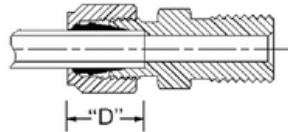
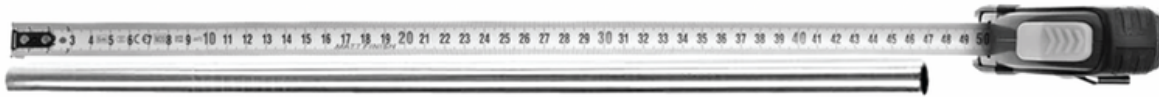


Pre-Swaging Guide

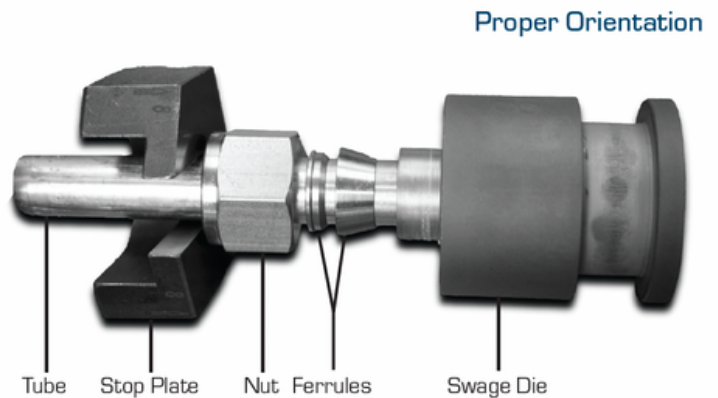
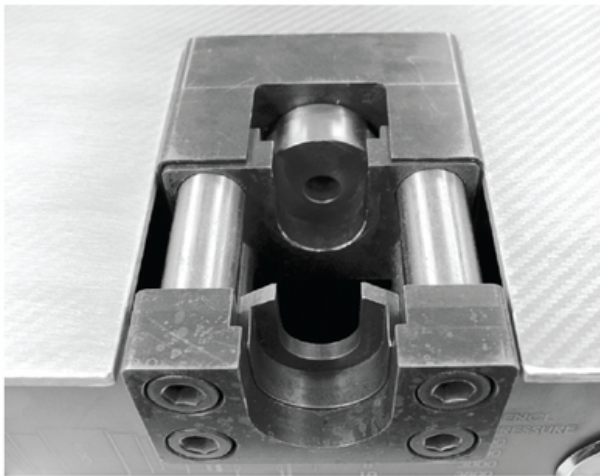
Setup:

1. Measure and pre-cut tube length, adding fitting insertion depths to each end:

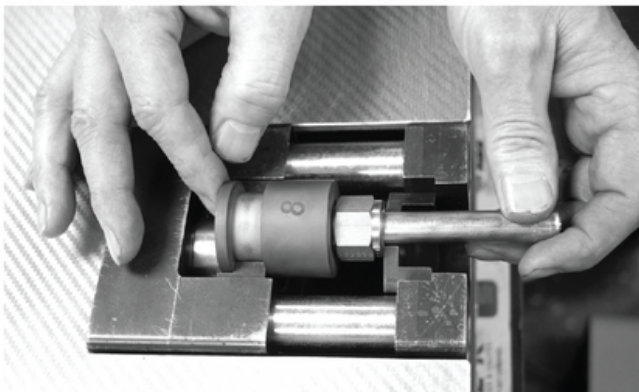


Tube O.D. Inches	1/16	1/8	3/16	1/4	5/16	3/8	1/2	5/8	3/4	7/8	1	1 1/4	1 1/2	2
"D" Tube Insertion Depth (in.)	0.38	0.52	0.56	0.61	0.66	0.69	0.94	0.98	0.98	1.05	1.22	1.61	1.96	2.65

2. Insert Stop Plate into Swaging head. Slide loose nut and ferrules onto tube and insert into swage die:



3. Insert tubing and swage die into Swaging head and pump to pressure for corresponding tube diameter:

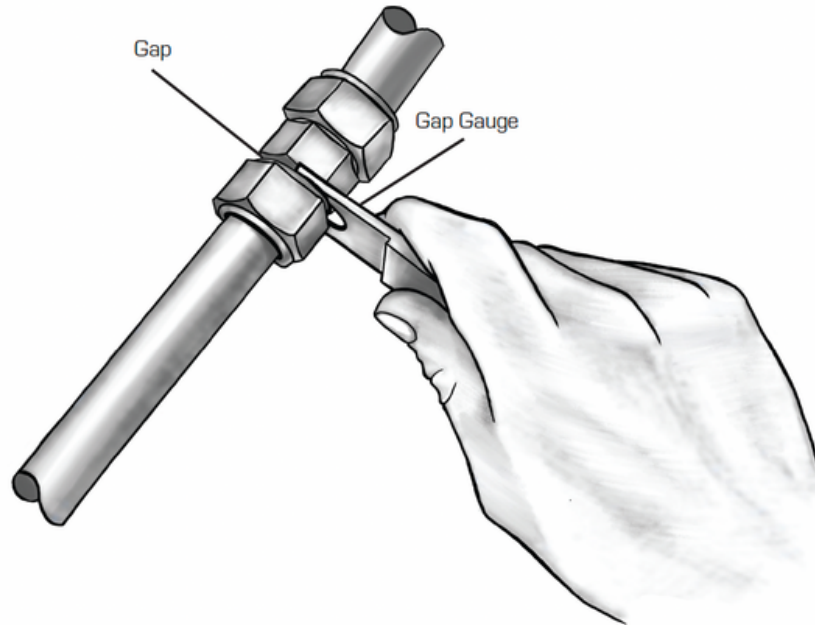


CBC SIZE	REFERENCE SWAGE PRESSURE
4	2600
6	2700
7	2900
8	3000
10	3800
12	4600
14	5200
16	6000

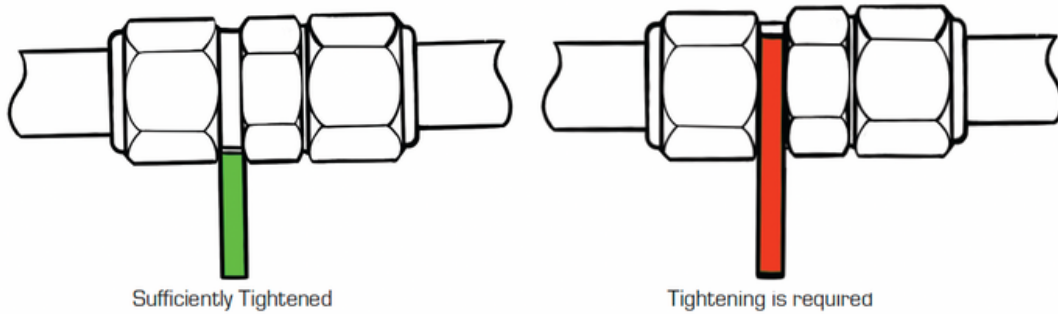
MAX. PRESSURE 7500 PSI

NOTE: This chart can be found on the front of the BTSU and DSU

4. Repeat process on second end of tube and install pre-swaged tube to the instructions below:



The gauge should NOT fit into the gap when tightened properly



Gauging Instructions:

Position the Tylok BTSU gap inspection gauge adjacent to the gap between the nut and body hex.

- If the gauge will not enter the gap, the fitting is sufficiently tightened.
- If the gauge will enter the gap, additional tightening is required.