

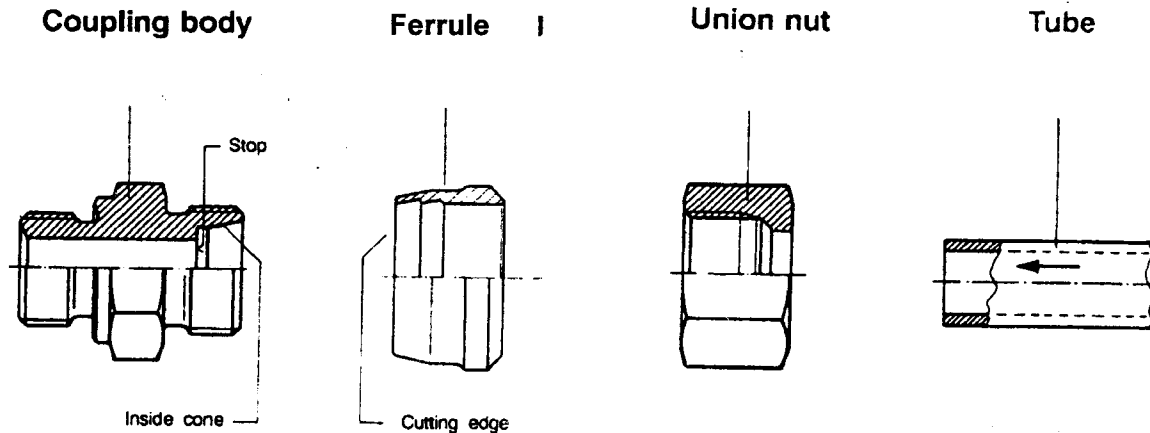


# ASTON FITTINGS & FLANGES MANUFACTURING LTD.



CERT No. LRQ. 0961092

## ASTON single ferrule fittings Assembly Instructions for stainless steel



- 1) Cut the tube square (do not use a role cutter) and de-burr the end of the tube inside and out.
- 2) Fittings should always be lubricated, pre-assembled in a vice and a hardened pre-assembly tool used when assembling several fittings.
- 3) Lubricate the nut, ferrule and body cone using anti-seize paste.
- 4) Put the nut and ferrule on the tube. Thicker end of the ferrule should face the nut thin end towards the cut end of the tube so it goes into the cone first.
- 5) Put the tube nut and ferrule onto the body of the fitting. The tube should butt firmly onto the step in the body
- 6) Tighten the nut by hand as much as possible, and then mark a datum mark on the nut and tube.
- 7) Hold the tube in one hand and with the correct size spanner tighten the nut until the ferrule is felt to grip the tube. The nut should then be tightened another 1 -1 1/2 turns. The tube should not be able to rotate. Larger fittings will need an extension to the spanner.
- 8) Loosen the nut and check the assembly. The ferrule will have cut into the tube and sit flush on the whole circumference of the tube. The ferrule can turn but not move forwards or backwards.
- 9) Where re-assembly is required assemble the fittings to hand tight and tighten to the previous fully tight position and tighten a further 1/16 to 1/4 turn after reaching the previous fully tight position.

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