

# EO Assembly

The proper make-up and assembly of EO bite type fittings, as with other fittings, is critical to their proper functioning. Proper assembly consists of the following steps:

1. Cutting, deburring and cleaning of the tube
2. Pre-set of progressive ring
3. Pre-set inspection
4. Installation

Step 1 (cutting, deburring and cleaning of the tube) has been previously covered on [pages T12-T13](#).

## Pre-set of Progressive Ring

The EO fitting requires a pre-set operation that creates a bite by the progressive ring into the outer surface of the tube. There are two methods of achieving the pre-set:

- Manually with the fitting body or hardened pre-assembly tool
- Hydraulically with the EO-Karrymat, EOMAT III, Hydra Tool or Hyferset

## Pre-set Using the Fitting Body or Hardened Pre-assembly Tool

Pre-setting with the fitting body is only recommended for steel and copper tubes. For frequent pre-setting, stainless steel tube and hose standpipe fittings, a hardened pre-assembly tool (VOMO) is strongly recommended (see [Fig. T40](#)).

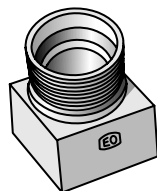


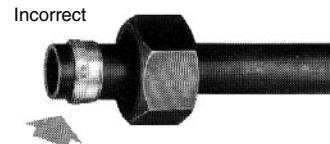
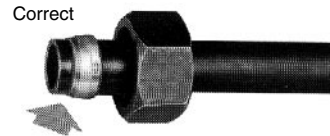
Fig. T40 – VOMO pre-assembly tool

### Steps for pre-set using the fitting body or the hardened pre-assembly tool.

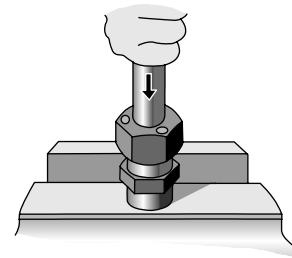
1. Lubricate thread and cone of fitting body or hardened pre-assembly tool, as well as the progressive ring and nut threads.



2. Slip nut and progressive ring over tube, assuring that they are in the proper orientation.



3. Screw nut onto fitting body or hardened pre-assembly tool until finger-tight or light wrench resistance. Hold tube against the shoulder in the cone of the fitting body or hardened pre-assembly tool.



4. Mark nut and tube in the finger-tight or light wrench-resistant position.

