

Gaugeable Preswaging Tool

Tools Required for Gaugeable Preswaging

Gaugeable preswage 1/4, 3/8, 1/2, and 5/8 in. (6, 8, 10, 12, and 16 mm)	
Nut wrench	
Body wrench	
Standard gap gauge	
Severe-service gap gauge	

Instructions

1. Install the Swagelok® nut and ferrules onto the preswaging tool. *Fig. 1*

Fig. 1



2. Insert the tube into the preswaging tool until it rests firmly on the shoulder of the tool; rotate the nut finger-tight. *Fig. 2*

Fig. 2



3. While holding the preswaging tool steady, tighten the nut with a wrench until it stops against the collar. *Fig. 3*

Fig. 3



4. Loosen the nut and remove the tube with preswaged ferrules from the preswaging tool. If the tube sticks, gently rock it back and forth. Do not turn the tube. *Fig. 4*

Fig. 4



Swagelok

Tube Fitting Installation

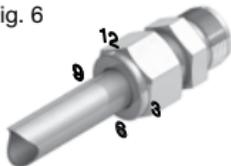
1. Insert the tube with preswaged ferrules into the fitting until the front ferrule seats against the fitting body; rotate the nut finger-tight. *Fig. 5.*

Fig. 5



2. Mark the nut at the 6 o'clock position. *Fig. 6*

Fig. 6



3. While holding the fitting body steady, tighten the nut one-half turn to the 12 o'clock position. *Fig. 7.*

Note: If assembling fittings for high-pressure applications or high safety-factor systems, tighten one hex flat further than one-half turn.

Fig. 7



Gaugeability

On initial installation, the Swagelok gap inspection gauge assures the installer or inspector that a fitting has been sufficiently tightened.

If the nut was tightened additionally during installation (step 3), use Fig. 8 for gauging, otherwise use Fig. 9.

Fig. 8



Position the Swagelok gap inspection gauge next to the gap between the nut and body. *Fig. 9.*

- If the gauge will not enter the gap, the fitting is sufficiently tightened.
- If the gauge will enter the gap, additional tightening is required.

Fig. 9

