), a lock washer, and one end of the **lanyard** to the side of the **plenum** with the tapped hole.
2. Use a **screw** (#4-40 UNC) and lock washer to attach the **centering gauge** to the other end of the **lanyard**.





Series 5, 10, and 20 Weld Head Tube Fixture Block

Alignment Adjustment Instructions

1. Loosen the four **cap screws** on the **fixture side plate** pointed to by the arrows on the **plenum**.
2. Place a minimum length of tubing in the **collets** so it rests across both side plates.

Weld Head Series	Minimum Tubing Length, in. (mm)
Series 5	1.50 (38.1)
Series 10	2.00 (50.8)
Series 20	3.00 (76.2)

3. Lock down the stationary **fixture side plate** and then the loosened **fixture side plate** using the **latches** at the top of the fixture side plates.
4. Tighten the four **cap screws** loosened in step 1.
5. Release the latching mechanism, and remove the straight length of tubing.