



# SMITH-COOPER<sup>®</sup>

## I N T E R N A T I O N A L



2867 S. Vail Avenue, Commerce, CA 90040

Phone: 323-890-4455

Fax: 323-890-4456

## **COMPRESSION TUBE FITTING ASSEMBLY**

### **TUBE PREPARATION**

- Use a tubing cutter to cut the tube to the desired length. If using a tubing cutter is not possible, ensure that the tube is cut squarely and the ends are free of burrs.
- Clean tube ends to remove any foreign material.
- Ensure that the tube being used does not have any visible scratches or surface defects within 1" of the tube ends.

### **ASSEMBLY**

- Verify that all connection parts are assembled in the correct sequence; Fitting body, followed by the front ferrule, then the back ferrule and finally the nut. (NOTE: Single ferrule fittings do not have the back ferrule.)
- Insert the tube end completely through the nut, back ferrule and front ferrule until it makes contact with the body shoulder.
- Hand-tighten the nut until it stops.
- Make a "zero position" scribe mark on the body and the nut.
- Ensure that the wrenches used are of the correct size for the nut and the body.
- Hold the body firmly with a back-up wrench and tighten the nut a minimum of 1-1/4 turns from the zero point using a wrench. The fitting is now fully tightened and ready to hold the rated pressure.

### **RETIGHTENING AFTER DISASSEMBLY**

- Before reconnection, ensure that the taper surface of the body and the surface of the front ferrule are clean and free of any foreign material.
- Insert the tube end into the body and hand tighten the nut until the front ferrule is in full contact with the taper surface of the body.
- Using a wrench, tighten the nut approximately 1/4 turn.

October 1, 2015