

## Installation Instructions

### Caps and Plugs



#### Caps

See Swagelok tube fitting installation and reassembly, page 69.



#### Plugs

While holding fitting body steady, tighten the plug one-quarter turn from the finger-tight position.

*For 1/16, 1/8, and 3/16 in.; 2, 3, and 4 mm tube fittings, tighten the plug one-eighth turn.*

*For over 1 in./25 mm tube fittings, tighten the plug one-quarter turn.*

**⚠ Do not use the Swagelok gap inspection gauge with plug assemblies.**

#### Reassembly

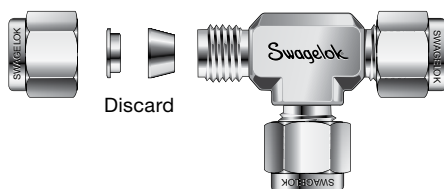
You may disassemble and reassemble Swagelok plugs many times. Make subsequent connections by slightly tightening with a wrench after snugging the nut by hand.

### Port Connectors

Connect the machined ferrule end **before** connecting the tube adapter end.

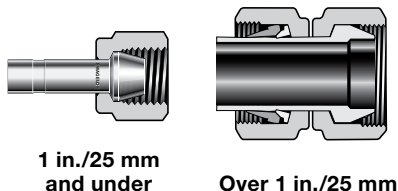
#### Machined Ferrule End

1. Remove the nut and ferrules from the Swagelok end connection. Discard the ferrules.

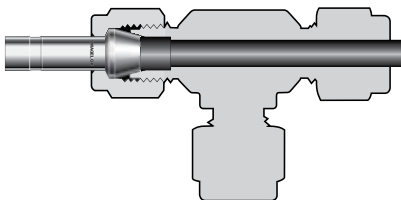


2. Slip the nut over the machined ferrule end of the port connector.

**Over 1 in./25 mm sizes:** The nut is preassembled on the port connector.

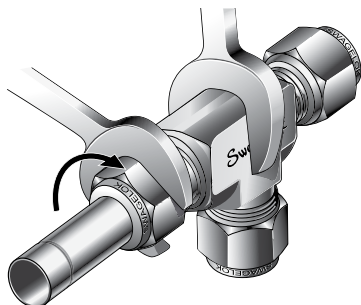


3. Insert the port connector into the end connection and finger-tighten the nut.



4. While holding fitting body steady, tighten the nut one-quarter turn.

*For 1/16, 1/8, and 3/16 in.; 2, 3, and 4 mm tube fittings, tighten the nut one-eighth turn.*



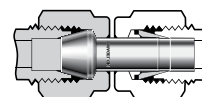
**⚠ Do not use the Swagelok gap inspection gauge with machined ferrule ends.**

#### Reassembly

You may disassemble and reassemble Swagelok port connectors many times. Make subsequent connections by slightly tightening with a wrench after snugging the nut by hand.

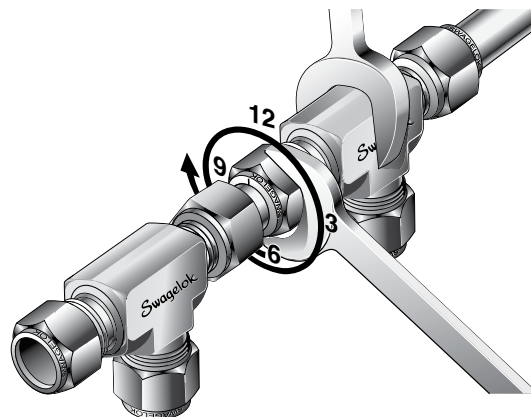
#### Tube Adapter End

5. Insert the tube adapter until it rests firmly on the shoulder of the Swagelok tube fitting body. Finger-tighten the nut.



**Over 1 in./25 mm sizes:** Remove and discard the nut and ferrules from the end connection, then insert the tube adapter.

6. Mark the nut at the 6 o'clock position. While holding fitting body steady, tighten the nut one and one-quarter turns to the 9 o'clock position.



*For 1/16, 1/8, and 3/16 in.; 2, 3, and 4 mm tube fittings, tighten the nut three-quarters turn to the 3 o'clock position.*

*For preswaged over 1 in./25 mm and over tube fittings, tighten the nut one-half turn to the 12 o'clock position.*

**⚠ Do not use the Swagelok gap inspection gauge with preswaged tube adapter connections over 1 in./25 mm.**

#### Reassembly

See Swagelok tube fitting reassembly, page 69.