



## Installation Instructions Over 1 in. or 25 mm Swagelok® Tube Fittings

Follow this procedure when installing Swagelok tube fittings in sizes over 1 in. or 25 mm.

1. Use the Swagelok multihead hydraulic swaging unit (MHSU) in accordance with its furnished instructions to swage the ferrules onto the tubing.
2. After swaging:
  - Apply the enclosed lubricant sparingly to the Swagelok tube fitting body threads.
  - Apply a similar amount of the lubricant to the rear surface of the back ferrule.
3. Install the swaged assembly (tubing, nut, front and back ferrules) into the fitting body and tighten nut 1/2 turn past hand-tight position while holding fitting body steady with a backup wrench.

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