

Ferulok Assembly

Ferulok fitting assembly consists of the following steps:

- 1) Cutting, deburring and cleaning of the tube
- 2) Ferrule pre-set
- 3) Pre-set inspection
- 4) Installation

Step 1 (cutting, deburring and cleaning of the tube) has been previously covered (see [page T12](#)).

For the recommended minimum and maximum tube wall thickness for Ferulok fittings, please refer to [Table D2](#) on page D5.

Ferrule Pre-set

Prior to final installation, the Ferulok fitting requires a pre-setting operation that creates a bite by the ferrule into the outer surface of the tubing. Pre-setting can be accomplished by two different methods: hydraulically using a Hyferset Tool or a Hydra-Tool, or manually using a hardened Ferulset tool or the fitting body.

Prior to pre-setting, determine the tube length allowance "A" using [Table T22](#).

Pre-setting using Ferulset Tool or Fitting Body

| Nominal Tube O.D. | A |
|-------------------|------|
| 1/8 | 0.19 |
| 3/16 | 0.23 |
| 1/4 | 0.23 |
| 5/16 | 0.25 |
| 3/8 | 0.25 |
| 1/2 | 0.31 |
| 5/8 | 0.35 |
| 3/4 | 0.35 |
| 7/8 | 0.35 |
| 1 | 0.42 |
| 1 1/4 | 0.42 |
| 1 1/2 | 0.49 |
| 2 | 0.49 |

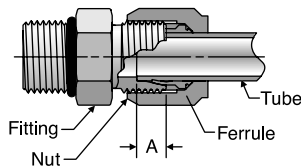


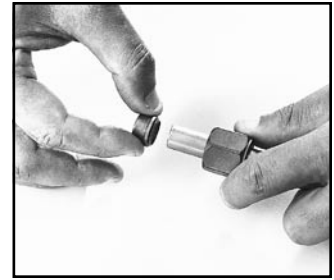
Fig. T32 — Tube length allowance

Table T22 — Tube length allowance

Ferulset pre-setting tools made from hardened steel are available for sizes 2 through 32. (See [page S38](#).) They are recommended over the fitting body because they can be used repeatedly to perform the pre-set operation. The fitting body can be used only once for pre-setting and should be used during final installation with the pre-set tube line. The following steps are required for proper pre-set of the ferrule using the Ferulset tool or fitting body.



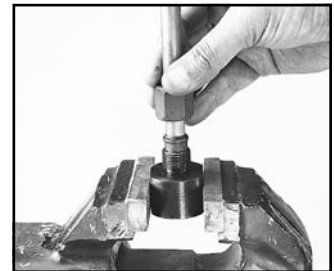
Step 1 – Lubricate thread and cone of Ferulset Tool (or fitting body).



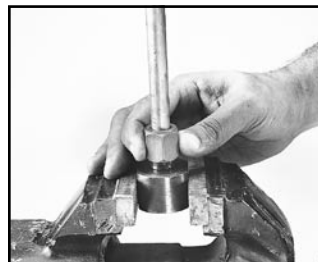
Step 2 – Slip nut and ferrule over deburred tube end. Be sure the long, straight end of the ferrule points toward tube end.



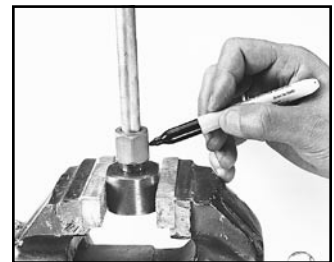
Step 3 – Lubricate ferrule with system fluid or a compatible lubricant.



Step 4 – Bottom tube end firmly on internal shoulder of Ferulset Tool (or fitting body).



Step 5 – Manually screw nut onto Ferulset Tool or fitting body until finger tight.



Step 6 – Make reference mark on nut and tube.



Step 7 – Hold tube steady against internal shoulder of Ferulset Tool or fitting body and tighten nut an additional 1-3/4 turns.



Step 8 – Loosen nut and check for proper pre-set. Use the following inspection criteria.

*No additional lubrication is required with stainless steel fittings as the nuts are pre-lubricated.

Dimensions and pressures for reference only, subject to change.