

**DK-LOK**<sup>®</sup>

DK-Lok Tube Fittings

# Tube Fitting Installation and Reassembly Safety Instruction

## Up to 1 inch or 25mm and Under

## Over 1 inch or 25 mm and Larger

## Reassembly - All Size

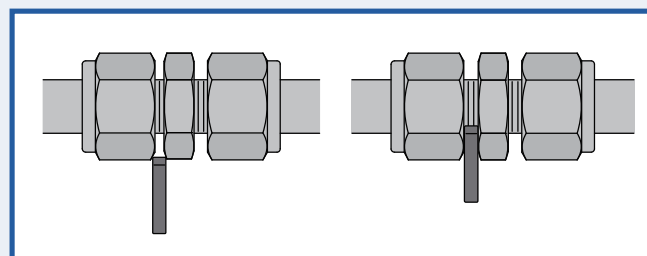
This instruction applies to DK-LOK Tube Fittings. A leak-tight and mechanically safe installation is easily made by just turning the nut 1 1/4 turn. (or 3/4 turn for small sizes)

1. Preswage the ferrules onto the tube using the DK-LOK HSU (Hydraulic Swaging Unit)
2. Apply the lubricant (DKLUB-0311) slightly to the body thread and the rear surface of the back ferrule.
3. Insert the tube with preswaged ferrules into the fitting body and tighten the nut by hand tight.
4. Mark the nut at the 6 o'clock position.
5. While holding the fitting body steady with a back-up wrench, tighten the nut one-half turn.

Check gap between nut and body, using the appropriate sized gauge to ensure that the fitting is tightened sufficiently.

### Gaugeability

DK-LOK gap inspection gauge effectively checks the gap dimensions for initial make-up. Position the DK-LOK inspection gauge next to the gap between the nut and body.



If the gauge will not enter between the fitting's nut and body hex, no additional tightening is required.

If the gauge will enter between the fitting's nut and body hex, additional tightening is required.

DK-LOK Tube Fitting connections may be disconnected and remade repeatedly.

1. Before disassembly mark the position of the nut in relation to the fitting body.

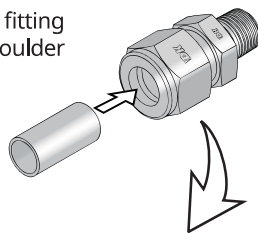
2. To reassemble simply, insert the tubing with the previously swaged ferrules and nut into the fitting body until the front ferrule seats within the fitting body.

1. Tighten the nut with a wrench to the original position as indicated by the previous marks lining up.

2. At this point tighten the nut slightly so the mark passes the mark on the body slightly as indicated in the figure.

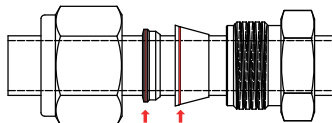
**Note :** Do not use the DK-LOK gap inspection gauge with reassembled fittings.

1. Insert the tubing into the DK-LOK tube fitting until the tubing end bottoms on the shoulder of the fitting body.

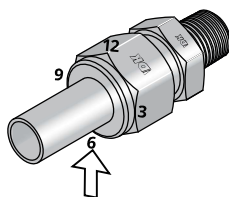


### DK-LOK Installation for high pressure or high safety applications

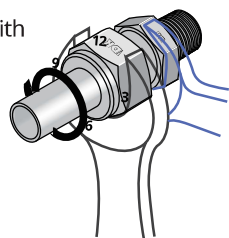
Wrench-tighten the nut until the tube does not rotate freely by hand.



2. Mark the nut at the 6 o'clock position for identification of starting point.



3. While holding the fitting body stable with a back-up wrench, tighten the nut 1 1/4 turn to the 9 o'clock position.



**Note :** Only 3/4 turn from finger tight is required for 1/16", 1/8", 3/16", 2mm, 3mm and 4 mm sizes.