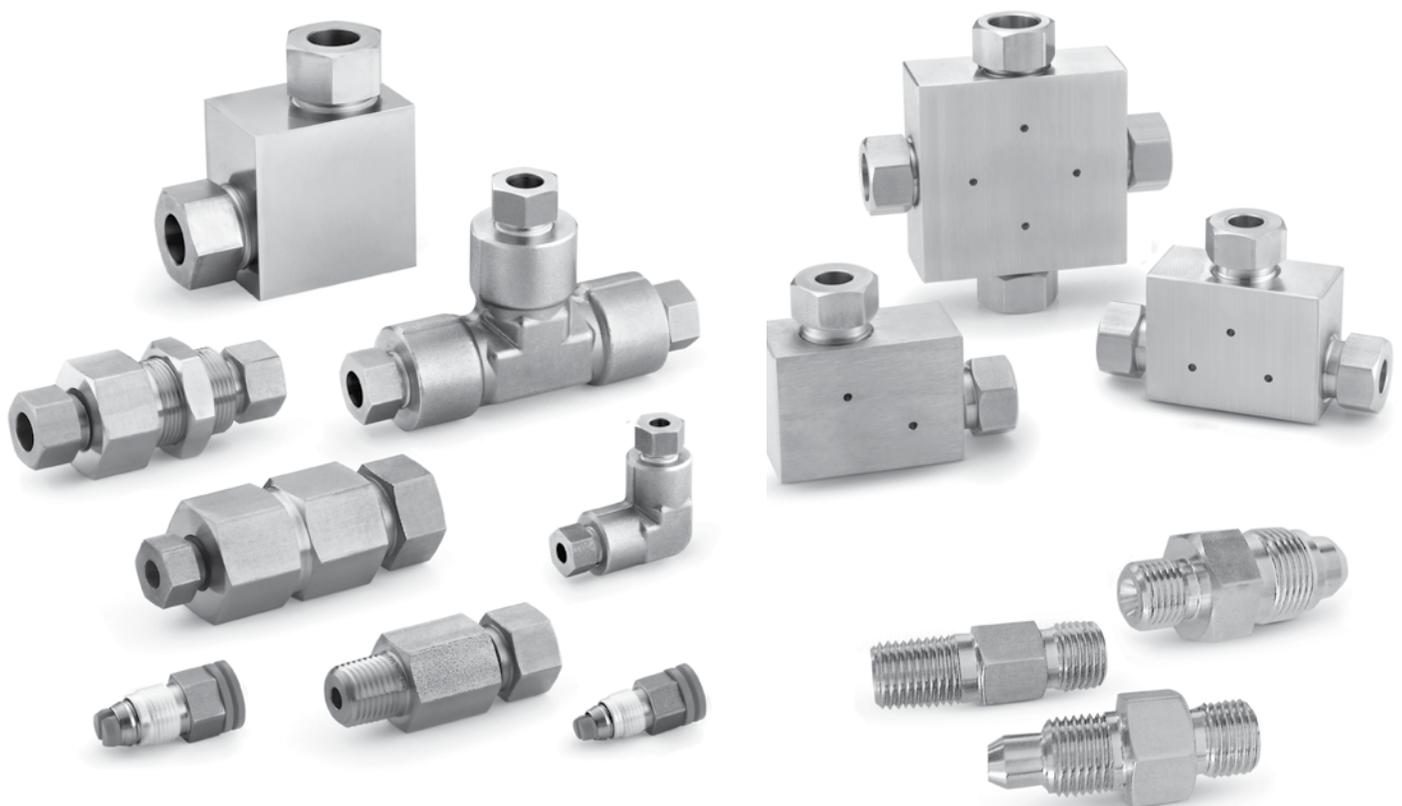


Swagelok® Medium- and High-Pressure Fittings and Adapters—Alloy Materials

Alloy 2507 and Alloy 625

For Pressures up to 40 000 psig (2756 bar)



FK and IPT Series

- Cone and thread or medium-pressure tube fitting connections
- Excellent corrosion resistance in chloride-containing environments
 - Alloy 625 meets NACE® MR0175/ISO15156
 - Alloy 2507 meets NACE® MR0175/ISO15156 and NORSOK M-630 and M-650

Swagelok® Medium- and High-Pressure Fittings

Since 1947, Swagelok has designed, developed, and manufactured high-quality fluid system products to meet the evolving needs of global industries. Our focus is on understanding our customers' needs, finding timely solutions, and adding value with our products and services.

This catalog provides the technical detail required for alloy medium and high pressure products that are used in high chloride applications. In the following pages you will find technical and ordering information for Swagelok cone and thread and medium-pressure tube fittings. These products have the following pressure characteristics:

Product Type		Maximum Working Pressure, psig (bar)			
		Medium Pressure		High Pressure	
		Alloy 2507	Alloy 625	Alloy 2507	Alloy 625
IPT Series	Cone & Thread Fittings, Adapters, and Couplings	Up to 20 000 (1378)	Up to 15 000 (1034)	Up to 40 000 (2756)	Up to 36 000 (2480)
	Cone & Thread Tubing	Up to 20 000 (1378)		Up to 40 000 (2756)	Up to 36 000 (2480)
FK Series	Medium Pressure Gaugeable Tube Fitting	No		No	No
	Tubing	Up to 20 000 (1378) ^①		No	No

① For stainless steel products using alloy 2507 tubing options, up to 20 000 psig (1378 bar), see catalog MS-02-472.

Applications

Medium- and high-pressure fittings and components are designed to meet requirements of demanding applications such as the following:

- Oil and gas
 - Wellhead control panels
 - Hydraulic control panels
 - Grease injector units
 - Blowout preventers
 - Chemical injection skids

Product Ratings

Swagelok Company rates products based on the principles of two ASME standards:

- ASME B31.3, Process Piping (Base Code)
- ASME B31.3, Process Piping, Chapter IX High Pressure Piping (Chapter IX)

As such, some products reference two pressure ratings for the same product. To ensure safe product selection, it is important for the system designer and user to understand how each standard applies to the application when selecting a product.

Compatibility of Cone and Thread Fittings

Swagelok IPT series medium- and high-pressure cone and thread fittings may be assembled with cone and thread fittings and tube end assemblies from other manufacturers who follow the dimensions referenced in the table “Dimensions—Cone & Thread End Connections,” on page 20.

Important: The above statement applies *only* to Swagelok IPT series medium- and high-pressure cone and thread fittings.

API-6A, Specification for Wellhead and Christmas Tree Equipment, defines the dimensions for the 9/16 inch high-pressure cone and thread fitting. Swagelok Company complies with the mechanical sealing dimensions called out in this specification. No other sizes or styles of cone and thread fittings or tubing are referenced in API-6A.

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Medium- and High-Pressure Fittings,
Tubing, Valves and Accessories

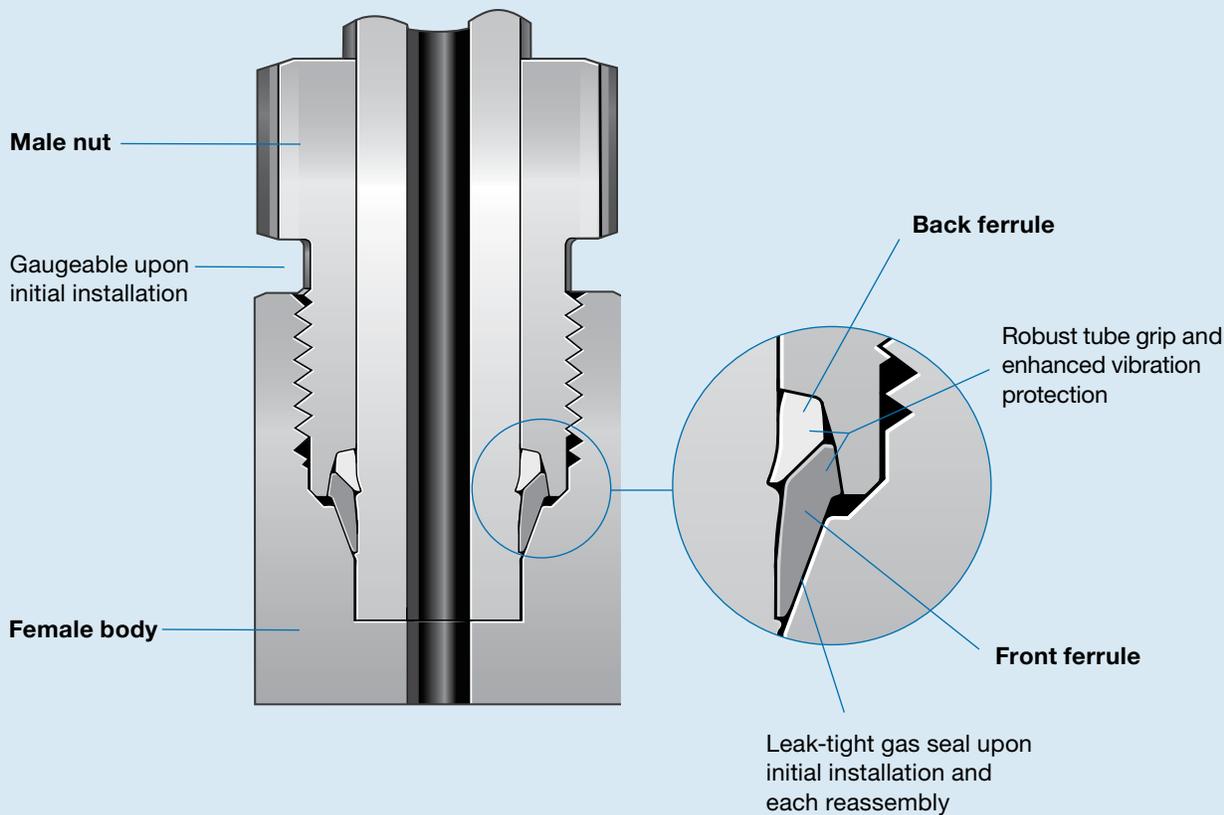
Coning and Threading Tool

Alloy 2507 Tube Fitting

Tube Benders

Lubricants and Sealants

Swagelok Medium-Pressure Tube Fittings



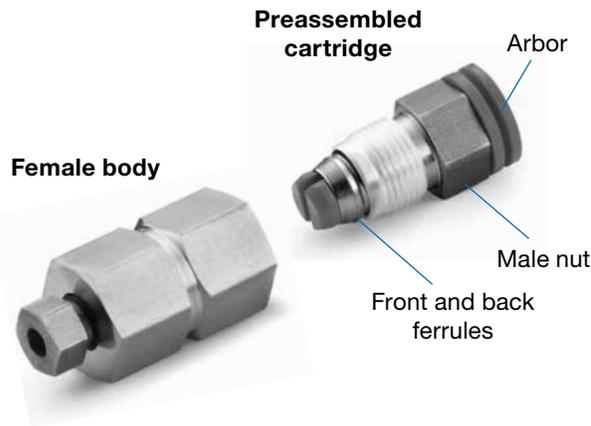
Features

The simple two-piece design of Swagelok patented medium-pressure tube fittings and adapters consists of a female fitting body and preassembled cartridge containing the male nut and front and back ferrules on a disposable plastic arbor. The preassembled cartridge ensures installers of correct ferrule orientation, visual confirmation of ferrule presence, and proper installation into the female body. Components are released only after the nut is threaded finger-tight on the fitting body.

The Swagelok medium-pressure tube fitting offers a leak-tight gas seal and vibration resistance in applications up to 15 000 psig (1034 bar).

Additional features of this tube fitting technology include:

- Patented low-temperature case hardening processing of the ferrules, plus the specially designed ferrule geometry, promotes a hinging-colletting™ action
 - Robust tube grip
 - Enhanced vibration protection
- Materials selected in accordance with NACE MR0175/ISO 15156. For additional information on NACE compliance, see Ordering Information and Dimensions, page 7.
- For stainless steel products using alloy 2507 tubing options, see catalog MS-02-472.



Materials of Construction

Component	Material/ASTM Specification
<i>Body</i>	<i>Alloy 625/B564 or B446</i>
<i>Front ferrule</i>	<i>Alloy 625/B446</i>
Nut ^①	Alloy 625/B446
Back ferrule	Alloy 625/B446

Wetted components listed in *italics*.

① Silver plated.

Pressure Ratings

Pressure ratings are dependent on the end connection or system component with the lowest pressure rating. Ratings for the end connections used in this catalog are identified below.

Swagelok Medium-Pressure Tube Fittings

Swagelok medium-pressure ends are rated to the working pressure of the tubing as listed below. Calculations are based on maximum outside diameter and minimum wall thickness.

Heavy-Wall Annealed Alloy 625 Tubing^①

Allowable working pressures are calculated from an S value of 40 000 psi (275.7 MPa) for ASTM B444 Grade 1 tubing at –20 to 100°F (–28 to 37°C), as listed in ASME B31.3, Table A-1; tubing outside diameter and wall thickness tolerances from ASTM B444 for small-diameter tube. See **Elevated Temperature Factors** for tubing used above 100°F (37°C).

Tube OD in.	Tube Wall Thickness, in.					
	0.035	0.049	0.065	0.083	0.109	0.165
	Working Pressure, psig (bar)					
1/4	11 200 (772)	15 000 (1034)	15 000 (1034)			
3/8		10 300 (710)	14 200 (978)	15 000 (1034)		
1/2			10 300 (710)	13 500 (930)	15 000 (1034)	
3/4						15 000 (1034)

① No allowance is made for corrosion, erosion, or elevated temperatures.

Suggested Ordering Information

Fully annealed, high-quality type alloy 625 tubing ASTM B444 Grade 1 or equivalent. Hardness not to exceed 25 HRC or 226 HV. Tubing to be free of scratches and suitable for bending and flaring.

Elevated Temperature Factors

To determine allowable working pressure at elevated temperatures, multiply allowable working pressures from the tables above by a factor shown in the table below.

Temperature		Alloy 625 Grade 1 Tubing
°F	°C	
200	93	1.00
400	204	1.00
600	315	0.95
800	426	0.93
1000	537	0.93

Example: heavy-wall alloy 625 tubing 1/4 in. OD × 0.065 in. wall at 1000°F (537°C):

- The allowable working pressure at –20 to 100°F (–28 to 37°C) is 15 000 psig (1034 bar).
- The elevated temperature factor for 1000°F (537°C) is 0.93:
 $15\,000\text{ psig (1034 bar)} \times 0.93 = 13\,950\text{ psig (961 bar)}$

The allowable working pressure for heavy-wall annealed alloy 625 tubing 1/4 in. OD × 0.065 in. wall at 1000°F (537°C) is 13 950 psig (961 bar).

NPT End Connections^①

Male and Female NPT Size in.	Pressure Rating psig (bar)
1/4, 3/8, 1/2	12 000 (826)
3/4	10 000 (689)

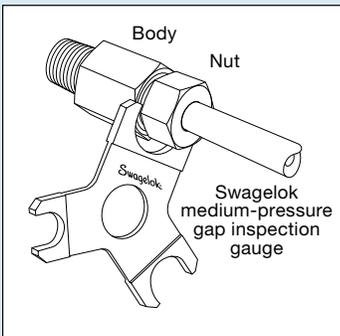
① No allowance is made for corrosion, erosion, or elevated temperatures.

Tubing/Fitting Compatibility Matrix

The medium-pressure FK series tubing and the IPT series cone and thread tubing generally are not compatible with other series of medium- and high-pressure fittings in this catalog. See the table below for compatibility by series.

Tubing		Fitting	
Description	Sizing	FK Series Medium Pressure	IPT Series Cone & Thread Medium & High Pressure
FK Series Medium-Pressure Tubing	True OD Tubing	Yes, except 9/16 in.	No
IPT Series Cone & Thread Tubing	Nominal OD Tubing	9/16 and 3/4 in. ONLY	Yes

Gaugeability



On initial installation, the **Swagelok medium-pressure gap inspection gauge** assures the installer or inspector that a fitting has been sufficiently tightened.

Position the Swagelok medium-pressure gap inspection gauge next to the gap between the nut and body.

- If the gauge will not enter the gap, the fitting is sufficiently tightened.
- If the gauge will enter the gap, additional tightening is required.

Cleaning and Packaging

All medium-pressure fittings are cleaned in accordance with Swagelok *Standard Cleaning and Packaging (SC-10)*, MS-06-62.

Each medium-pressure fittings includes one preassembled cartridge that contains the male nut and front and back ferrules on a disposable plastic arbor.

Ordering Information and Dimensions

Dimensions are for reference only and are subject to change. Dimensions shown are with Swagelok nuts finger-tight.

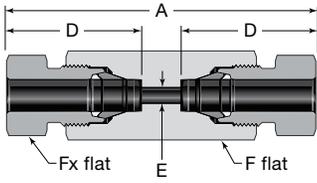
Standard products are NACE compliant up to 300°F (149°C) at any H₂S partial pressure. For NACE compliant applications above 300°F (149°C) at any H₂S partial pressure, add **-SG2** to the ordering number.

Example: 625-4FK0-6-**SG2**

Additional configurations and adapters are available on request. Contact your authorized Swagelok sales and service representative.

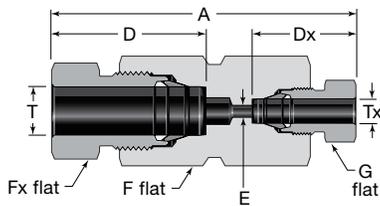
Straight Fittings

Unions



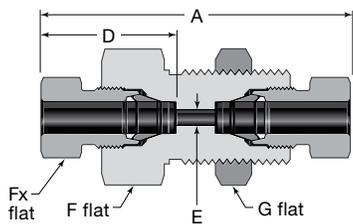
Union

Tube OD in.	Ordering Number	Dimensions, in.				
		A	D	E	F	Fx
1/4	625-4FK0-6	2.25	1.08	0.13	11/16	9/16
3/8	625-6FK0-6	2.81	1.34	0.21	13/16	11/16
1/2	625-8FK0-6	3.36	1.59	0.38	1 1/16	7/8
3/4	625-12FK0-6	4.84	2.29	0.56	1 5/8	1 3/8



Reducing Union

Tube OD in.		Ordering Number	Dimensions, in.						
T	Tx		A	D	Dx	E	F	Fx	G
3/8	1/4	625-6FK0-6-4	2.64	1.34	1.08	0.13	13/16	11/16	9/16
1/2	1/4	625-8FK0-6-4	2.90	1.59	1.34	0.13	1 1/16	7/8	9/16
	3/8	625-8FK0-6-6	3.19	1.59	1.34	0.21	1 1/16	7/8	11/16
3/4	1/2	625-12FK0-6-8	4.26	2.29	1.59	0.38	1 5/8	1 3/8	7/8

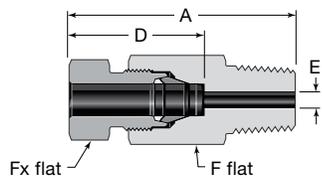


Bulkhead Union

Tube OD in.	Ordering Number	Dimensions, in.							Panel Hole Size	Maximum Panel Thickness
		A	D	E	F	Fx	G			
1/4	625-4FK0-61	2.25	1.08	0.13	1 1/16	9/16	15/16	49/64	0.50	
3/8	625-6FK0-61	2.81	1.34	0.21	1 1/16	11/16	1 1/16	57/64	0.66	
1/2	625-8FK0-61	3.38	1.59	0.38	1 1/2	7/8	1 5/16	1 9/64	0.75	
3/4	625-12FK0-61	4.84	2.29	0.56	2 1/4	1 3/8	2 1/4	1 61/64	1.00	

Straight Fittings

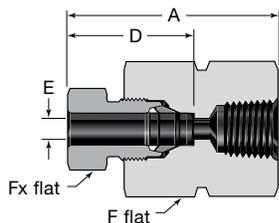
Male Connectors



NPT

Tube OD in.	NPT Size in.	Ordering Number	Dimensions, in.				
			A	D	E	F	Fx
1/4	1/4	625-4FK0-1-4	1.74	1.08	0.13	11/16	9/16
	3/8	625-4FK0-1-6	1.74	1.08	0.13	11/16	9/16
	1/2	625-4FK0-1-8	1.93	1.08	0.13	7/8	9/16
3/8	1/4	625-6FK0-1-4	2.03	1.34	0.21	13/16	11/16
	3/8	625-6FK0-1-6	2.03	1.34	0.21	13/16	11/16
	1/2	625-6FK0-1-8	2.22	1.34	0.21	7/8	11/16
1/2	1/4	625-8FK0-1-4	2.33	1.59	0.25	1 1/16	7/8
	3/8	625-8FK0-1-6	2.33	1.59	0.33	1 1/16	7/8
	1/2	625-8FK0-1-8	2.52	1.59	0.38	1 1/16	7/8
	3/4	625-8FK0-1-12	2.52	1.59	0.38	1 1/16	7/8
3/4	1/2	625-12FK0-1-8	3.37	2.29	0.41	1 5/8	1 3/8
	3/4	625-12FK0-1-12	3.37	2.29	0.56	1 5/8	1 3/8

Female Connectors

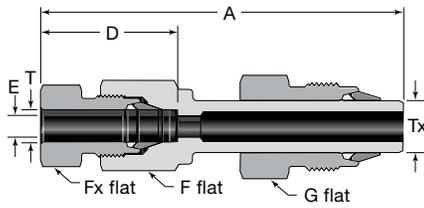


NPT

Tube OD in.	NPT Size in.	Ordering Number	Dimensions, in.				
			A	D	E	F	Fx
1/4	1/4	625-4FK0-7-4	1.85	1.08	0.13	1 1/16	9/16
3/8	1/4	625-6FK0-7-4	2.10	1.34	0.21	1 1/16	11/16
1/2	1/4	625-8FK0-7-4	2.42	1.59	0.38	1 1/16	7/8
	1/2	625-8FK0-7-8	2.66	1.59	0.38	1 1/2	7/8
3/4	1/2	625-12FK0-7-8	3.40	2.29	0.56	1 5/8	1 3/8

Straight Fittings

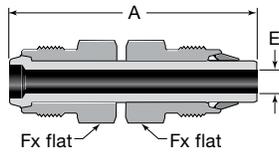
Reducers



Tube OD in.		Ordering Number	Dimensions, in.					
T	Tx		A	D	E	F	Fx	G
1/4	3/8	625-4FK0-R-6FK	2.97	1.08	0.13	11/16	9/16	11/16
	1/2	625-4FK0-R-8FK	3.31	1.08	0.13	11/16	9/16	7/8
3/8	1/2	625-6FK0-R-8FK	3.52	1.34	0.21	13/16	11/16	7/8
1/2	3/8	625-8FK0-R-6FK	3.65	1.59	0.21	1 1/16	7/8	11/16
	3/4	625-8FK0-R-12FK	4.66	1.59	0.38	1 1/16	7/8	1 3/8
3/4	1/2	625-12FK0-R-8FK	4.76	2.29	0.28	1 5/8	1 3/8	7/8

Reducers are furnished with nuts and preswaged ferrules. See page 14 for installation information.

Port Connectors

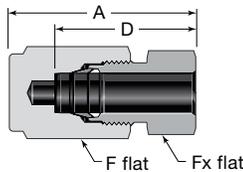


Tube OD in.	Ordering Number	Dimensions, in.		
		A	E	Fx
1/4	625-4FK0-PC	2.06	0.12	9/16
3/8	625-6FK0-PC	2.54	0.21	11/16
1/2	625-8FK0-PC	2.99	0.28	7/8
3/4	625-12FK0-PC	4.22	0.42	1 3/8

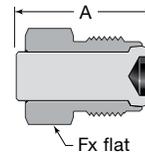
Port connectors are furnished with nuts and preswaged ferrules. See page 14 for installation information.

Caps and Plugs

Cap



Plug

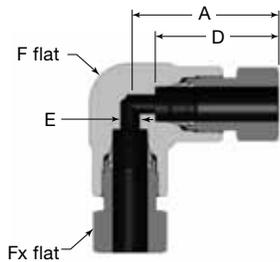


Tube OD in.	Ordering Number	Dimensions, in.			
		A	D	F	Fx
1/4	625-4FK0-C	1.33	1.08	11/16	9/16
3/8	625-6FK0-C	1.74	1.34	13/16	11/16
1/2	625-8FK0-C	2.05	1.59	1 1/16	7/8
3/4	625-12FK0-C	2.86	2.29	1 5/8	1 3/8

Tube OD in.	Ordering Number	Dimensions, in.	
		A	Fx
1/4	625-4FK0-P	1.03	9/16
3/8	625-6FK0-P	1.26	11/16
1/2	625-8FK0-P	1.45	7/8
3/4	625-12FK0-P	1.98	1 3/8

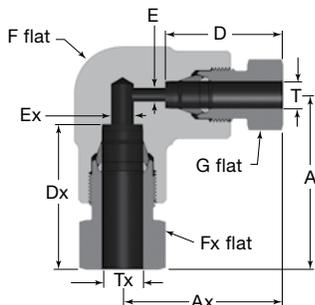
90° Elbows

Unions



Union

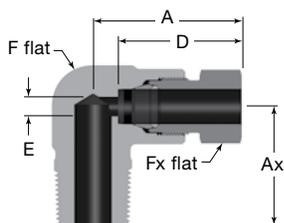
Tube OD in.	Ordering Number	Dimensions, in.				
		A	D	E	F	Fx
1/4	625-4FK0-9	1.48	1.08	0.13	13/16	9/16
3/8	625-6FK0-9	1.61	1.34	0.21	13/16	11/16
1/2	625-8FK0-9	2.62	1.59	0.38	1 1/4	7/8
3/4	625-12FK0-9	2.76	2.29	0.56	1 3/4	1 3/8



Reducing Union

Tube OD in.		Ordering Number	Dimensions, in.								
T	Tx		A	Ax	D	Dx	E	Ex	F	Fx	G
1/4	3/8	625-6FK0-9-4	1.61	1.48	1.08	1.34	0.13	0.21	13/16	11/16	9/16
	1/2	625-8FK0-9-4	2.62	2.40	1.08	1.59	0.13	0.38	1 1/4	7/8	9/16
3/8	1/2	625-8FK0-9-6	2.62	2.53	1.34	1.59	0.21	0.38	1 1/4	7/8	11/16
1/2	3/4	625-12FK0-9-8	2.76	2.44	1.59	2.29	0.38	0.56	1 3/4	1 3/8	7/8

Male

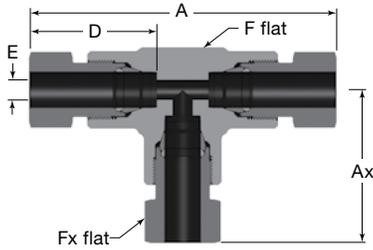


NPT

Tube OD in.	NPT Size in.	Ordering Number	Dimensions, in.					
			A	Ax	D	E	F	Fx
1/4	1/4	625-4FK0-2-4	1.48	1.11	1.08	0.13	13/16	9/16
	3/8	625-4FK0-2-6	1.48	0.97	1.08	0.13	13/16	9/16
	1/2	625-4FK0-2-8	1.48	1.37	1.08	0.13	13/16	9/16
3/8	1/4	625-6FK0-2-4	1.61	0.97	1.34	0.21	13/16	11/16
	3/8	625-6FK0-2-6	1.61	0.97	1.34	0.21	13/16	11/16
	1/2	625-6FK0-2-8	1.61	1.30	1.34	0.21	13/16	11/16
1/2	1/4	625-8FK0-2-4	2.62	1.48	1.59	0.25	1 1/4	7/8
	3/8	625-8FK0-2-6	2.62	1.48	1.59	0.28	1 1/4	7/8
	1/2	625-8FK0-2-8	2.62	1.67	1.59	0.28	1 1/4	7/8
3/4	1/2	625-12FK0-2-8	2.76	2.11	2.29	0.41	1 3/4	1 3/8
	3/4	625-12FK0-2-12	2.76	2.11	2.29	0.56	1 3/4	1 3/8

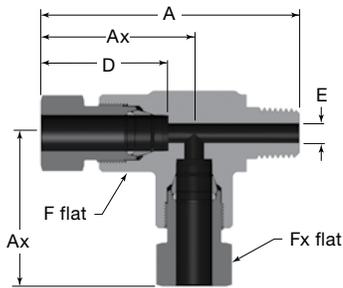
Tees

Unions



Tube OD in.	Ordering Number	Dimensions, in.					
		A	Ax	D	E	F	Fx
1/4	625-4FK0-3	2.96	1.48	1.08	0.13	13/16	9/16
3/8	625-6FK0-3	3.23	1.61	1.34	0.21	13/16	11/16
1/2	625-8FK0-3	5.24	2.62	1.59	0.38	1 1/4	7/8
3/4	625-12FK0-3	5.51	2.76	2.29	0.56	1 3/4	1 3/8

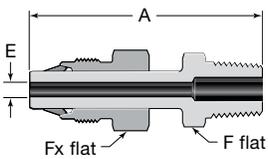
Male Run, NPT (TMT)



Tube OD in.	NPT Size in.	Ordering Number	Dimensions, in.					
			A	Ax	D	E	F	Fx
1/4	1/4	625-4FK0-3-4TMT	2.59	1.48	1.08	0.13	13/16	9/16
3/8	1/4	625-6FK0-3TMT	2.72	1.61	1.34	0.21	13/16	11/16
1/2	1/4	625-8FK0-3-4TMT	4.10	2.62	1.59	0.25	1 1/4	7/8
	3/8	625-8FK0-3TMT	4.10	2.62	1.59	0.28	1 1/4	7/8
3/4	3/4	625-12FK0-3TMT	4.49	2.76	2.29	0.56	1 3/4	1 3/8

Tube Adapters

Male NPT



Tube OD in.	NPT Size in.	Ordering Number	Dimensions, in.			
			A	E	F	Fx
1/4	1/4	625-4FK-TA-1-4	2.18	0.12	9/16	9/16
3/8	1/4	625-6FK-TA-1-4	2.53	0.21	9/16	11/16
	1/2	625-6FK-TA-1-8	2.78	0.21	7/8	11/16
1/2	1/4	625-8FK-TA-1-4	2.87	0.25	9/16	7/8
	1/2	625-8FK-TA-1-8	3.12	0.28	7/8	7/8
3/4	3/4	625-12FK-TA-1-12	3.92	0.42	1 1/16	1 3/8

Tube adapters are furnished with nuts and preswaged ferrules. See page 14 for installation information.

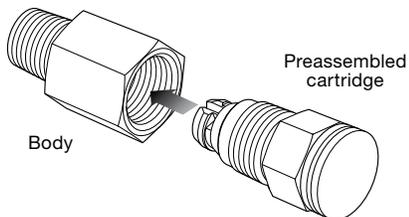
Installation Instructions

Medium-Pressure Tube Fitting Assembly—Alloy 625 Material

These instructions apply to alloy 625 medium-pressure tube fitting sizes from 1/4 to 3/4 in.

For 3/4 in. medium-pressure tube fittings *only*, you can use the Swagelok multihead hydraulic swaging unit (MHSU) to preswage the ferrules onto the tube and install in accordance with **Connections Preswaged with the MHSU**, page 14.

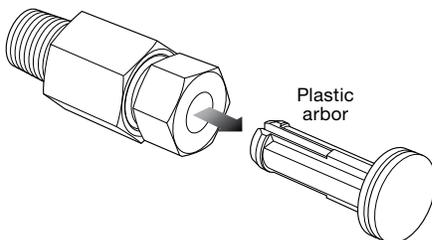
Fig. 1



1. Thread the preassembled cartridge (nut, ferrules, and plastic arbor) into the fitting body until finger-tight (Fig. 1).

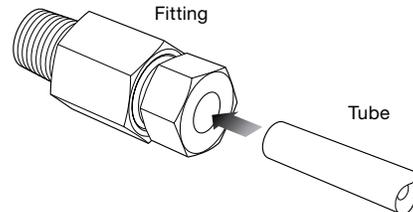
For temperatures above 400°F (204°C), use Silver Goop™ high-temperature thread lubricant on fitting nut threads.

Fig. 2



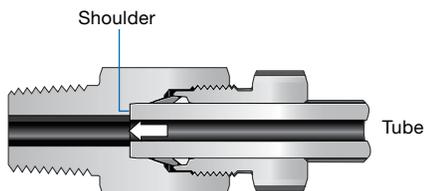
2. Remove the plastic arbor (Fig. 2).

Fig. 3



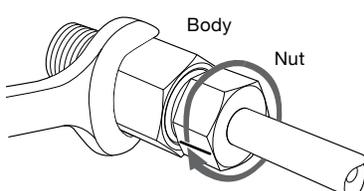
3. Insert the tube into the fitting (Fig. 3).

Fig. 4



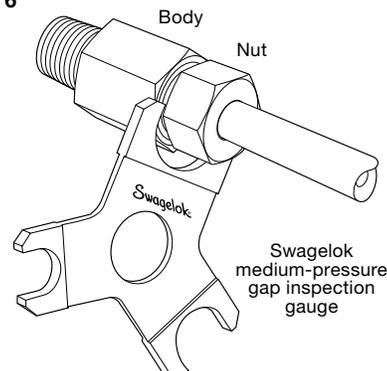
4. Make sure that the tube rests firmly on the shoulder of the fitting body (Fig. 4).

Fig. 5



5. Mark the nut, then hold the body steady and tighten the nut one full turn (Fig. 5).

Fig. 6



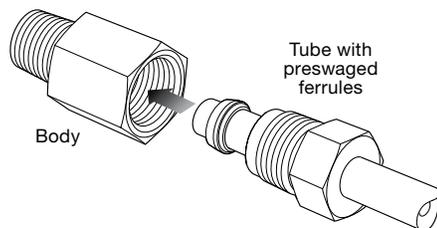
6. Use the Swagelok medium-pressure gap inspection gauge to ensure that the fitting has been tightened sufficiently (Fig. 6).

Installation Instructions

Connections Preswaged with the MHSU

These instructions apply to 3/4 in. alloy 625 medium-pressure tube fittings *only*. These fittings can also be assembled in accordance with **Medium-Pressure Tube Assembly**, page 13.

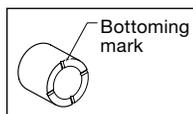
Fig. 1



1. Preswage the ferrules onto the tube using a Swagelok multihead hydraulic swaging unit (MHSU) and the appropriate medium-pressure tooling.

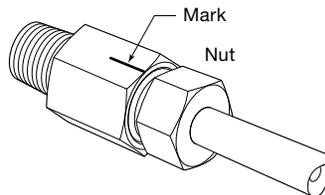
See the *Multihead Hydraulic Swaging Unit (MHSU) Setup and Operating Instructions*, MS-12-37.

2. Inspect the tube end for a bottoming mark. This radial indentation



indicates the tube was properly bottomed in the MHSU. If there is not a visible indentation, the preswaged assembly should not be used.

Fig. 2



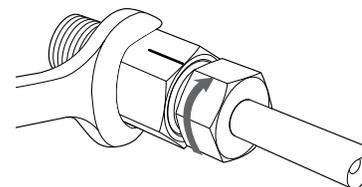
The MHSU should be used to preswage a set of ferrules only one time. If the ferrules were insufficiently preswaged, discard the ferrules and started the process again with a new set of ferrules.

3. Insert the tube with preswaged ferrules into the fitting until the front ferrule seats against the fitting body; rotate the nut finger-tight (Fig. 1).

For temperatures above 400°F (204°C), use Silver Goop high-temperature thread lubricant on fitting nut threads.

4. Place a mark on the fitting body in line with one of the hex points of the nut (Fig. 2).

Fig. 3



5. Hold the fitting body steady and tighten the nut one-third turn (Fig. 3). This is equivalent to advancing the nut two hex points from the mark.

6. Use the Swagelok medium-pressure gap inspection gauge to ensure that the fitting has been tightened sufficiently.

Caps and Plugs

Caps Installation

See **Medium-Pressure Tube Fitting Assembly**, page 13.

Plugs Installation

Hold the body steady and tighten the plug one-quarter turn from the finger-tight position.

Port Connectors Installation

For installation of the machined ferrule end of the port connector, see **Plugs Installation**, this page.

For installation of the pre-swaged ferrule end of the port connector, see **Tube Adapters and Reducers Installation**, this page.

Tube Adapters and Reducers Installation

For initial installation, insert the tube with preswaged ferrules into the body; rotate the nut finger-tight.

For temperatures above 400°F (204°C), use Silver Goop high-temperature thread lubricant on fitting nut threads.

- For preswaged 1/2 in. and smaller fittings, hold the body steady and rotate the nut to the previously pulled-up position. At this point, you will feel a significant increase in resistance. Tighten the nut an additional one-fourth turn.
- For preswaged 3/4 in. fittings, hold the fitting body steady and tighten the nut one-third turn.

Installation Instructions

Preswaging Tool

These instructions apply to alloy 625 medium-pressure tube fitting sizes from 1/4 to 1/2 in.

Fig. 1

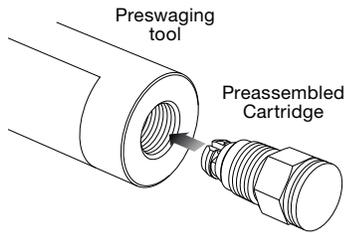


Fig. 2

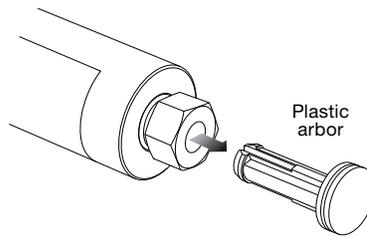


Fig. 3

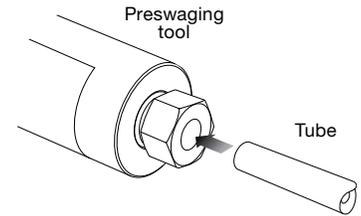


Fig. 4

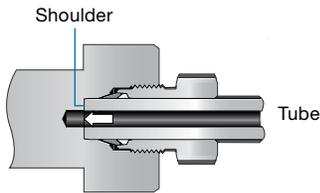


Fig. 5

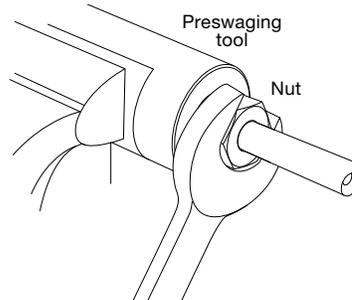


Fig. 6

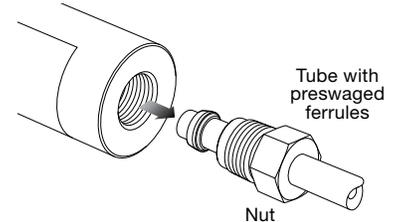


Fig. 7

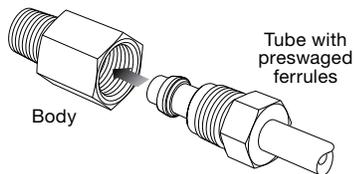
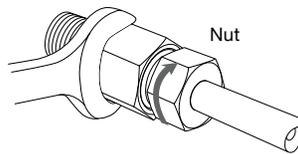


Fig. 8



1. Thread the preassembled cartridge (nut, ferrules, and plastic arbor) into the preswaging tool until finger-tight (Fig. 1).
2. Remove the plastic arbor (Fig. 2).
3. Insert the tube into the preswaging tool (Fig. 3).
4. Make sure that the tube rests firmly on the shoulder of the preswaging tool body; rotate the nut finger-tight (Fig. 4).

5. Hold the preswaging tool steady, mark the nut, then tighten the nut three-quarters turn (Fig. 5).

6. Loosen the nut.
7. Remove the tube with preswaged ferrules from the preswaging tool (Fig. 6).

If the tube sticks in the preswaging tool, remove the tube by gently rocking it back and forth. Do not turn the tube.

8. Insert the tube with preswaged ferrules into the fitting until the front ferrule seats against the fitting body; rotate the nut finger-tight (Fig. 7).

For temperatures above 400°F (204°C), use Silver Goop high-temperature thread lubricant on fitting nut threads.

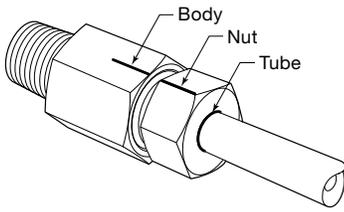
9. Rotate the nut to the previously pulled-up position. At this point, you will feel a significant increase in resistance. Tighten the nut an additional one-fourth turn with a wrench (Fig. 8).

⚠ Do not use a gap inspection gauge with fittings that were assembled using the preswaging tool.

Installation Instructions

Medium-Pressure Tube Fitting Reassembly—Alloy 625 Material

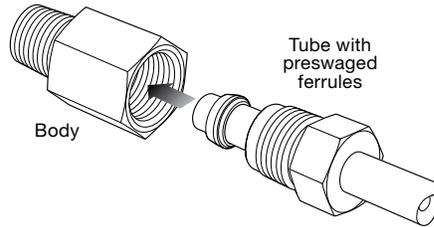
Fig. 1



You may disassemble and reassemble alloy 625 Swagelok medium-pressure tube fittings many times.

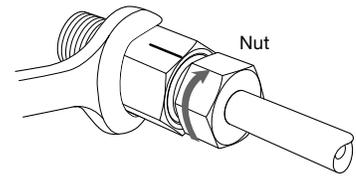
1. Prior to disassembly, mark the tube at the back of the nut; mark a line along the nut and fitting body flats. (Fig. 1). Use these marks to ensure that you return the nut to the previously pulled up position.

Fig. 2



2. Insert the tube with the preswaged ferrules into the fitting body until the front ferrule seats against the fitting body (Fig. 2).

Fig. 3



3. While holding the fitting body steady, rotate the nut with a wrench to the previously pulled-up position as indicated by the marks on the tube and flats. At this point, you will feel a significant increase in resistance. Tighten the nut slightly (Fig. 3).

⚠ Do not use a gap inspection gauge with reassembled fittings.

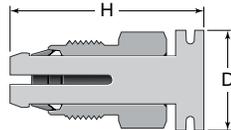
Replacement Parts

Nut and Ferrules Cartridge

Each cartridge contains a front ferrule, back ferrule, and male nut. Cartridges are assembled on orange arbors.



⚠ Do not use medium-pressure nut and ferrules with any other Swagelok tube fittings.



Tube OD	Ordering Number	Dimensions	
		D	H
Dimensions, in.			
1/4	625-4FK-NFSET	0.69	1.43
3/8	625-6FK-NFSET	0.81	1.72
1/2	625-8FK-NFSET	1.00	1.97
3/4	625-12FK-NFSET	1.60	2.59

Tools and Accessories

Preswaging Tool



For Swagelok tube fitting installations in close quarters, the Swagelok preswaging tool is a convenient accessory.

Tube OD	Ordering Number
Dimensions, in.	
1/4	MS-ST-4FK0
3/8	MS-ST-6FK0
1/2	MS-ST-8FK0

Depth Marking Tool



Swagelok depth marking tools help ensure that tubing is bottomed on the shoulder inside the Swagelok tube fitting body.

Tube OD	Ordering Number
Dimensions, in.	
1/4	MS-DMT-4FK0
3/8	MS-DMT-6FK0
1/2	MS-DMT-8FK0
3/4	MS-DMT-12FK0

Multihead Hydraulic Swaging Unit (MHSU)

- Preswages Swagelok 3/4 in. medium-pressure ferrules onto tubing
- Is standard with a tube marking feature to indicate when tube is properly bottomed
- Requires the 1 in./25mm and over MHSU unit and medium-pressure tooling

⚠ The MHSU cannot be used for preswaging 1/2 in. and under medium-pressure fittings.



1 in./25 mm and Over MHSU Unit Components

- Multihead hydraulic swaging unit
- 6 ft (1.8 m) hydraulic hose
- Retaining ring pliers
- Safety glasses
- Operating instructions
- Carrying case

Medium-Pressure Tooling Kit Components

- Die head set for Swagelok 3/4 in. medium-pressure tube fitting
- Gap inspection gauge

Description	Ordering Number
MHSU only (1 in./25 mm and over size)	MS-MHSU-O-E
3/4 in. medium-pressure tooling	MS-MHSUT-O-12FK-M

See the Swagelok *Gaugeable Tube Fittings and Adapter Fittings* catalog, MS-01-140, for more information about the MHSU.

See the Swagelok *Multihead Hydraulic Swaging Unit (MHSU) Setup and Operating Instructions*, MS-12-37, for instructions.

Tools and Accessories

Medium-Pressure Gap Inspection Gauge

The Swagelok medium-pressure gap inspection gauge assures the installer or inspector that the fitting has been sufficiently pulled up on initial installation, whether using a torque wrench, standard wrench tightening, or preswaging with the MHSU.



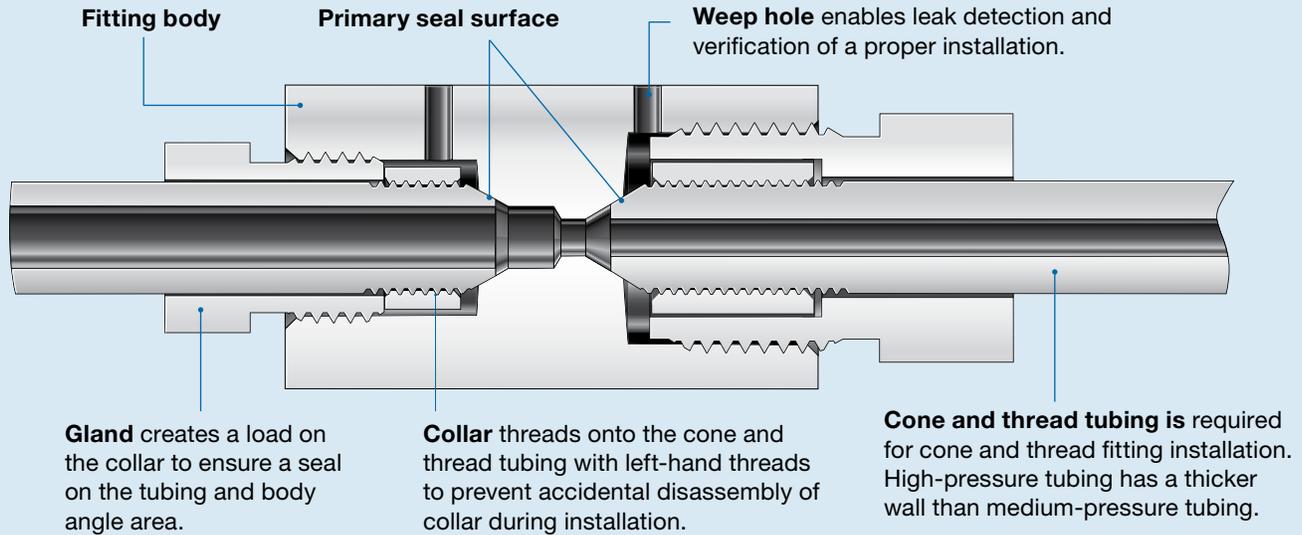
Tube OD in.	Ordering Number
1/4, 3/8, 1/2	MS-IG-FK0
3/4	MS-IG-12FK0

⚠ The medium-pressure gap inspection gauge is different from the gap gauge for all other Swagelok tube fittings.

Cone and Thread Fitting—IPT Series

Medium-pressure cone and thread end connection shown on left side of fitting

High-pressure cone and thread end connection shown on right side of fitting



Cone and Thread Fittings—IPT Series



Features

- All C&T adapters and couplings materials meet NACE MR0175/ISO 15156.
 - Alloy 2507 NORSOK M-630 and M-650
- Sizes available:
 - Medium-pressure—1/4 to 1 1/2 in.
 - High-pressure—1/4 to 9/16 in.

Pressure Ratings

Working pressure ratings are calculated from S values based on ASME B31.3 Process Piping, Chapter IX High Pressure Piping calculations.

Pressure ratings are dependent on the end connection or system component with the lowest pressure rating.

Ratings apply to annealed materials listed in the **Materials of Construction**.

For lower temperature use, see Alloy 2507 **Low-Temperature Ratings**.

- **Medium-pressure cone and thread end connections:**
 - Alloy 2507 rated up to 20 000 psig (1378 bar).
 - Alloy 625 rated up to 15 000 (1034) bar.
- **High-pressure cone and thread end connections:**
 - Alloy 2507 rated up to 40 000 psig (2756 bar).
 - Alloy 625 rated up to 36 000 (2480) bar.

Pressure Ratings

Elevated Temperature Factors

Multiply the working pressure from the table above by the appropriate factor to obtain working pressure at elevated temperatures.

Example: 1/4 in. annealed alloy 625 medium pressure Cone and Thread coupling at 500°F (260°C):

The working pressure at 100°F (37°C) is 15 000 psig (1034 bar).

The temperature factor for 500°F (260°C) is 0.97.

15 000 psig (1034 bar) × 0.97 is 14 550 psig (1003 bar).

1/4 in. annealed alloy 625 medium pressure Cone and Thread coupling at 500°F (260°C) is 14 550 psig (1003 bar).

Temperature		Factor	
°F	°C	Annealed Alloy 2507	Grade 1 Annealed Alloy 625
100	37	1	1
200	93	1	1
300	148	0.91	1
400 ^①	204	0.86	1
500	260		0.97
600	315		0.94
700	371		0.92
800	426		0.9
900	482		0.88
1000	537		0.87

^① Use of annealed alloy 2507 super duplex stainless steel at temperatures above 482°F (250°C) causes microstructural changes that lead to embrittlement and loss of corrosion resistance.

Alloy 2507 Low-Temperature Ratings

Fitting pressure ratings are for metal temperatures from –50 to 100°F (–46 to 37°C), based on –50°F (–46°C) impact tests performed on 2507 bar and forgings.

However, the NORSOK M-001 Materials Selection standard allows this tubing to be used at a minimum temperature of –50°F (–46°C). According to the NORSOK M-630 Material Data Sheets for Piping, 2507 tubing does not have to undergo low-temperature impact testing so long as wall thicknesses are below 0.236 in. (6 mm).

Materials of Construction

Component	Material/ASTM Specification	
	Annealed Alloy 2507	Grade 1 Annealed Alloy 625
<i>Body</i>	ASTM A479	ASTM B446
Gland	ASTM A479	ASTM B446
Collar	ASTM A479	ASTM B446

Wetted components listed in *italics*.

Tubing/Fitting Compatibility

For Tubing/Fitting Compatibility Matrix on page 7.

Alloy Tubing Selection

- High-quality, fully annealed alloy 625 tubing ASTM B444 Grade 1 or equivalent. Hardness not exceeding 25 HRC.
- High-quality, fully annealed alloy 2507 super duplex tubing, ASTM A789 or equivalent. Hardness not to exceed 32 HRC.
- Tubing to be free of detectable seams, laps, flaws, and fissures.
- Tubing shall meet the dimensions shown with total included run-out between the ID and OD not to exceed 10% of the average wall.

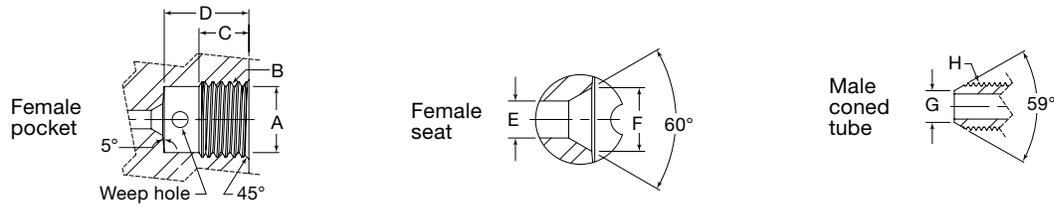
Fractional Tube OD in.	Nominal Tube OD in.	Nominal Tube ID in.	Pressure Rating psig (bar)	
			Alloy 2507	Alloy 625
Medium Pressure				
1/4	0.248 – 0.243	0.104 – 0.109	20 000 (1378)	15 000 (1037)
3/8	0.370 – 0.365	0.198 – 0.203		
9/16	0.557 – 0.552	0.307 – 0.312		
3/4	0.745 – 0.740	0.432 – 0.438		
1	0.995 – 0.990	0.557 – 0.562	15 000 (1037)	–
1 1/2	1.495 – 1.490	0.932 – 0.937		
High Pressure				
1/4	0.248 – 0.243	0.079 – 0.083	40 000 (2756)	36 000 (2480)
3/8	0.370 – 0.365	0.121 – 0.125		
9/16	0.557 – 0.552	0.182 – 0.187		

Cleaning and Packaging

All cone and thread fittings are cleaned in accordance with Swagelok *Standard Cleaning and Packaging (SC-10)*, MS-06-62.

Dimensions—Cone & Thread End Connections

- Dimensions are for reference only and are subject to change.
- Dimensions are the same as stainless steel design.



Fitting Size in.	Dimensions, in. (mm)								Tube Engagement Length
	A	B	C	D	E	F	G	H	
Medium Pressure									
1/4	0.39 (9.9)	7/16-20	0.28 (7.1)	0.50 (12.7)	0.11 (2.8)	0.19 (4.6)	0.14 (3.6)	1/4-28	0.56 (14.2)
3/8	0.52 (13.2)	9/16-18	0.38 (9.7)	0.63 (16.0)	0.20 (5.1)	0.31 (7.9)	0.25 (6.4)	3/8-24	0.69 (17.5)
9/16	0.75 (19.0)	13/16-16	0.44 (11.2)	0.75 (19.0)	0.31 (7.9)	0.50 (12.7)	0.41 (10.4)	9/16-18	0.84 (21.3)
3/4	0.95 (24.1)	3/4-14 NPSM	0.70 (17.8)	0.94 (23.9)	0.44 (11.2)	0.63 (16.0)	0.56 (14.2)	3/4-16	1.00 (25.4)
1	1.30 (33.0)	1 3/8-12	0.81 (20.6)	1.31 (33.3)	0.56 (14.2)	0.88 (22.4)	0.72 (18.3)	1-14	1.47 (37.3)
1 1/2	1.80 (45.6)	1 7/8-12	1.00 (25.4)	1.60 (40.6)	0.94 (23.8)	1.35 (34.3)	1.13 (28.6)	1 1/2-12	1.81 (46.0)
High Pressure									
1/4	0.52 (13.2)	9/16-18	0.38 (9.7)	0.44 (11.2)	0.09 (2.3)	0.17 (4.3)	0.13 (3.3)	1/4-28	0.50 (12.7)
3/8	0.69 (17.5)	3/4-16	0.53 (13.5)	0.63 (16.0)	0.13 (3.3)	0.27 (6.9)	0.22 (5.6)	3/8-24	0.69 (17.5)
9/16	1.05 (26.7)	1 1/8-12	0.62 (15.7)	0.75 (19.0)	0.19 (4.6)	0.38 (9.7)	0.28 (7.1)	9/16-18	0.88 (22.4)

⚠ When interchanging anti-vibration glands, it is recommended to install per the gland manufactures instructions.

Ordering Information and Dimensions

- Alloy cone and thread fittings are not supplied with collars and glands. Collar and glands must be ordered separately. See page 24.
- Collar and glands are shown for dimensional purposes only; dimensions are shown with cone and thread glands finger-tight.
- Dimensions are for reference only and are subject to change.
- Build an alloy cone and thread fitting ordering number by combining the designators as shown below.

1 Basic Ordering Number

2 Cone and Thread Pressure Rating

- 20 = Alloy 2507, MP
- 40 = Alloy 2507, HP
- 15 = Alloy 625, MP
- 36 = Alloy 625, HP

3 Cone and Thread Material

- 2507 = Alloy 2507
- 625 = Alloy 625

4 Nace Compliant Standard

NACE

1 2 3 4
CN6MF 20 - 2507 - NACE

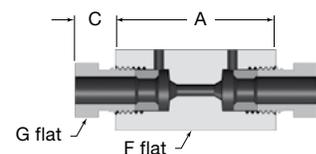
No pressure rating required for collars, glands, caps or plugs.

For adapters and couplings use pressure ratings from table (pages 25-33).

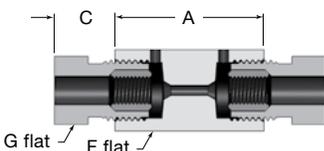
Example: CN4MF15-625-NACE

Couplings

Medium Pressure

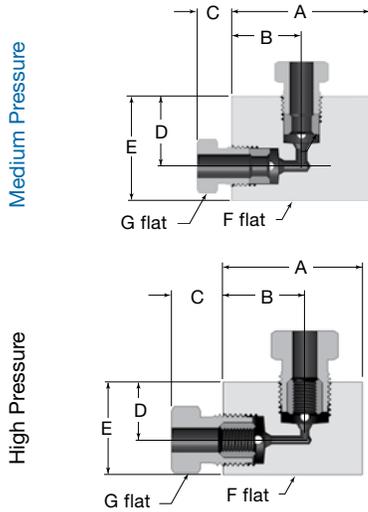


High Pressure



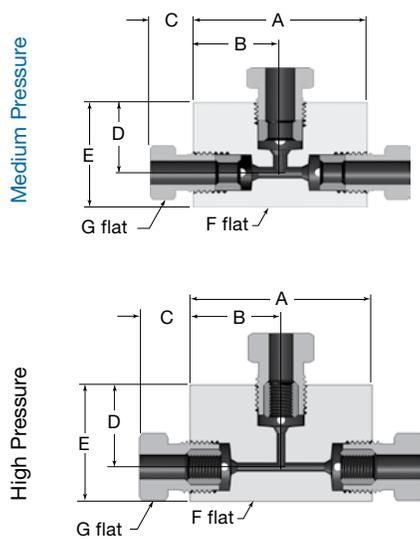
Tube OD in.	Basic Ordering Number	Dimensions, in. (mm)			
		A	C	F	G
Medium Pressure					
1/4	CN4MF	1.50 (38.1)	0.38 (9.7)	3/4	1/2
3/8	CN6MF	1.75 (44.5)	0.48 (12.2)	3/4	5/8
9/16	CN9MF	2.12 (53.8)	0.68 (17.3)	1	7/8
3/4	CN12MF	2.50 (63.5)	0.59 (15.0)	1 3/8	1 3/16
1	CN16MF	3.50 (88.9)	0.74 (18.8)	1 3/4	1 3/8
1 1/2	CN24MF	4.38 (111.2)	1.10 (27.9)	2 1/4	1 7/8
High Pressure					
1/4	CN4HF	1.38 (35.1)	0.59 (15.0)	3/4	5/8
3/8	CN6HF	1.75 (44.5)	0.72 (18.3)	1	13/16
9/16	CN9HF	2.25 (57.2)	1.00 (25.4)	1 3/8	1 3/16

Elbows



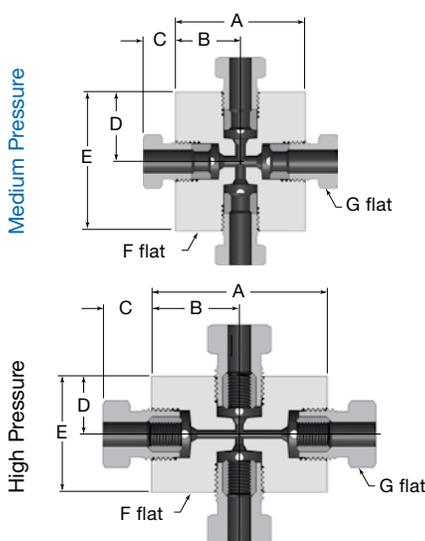
Tube OD in.	Basic Ordering Number	Dimensions, in. (mm)						
		A	B	C	D	E	F	G
Medium Pressure								
1/4	L4MF	1.50 (38.1)	0.75 (19.1)	0.38 (9.7)	0.75 (19.1)	1.13 (28.6)	5/8	1/2
3/8	L6MF	2.00 (50.8)	1.00 (25.4)	0.48 (12.2)	1.00 (25.4)	1.38 (35.1)	3/4	5/8
9/16	L9MF	2.50 (63.5)	1.25 (31.8)	0.68 (17.3)	1.25 (31.8)	1.75 (44.5)	1	7/8
3/4	L12MF	3.00 (76.2)	1.50 (38.1)	0.59 (15)	1.50 (38.1)	2.25 (57.2)	1 3/8	1 3/16
1	L16MF	4.13 (105)	2.06 (52.3)	0.74 (18.8)	2.06 (52.3)	3.00 (76.2)	1 3/4	1 3/8
1 1/2	L24MF	5.75 (146)	2.88 (73.0)	1.10 (27.9)	2.88 (73.0)	4.00 (101.6)	2 1/4	1 7/8
High Pressure								
1/4	L4HF	1.50 (38.1)	0.88 (22.4)	0.59 (15)	0.63 (15.9)	1.00 (25.4)	1	5/8
3/8	L6HF	2.00 (50.8)	1.25 (31.8)	0.72 (18.3)	1.00 (25.4)	1.50 (38.1)	1	13/16
9/16	L9HF	2.62 (66.5)	1.88 (47.6)	1.00 (25.4)	1.13 (28.6)	1.88 (47.6)	1 1/2	1 3/16

Tees



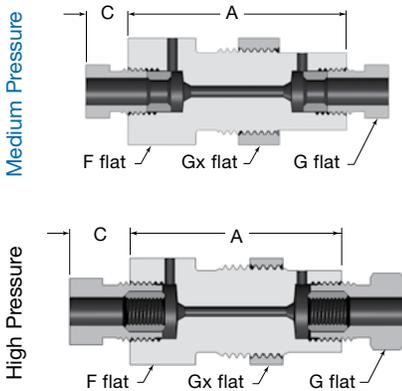
Tube OD in.	Basic Ordering Number	Dimensions, in. (mm)						
		A	B	C	D	E	F	G
Medium Pressure								
1/4	T4MF	1.50 (38.1)	0.75 (19.1)	0.38 (9.7)	0.75 (19.1)	1.13 (28.6)	5/8	1/2
3/8	T6MF	2.00 (50.8)	1.00 (25.4)	0.48 (12.2)	1.00 (25.4)	1.38 (35.1)	3/4	5/8
9/16	T9MF	2.50 (63.5)	1.25 (31.8)	0.68 (17.3)	1.25 (31.8)	1.75 (44.5)	1	7/8
3/4	T12MF	3.00 (76.2)	1.50 (38.1)	0.59 (15)	1.50 (38.1)	2.25 (57.2)	1 3/8	1 3/16
1	T16MF	4.12 (105)	2.06 (52.3)	0.74 (18.8)	2.06 (52.3)	3.00 (76.2)	1 3/4	1 3/8
1 1/2	T24MF	5.75 (146)	2.88 (73.0)	1.10 (27.9)	2.88 (73.0)	4.00 (101.6)	2 1/4	1 7/8
High Pressure								
1/4	T4HF	2.00 (50.8)	1.00 (25.4)	0.59 (15)	0.88 (22.4)	1.25 (31.8)	1	5/8
3/8	T6HF	2.00 (50.8)	1.00 (25.4)	0.72 (18.3)	1.06 (27.0)	1.56 (39.6)	1	13/16
9/16	T9HF	2.62 (66.5)	1.31 (33.3)	1.00 (25.4)	1.38 (34.9)	2.12 (53.8)	1 1/2	1 3/16

Crosses



Tube OD in.	Basic Ordering Number	Dimensions, in. (mm)						
		A	B	C	D	E	F	G
Medium Pressure								
1/4	X4MF	1.50 (38.1)	0.75 (19.1)	0.38 (9.7)	0.75 (19.1)	1.50 (38.1)	5/8	1/2
3/8	X6MF	2.00 (50.8)	1.00 (25.4)	0.48 (12.2)	1.00 (25.4)	2.00 (50.8)	3/4	5/8
9/16	X9MF	2.50 (63.5)	1.25 (31.8)	0.68 (17.3)	1.25 (31.8)	2.50 (63.5)	1	7/8
3/4	X12MF	3.00 (76.2)	1.50 (38.1)	0.59 (15)	1.50 (38.1)	3.00 (76.2)	1 3/8	1 3/16
1	X16MF	4.12 (105)	2.06 (52.3)	0.74 (18.8)	2.06 (52.3)	4.12 (105)	1 3/4	1 3/8
High Pressure								
1/4	X4HF	2.00 (50.8)	1.00 (25.4)	0.59 (15.0)	0.63 (16.0)	1.25 (31.8)	1	5/8
3/8	X6HF	2.00 (50.8)	1.00 (25.4)	0.72 (18.3)	1.06 (27.0)	2.12 (53.8)	1	13/16
9/16	X9HF	2.62 (66.5)	1.31 (33.3)	1.00 (25.4)	1.38 (34.9)	2.75 (69.8)	1 1/2	1 3/16

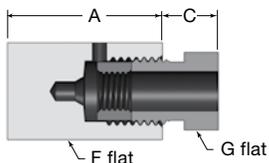
Bulkheads



Tube OD in.	Basic Ordering Number	Dimensions, in. (mm)						
		A	C	F	G	Gx	Panel Hole Size	Panel Thickness Max
Medium Pressure								
1/4	BH4MF	2.00 (50.8)	0.38 (9.7)	1	1/2	1	0.88 (22.4)	0.38 (9.7)
3/8	BH6MF	2.00 (50.8)	0.48 (12.2)	1	5/8	1	0.94 (23.9)	0.38 (9.7)
9/16	BH9MF	2.62 (66.5)	0.68 (17.3)	1 3/8	7/8	1 3/8	1.25 (31.8)	0.50 (12.7)
3/4	BH12MF	2.62 (66.5)	0.59 (15)	1 7/8	1 3/16	1 7/8	1.69 (42.9)	0.38 (9.7)
1	BH16MF	3.50 (88.9)	0.74 (18.8)	2 1/8	1 3/8	2 1/8	2.00 (50.8)	0.50 (12.7)
High Pressure								
1/4	BH4HF	2.00 (50.8)	0.59 (15.0)	1	5/8	1	0.94 (23.9)	0.50 (12.7)
3/8	BH6HF	2.38 (40.5)	0.72 (18.3)	1 3/8	13/16	1 3/8	1.12 (28.4)	0.38 (9.7)
9/16	BH9HF	2.75 (69.9)	1.00 (25.4)	1 7/8	1 3/16	1 7/8	1.75 (44.5)	0.62 (15.7)

Caps and Plugs

Caps

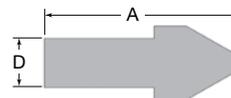


Medium-pressure configuration shown

Tube OD in.	Basic Ordering Number	Dimensions, in. (mm)			
		A	C	F	G
Medium Pressure					
1/4	CA4M	1.00 (25.4)	0.38 (9.7)	5/8	1/2
3/8	CA6M	1.25 (31.8)	0.48 (12.2)	3/4	5/8
9/16	CA9M	1.50 (38.1)	0.68 (17.3)	1	7/8
3/4	CA12M	1.75 (44.5)	0.59 (15)	1 3/8	1 3/16
1	CA16M	2.25 (57.2)	0.74 (18.8)	1 3/4	1 3/8
High Pressure					
1/4	CA4H	1.06 (27.0)	0.59 (15)	3/4	5/8
3/8	CA6H	1.25 (31.8)	0.72 (18.3)	1	13/16
9/16	CA9H	1.62 (41.2)	1.00 (25.4)	1 3/8	1 3/16

Caps are manufactured with two or four flats.

Plugs



Tube OD in.	Basic Ordering Number	Dimensions, in. (mm)	
		A	D
Medium Pressure			
1/4	PL4M-	1.00 (25.4)	0.25 (6.4)
3/8	PL6M-	1.25 (31.8)	0.38 (9.5)
9/16	PL9M-	1.56 (39.6)	0.56 (14.2)
3/4	PL12M-	1.62 (41.2)	0.75 (19.5)
1	PL16M-	2.19 (55.6)	1.00 (25.4)
1 1/2	PL24M-	3.01 (76.5)	1.50 (38.1)
High Pressure			
1/4	PL4H-	1.16 (29.4)	0.25 (6.4)
3/8	PL6H-	1.56 (39.6)	0.38 (9.5)
9/16	PL9H-	2.00 (50.8)	0.56 (14.2)

Collars and Glands

Collars



Glands



Tube OD in.	Basic Ordering Number		
	Collar	Gland	Antivibration Gland
Medium Pressure			
1/4	CL4M-	GL4M-	AV4M-
3/8	CL6M-	GL6M-	AV6M-
9/16	CL9M-	GL9M-	AV9M-
3/4	CL12M-	GL12M-	AV12M-
1	CL16M-	GL16M-	AV16M-
1 1/2	CL24M-	GL24M-	AV24M-
High Pressure			
1/4	CL4H-	GL4H-	AV4H-
3/8	CL6H-	GL6H-	AV6H-
9/16	CL9H-	GL9H-	AV9H-

To order collars and glands in 316 stainless steel, see the Swagelok *Medium- and High-Pressure Fittings, Tubing, Valves, and Accessories* catalog, MS-02-472.

Antivibration Glands



Medium-pressure anti-vibration glands include the anti-vibration gland nut, collet body and collet. Example: AV6M-625-NACE



High-pressure anti-vibration glands include the anti-vibration gland nut and collet. Example: AV6H-2507-NACE

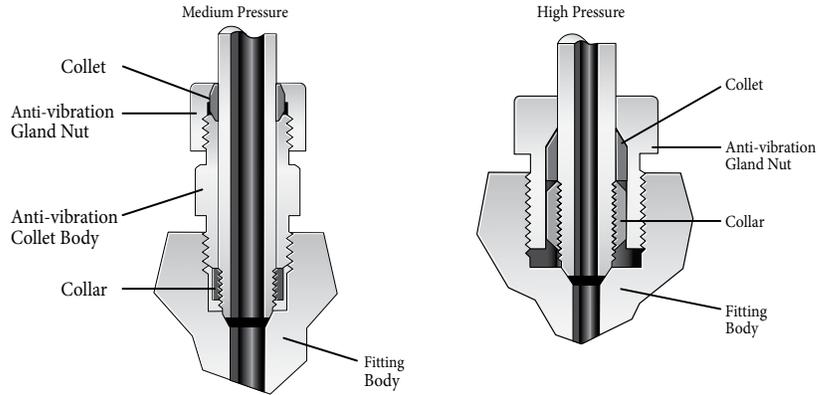
Options and Accessories

Antivibration

For systems that experience shock or vibration, it is recommended to use anti-vibration components to help extend the life of the tubing connection

Antivibration connection components are available for all cone and thread fittings. To order, add **-AV** to the ordering number.

Example: CN4MF20-**AV**



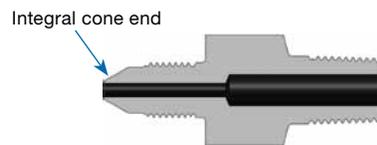
Cone and Thread Adapters and Couplings—IPT Series

Features

- End connection types include
 - NPT
 - Medium-pressure cone and thread (C&T)
 - High-pressure cone and thread (C&T).
- All C&T adapters and couplings materials meet NACE MR0175/ISO 15156.
 - Alloy 2507 NORSOK M-630 and M-650
- Sizes available:
 - Medium-pressure—1/4 to 1 1/2 in.
 - High-pressure—1/4 to 9/16 in.
- C&T adapters and couplings are available in one piece design *only*.



One-piece Design

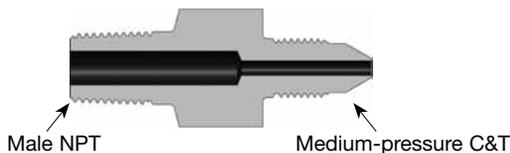


- One-piece design is standard for alloy fittings.
- Features integral cone end on body for ease of assembly.

Ordering Information

Male-to-Male Adapters and Couplings

Male NPT to Medium-Pressure Cone and Thread



Male NPT Size in.	Medium-Pressure C&T Size in.	Basic Ordering Number	Pressure Ratings	
			Alloy 2507 psig (bar)	Alloy 625 psig (bar)
1/4	1/4	CN4NM4MM	15 000 (1034)	12 000 (826)
	3/8	CN4NM6MM		
	9/16	CN4NM9MM		
	3/4	CN4NM12MM		
	1	CN4NM16MM		
3/8	1/4	CN6NM4MM	15 000 (1034)	12 000 (826)
	3/8	CN6NM6MM		
	9/16	CN6NM9MM		
	3/4	CN6NM12MM		
	1	CN6NM16MM		
1/2	1/4	CN8NM4MM	15 000 (1034)	12 000 (826)
	3/8	CN8NM6MM		
	9/16	CN8NM9MM		
	3/4	CN8NM12MM		
	1	CN8NM16MM		
3/4	1/4	CN12NM4MM	10 000 (689)	10 000 (689)
	3/8	CN12NM6MM		
	9/16	CN12NM9MM		
	3/4	CN12NM12MM		
	1	CN12NM16MM		
1	1/4	CN16NM4MM	10 000 (689)	10 000 (689)
	3/8	CN16NM6MM		
	9/16	CN16NM9MM		
	3/4	CN16NM12MM		
	1	CN16NM16MM		

Male NPT to High-Pressure Cone and Thread



Male NPT Size in.	High-Pressure C&T Size in.	Basic Ordering Number	Pressure Ratings	
			Alloy 2507 psig (bar)	Alloy 625 psig (bar)
1/4	1/4	CN4NM4HM	15 000 (1034)	12 000 (826)
	3/8	CN4NM6HM		
	9/16	CN4NM9HM		
3/8	1/4	CN6NM4HM	15 000 (1034)	12 000 (826)
	3/8	CN6NM6HM		
	9/16	CN6NM9HM		
1/2	1/4	CN8NM4HM	15 000 (1034)	12 000 (826)
	3/8	CN8NM6HM		
	9/16	CN8NM9HM		
3/4	1/4	CN12NM4HM	10 000 (689)	10 000 (689)
	3/8	CN12NM6HM		
	9/16	CN12NM9HM		
1	1/4	CN16NM4HM	10 000 (689)	10 000 (689)
	3/8	CN16NM6HM		
	9/16	CN16NM9HM		

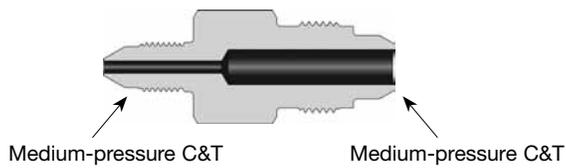
Male NPT to Male NPT



Male NPT Size in.	Male NPT Size in.	Basic Ordering Number	Pressure Ratings	
			Alloy 2507 psig (bar)	Alloy 625 psig (bar)
1/4	1/4	CN4NM	15 000 (1034)	12 000 (826)
	3/8	CN4NF6NM		
	1/2	CN4NF8NM	10 000 (689)	10 000 (689)
	3/4	CN4NF12NM		
	1	CN4NF16NM		
3/8	3/8	CN6NM	15 000 (1034)	12 000 (826)
	1/2	CN6NF8NM		
	3/4	CN6NF12NM	10 000 (689)	10 000 (689)
	1	CN6NF16NM		
1/2	1/2	CN8NM	15 000 (1034)	12 000 (826)
	3/4	CN8NF12NM		
	1	CN8NF16NM	10 000 (689)	10 000 (689)
3/4	3/4	CN12NM	10 000 (689)	10 000 (689)
	1	CN12NF16NM		
1	1	CN16NM	10 000 (689)	10 000 (689)

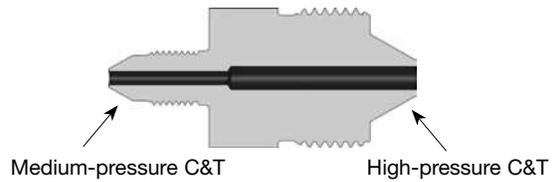
Male-to-Male Adapters and Couplings

Medium-Pressure Cone and Thread to Medium-Pressure Cone and Thread



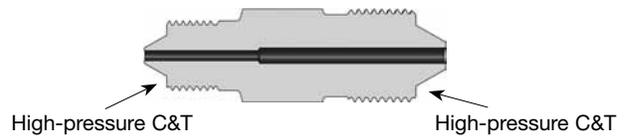
Medium-Pressure C&T Size in.	Medium-Pressure C&T Size in.	Basic Ordering Number	Pressure Ratings	
			Alloy 2507 psig (bar)	Alloy 625 psig (bar)
1/4	1/4	CN4MM	20 000 (1378)	15 000 (1034)
	3/8	CN4MM6MM		
	9/16	CN4MM9MM		
	3/4	CN4MM12MM		
	1	CN4MM16MM		
3/8	3/8	CN6MM	20 000 (1378)	15 000 (1034)
	9/16	CN6MM9MM		
	3/4	CN6MM12MM		
	1	CN6MM16MM		
9/16	9/16	CN9MM	20 000 (1378)	15 000 (1034)
	3/4	CN9MM12MM		
	1	CN9MM16MM		
3/4	3/4	CN12MM	20 000 (1378)	15 000 (1034)
	1	CN12MM16MM		
1	1	CN16MM	20 000 (1378)	15 000 (1034)

Medium-Pressure Cone and Thread to High-Pressure Cone and Thread



Medium-Pressure C&T Size in.	High-Pressure C&T Size in.	Basic Ordering Number	Pressure Ratings	
			Alloy 2507 psig (bar)	Alloy 625 psig (bar)
1/4	1/4	CN4MM4HM	20 000 (1378)	15 000 (1034)
	3/8	CN4MM6HM		
	9/16	CN4MM9HM		
3/8	1/4	CN6MM4HM	20 000 (1378)	15 000 (1034)
	3/8	CN6MM6HM		
	9/16	CN6MM9HM		
9/16	1/4	CN9MM4HM	20 000 (1378)	15 000 (1034)
	3/8	CN9MM6HM		
	9/16	CN9MM9HM		
3/4	1/4	CN12MM4HM	20 000 (1378)	15 000 (1034)
	3/8	CN12MM6HM		
	9/16	CN12MM9HM		
1	1/4	CN16MM4HM	20 000 (1378)	15 000 (1034)
	3/8	CN16MM6HM		
	9/16	CN16MM9HM		

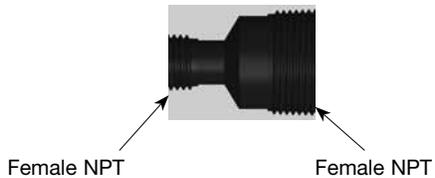
High-Pressure Cone and Thread to High-Pressure Cone and Thread



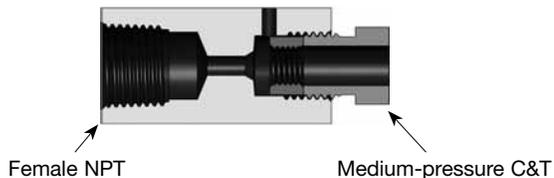
High-Pressure C&T Size in.	High-Pressure C&T Size in.	Basic Ordering Number	Pressure Ratings	
			Alloy 2507 psig (bar)	Alloy 625 psig (bar)
1/4	1/4	CN4HM	40 000 (2756)	36 000 (2480)
	3/8	CN4HM6HM		
	9/16	CN4HM9HM		
3/8	3/8	CN6HM	40 000 (2756)	36 000 (2480)
	9/16	CN6HM9HM		
9/16	9/16	CN9HM	40 000 (2756)	36 000 (2480)

Female-to-Female Adapters and Couplings

Female NPT to Female NPT



Female NPT to Medium-Pressure Cone and Thread

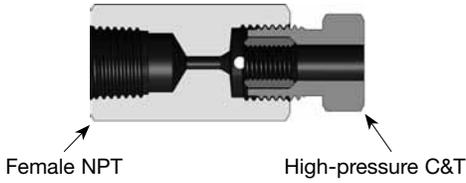


Female NPT Size in.	Female NPT Size in.	Basic Ordering Number	Pressure Ratings	
			Alloy 2507 psig (bar)	Alloy 625 psig (bar)
1/4	1/4	CN4NF	15 000 (1034)	12 000 (826)
	3/8	CN4NF6NF		
	1/2	CN4NF8NF		
	3/4	CN4NF12NF	10 000 (689)	10 000 (689)
	1	CN4NF16NF		
3/8	3/8	CN6NF	15 000 (1034)	12 000 (826)
	1/2	CN6NF8NF		
	3/4	CN6NF12NF	10 000 (689)	10 000 (689)
	1	CN6NF16NF		
1/2	1/2	CN8NF	15 000 (1034)	12 000 (826)
	3/4	CN8NF12NF		
	1	CN8NF16NF	10 000 (689)	10 000 (689)
3/4	3/4	CN12NF	10 000 (689)	10 000 (689)
	1	CN12NF16NF		
1	1	CN16NF	10 000 (689)	10 000 (689)

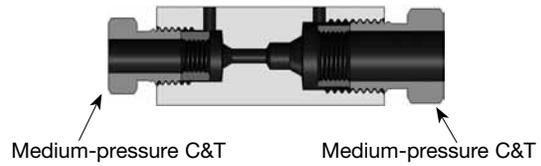
Female NPT Size in.	Medium-Pressure C&T Size in.	Basic Ordering Number	Pressure Ratings	
			Alloy 2507 psig (bar)	Alloy 625 psig (bar)
1/4	1/4	CN4NF4MF	15 000 (1034)	12 000 (826)
	3/8	CN4NF6MF		
	9/16	CN4NF9MF		
	3/4	CN4NF12MF		
	1	CN4NF16MF		
3/8	1/4	CN6NF4MF	15 000 (1034)	12 000 (826)
	3/8	CN6NF6MF		
	9/16	CN6NF9MF		
	3/4	CN6NF12MF		
1/2	1	CN6NF16MF	15 000 (1034)	12 000 (826)
	1/4	CN8NF4MF		
	3/8	CN8NF6MF		
	9/16	CN8NF9MF		
	3/4	CN8NF12MF		
3/4	1	CN8NF16MF	10 000 (689)	10 000 (689)
	1/4	CN12NF4MF		
	3/8	CN12NF6MF		
	9/16	CN12NF9MF		
	3/4	CN12NF12MF		
1	1	CN12NF16MF	10 000 (689)	10 000 (689)
	1/4	CN16NF4MF		
	3/8	CN16NF6MF		
	9/16	CN16NF9MF		
	3/4	CN16NF12MF		
	1	CN16NF16MF		

Female-to-Female Adapters and Couplings

Female NPT to High-Pressure Cone and Thread



Medium-Pressure Cone and Thread to Medium-Pressure Cone and Thread



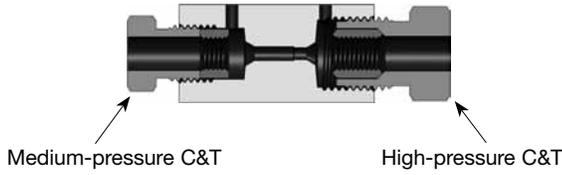
Female NPT Size in.	HP C&T Size in.	Basic Ordering Number	Pressure Ratings	
			Alloy 2507 psig (bar)	Alloy 625 psig (bar)
1/4	1/4	CN4NF4HF	15 000 (1034)	12 000 (826)
	3/8	CN4NF6HF		
	9/16	CN4NF9HF		
3/8	1/4	CN6NF4HF	15 000 (1034)	12 000 (826)
	3/8	CN6NF6HF		
	9/16	CN6NF9HF		
1/2	1/4	CN8NF4HF	15 000 (1034)	12 000 (826)
	3/8	CN8NF6HF		
	9/16	CN8NF9HF		
3/4	1/4	CN12NF4HF	10 000 (689)	10 000 (689)
	3/8	CN12NF6HF		
	9/16	CN12NF9HF		
1	1/4	CN16NF4HF	10 000 (689)	10 000 (689)
	3/8	CN16NF6HF		
	9/16	CN16NF9HF		

Medium-Pressure C&T Size in.	Medium-Pressure C&T Size in.	Basic Ordering Number	Pressure Ratings	
			Alloy 2507 psig (bar)	Alloy 625 psig (bar)
1/4	1/4	CN4MF	20 000 (1378)	15 000 (1034)
	3/8	CN4MF6MF		
	9/16	CN4MF9MF		
	3/4	CN4MF12MF		
3/8	1	CN4MF16MF	20 000 (1378)	15 000 (1034)
	3/8	CN6MF		
	9/16	CN6MF9MF		
	3/4	CN6MF12MF		
9/16	1	CN6MF16MF	20 000 (1378)	15 000 (1034)
	9/16	CN9MF		
	3/4	CN9MF12MF		
3/4	1	CN9MF16MF	20 000 (1378)	15 000 (1034)
	3/4	CN12MF		
1	1	CN12MF16MF	20 000 (1378)	15 000 (1034)
	1	CN16MF		

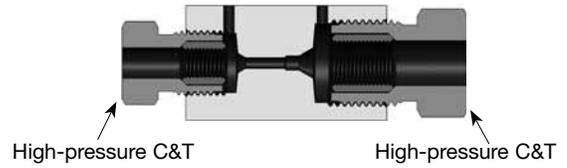
Manufactured with two or four flats.

Female-to-Female Adapters and Couplings

Medium-Pressure Cone and Thread to High-Pressure Cone and Thread



High-Pressure Cone and Thread to High-Pressure Cone and Thread



Medium-Pressure C&T Size in.	High-Pressure C&T Size in.	Basic Ordering Number	Pressure Ratings	
			Alloy 2507 psig (bar)	Alloy 625 psig (bar)
1/4	1/4	CN4MF4HF	20 000 (1378)	15 000 (1034)
	3/8	CN4MF6HF		
	9/16	CN4MF9HF		
3/8	1/4	CN6MF4HF	20 000 (1378)	15 000 (1034)
	3/8	CN6MF6HF		
	9/16	CN6MF9HF		
9/16	1/4	CN9MF4HF	20 000 (1378)	15 000 (1034)
	3/8	CN9MF6HF		
	9/16	CN9MF9HF		
3/4	1/4	CN12MF4HF	20 000 (1378)	15 000 (1034)
	3/8	CN12MF6HF		
	9/16	CN12MF9HF		
1	1/4	CN16MF4HF	20 000 (1378)	15 000 (1034)
	3/8	CN16MF6HF		
	9/16	CN16MF9HF		

High-Pressure C&T Size in.	High-Pressure C&T Size in.	Basic Ordering Number	Pressure Ratings	
			Alloy 2507 psig (bar)	Alloy 625 psig (bar)
1/4	1/4	CN4HF	40 000 (2756)	36 000 (2480)
	3/8	CN4HF6HF		
	9/16	CN4HF9HF		
3/8	1/4	CN4HF6HF	40 000 (2756)	36 000 (2480)
	3/8	CN6HF		
	9/16	CN6HF9HF		
9/16	1/4	CN4HF9HF	40 000 (2756)	36 000 (2480)
	3/8	CN6HF9HF		
	9/16	CN9HF		

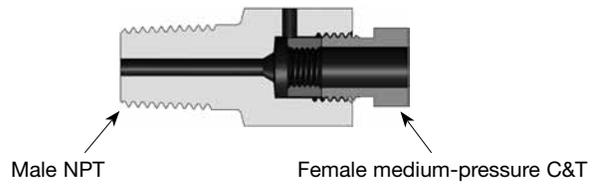
Manufactured with two or four flats.

Male-to-Female Adapters and Couplings

Male NPT to Female NPT



Male NPT to Medium-Pressure Cone and Thread

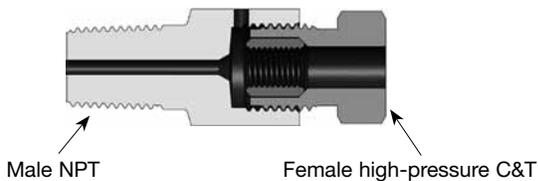


Male NPT Size in.	Female NPT Size in.	Basic Ordering Number	Pressure Ratings	
			Alloy 2507 psig (bar)	Alloy 625 psig (bar)
1/4	1/4	CN4NM4NF	15 000 (1034)	12 000 (826)
	3/8	CN4NM6NF		
	1/2	CN4NM8NF	10 000 (689)	10 000 (689)
	3/4	CN4NM12NF		
	1	CN4NM16NF		
3/8	1/4	CN6NM4NF	15 000 (1034)	12 000 (826)
	3/8	CN6NM6NF		
	1/2	CN6NM8NF	10 000 (689)	10 000 (689)
	3/4	CN6NM12NF		
	1	CN6NM16NF		
1/2	1/4	CN8NM4NF	15 000 (1034)	12 000 (826)
	3/8	CN8NM6NF		
	1/2	CN8NM8NF	10 000 (689)	10 000 (689)
	3/4	CN8NM12NF		
	1	CN8NM16NF		
3/4	1/4	CN12NM4NF	10 000 (689)	10 000 (689)
	3/8	CN12NM6NF		
	1/2	CN12NM8NF	10 000 (689)	10 000 (689)
	3/4	CN12NM12NF		
	1	CN12NM16NF		
1	1/4	CN16NM4NF	10 000 (689)	10 000 (689)
	3/8	CN16NM6NF		
	1/2	CN16NM8NF	10 000 (689)	10 000 (689)
	3/4	CN16NM12NF		
	1	CN16NM16NF		

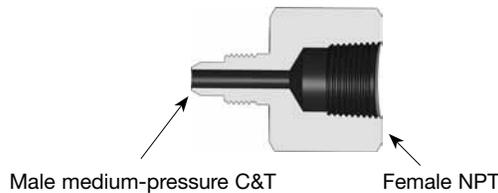
Male NPT Size in.	Female Medium-Pressure C&T Size in.	Basic Ordering Number	Pressure Ratings	
			Alloy 2507 psig (bar)	Alloy 625 psig (bar)
1/4	1/4	CN4NM4MF	15 000 (1034)	12 000 (826)
	3/8	CN4NM6MF		
	9/16	CN4NM9MF	15 000 (1034)	12 000 (826)
	3/4	CN4NM12MF		
	1	CN4NM16MF		
3/8	1/4	CN6NM4MF	15 000 (1034)	12 000 (826)
	3/8	CN6NM6MF		
	9/16	CN6NM9MF	15 000 (1034)	12 000 (826)
	3/4	CN6NM12MF		
	1	CN6NM16MF		
1/2	1/4	CN8NM4MF	15 000 (1034)	12 000 (826)
	3/8	CN8NM6MF		
	9/16	CN8NM9MF	15 000 (1034)	12 000 (826)
	3/4	CN8NM12MF		
	1	CN8NM16MF		
3/4	1/4	CN12NM4MF	10 000 (689)	10 000 (689)
	3/8	CN12NM6MF		
	9/16	CN12NM9MF	10 000 (689)	10 000 (689)
	3/4	CN12NM12MF		
	1	CN12NM16MF		
1	1/4	CN16NM4MF	10 000 (689)	10 000 (689)
	3/8	CN16NM6MF		
	9/16	CN16NM9MF	10 000 (689)	10 000 (689)
	3/4	CN16NM12MF		
	1	CN16NM16MF		

Male-to-Female Adapters and Couplings

Male NPT to High-Pressure Cone and Thread



Medium-Pressure Cone and Thread to Female NPT

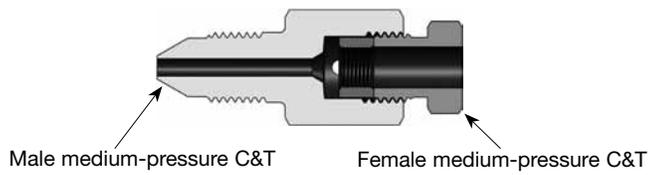


Male NPT Size in.	Female High-Pressure C&T Size in.	Ordering Number	Pressure Ratings	
			Alloy 2507 psig (bar)	Alloy 625 psig (bar)
1/4	1/4	CN4NM4HF	15 000 (1034)	12 000 (826)
	3/8	CN4NM6HF		
	9/16	CN4NM9HF		
3/8	1/4	CN6NM4HF	15 000 (1034)	12 000 (826)
	3/8	CN6NM6HF		
	9/16	CN6NM9HF		
1/2	1/4	CN8NM4HF	15 000 (1034)	12 000 (826)
	3/8	CN8NM6HF		
	9/16	CN8NM9HF		
3/4	1/4	CN12NM4HF	10 000 (689)	10 000 (689)
	3/8	CN12NM6HF		
	9/16	CN12NM9HF		
1	1/4	CN16NM4HF	10 000 (689)	10 000 (689)
	3/8	CN16NM6HF		
	9/16	CN16NM9HF		

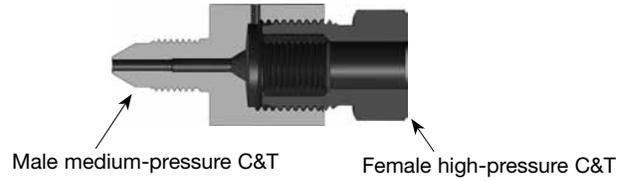
Male Medium-Pressure C&T Size in.	Female NPT Size in.	Ordering Number	Pressure Ratings			
			Alloy 2507 psig (bar)	Alloy 625 psig (bar)		
1/4	1/4	CN4MM4NF	15 000 (1034)	12 000 (826)		
	3/8	CN4MM6NF				
	1/2	CN4MM8NF				
	3/4	CN4MM12NF				
1	1	CN4MM16NF	10 000 (689)	10 000 (689)		
	3/8	CN6MM4NF	15 000 (1034)	12 000 (826)		
1/2	CN6MM6NF					
3/4	CN6MM8NF					
3/8	3/4	CN6MM12NF	10 000 (689)	10 000 (689)		
	1	CN6MM16NF				
	1/4	CN9MM4NF			15 000 (1034)	12 000 (826)
	3/8	CN9MM6NF				
1/2	CN9MM8NF					
1/2	3/4	CN9MM12NF	10 000 (689)	10 000 (689)		
	1	CN9MM16NF				
	1/4	CN12MM4NF			15 000 (1034)	12 000 (826)
	3/8	CN12MM6NF				
1/2	CN12MM8NF					
3/4	3/4	CN12MM12NF	10 000 (689)	10 000 (689)		
	1	CN12MM16NF				
	1/4	CN16MM4NF			15 000 (1034)	12 000 (826)
	3/8	CN16MM6NF				
1/2	CN16MM8NF					
3/4	CN16MM12NF	10 000 (689)	10 000 (689)			
1	CN16MM16NF					

Male-to-Female Adapters and Couplings

Medium-Pressure Cone and Thread to Medium-Pressure Cone and Thread



Medium-Pressure Cone and Thread to High-Pressure Cone and Thread

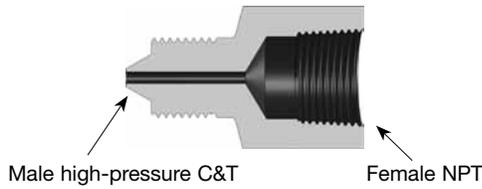


Male Medium-Pressure C&T Size in.	Female Medium-Pressure C&T Size in.	Basic Ordering Number	Pressure Ratings	
			Alloy 2507 psig (bar)	Alloy 625 psig (bar)
1/4	1/4	CN4MM4MF	20 000 (1378)	15 000 (1034)
	3/8	CN4MM6MF		
	9/16	CN4MM9MF		
	3/4	CN4MM12MF		
	1	CN4MM16MF		
3/8	1/4	CN6MM4MF	20 000 (1378)	15 000 (1034)
	3/8	CN6MM6MF		
	9/16	CN6MM9MF		
	3/4	CN6MM12MF		
	1	CN6MM16MF		
9/16	1/4	CN9MM4MF	20 000 (1378)	15 000 (1034)
	3/8	CN9MM6MF		
	9/16	CN9MM9MF		
	3/4	CN9MM12MF		
	1	CN9MM16MF		
3/4	1/4	CN12MM4MF	20 000 (1378)	15 000 (1034)
	3/8	CN12MM6MF		
	9/16	CN12MM9MF		
	3/4	CN12MM12MF		
	1	CN12MM16MF		
1	1/4	CN16MM4MF	20 000 (1378)	15 000 (1034)
	3/8	CN16MM6MF		
	9/16	CN16MM9MF		
	3/4	CN16MM12MF		
	1	CN16MM16MF		
1 1/2	1/4	CN24MM4MF	15 000 (1034)	
	9/16	CN24MM9MF		
	1	CN24MM16MF		
	1 1/2	CN24MM24MF		

Male Medium-Pressure C&T Size in.	Female High-Pressure C&T Size in.	Basic Ordering Number	Pressure Ratings	
			Alloy 2507 psig (bar)	Alloy 625 psig (bar)
1/4	1/4	CN4MM4HF	20 000 (1378)	15 000 (1034)
	3/8	CN4MM6HF		
	9/16	CN4MM9HF		
3/8	1/4	CN6MM4HF	20 000 (1378)	15 000 (1034)
	3/8	CN6MM6HF		
	9/16	CN6MM9HF		
9/16	1/4	CN9MM4HF	20 000 (1378)	15 000 (1034)
	3/8	CN9MM6HF		
	9/16	CN9MM9HF		
3/4	1/4	CN12MM4HF	20 000 (1378)	15 000 (1034)
	3/8	CN12MM6HF		
	9/16	CN12MM9HF		
1	1/4	CN16MM4HF	20 000 (1378)	15 000 (1034)
	3/8	CN16MM6HF		
	9/16	CN16MM9HF		

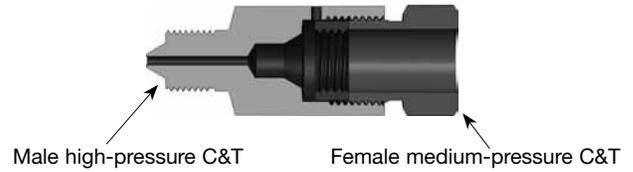
Male-to-Female Adapters and Couplings

High-Pressure Cone and Thread to Female NPT



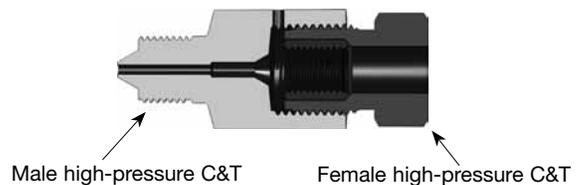
Male High-Pressure C&T Size in.	Female NPT Size in.	Basic Ordering Number	Pressure Ratings	
			Alloy 2507 psig (bar)	Alloy 625 psig (bar)
1/4	1/4	CN4HM4NF	15 000 (1034)	12 000 (826)
	3/8	CN4HM6NF		
	1/2	CN4HM8NF		
	3/4	CN4HM12NF	10 000 (689)	10 000 (689)
	1	CN4HM16NF		
3/8	1/4	CN6HM4NF	15 000 (1034)	12 000 (826)
	3/8	CN6HM6NF		
	1/2	CN6HM8NF		
	3/4	CN6HM12NF	10 000 (689)	10 000 (689)
	1	CN6HM16NF		
9/16	1/4	CN9HM4NF	15 000 (1034)	12 000 (826)
	3/8	CN9HM6NF		
	1/2	CN9HM8NF		
	3/4	CN9HM12NF	10 000 (689)	10 000 (689)
	1	CN9HM16NF		

High-Pressure Cone and Thread to Medium-Pressure Cone and Thread



Male High-Pressure C&T Size in.	Female Medium-Pressure C&T Size in.	Basic Ordering Number	Pressure Ratings	
			Alloy 2507 psig (bar)	Alloy 625 psig (bar)
1/4	1/4	CN4HM4MF	20 000 (1378)	15 000 (1034)
	3/8	CN4HM6MF		
	9/16	CN4HM9MF		
	3/4	CN4HM12MF		
	1	CN4HM16MF		
3/8	1/4	CN6HM4MF	20 000 (1378)	15 000 (1034)
	3/8	CN6HM6MF		
	9/16	CN6HM9MF		
	3/4	CN6HM12MF		
	1	CN6HM16MF		
9/16	1/4	CN9HM4MF	20 000 (1378)	15 000 (1034)
	3/8	CN9HM6MF		
	9/16	CN9HM9MF		
	3/4	CN9HM12MF		
	1	CN9HM16MF		

High-Pressure Cone and Thread to High-Pressure Cone and Thread

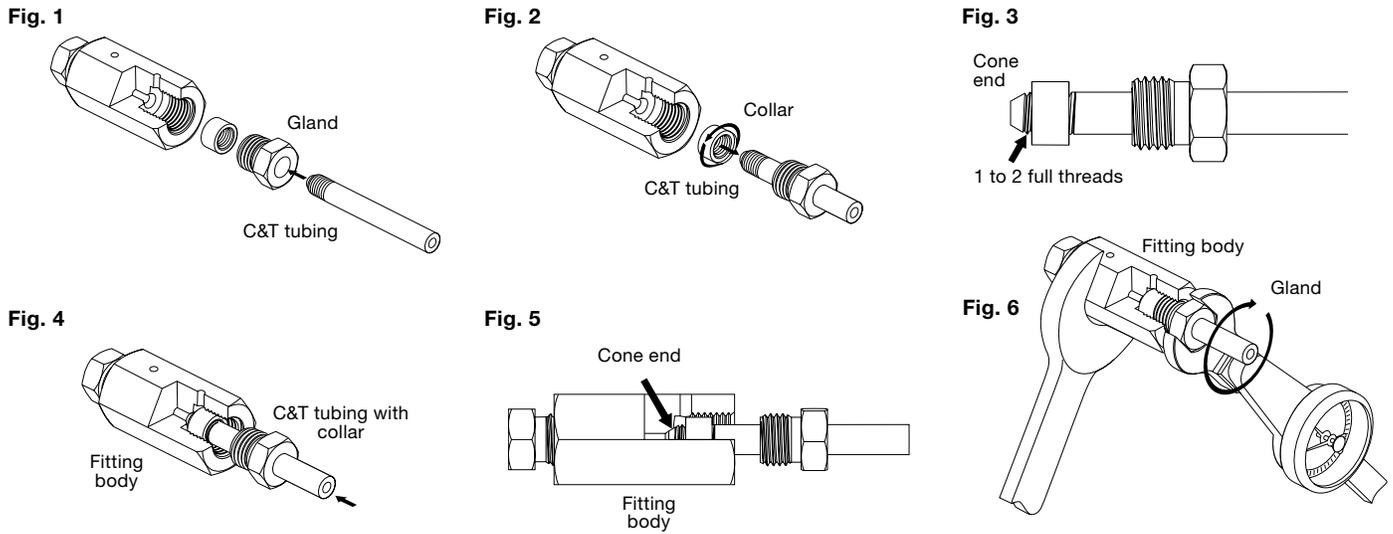


Male High-Pressure C&T Size in.	Female High-Pressure C&T Size in.	Basic Ordering Number	Pressure Ratings	
			Alloy 2507 psig (bar)	Alloy 625 psig (bar)
1/4	1/4	CN4HM4HF	40 000 (2756)	36 000 (2480)
	3/8	CN4HM6HF		
	9/16	CN4HM9HF		
3/8	1/4	CN6HM4HF	40 000 (2756)	36 000 (2480)
	3/8	CN6HM6HF		
	9/16	CN6HM9HF		
9/16	1/4	CN9HM4HF	40 000 (2756)	36 000 (2480)
	3/8	CN9HM6HF		
	9/16	CN9HM9HF		

Installation Instructions

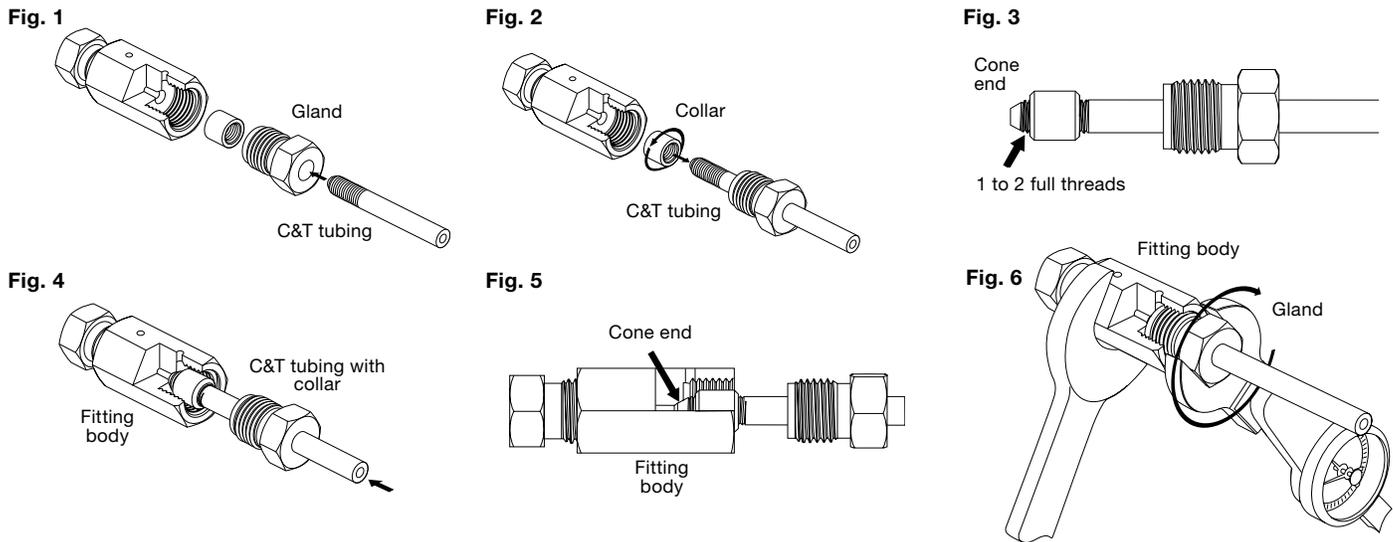
Medium-Pressure Cone and Thread Fitting Assembly

These figures apply to 1/4, 3/8, 9/16, 3/4, 1 and 1 1/2 in. medium-pressure cone and thread fitting sizes.



High-Pressure Cone and Thread Fitting Assembly

These figures apply to 1/4, 3/8, and 9/16 in. high-pressure cone and thread fitting sizes.



Installation Instructions

- Lubricate all male threads with an anti-seize lubricant, such as a Swagelok Goop product. Lubricate the cone end of the tubing with a system compatible lubricant.
NOTE: Anti-vibration collet bodies and gland nuts containing dry film lubricate applied at the factory do not need additional lubrication.
- For standard fittings, slide the C&T tubing into the gland (Fig. 1). For anti-vibration option (see diagram on page 24), slide anti-vibration gland nut and collet onto tubing.

For medium-pressure anti-vibration fittings, slide the anti-vibration collet body onto tubing.

Note: Ensure proper orientation of collet body. Tapered face of collet body is to mate with collet.

- Thread the collar counter-clockwise (left-hand thread) onto the C&T tubing (Fig. 2).
- Continue threading until 1 to 2 full threads are exposed at the cone end of the tubing. This will indicate proper position of the collar (Fig. 3).

- Insert the C&T tubing with the collar into the fitting body (Fig. 4).
- Make sure the cone end of the tubing rests firmly on the angled seat of the fitting body (Fig. 5).
- For standard fittings thread the gland into the fitting body until finger tight. Hold the fitting body steady and tighten the gland (Fig. 6) to the required torque.

For high-pressure anti-vibration fittings, thread the gland nut into the fitting body until finger tight. Hold the body steady and tighten the gland to the required torque.

For medium-pressure anti-vibration fittings thread the anti-vibration collet body into the fitting body until finger tight. Tighten the anti-vibration collet body to specified torque. Then thread the anti-vibration gland nut onto the anti-vibration collet body until finger tight. Tighten the anti-vibration gland nut to the required torque. The collet will grip the tube when the anti-vibration gland nut is tightened.

Medium-Pressure C&T Fitting

Fitting Size in.	Required Torque, ft·lb (N·m)	
	316 SS and Alloy 2507	Alloy 625
1/4	20 (27.2)	15 (20.3)
3/8	30 (40.7)	25 (33.9)
9/16	55 (74.6)	40 (54.2)
3/4	90 (123)	70 (94.9)
1	150 (204)	115 (156)
1 1/2	200 (271)	-

High-Pressure C&T Fitting

Fitting Size in.	Required Torque, ft·lb (N·m)	
	316 SS and Alloy 2507	Alloy 625
1/4	25 (33.9)	15 (20.3)
3/8	50 (67.8)	30 (40.7)
9/16	110 (150)	65 (88.1)

Related Products

Medium- and High-Pressure Fittings, Tubing, Valves, and Accessories

Swagelok offers a complete line of medium- and high-pressure products. For more information, see the Swagelok *Medium- and High-Pressure Fittings, Tubing, Valves and Accessories* catalog, MS-02-472.



Alloy 2507 Tube Fitting

See the Swagelok *Gageable Alloy 2507 Super Duplex Tube Fittings* catalog, MS-01-174, for more information.



Coning and Threading Tool

See the Swagelok *Medium- and High-Pressure Fittings, Tubing, Valves, and Accessories* catalog, MS-02-472, for more information.



Tube Benders

For tube benders, see the Swagelok *Tubing Tools and Accessories* catalog, MS-01-179.



Lubricants and Sealants

See the Swagelok *Leak Detectors, Lubricants, and Sealants* catalog, MS-01-91, for more information.



Safe Product Selection

When selecting a product, the total system design must be considered to ensure safe, trouble-free performance. Function, material compatibility, adequate ratings, proper installation, operation, and maintenance are the responsibilities of the system designer and user.

Caution: Do not mix parts with those of other manufacturers.

Warranty Information

Swagelok products are backed by The Swagelok Limited Lifetime Warranty. For a copy, visit swagelok.com or contact your authorized Swagelok representative.

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