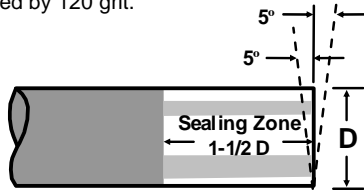


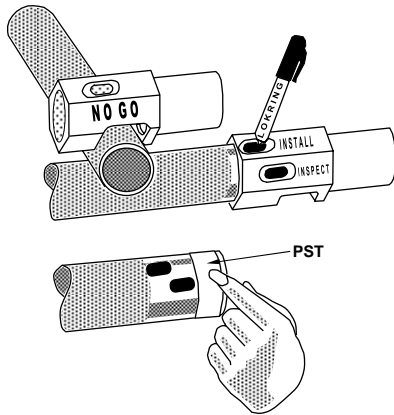
INSTALLATION PROCEDURE

Note: Refer to LOKRING procedure LP-105 for detailed installation instructions

STEP 1: Cut tube to within 5° square. Using 120 grit Aluminum oxide abrasive cloth, sand tube sealing zone in circumferential direction to clean surface and remove scratches. If deep pits or scratches persist, use 60 grit, followed by 120 grit.



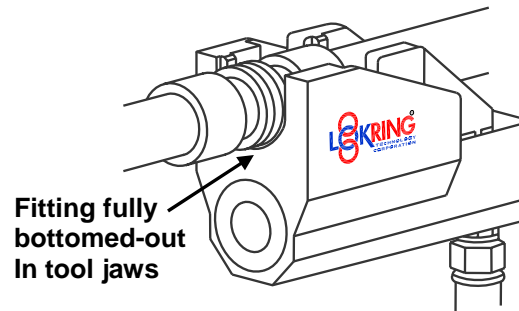
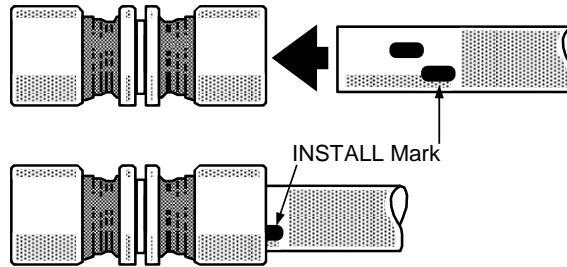
Step 2: Using Multipurpose Gage, verify that tube OD is correctly sized, and mark tube ends as shown.



Special Note: A thin coat of Loctite® 567 PST (Pipe Sealant with Teflon) is required in Automotive paint applications and is strongly recommended for other applications which must seal gas tight where the tube wall thickness to OD ratio is less than 0.07. The use of PST compensates for minor tube imperfections. For example, a 1 1/2" OD tube with 0.065" wall would have a ratio of $(0.065/1.50) = 0.043$ and should have PST applied. The PST should be applied just back from the end of the tube up to the inspect mark; care should be taken to prevent excess PST from entering the system at the tube end.

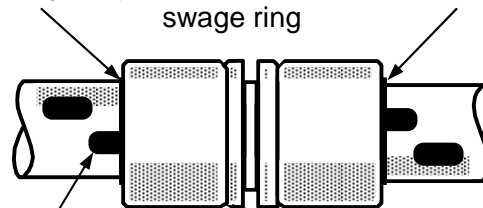
STEP 3: Select and assemble required LOKRING tool. Inspect and cycle tool to assure proper function.

STEP 4: Position fitting on "INSTALL" mark, fully engage and actuate tool.



STEP 5: Carry out visual checks below to verify successful installation.

Fitting body protrudes from underneath swage ring



INSPECT mark partially covered

Small gap is acceptable

LOKRING **INSTALLER'S** **Field Installation Guide** **Automotive Paint** **Applications**

For Series SS40 & SS-3000,
316L Stainless Steel
LOKRING™ Tube Fittings

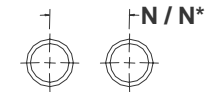
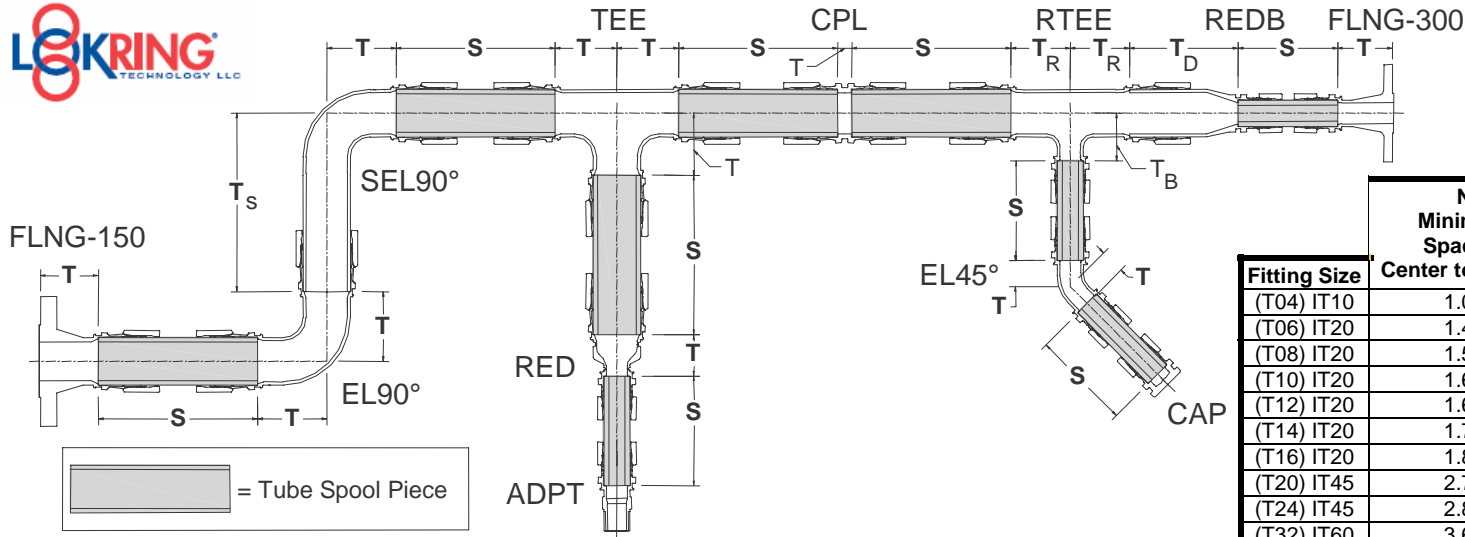


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8.03F Tri-Fold Handout For Tube Fittings in
Automotive Paint Applications (07-02-09)



| Fitting Size | N Minimum Spacing Center to Center | N* Minimum Spacing Center to Center, with fittings adjacent each other |
|--------------|--|---|
| (T04) IT10 | 1.09 | 1.23 |
| (T06) IT20 | 1.49 | 1.67 |
| (T08) IT20 | 1.56 | 1.74 |
| (T10) IT20 | 1.62 | 1.83 |
| (T12) IT20 | 1.68 | 1.89 |
| (T14) IT20 | 1.74 | 1.91 |
| (T16) IT20 | 1.81 | 1.99 |
| (T20) IT45 | 2.71 | 2.99 |
| (T24) IT45 | 2.83 | 3.14 |
| (T32) IT60 | 3.63 | 3.91 |
| (T40) IT60 | 3.88 | 4.21 |

| LOKRING Fitting ¹ (Tube) | LOKTOOL Head | "S" Min ² | Fitting Take-Out "T" in 1/16" Increments | | | | Reducing Fittings | RTEE T _R | RTEE T _B | RED T |
|--|-----------------|-------------------------|--|----------|-------|---------|--------------------------------|------------------------|------------------------|----------|
| | | | TEE | EL90 | CPL | EL45 | | | | |
| SS40-XXX-T04 (1/4" Tube) | IT10 | 2-3/16" | 1-1/2" | N/A | 1/16" | N/A | 3/8"x1/4" (T06xT04) | 1-1/8" | 1-7/16" | 1-3/16" |
| SS40-XXX-T06 (3/8" Tube) | IT20 | 3" | 1-1/8" | 1-3/16" | N/A | 1-3/16" | 1/2"x1/4" (T08xT04) | N/A | N/A | 1" |
| SS40-XXX-T08 (1/2" Tube) | IT20 | 3-3/16" | 15/16" | 1" | N/A | 1-1/16" | 1/2"x3/8" (T08xT06) | 15/16" | 1-1/8" | 11/16" |
| SS40-XXX-T10 (5/8" Tube) | IT20 | 3-5/8" | 1-1/16" | 1-1/16" | N/A | 7/8" | 5/8"x1/2" (T10xT08) | 1-1/16" | 1-1/4" | 3/4" |
| SS40-XXX-T12 (3/4" Tube) | IT20 | 3-11/16" | 1-7/16" | 1-7/16" | N/A | 1-1/16" | 3/4"x5/8" (T12xT10) | 1-3/16" | 1-5/16" | 3/4" |
| SS3000-XXX-T14 (7/8" Tube) | IT20 | 3-1/2" | 1-5/16" | 1-9/16" | N/A | 1-3/16" | 7/8"x3/4" (T14xT12) | 1-5/16" | 1-3/16" | 11/16" |
| SS3000-XXX-T16 (1" Tube) | IT20 | 3-3/4" | 1-5/16" | 2" | N/A | 1-3/8" | 1"x7/8" (T16xT14) | 1-5/16" | 1-5/16" | 13/16" |
| SS3000-XXX-T20 (1-1/4" Tube) | IT45 | 4-11/16" | 1-7/8" | 1-7/8" | N/A | 1-1/4" | 1-1/4"x1" (T20xT16) | 1-7/8" | 2" | 7/8" |
| SS3000-XXX-T24 (1-1/2" Tube) | IT45 | 4-7/8" | 2-5/16" | 2-5/16" | N/A | 1-7/16" | 1-1/2"x1-1/4" (T24xT20) | 2-5/16" | 2-5/16" | 13/16" |
| SS40-XXX-T32 (2" Tube) | IT60 | 5-15/16" | 3-3/16" | 3-11/16" | N/A | 2-1/16" | | | | |
| SS40-XXX-T40 (2-1/2" Tube) | IT60 | 7-7/8" | 3-5/16" | 3-13/16" | N/A | 2-3/16" | | | | |

1. Stainless steel tube to ASTM-A269 or A213 and MIL-P-24691/3 or MIL-T-8606. Refer to LOKRING specification **FS40-T** for qualified Tube specifications and wall thicknesses.
 2. Minimum cut spool length "S" listed is for reverse installation. Spool lengths may be decreased slightly if one fitting end can be pulled up prior to positioning the second end and the reverse position of the tool is used for the installation.