



Swagelok Tube Fitting Instructions

Installation Instructions:



1. Insert tubing into the Swagelok tube fitting. Make sure that the **tubing rests firmly on the shoulder of the tube fitting body** and that the **nut is finger-tight**.



2. Scribe the nut at the 6 o'clock position.



3. While holding fitting body steady with a back-up wrench, tighten the nut 1 1/4 turns to the 9 o'clock position.

Note: For 1/16, 1/8, and 3/16 in.; 2, 3, and 4 mm tube fittings, tighten the nut 3/4 turn to the 3 o'clock position.



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

Position the Swagelok gap inspection gage next to the gap between the nut and body.

- If the gage **will not** enter the gap, the **fitting is sufficiently tightened**.
- If the gage **will** enter the gap, **additional tightening is required**.

Reassembly Instructions—You may disassemble and reassemble a Swagelok tube fitting many times.

1. Insert tubing with pre-swaged ferrules into the fitting body until the front ferrule seats.
2. Rotate the nut with a wrench to the previously pulled-up position, at this point a significant increase in resistance will be encountered.
3. Tighten slightly with a wrench (approximately a quarter turn).

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