

**Assembly Instructions**

1. Cut the tube cleanly and squarely removing all burrs.
2. Slip tube nut and sleeve over tube.
3. Insert tubing in fitting body as far as it will go and tighten nut until stop is reached. The elastic sleeve ordinarily will extrude slightly around the tube at the end of the nut. This extrusion further aids in isolating the tube from the nut.

**Assembly Instructions for Higher Pressure Applications**

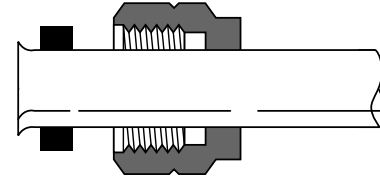
1. Consult pressure chart to determine if tubing should be belled for your particular application.
2. Slip the nut and sleeve over tubing. The sleeve should be positioned near end of tubing just behind the surface to be belled.
3. Bell tubing with standard 45° flaring tool or 90° punch. The size of bell should be approximately that shown.

**Pressure Chart**

In high pressure applications and sizes larger than 1/2" O.D., the tube end should be belled or flared.

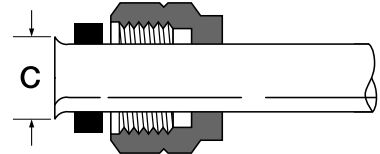
CONDITION	TUBE O.D.	TUBE NOT BELLED	TUBE BELLED OR FLARED
STATIC PRESSURE	3/16"	500	1000
	1/4"	500	1000
	5/16"	450	900
	3/8"	350	700
	1/2"	200	500
MINOR SURGES AND/OR VIBRATIONS	5/8"	400	400
	3/16"	400	800
	1/4"	400	800
	5/16"	325	700
	3/8"	225	500
SEVERE VIBRATIONS OR SHOCK	1/2"	150	375
	5/8"	300	300
	3/16"	300	600
	1/4"	300	600
	5/16"	225	500
	3/8"	175	400
	1/2"	100	250
	5/8"		100

**Sleeve Position**



**Recommended Size of Bell**

TUBE O.D.	BELL DIA. C
1/8"	.190-.160
3/16"	.255-.225
1/4"	.318-.288
5/16"	.381-.351
3/8"	.444-.414
1/2"	.569-.539
5/8"	.694-.664
3/4"	.819-.789
7/8"	.944-.914



**Tube Length Calculator**

This table shows distance tube extends beyond face of Vibra-Lok fitting body on installation with bell on tubing and without bell on tubing.

O.D. of TUBE	A	B
	With BELL	Without BELL
1/8"	3/16"	3/16"
3/16"	3/16"	7/32"
1/4"	3/16"	1/4"
5/16"	3/16"	1/4"
3/8"	3/16"	1/4"
1/2"	3/16"	11/32"
5/8"	3/16"	Tubing should be belled
3/4"	3/16"	
7/8"	1/4"	

