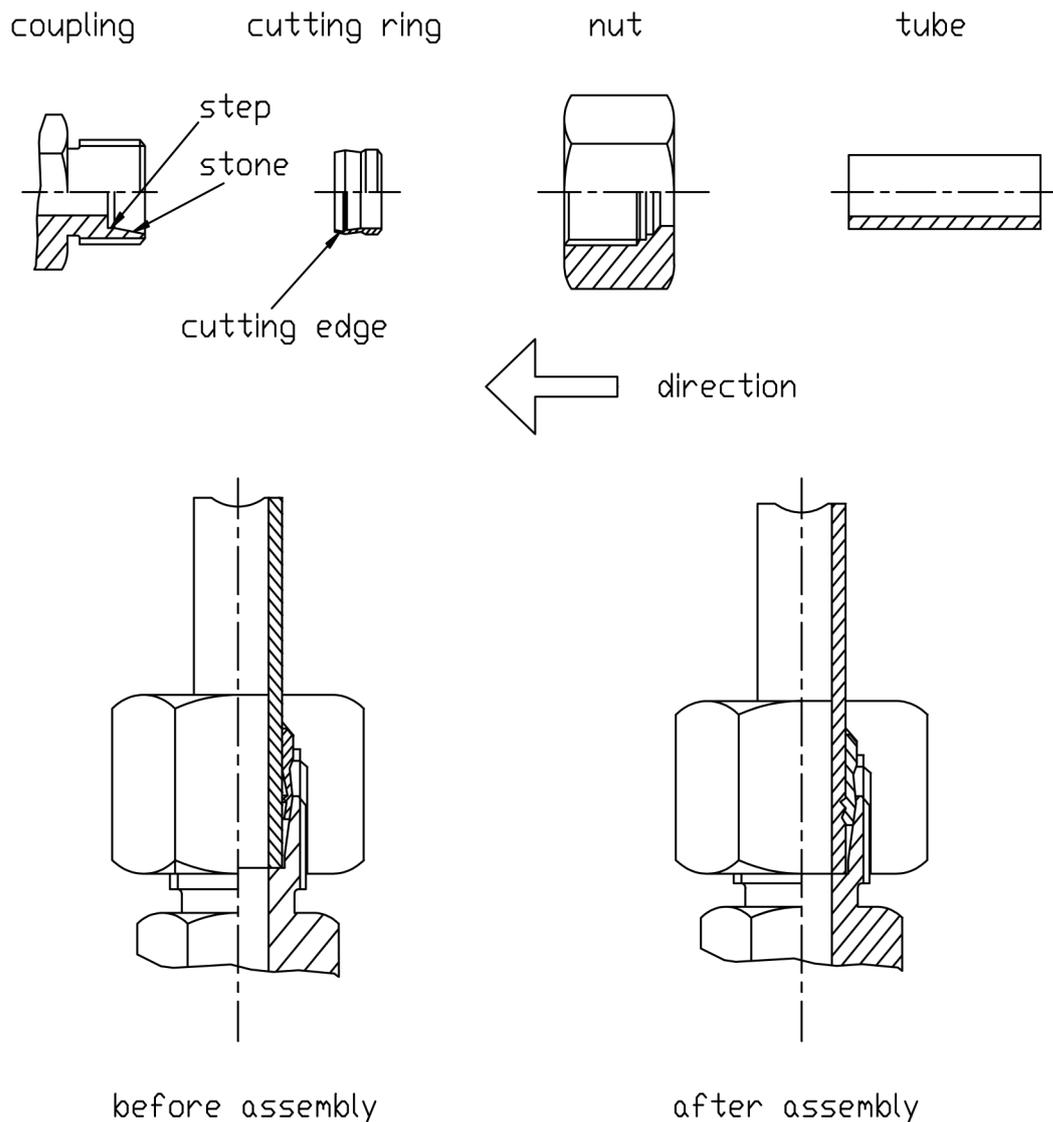


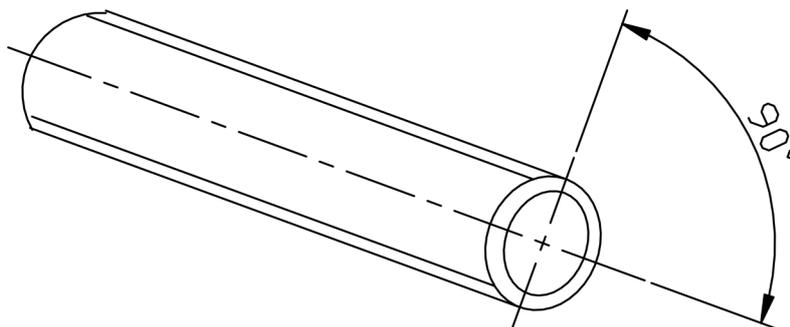
Assembly Instructions

- 1) Cut the tube square (do not use a roll cutter) and deburr the end of the tube inside and out.
- 2) Fittings should always be lubricated, pre-assembled in a vice and a hardened pre-installation body used when assembling several fittings.
- 3) Lubricate the nut, cutting ring (ferrule) and body cone.
- 4) Place the nut and cutting ring on the tube. The thicker end of the cutting ring must face the nut.
- 5) Put the tube, nut and cutting ring onto the body of the fitting. The tube should butt firmly onto the step in the body.
- 6) Tighten the nut by hand as much as possible, then mark the tube and nut.
- 7) Hold the tube in one hand and with the correct size spanner, tighten the nut until the cutting ring is felt to grip the tube. The nut should then be tightened for another 1 to 1-1/2 turns. The tube should not be able to rotate. Large size fittings will need an extension to the spanner.
- 8) Loosen the nut and check assembly. The cutting ring will have cut into the tube and sit flush on the whole circumference. The cutting ring can turn but should not be able to move backwards or forwards.
- 9) Finally, re-assemble the fittings with a spanner and apply about another 1/16 turn after reaching the tight position.

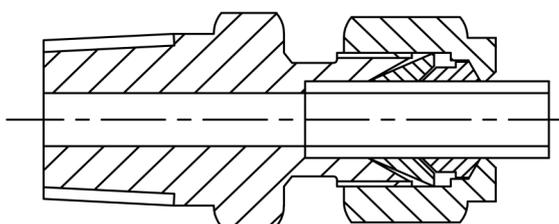


ASSEMBLY INSTRUCTIONS

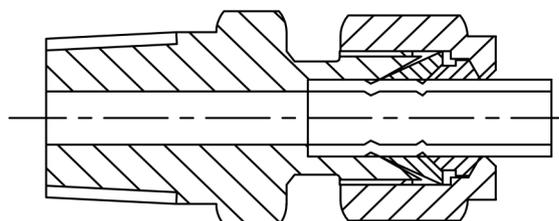
1. Cut the tube to the required length making sure ends are square and all burrs removed.



2. Insert the tube into the fitting and ensure that it is pushed firmly onto the stop inside.



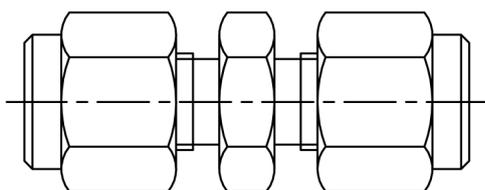
3. Make sure the nut is finger tight and then turn the nut another 1-1/4 turns.



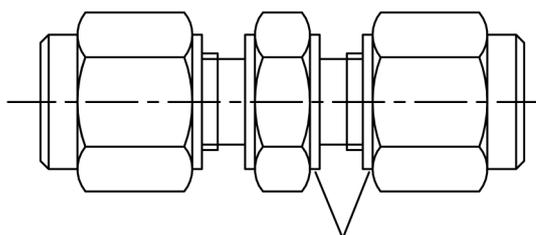
4. Fittings can be assembled and disassembled many times. On reassembly tighten the nut until finger tight, then tighten with a wrench until a rise in torque is felt. Finally tighten another 1/4 turn

IDENTIFICATION OF FRACTIONAL AND METRIC FITTINGS

FRACTIONAL



METRIC



MACHINED COLLAR ON NUT AND BODY