

Double ferrule compression fittings **Range 54**



Due to their design, double ferrule compression fittings are very often used in high-pressure systems, vacuum systems or systems that are subjected to vibrations.

Safety Information:

- Do not bleed the system by loosening the compression fitting's nut or cap.
- Do not assemble or tighten double ferrule compression fittings when your system is pressurised.
- Check that the pipe is correctly positioned against the bottom of the hole in the compression fitting's body before you tighten the nut.
- Always use sealing products on its tapered threads (e.g. PTFE tape, silicon grease etc.).
- Do not mix materials or compression fitting parts (ferrules, nuts or compression fitting bodies) made by different manufacturers.
- You should only use them with seamless pipes with D4/T3 dimensional tolerance.
- You should never screw the body of a double ferrule compression fitting. You should always keep the compression fitting's body still while you tighten the nut.
- Do not disassemble double ferrule compression fittings unless you are going to assemble them onto piping.
- Please follow the installation instructions. Do not over tighten double ferrule compression fittings, as this will not improve their sealing and could instead cause fatigue in the ferrule material and make it difficult to disassemble them.
- You should only use long reducers with female HY-LOK connectors.

Installation instructions:

You can quickly, easily and completely reliably install double ferrule compression fittings for HY-LOK pipes with a diameter less than or equal to 25mm/1" just using hand tools.

For pipe diameters greater than 25mm/1", you will need to use a hydraulic press fitting tool to press fit the ferrules onto your pipes.

Pipe preparation

1. Cut the pipe square and deburr its internal AND external surfaces.
2. Check the pipe: it must be clean and it must not be deformed or have any oval distortion defects.

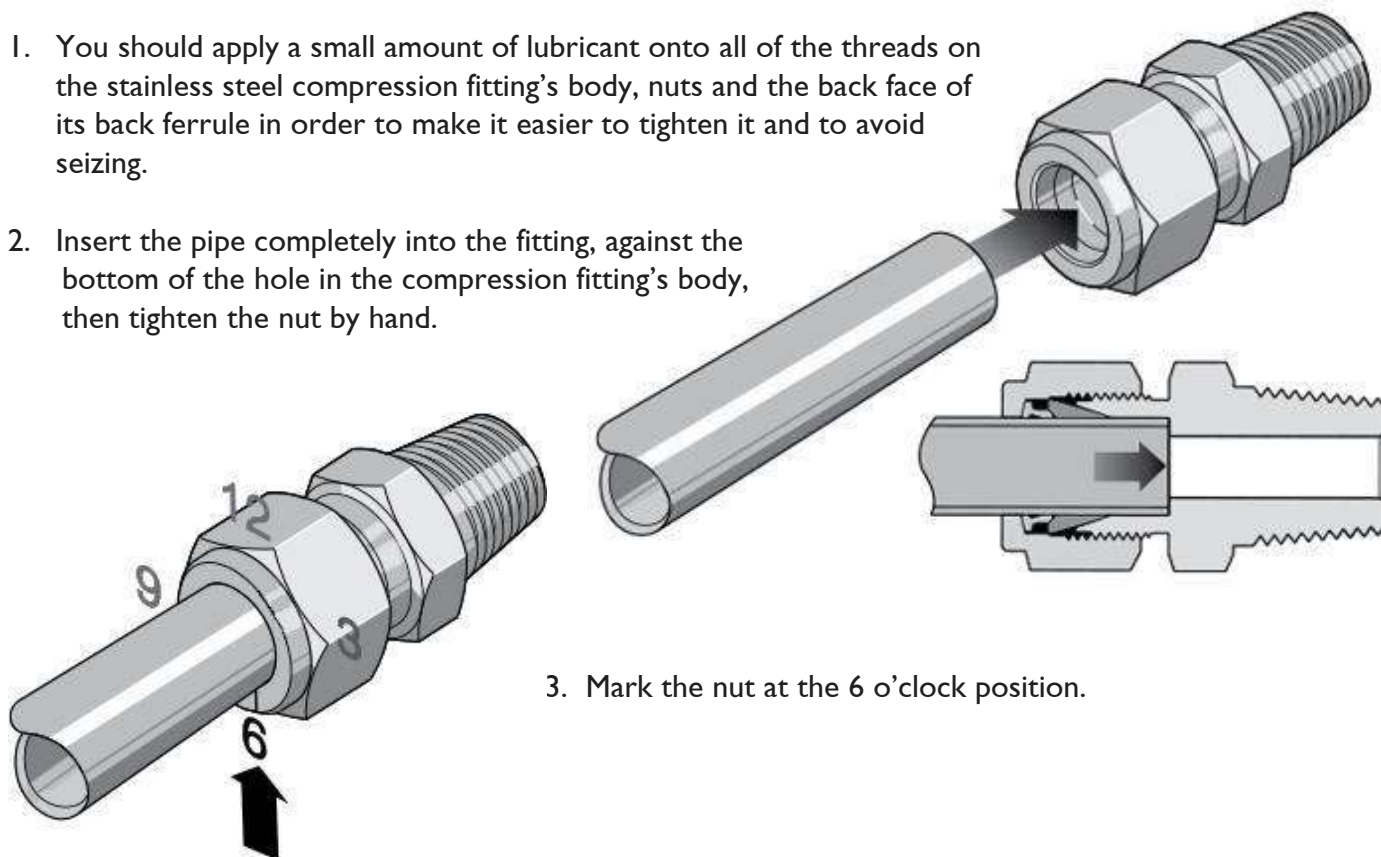


HY-LOK connectors – up to 25mm/1"

You should follow these instructions for traditional double ferrule compression fittings and for fittings with improved back ferrule geometry.

Assembly

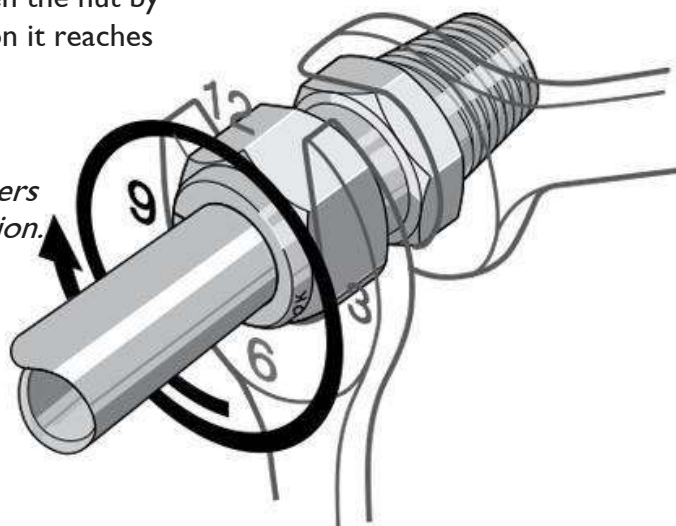
1. You should apply a small amount of lubricant onto all of the threads on the stainless steel compression fitting's body, nuts and the back face of its back ferrule in order to make it easier to tighten it and to avoid seizing.
2. Insert the pipe completely into the fitting, against the bottom of the hole in the compression fitting's body, then tighten the nut by hand.



3. Mark the nut at the 6 o'clock position.

4. Keep the compression fitting's body still and tighten the nut by one and a quarter turn until the mark you made on it reaches the 9 o'clock position.

For 2, 3 and 4mm or 1/16", 1/8" and 3/16" compression fittings, tighten the nut by three quarters of a turn until the mark reaches the 3 o'clock position.



HY-LOK connectors – over 25mm/1"

1. Use a hydraulic or electric HY-LOK press fitting tool to preswage the ferrules onto the piping.
2. You should apply a small amount of lubricant onto all of the threads on the compression fitting's body, nuts and the back face of its back ferrule.
3. Insert the pipe with the preswaged ferrules completely into the compression fitting, until the front ferrule stops against the compression fitting's body, then tighten the nut by hand.
4. Mark the nut at the 6 o'clock position.
5. Keep the compression fitting's body still and tighten the nut by half a turn until the mark you made on it reaches the 12 o'clock position.

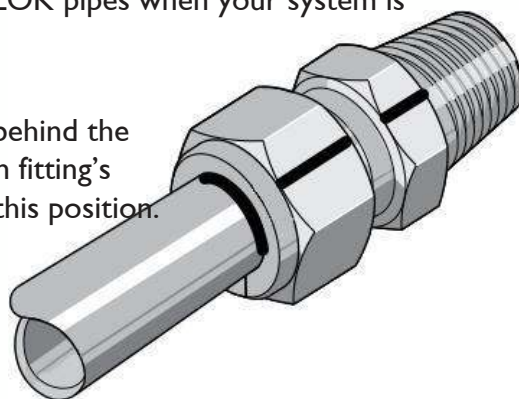
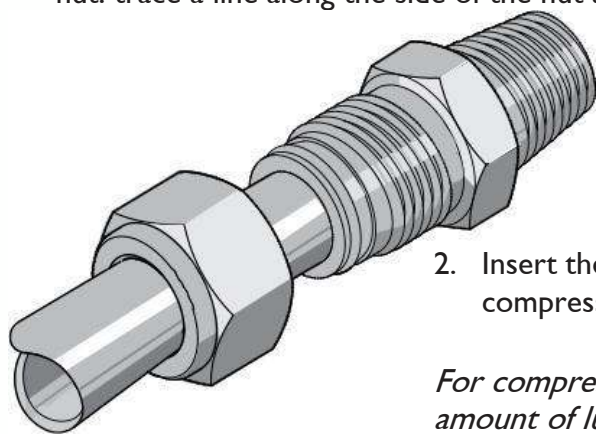
Disassembly and reassembly

Double ferrule HY-LOK compression fittings can be disassembled and reassembled several times without this damaging their sealing capacity.



Do not disassemble a compression fitting for HY-LOK pipes when your system is pressurised.

1. Before you disassemble a compression fitting, mark the pipe behind the nut: trace a line along the side of the nut and the compression fitting's body. When you reassemble, align the nut back to this position.



2. Insert the pipe with the preswaged ferrules completely into the compression fitting, until the front ferrule stops against its body.

For compression fittings with dimensions above 25mm/1": reapply a small amount of lubricant onto the threads on their body and the back face of their back ferrule if necessary.

3. Keep the compression fitting's body still and tighten the nut using a wrench until the lines you drew on the pipe and the sides of the nuts are lined up. You will feel a significant increase in resistance when you reach this point. Tighten the nut lightly.

