

Swagelok

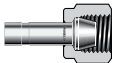
Installation Instructions for Swagelok® Port Connectors

Machined Ferrule End

1. Remove the nut and ferrules from the Swagelok end connection. Discard the ferrules.

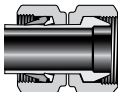


2. Slip the nut over the machined ferrule end of the port connector.



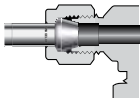
Over 1 in./25 mm sizes:

The nut is preassembled on the port connector.



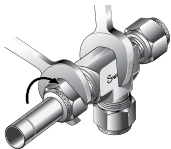
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3. Insert the port connector into the end connection and finger-tighten the nut.



4. While holding fitting body steady, tighten the nut one-quarter turn.

For 1/16, 1/8, and 3/16 in.; 2, 3, and 4 mm tube fittings, tighten the nut one-eighth turn.



- ⚠ Do not use the Swagelok gap inspection gauge with machined ferrule ends.**

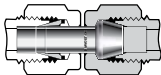
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Note: Connect the machined ferrule end before connecting the tube adapter end.

Tube Adapter End

5. Insert the tube adapter until it rests firmly on the shoulder of the Swagelok tube fitting body. Finger-tighten the nut.

Over 1 in./25 mm sizes: Remove and discard the nut and ferrules from the end connection, then insert the preswaged tube adapter.

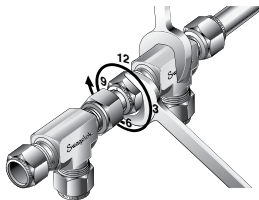


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6. Mark the nut at the 6 o'clock position. While holding fitting body steady, tighten the nut one and one-quarter turns to the 9 o'clock position.

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

For preswaged over 1 in. and over 25 mm tube fittings, tighten the nut one-half turn to the 12 o'clock position.



- ⚠ Do not use the Swagelok gap inspection gauge with preswaged tube adapter connections over 1 in./25 mm.**