

Swagelok

Instructions for Swagelok® Jacketed Tube Connector Installation Instructions

These instructions apply to jacketed tube connectors sizes 1/4 in., 3/8 in. and 1/2 in.

1. Cut the jacketed tubing to the desired length.



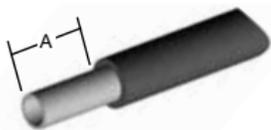
2. Cut and remove the jacket from the tubing to the proper length for insertion into the jacketed tube connector. Refer to the table for jacket cut lengths.

⚠ Caution

Insufficient cut length can result in tube fitting failure.

Notice

Excessive cut length can affect the environmental seal.



Tube OD, in.	Jacket Cut Length "A", in. (mm)	Jacket Cut Tolerance, in. (mm)
1/4	7/8 (22.2)	± 1/8 (3.2)
3/8	1 (25.4)	
1/2	1 1/8 (28.6)	

3. Install the JTC seal cartridge onto the tube fitting body finger-tight.



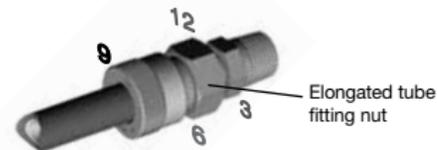
4. Remove the arbor from the jacket seal nut.



5. Fully insert the tube into the fitting until it rests against the shoulder. Verify the tube fitting nut is finger-tight.



6. Mark the elongated tube fitting nut at the 6 o'clock position.



7. While holding the fitting body steady, tighten the elongated tube fitting nut one and one-quarter turns to the 9 o'clock position.



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Gaugeability

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

Position the Swagelok gap inspection gauge next to the gap between the elongated tube fitting nut and the body.

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



Leak Testing and Final Assembly

1. If performing *pressure decay* leak test, proceed to step 2; if performing a *leak test with liquid leak detector*, remove the jacket seal nut from the elongated tube fitting nut and perform the test. Replace the jacket seal nut.



2. Tighten the jacket seal nut hand-tight. The jacket seal nut will cover the vent O-ring when it is sufficiently tightened. If desired, perform a *pressure decay* leak test.

