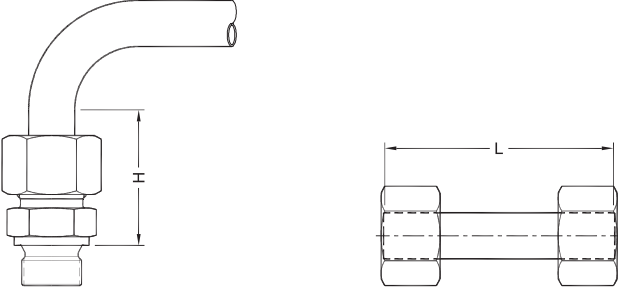


Assembly Process

Preparation of Tube



Maximum height H for Straight tube end

Minimum length L for short piece of tube

Series Tube o.d.	LL Series			L Series								S Series										
	4	6	8	6	8	10	12	15	18	22	28	35	42	6	8	10	12	16	20	25	30	38
H min	24	25	26	31	31	33	33	36	38	42	42	48	48	35	35	37	37	43	50	54	58	65
L min	30	32	33	39	39	42	42	45	48	53	53	60	60	44	44	47	47	54	63	68	73	82

Saw off Tube at 90°



Do not use Tube cutters



Tube cut with tube cutter
generates heavy burr/bevel cut



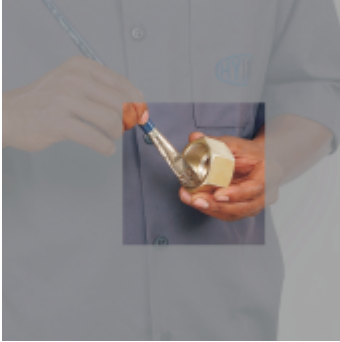
Saw off Tube

Deburr inside and Outside edges
of tube upto 0.2x45°



Assembly Process

Lubricate threads (External and Internal), cone of the Coupling body and the Ferrule



Slip the Coupling Nut and Ferrule over tube end



Assembly Process

Ensure Coupling Nut and Ferrule are facing the right way



✓ **Correct**



✗ **Incorrect**

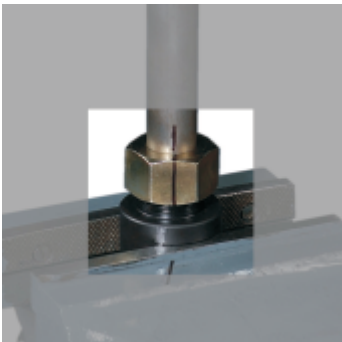
Screw the Coupling Nut manually on to Coupling body until finger tight.



Tighten the coupling Nut by spanner until the tube stops rotating by hand



Mark the Coupling Nut and holding device to measure the prescribed turns



Tighten the Coupling Nut around 1 1/4 to 1 1/2 round
Tube must not rotate



Sectional View of Straight Coupling assembly with Tube

