

Installation Instructions

Installation of 20D Series Connections

For Tube O.D. 1/8", 1/4", 3/8" and 1/2"

Without Manual Presetting Tool

1. Put the nut and ferrules onto the tubing in fixed sequence and orientation (Fig. 1).
2. Insert the tubing into the fitting body or the valve. Finger tight the nut. Make sure that the tubing rests firmly on the shoulder of the fitting body or the valve (Fig. 2).
3. Mark the nut and the fitting body or the valve (Fig. 3).
4. Hold the fitting body or the valve steady. Refer to Table 1 to tighten the nut with a wrench to the specified number of turns, noting that the number of turns varies for different types of tubing (Fig. 4).

Table 1		
Tube Type/Specification	T15A/T20D Tubing	T20M Tubing
1/8"	1 1/4 turns	/
1/4"	1 1/2 turns	1 3/4 turns
3/8"	1 1/2 turns	1 1/2 turns
1/2"	1 1/2 turns	/

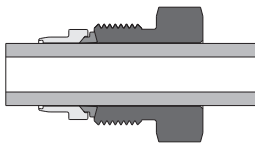


Fig.1

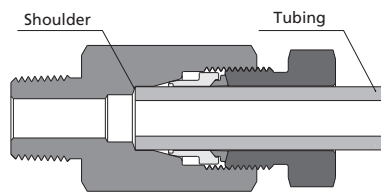


Fig.2

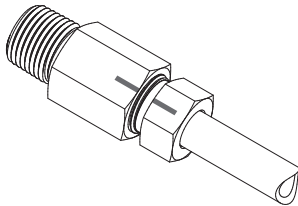


Fig.3

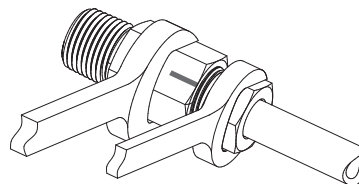


Fig.4

With Manual Presetting Tool

1. Put the nut and ferrules onto the tubing in fixed sequence and orientation (Fig. 1).
2. Insert the tubing into the manual presetting tool. Finger tight the nut. Make sure that the tubing rests firmly on the shoulder of the presetting tool (Fig. 5).
3. Mark the nut and the manual presetting tool (Fig. 6).
4. Hold the manual presetting tool steady. Refer to Table 1 to tighten the nut with a wrench to the specified number of turns, noting that the number of turns varies for different types of tubing (Fig. 4).
5. Loosen the nut and remove the tubing with preassembled ferrules from the manual presetting tool (Fig. 7).
Note: If the tubing sticks into the manual presetting tool, remove the tubing by gently rocking it back and forth. Do not rotate the tubing.
6. Insert the tubing with preassembled ferrules into the fitting body or the valve. Finger tight the nut (Fig. 8).
7. Tighten the nut 1/4 turn with a wrench while holding the fitting body or the valve steady.

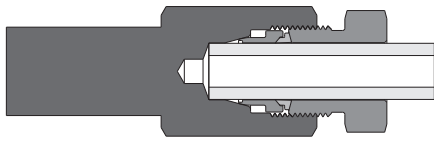


Fig.5

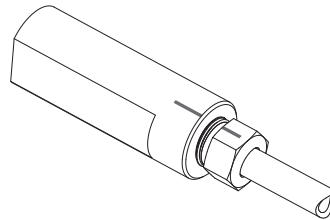


Fig.6

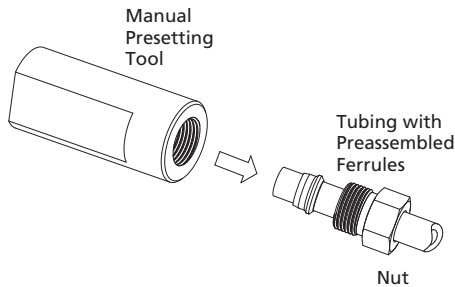


Fig.7

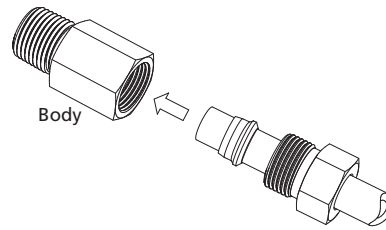


Fig.8

For Tube O.D. 1/2", 9/16", 3/4" and 1"

1. Preassemble the ferrules onto tubing using the hydraulic presetting tool. For details, please contact FITOK for instruction manual Hydraulic Presetting Tools.
2. Insert the tubing with preassembled ferrules into the fitting body or the valve. Finger tight the nut.
3. While holding the fitting body or the valve steady, tighten the nut 1/4 turn for tubing O.D. 1/2", 9/16" and 3/4" and 1/2" turn for tubing O.D. 1" with a wrench.

Reinstallation Instructions

1. Insert the tubing with preassembled ferrules into the fitting body or the valve.
2. While holding the fitting body or the valve steady, for tubing O.D. 1", tighten the nut to the previous assembly position and further tighten it with a wrench; for other dimension tubing, tighten the nut 1/4 turn with a wrench for the initial reinstallation, and for reinstallations thereafter, tighten the nut to the previous assembly position and further tighten it with a wrench.

For Plugs

1. Insert the plug into the fitting body or the valve.
2. For initial installation, finger tight the nut, further wrench tighten 1/2 turn while holding the fitting body or the valve body steady. For reinstallations thereafter, starting from the final tightened position in the previous assembly, further wrench tighten as may be necessary.

Cautions

1. Tube end includes tubing, ferrules and ferrule nut.
2. Do not loosen or tighten fittings when the system is pressurized.
3. When assembling a tube fitting, screw the nut while holding the body steady.

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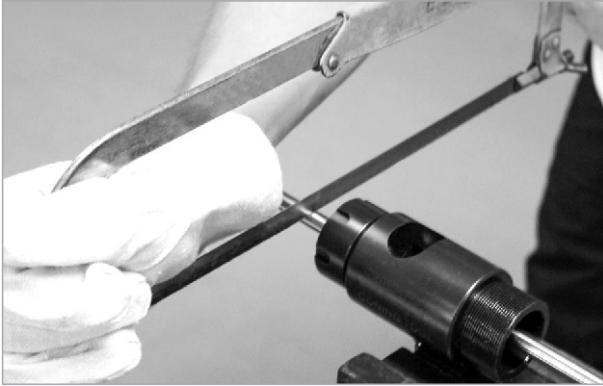
Installation of Medium & High Pressure Coned and Threaded Connections

1. Cut off tubing to desired length and deburr ends.

Note: When cutting tubing with abrasive cutting off wheel, tubing should not be over heated effecting material properties.

Tips: The housing assemblies of manual coning tool can be used to clamp the tubing.

Suitable manual reseating tool can help to deburr ends.



The length L can be calculated by this way:

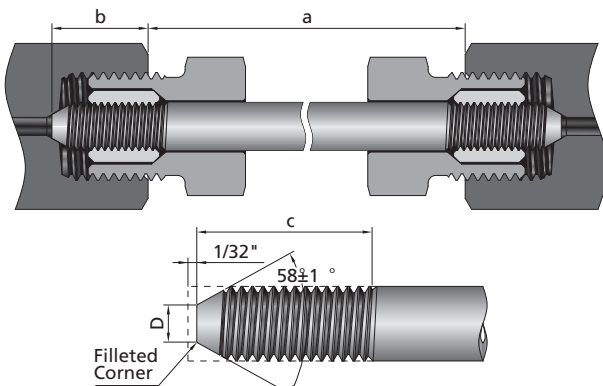


Fig.1

$$L = a + 2b + 2 \times 1/32''$$

L: Tubing length

a: Component distance

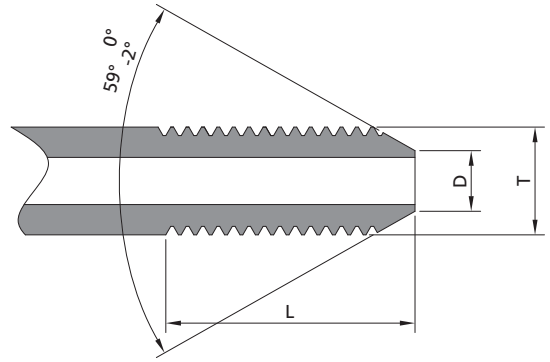
b: Tubing engagement (please see the table below)

1/32'': Standard face distance per tubing

Rated Pressure psig (bar)	Connection Type	Tube O.D. x I.D. in.	b in. (mm)
20000 (1379)	MF4	1/4 × 0.109	0.55(13.97)
	MF6	3/8 × 0.203	0.69(17.53)
	MF9	9/16 × 0.312	0.84(21.34)
60000 (4137)	HF4	1/4 × 0.083	0.50(12.70)
	HF6	3/8 × 0.125	0.69(17.53)
	HF9	9/16 × 0.188	0.84(21.34)

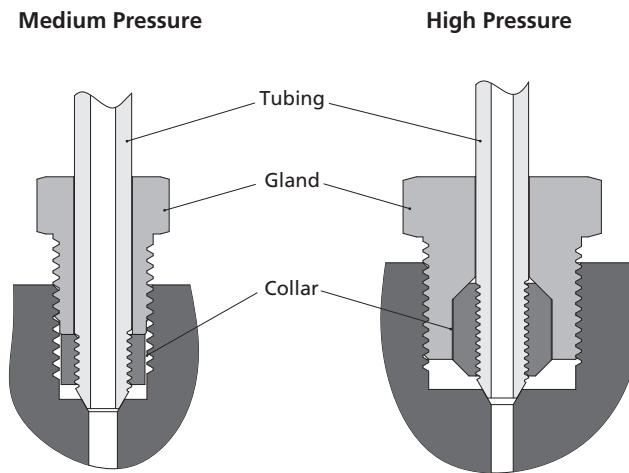
2. Process the tube end into the structure as shown on the right. For dimensions please see the table below.

Tips: For 1/4", 3/8" and 9/16" O.D. tubing, manual coning and threading tools can be used to make coned and threaded nipples.



Tube O.D. x I.D. in.	Connection	T - Thread Size (Left Hand)	D in. (mm)	L in. (mm)
1/4 x 0.109	MF4	1/4-28 UNF	0.14 (3.6)	0.34 (8.7)
3/8 x 0.203	MF6	3/8-24 UNF	0.25 (6.4)	0.44 (11.1)
9/16 x 0.312	MF9	9/16-18 UNF	0.41 (10.3)	0.50 (12.7)
3/4 x 0.438	MF12	3/4-16 UNF	0.56 (14.3)	0.63 (15.9)
1 x 0.562	MF16	1-14 UNS	0.72 (18.3)	0.78 (19.8)
1/4 x 0.083	HF4	1/4-28 UNF	0.13 (3.2)	0.56 (14.3)
3/8 x 0.125	HF6	3/8-24 UNF	0.22 (5.6)	0.75 (19.1)
9/16 x 0.188	HF9	9/16-18 UNF	0.28 (7.1)	0.94 (23.8)

3. First, insert the tube through the gland, and then screw in the collar counterclockwise (left-hand threads) until the conical end of the tube showing 1-2 full threads.
4. Apply thread lubricant evenly on the gland threads, and if possible, coat the cone tip with a small amount of lubricant which is compatible with the system media.



5. Insert the tubing into the connecting port and finger tighten the gland.
6. Use a torque wrench to tighten the gland with the required torque shown in the table below while holding fitting body or valve steady.

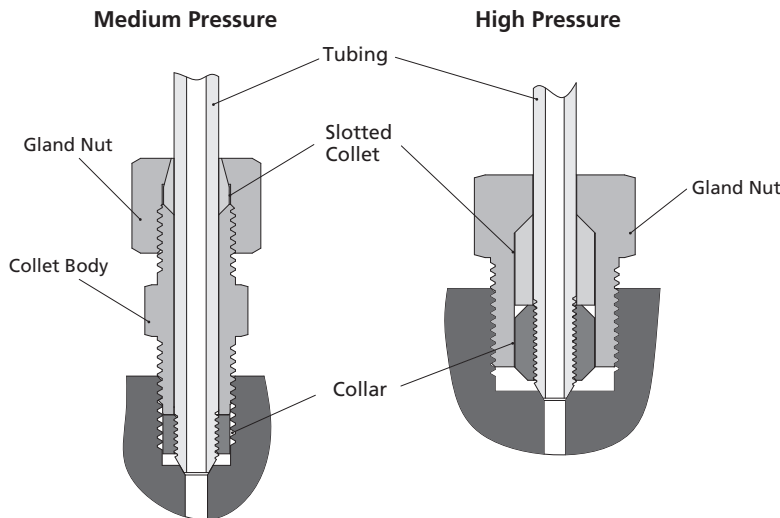
Tube O.D. x I.D. in.	Connection	Required Torque for Standard Service Products ft.-lbs. (N.m) ^①	Required Torque for Sour Service Products ft.-lbs. (N.m) ^①
1/4 x 0.109	MF4	20 (27.1)	10 (13.6)
3/8 x 0.203	MF6	30 (40.6)	15 (20.3)
9/16 x 0.312	MF9	55 (74.5)	30 (40.7)
3/4 x 0.438	MF12	90 (122)	45 (61.0)
1 x 0.562	MF16	125 (170)	100 (135.6)
1/4 x 0.083	HF4	25 (33.9)	15 (20.3)
3/8 x 0.125	HF6	50 (67.8)	25 (33.9)
9/16 x 0.188	HF9	110 (149.1)	55 (74.6)

Installation of Medium & High Pressure Anti-Vibration Gland Assembly

Anti-Vibration Gland Assembly replaces the standard gland.

1. Insert coned and threaded tubing through the Anti-Vibration Gland Assembly in the correct order as shown in the following figure, and then screw in the collar until the conical end of the tube showing 1-2 full threads.
2. For 20M series medium pressure Anti-Vibration Gland Assembly, tighten collet body to required torque for standard fittings while holding fitting body or valve steady. Then finger tighten the gland nut, and tighten the gland nut 1-1/4 turns for initial installation with a wrench while holding the collet body steady. For reinstallation, tighten the gland nut with a wrench from finger tight to 3/4 turn.
3. For 60H series high pressure Anti-Vibration Gland Assembly, use a torque wrench to tighten the gland nut with the required torque shown in the table below while holding fitting body or valve steady.

Tube O.D. x I.D. in.	Connection	Required Torque ft.-lbs. (N.m)
1/4 x 0.083	HF4	10 (13.6)
3/8 x 0.125	HF6	28 (38.0)
9/16 x 0.188	HF9	75 (101.7)



Note: When installing, please follow the given method and required torque ; otherwise it will affect the performance of the product.

Fittings
Tubing
Quick Couplings
Line Filters
Valves
Sour Service Products
Subsea Valves
Part Number Crossover Charts