

### Deburring

Lightly deburr the I.D. and O.D. of the tube end to remove burrs and sharp edges. Use the In-Ex deburring tool or power deburring tool (shown on [page S23](#)), or emery paper if using tube cutter (for soft tube) or hacksaw. Use front mounted deburring tools if using TP432 or TP1025 tube preparation center found on [page S55](#).

**Note:** Point tube end downward during deburring to keep chips from entering the tube.

### Cleaning

Remove metal chips from I.D. with a brush or compressed air. Wipe the I.D. and the O.D. of the deburred tube end with a clean rag. Debris present in the tube end can result in system contamination or can get embedded into the flange or flare, causing imperfections that are potential leak paths.

## Seal-Lok and Seal-Lok Lite Assembly

The proper assembly of the Seal-Lok fitting requires several steps, each important in guaranteeing a leak-free connection and a long service life:

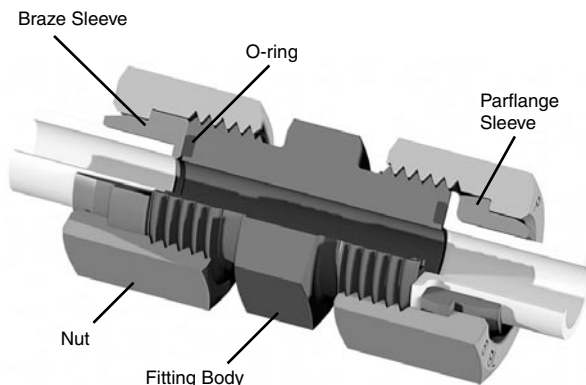
1. Cutting, deburring and cleaning the tube
2. Sleeve Attachment
3. Inspection of sleeve attachment
4. Final installation

The first step of cutting, deburring and cleaning has been covered in a previous section (see [page T12](#)).

For recommended minimum and maximum tube wall thickness for Seal-Lok fittings, please refer to [Table A2](#) and [A3](#) on page A7.

### Sleeve Attachment

Attaching the sleeve to the tube end is the next critical assembly step. This can be accomplished by two methods: flanging or brazing.

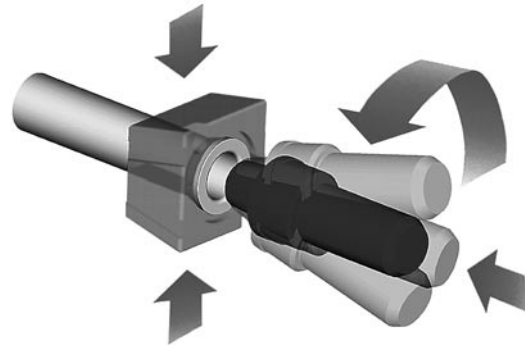


**Fig. T14 – Seal-Lok Union cutaway with flanged and brazed assemblies**

### Flanging

The flanging method requires the use of an appropriate forming machine to create the flange or flat face on the tube end. Since the flat face of the flanged tube seals against the O-ring within the fitting groove, it is important that this surface be relatively smooth. Proper tube end preparation (cutting, deburring and cleaning) will help accomplish this goal.

The Parker Parflange® machines utilize an orbital cold forming process to produce a flat, smooth, rigidly supported 90° sealing surface on the tube end.



**Fig. T15 – Parker's exclusive orbital spindle motion produces a perfect flange every time**

Parker offers a bench mount model known as the Parflange 1025, shown in Fig. T16, as well as a more versatile, fully automated high speed model, Parflange 1050. For additional information on the Parflange machines and tooling, refer to [section S](#) of this catalog.



**Fig. T16 – Parflange 1025 machine**