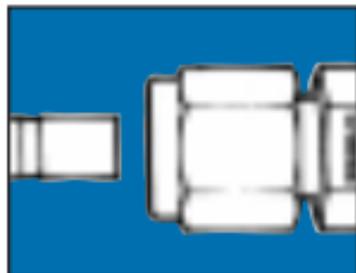


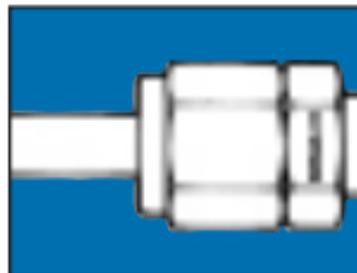
Swagelok PFA Tube Fitting Assembly Instructions



STEP 1
Insert grooved end of tubing into fitting body until clicking sound is heard.



STEP 2
With backup wrench supporting body, tighten blue nut with wrench until no gap is visible between nut and body hexes.



STEP 3
Assembly is complete when nut and body hexes are aligned.

Swagelok[®]

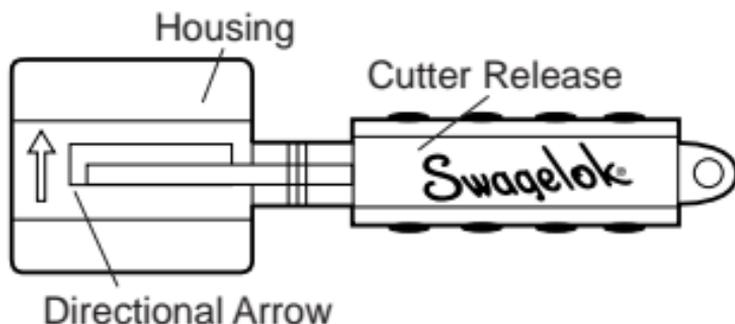
www.swagelok.com

These instructions are also available in French, Italian, German and Spanish.

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Swagelok 1/4, 3/8, and 1/2 in. Groove Cutter

This cutter grooves PFA tubing used in Swagelok PFA tube fittings. The groove is precisely positioned to receive ferrules during pull-up, ensuring proper ferrule action on PFA tubing.



To ensure proper sealing, PFA tubing must be cut squarely and be free of chips, burrs, and nicks.

Groove Cutting Instructions

1. Pull cutter release away from housing.
2. Insert tubing into housing until it is fully bottomed.
3. Grasp tubing near housing and push cutter release and housing together.
4. Hold tubing firmly and rotate groove cutter three complete revolutions in the direction shown by the arrow on the housing.
5. Remove tubing by pulling housing and cutter release apart.
6. Groove must be uniform in depth and free of burrs. If not, cut off tubing squarely above groove and repeat groove cutting instructions.