

Ferulok Troubleshooting Guide

Problems with bite type hydraulic fittings are most often traced to faulty Pre-Set/Assembly procedure.

Problem / Probable Cause	Remedy
Tube not bottomed	Check for the indentation on the tube end or compare the length from the end of the tube to the front end of the ferrule of a known good assembly to that of the assembly in question. This assembly should be scrapped. (Fig. T35)
Shallow bite	Inspect for turned up ridge of material. A failure to achieve this ridge can be traced either to the nut not being tightened enough or the tube not being bottomed against the stop which allowed the tube to travel forward with the ferrule. In some instances this assembly may be re-worked. (Fig. T36)
Over-set ferrule	Too much pressure or more than 1 3/4 turns from finger tight were used to pre-set ferrule, or the nut was severely over-tightened in final assembly. This assembly should be scrapped. (Fig. T37)
Ferrule cocked on tube	The ferrule may become cocked on the tube when the tube end is not properly lined up with the body. Generally, this condition is caused by faulty tube bending. All bent tube assemblies should drop into the fitting body prior to make up. This assembly should be scrapped. (Fig. T38)
No bite	If all of the prior checks have been made and the ferrule still shows no sign of biting the tube, it may be that the tube is too hard. This assembly should be scrapped. (Fig. T39)

Table T23 – Ferulok fitting troubleshooting guide

Caution: Pre-set tools such as the Ferulset and Hyferset are preferred for pre-setting ferrules prior to final assembly. However, when an actual fitting body is used to pre-set the ferrule, that body should be connected only to the specific ferrule it was used to pre-set.

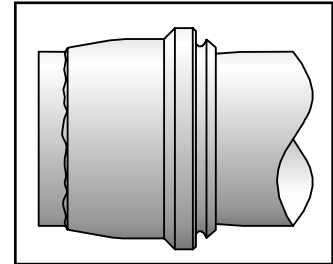


Fig. T35 – Tube not bottomed

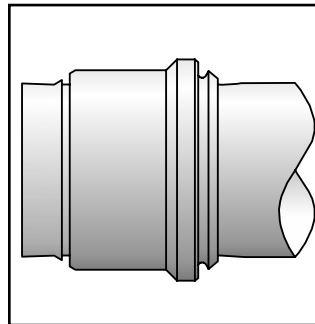


Fig. T36 – Shallow bite

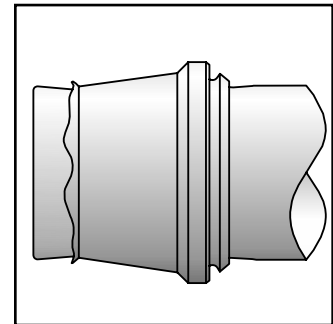


Fig. T37 – Over-set ferrule

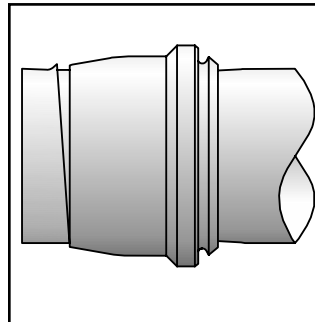


Fig. T38 – Ferrule cocked on tube

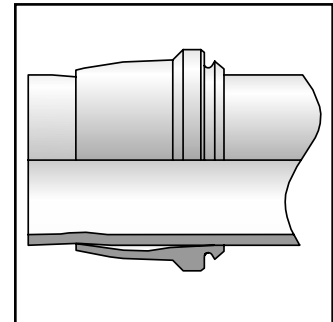


Fig. T39 – No bite

Dimensions and pressures for reference only, subject to change.