

Pre-Setting Tools

Hydra-Tool Pre-Setting Pressures for EO and EO-2 Steel Fittings

Pressures for Steel EO Fittings Using Stop Adapter (971107 & 971108)

| Pre-Setting Pressures (psi) for EO Fittings Wall Thickness (mm) | | | | | | | |
|--|--------|-----|-------|-------|-------|-------|-------|
| Size | Series | 1.0 | 1.5 | 2.0 | 2.5 | 3.0 | 4.0 |
| 6 | L | 500 | 500 | 500 | | | |
| 6 | S | 500 | | | | | |
| 8 | L | 500 | | 500 | | | |
| 8 | S | 500 | 500 | | | | |
| 10 | L | | 500 | | | | |
| 10 | S | | 500 | | | | |
| 12 | L | 300 | 300 | 500 | | | |
| 12 | S | | 300 | | | | |
| 14 | S | | | 1,500 | | | |
| 15 | L | | 500 | 800 | | | |
| 16 | S | | | 1,200 | | 1,300 | |
| 18 | L | | 1,000 | | | 1,300 | |
| 20 | S | | | | 2,000 | | |
| 22 | L | | 1,500 | 1,500 | | | |
| 25 | S | | | | | 2,000 | 2,000 |
| 28 | L | | | 2,000 | | | |
| 30 | S | | | | | 3,000 | |
| 35 | L | | | 3,000 | | 3,300 | |
| 38 | S | | | | | | 3,500 |
| 42 | L | | | | | 4,000 | |

Table V11 — Pre-Setting Pressures for Steel EO Fittings

NOTE: The values provided in this chart are provided as a guide only and normally will produce a satisfactory bite when using the Parker Hydra-Tool.

Pressures for Steel EO-2 Fittings Using Stop Adapter (971107 & 971108)

| Hydra-Tool Pre-Setting Pressures (psi) for EO-2 Fittings in Steel and Stainless Steel Using the Stop Adapter | | |
|--|--------|-------|
| Size | Series | psi |
| 6 | L | 1,100 |
| 6 | S | 1,100 |
| 8 | L | 1,300 |
| 8 | S | 1,300 |
| 10 | L | 1,800 |
| 10 | S | 1,800 |
| 12 | L | 2,000 |
| 12 | S | 2,000 |
| 14 | S | 2,300 |
| 15 | L | 2,300 |
| 16 | S | 3,000 |
| 18 | L | 3,000 |
| 20 | S | 4,100 |
| 22 | L | 3,100 |
| 25 | S | 5,500 |
| 28 | L | 3,700 |
| 30 | S | 6,600 |
| 35 | L | 5,300 |
| 38 | S | 8,400 |
| 42 | L | 7,600 |

Table V12 — Pre-Setting Pressures for Steel and Stainless Steel EO-2 Fittings

NOTE: The values provided in this chart are provided as a guide only and normally will produce a satisfactory bite when using the Parker Hydra-Tool.

Hydra-Tool Pre-Setting Pressures for Ferulok Fittings^{1) 2) 3)}

| Tube Size | Wall Thickness – Steel | | | | | | | Wall Thickness – Stainless Steel | | | | | | |
|-----------|------------------------|-------|-------|-------|-------|-------|-------|----------------------------------|-------|-------|-------|-------|-------|-------|
| | 0.035 | 0.049 | 0.065 | 0.083 | 0.095 | 0.109 | 0.120 | 0.035 | 0.049 | 0.065 | 0.083 | 0.095 | 0.109 | 0.120 |
| 4 | 300 | 300 | 500 | 600 | 600 | 600 | | 300 | 300 | 500 | 700 | 700 | 700 | |
| 6 | 300 | 500 | 600 | 700 | 700 | 700 | 700 | 300 | 500 | 700 | 700 | 700 | 700 | 800 |
| 8 | | 500 | 700 | 800 | 900 | 1,000 | 1,000 | | 600 | 700 | 1,000 | 1,000 | 1,100 | 1,100 |
| 10 | | | 700 | 900 | 1,000 | 1,100 | 1,100 | | | 800 | 1,000 | 1,100 | 1,300 | 1,300 |
| 12 | | | 900 | 1,000 | 1,100 | 1,100 | 1,300 | | | 1,000 | 1,100 | 1,300 | 1,300 | 1,500 |
| 14 | | | 1,000 | 1,100 | 1,100 | 1,300 | 1,500 | | | 1,000 | 1,300 | 1,300 | 1,500 | 1,600 |
| 16 | | | | 1,100 | 1,300 | 1,500 | 1,600 | | | | 1,500 | 1,500 | 1,600 | 1,600 |
| 20 | | | | | 1,500 | 1,600 | 1,800 | | | | | 1,600 | 2,000 | 2,000 |
| 24 | | | | | 1,800 | 2,000 | 2,300 | | | | | 2,100 | 2,300 | 2,300 |
| 32 | | | | | 2,800 | 2,900 | 3,300 | | | | | 3,100 | 3,300 | 3,300 |

Table V13 — Hydra-Tool Recommended Pre-Setting Pressures for Inch Tube

- 1) These values are provided as a guide only and normally will produce a satisfactory bite.
- 2) Ferulok pre-setting dies are positive stop dies. Use of above pressures is optional.
- 3) For wall thicknesses greater than those listed, [contact the Tube Fittings Division](#).



Dimensions and pressures for reference only, subject to change.