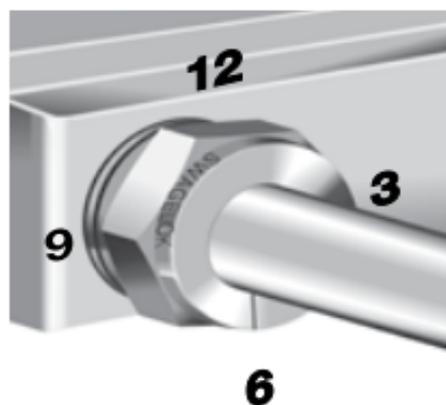


Female Swagelok tube fittings are installed in three easy steps:



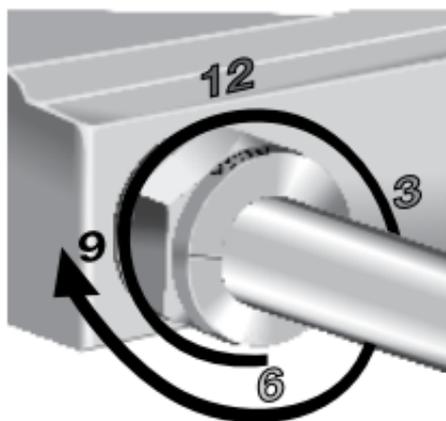
### **Step 1**

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



### **Step 2**

Scribe the nut at the 6 o'clock position.



### **Step 3**

While holding the valve body steady, tighten the Swagelok nut one and one-quarter turns. Using the scribe mark, make one complete revolution and continue to the 9 o'clock position. For 1/16, 1/8, and 3/16 in., and 2, 3, and 4 mm size tube fittings, tighten three-quarters turn to the 3 o'clock position.

*Use the appropriate Swagelok gap inspection gauge to check for sufficient pull-up.*

# Installation Instructions for Female Swagelok® Tube Fittings

Female Swagelok tube fittings have a deeper tube bore than standard Swagelok tube fittings. Because of the deeper tube bore, the following cannot be used in a female Swagelok tube fitting:

1. Tube fitting reducers.
2. Tube adapters.
3. Tube ends that have been pre-swaged with a pre-swaging tool.
4. Tube ends that have been previously swaged into a Swagelok tube fitting.

**WARNING: Do not mix/interchange Swagelok products or components not governed by industrial design standards, including Swagelok tube fitting end connections, with those of other manufacturers.**

Pressure ratings for valves with Swagelok tube fitting ends may be lower. See *Tubing Data*, MS-01-107, for more information.

The Swagelok logo is written in a stylized, cursive font. The letters are thick and black, with a registered trademark symbol (®) at the end of the word.

[www.swagelok.com](http://www.swagelok.com)

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