

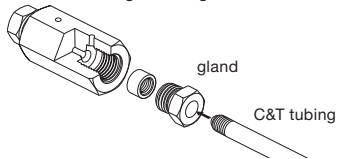


## Instructions for Cone and Thread Fittings

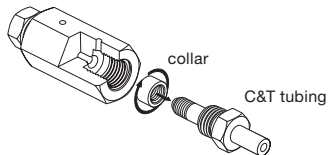
### Medium-Pressure Cone and Thread (C&T) Fitting Assembly

These instructions apply to 316 stainless steel, alloy 2507, and alloy 625 medium-pressure cone & thread fitting in sizes 1/4, 3/8, 9/16, 3/4, 1 and 1 1/2 in.

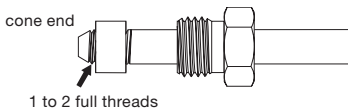
1. Lubricate all **male threads** with an anti-seize lubricant, such as a Swagelok® Goop™ product. Lubricate the **cone end of the tubing** with a system compatible lubricant.
2. Slide the **C&T tubing** into the **gland**.



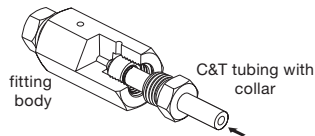
3. Thread the **collar** counter-clockwise (left-hand thread) onto the **C&T tubing**.



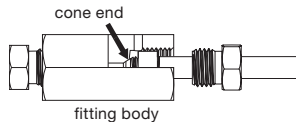
4. Continue threading until **1 to 2 full threads** are exposed at the **cone end** of the tubing. This will indicate proper position of the collar.



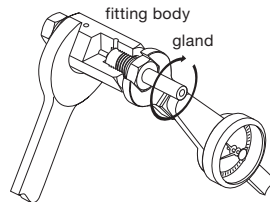
5. Insert the **C&T tubing with collar** into the **fitting body**.



6. Make sure the **cone end** of tubing rests firmly on the angled seat of the **fitting body**.



7. Thread the **gland** into the **fitting body** until finger-tight. Hold the **fitting body** steady and tighten the **gland** to the required torque shown.



### Medium-Pressure C&T Fitting

| Fitting Size<br>in. | Required Torque<br>ft-lb (N·m) |           |
|---------------------|--------------------------------|-----------|
|                     | 316 SS and<br>Alloy 2507       | Alloy 625 |
| 1/4                 | 20 (27.2)                      | 15 (20.3) |
| 3/8                 | 30 (40.7)                      | 25 (33.9) |
| 9/16                | 55 (74.6)                      | 40 (54.2) |
| 3/4                 | 90 (123)                       | 70 (94.9) |
| 1                   | 150 (204)                      | 115 (156) |
| 1 1/2               | 200 (271)                      | —         |

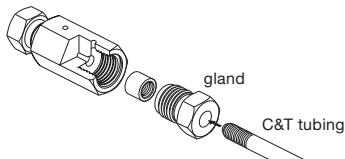


## Instructions for Cone and Thread Fittings

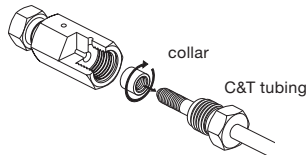
### High-Pressure Cone and Thread (C&T) Fitting Assembly

These instructions apply to 316 stainless steel, alloy 2507, and alloy 625 high-pressure cone & thread fitting in sizes 1/4, 3/8, and 9/16 in.

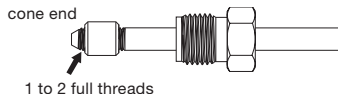
1. Lubricate all male threads with an anti-seize lubricant, such as a Swagelok® Goop™ product. Lubricate the cone end of the tubing with a system compatible lubricant.
2. Slide the **C&T tubing** into the **gland**.



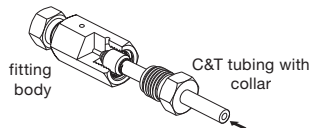
3. Thread the **collar** counter-clockwise (left-hand thread) onto the **C&T tubing**.



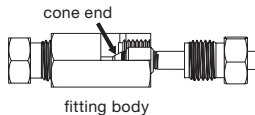
4. Continue threading until **1 to 2 full threads** are exposed at the **cone end** of the tubing. This will indicate proper position of the collar.



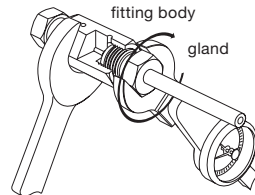
5. Insert the **C&T tubing with collar** into the **fitting body**.



6. Make sure the **cone end** of tubing rests firmly on the angled seat of the **fitting body**.



7. Thread the **gland** into the **fitting body** until finger-tight. Hold the **fitting body** steady and tighten the **gland** to the required torque shown.



### High-Pressure C&T Fitting

| Fitting Size<br>in. | Required Torque<br>ft-lb (N·m) |           |
|---------------------|--------------------------------|-----------|
|                     | 316 SS and<br>Alloy 2507       | Alloy 625 |
| 1/4                 | 25 (33.9)                      | 15 (20.3) |
| 3/8                 | 50 (67.8)                      | 30 (40.7) |
| 9/16                | 110 (150)                      | 65 (88.1) |