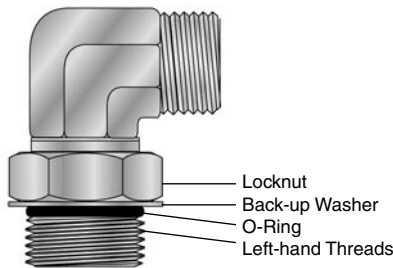


Counterbores and taps used to machine the various parallel thread ports can be found in section S.

For assembly purposes, there are two main categories of parallel port ends: adjustable and non-adjustable. Adjustable port ends are commonly found on shaped fittings to allow for proper orientation of the fitting. Besides the elastomeric seal, adjustable port ends are assembled with a locknut and a back-up washer as shown in Fig. T6. Non-adjustable port ends are found on straight fittings.



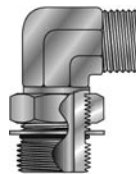
**Fig. T6 – Adjustable Port End Assembly**

The general assembly procedure for all adjustable parallel thread port ends is the same. Likewise, the assembly procedure is the same for all non-adjustable parallel thread port ends.

**Adjustable Port End Assembly**

1. Inspect components to ensure that male and female port threads and sealing surfaces are free of burrs, nicks and scratches, or any foreign material.
2. If O-ring or seal is not pre-installed to fitting male port end, install proper size O-ring or seal, taking care not to damage it.
3. Lubricate O-ring with light coat of system fluid or a compatible lubricant to help the O-ring slide smoothly into the port and avoid damage.
4. Back off lock nut as far as possible. Make sure back-up washer is not loose and is pushed up as far as possible.

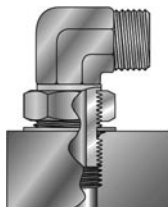
Locknut Completely Backed-Off



**Step 4**

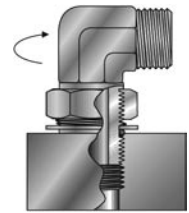
5. Screw fitting into port until the back-up washer or the retaining ring contacts face of the port. Light wrenching may be necessary. **Over tightening may damage washer.**

(This potential damage was eliminated with Parker's Robust Port)

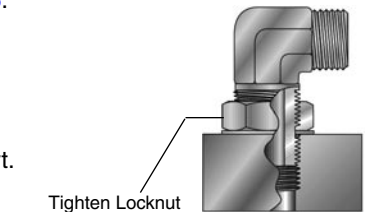


**Step 5**

6. To align the tube end of the fitting to accept incoming tube or hose assembly, unscrew the fitting by the required amount, but not more than one full turn.
7. Using two wrenches, hold fitting in desired position and tighten locknut to the proper torque value from the appropriate table located on [pages T5 - T6](#).
8. Inspect to ensure that O-ring is not pinched and that washer is seated flat on face of port.



**Step 6**

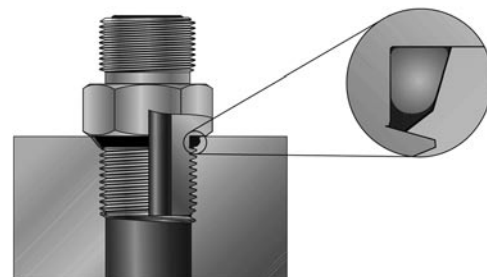


Tighten Locknut with Torque Wrench

**Steps 7 and 8**

**Non-adjustable Port End Assembly**

1. Inspect components to ensure that male and female port threads and sealing surfaces are free of burrs, nicks, and scratches, or any foreign material.
2. If O-ring or seal is not pre-installed to fitting male port end, install proper size O-ring or seal, taking care not to damage it.
3. Lubricate O-ring with light coating of system fluid or a compatible lubricant to help the O-ring slide past the port entrance corner and avoid damaging it. "ED" seal does not need lubrication.
4. Screw fitting into port and tighten to proper torque from the appropriate table located on [pages T5 - T6](#).



**Fig. T7 — Non-Adjustable Port End Assembly**