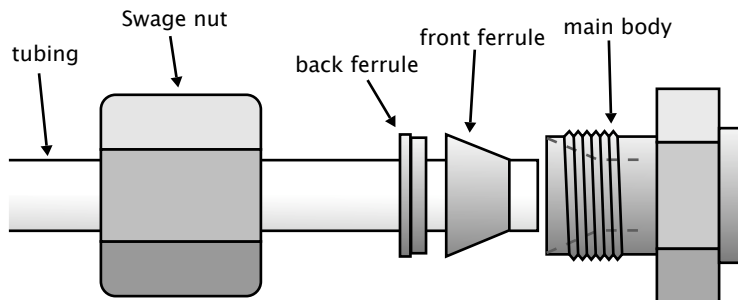


# Swagelok™ instructions (for metal ferrules)

When assembled correctly, Swagelok™ fittings form a leak tight seal and can be re-tightened many times. The position of the ferrule sets must be correct for the Swagelok™ fitting to work properly. The front ferrule must be placed such that the cone shape fits into the main body. Behind the front ferrule is the back ferrule; the small-ridged side needs to go against the front ferrule as shown. Following the ferrules is the Swagelok™ nut.



## Step 1

Simply insert the tubing into the Swagelok™ Tube Fitting. Make sure that the tubing rests firmly on the inner shoulder of the fitting and that the nut is finger-tight.

## Step 2

Before tightening the Swagelok™ nut, scribe the nut at the 6 o'clock position.

## Step 3

Hold the fitting body steady with a back-up wrench and tighten the nut 1-1/4 turns. Watch the scribe mark make one complete revolution and continue to the 9 o'clock position. By scribing the nut at the 6 o'clock position as it appears to you, there will be no doubt as to the starting position.

This procedure will permanently “swage” on the new ferrule set. This only needs to be done with new ferrules. Once “swaged” the assembly can be taken apart and re-sealed many times. Generally to re-seal a previously “swaged” fitting, the nut should be turned about 1/8 past finger tight. If leaking occurs, slowly tighten the nut past the 1/8 turn only as far as needed to achieve a leak free seal.