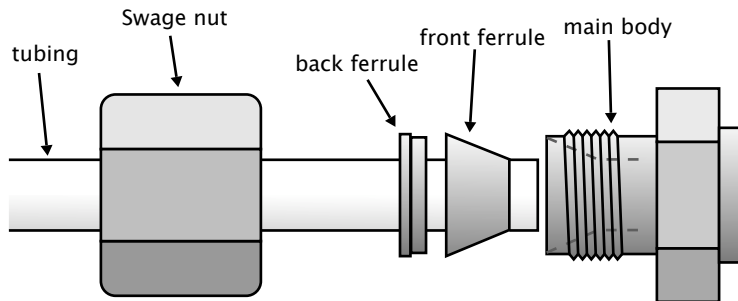


Swagelok™ instructions (for plastic ferrules)

When assembled correctly, Swagelok™ fittings form a leak tight seal and can be re-tightened many times. The use of plastic ferrules allows for a “non-permeant” seal which means the ferrule sets can be easily removed and reused on new tubing. In contrast, once metal ferrules are swaged in place they cannot be removed or reused. The position of the ferrule sets must be correct for the Swagelok™ fitting to work properly. The front ferrule must be placed such that the cone shape fits into the main body. Behind the front ferrule is the back ferrule; the small-ridged side needs to go against the front ferrule as shown. Following the ferrules is the Swagelok™ nut.



Step 1

Simply insert the tubing into the Swagelok™ Tube Fitting. Make sure that the tubing rests firmly on the inner shoulder of the fitting and that the nut is finger-tight.

Step 2

Nylon ferrules only need to be tightened a little past finger tight (about 1/8 a turn). Use caution, over tightening will destroy the ferrule set. If leaking occurs, slowly tighten the nut past the 1/8 turn only as far as needed to achieve a leak free seal.

Step 3 (if needed)

If the ferrule set becomes worn-out or damaged, replace both front and back ferrules with a new set. Do not intermix used ferrules and new ferrules, replaces only as a set. Generally plastic ferrules can be used 10 or more times without leakage problem. If you are not getting these results you are most likely over-tightening the ferrules.