

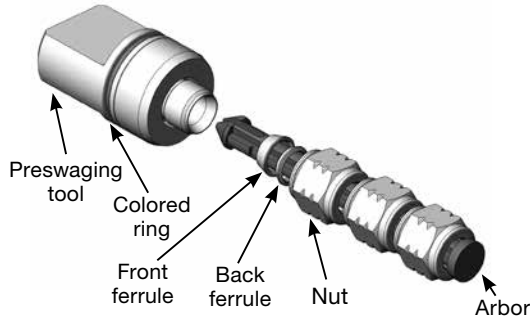
AbT Manual Preswaging Tool



Instructions

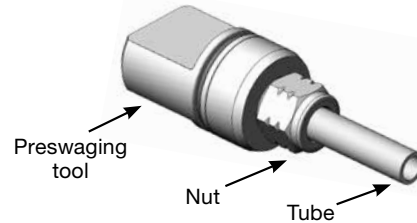
Note: Preswaging tool should be free of contamination before use. Remove contamination with a clean, dry cloth; clean dry shop air; or nitrogen.

1. Install the Swagelok nut and ferrules onto the AbT manual preswaging tool by pushing the arbor into the preswaging tool. (Preswaging tool identified with a blue ring for fractional sizes or a yellow ring for metric sizes.)

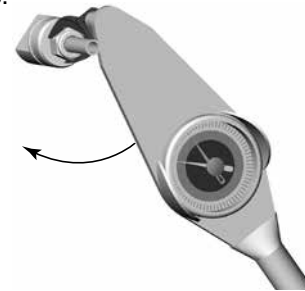


2. Rotate the nut until finger-tight, and then pull out the arbor.

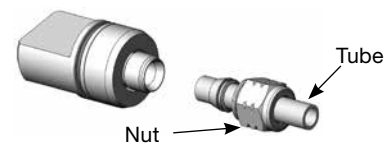
3. Loosen the nut slightly, insert the tube into the AbT manual preswaging tool until it bottoms firmly into the tool. Rotate the nut until finger-tight.



4. While holding the AbT manual preswaging tool steady (in a vise or with a wrench) and with the tube fully bottomed, tighten the nut with a wrench to the applicable torque range found in the table on reverse side.



5. Loosen the nut and remove the tube with the preswaged ferrules from the AbT manual preswaging tool. If the tube sticks, gently rock it back and forth. Do not turn the tube.



Preswage Torque Table

Tube Size		Preswaging Torque Allowable Range in.·lb (N·m)
OD × Wall	Max OD	
Fractional, in.		
1/4 × 0.028	0.254	170 ± 13 (19 ± 1.5)
1/4 × 0.035		150 ± 13 (17 ± 1.5)
1/4 × 0.049		170 ± 13 (19 ± 1.5)
3/8 × 0.049	0.379	270 ± 14 (30.5 ± 1.5)
3/8 × 0.065	0.379	360 ± 18 (40.5 ± 2)
1/2 × 0.049	0.503	540 ± 27 (61 ± 3)
1/2 × 0.065		660 ± 33 (74.5 ± 3.75)
1/2 × 0.083	0.503	660 ± 33 (74.5 ± 3.75)
Metric, mm		
6 × 1.0	6.09	150 ± 13 (17 ± 1.5)
8 × 1.0	8.10	215 ± 11 (24 ± 1.25)
8 × 1.2		
10 × 1.0	10.10	360 ± 18 (40.5 ± 2)
10 × 1.5		
12 × 1.5		
12 × 1.8	12.07	660 ± 33 (74.5 ± 3.75)

CAUTION:
Use of tubing above the recommended Max OD may result in the tube not fully bottoming into the preswage tool.

Ordering Numbers

Tube Size	Manual Preswaging Tool	Nut and Ferrule Set
Fractional, in.		
1/4	MS-ST-400-ABT	SS-4ABT-NFSET
3/8	MS-ST-600-ABT	SS-6ABT-NFSET
1/2	MS-ST-810-ABT	SS-8ABT-NFSET
Metric, mm		
6	MS-ST-6M0-ABT	SS-6MABT-NFSET
8	MS-ST-8M0-ABT	SS-8MABT-NFSET
10	MS-ST-10M0-ABT	SS-10MABT-NFSET
12	MS-ST-12M0-ABT	SS-12MABT-NFSET

For additional information, see www.swagelok.com.