

Assembly Instructions for 37 Degree Tube Fittings and Adapters

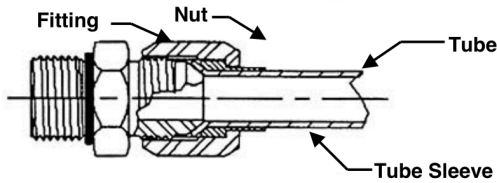


Fig.20 37° Tube Fitting Assembly

Method A. Installation Torque

1. Inspect components for damage or contamination.
2. If O-Ring (**FLARE-O® only**) is not present, install correct O-Ring in FLARE-O® groove, taking care not to cut or nick the O-Ring.
3. Lubricate the O-Ring with a light coat of system fluid or compatible oil.
4. Align tube/hose to mating fitting allowing hand connection. To assure proper alignment, two to three turns of nut should be easily permitted.
5. Tighten tube nut to torque listed in Table K.

Table K. Assembly Torque, 37° Tube Fittings					
Tube Size	Thread Size	37° Tube/ Swivel Nut		FLARE-O® Tube/ Swivel Nut	
		Ft. Lbs.	Nm.	Ft. Lbs.	Nm.
-2	5/16-24	6-7	8-9	-	-
-3	3/8-24	8-9	11-12	-	-
-4	7/16-20	11-12	15-16	7-8	9-11
-5	1/2-20	14-15	19-21	10-12	13-16
-6	9/16-18	18-20	24-28	14-16	19-22
-8	3/4-16	36-39	49-53	21-24	28-33
-10	7/8-14	57-63	77-85	28-32	38-43
-12	1 1/16-12	79-88	107-119	52-56	71-76
-14	1 3/16-12	94-103	127-140	60-64	81-87
-16	1 5/16-12	108-113	147-154	63-72	85-98
-20	1 5/8-12	127-133	172-181	84-96	114-130
-24	1 7/8-12	158-167	215-226	91-104	123-141
-32	2 1/2-12	245-258	332-350	210-240	285-325

Method B. Flats From Finger Tight (F.F.F.T.)

1. Inspect components for damage or contamination.
2. Align tube/hose to mating fitting allowing hand connection. To assure proper alignment, two to three turns of nut should be easily permitted.
3. Finger tighten or lightly wrench nut to seat sealing surfaces.
4. Mark nut and adjacent fitting surface to indicate initial seating position. See Fig.21.
5. Finish tightening nut by turning the appropriate F.F.F.T. as indicated in Table L.
6. Mark final tightening position on fitting by extending the existing mark from the nut to the adjacent fitting surface. See Fig.22.

Table L. Flats From Finger Tight Installation Method ¹					
Tube Size	Straight Thread Size	37° Tube Nut F.F.F.T.	FLARE-O® Tube Nut F.F.F.T.	Swivel Nut F.F.F.T.	FLARE-O® Swivel Nut F.F.F.T.
-2	5/16-24	---	---	---	---
-3	3/8-24	---	---	---	---
-4	7/16-20	2	2	1.5	1
-5	1/2-20	2	2	2	1.5
-6	9/16-18	1.5	1.5	1.5	1.25
-8	3/4-16	1.5	1.5	1.25	1.25
-10	7/8-14	1.5	1.5	1	1
-12	1 1/16-12	1.25	1.25	1	1
-14	1 3/16-12	1.25	1.25	1	1
-16	1 5/16-12	1	1	1	1
-20	1 5/8-12	1	1	1	1
-24	1 7/8-12	1	1	1	1
-32	2 1/2-12	1	1	1	1

1) Recommended for use only when installation by torque method is not practical.

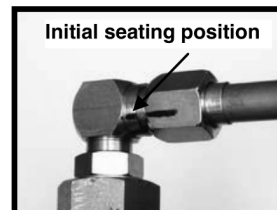


Fig.21 Mark finger tight position

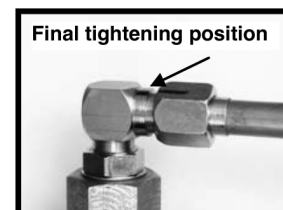


Fig.22 Mark final tightening position