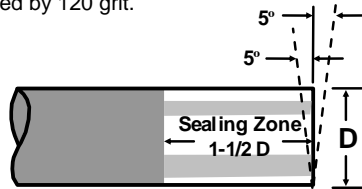


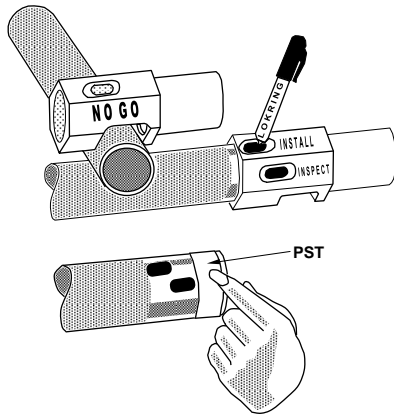
INSTALLATION PROCEDURE

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.

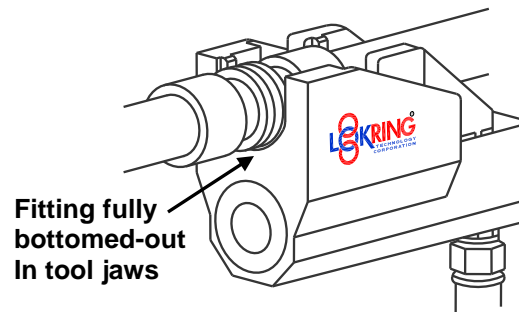
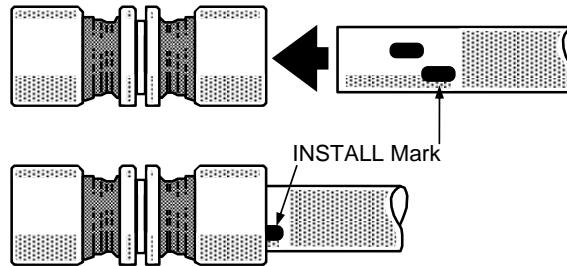


Special Note: If LP-105 Lokring Installation Instructions Section on Pipe/Tube End Preparation is adhered to and found not to be effective in removing the Bad Pipe/tube Conditions, an anaerobic pipe/tube thread sealant such as Loctite 567 PST thread sealant may be applied to the pipe/tube surface within the Sealing Zone to enhance the seal. Refer to LP-105 for instructions on applying the PST sealant.

The proper preparation of the outside diameter is the responsibility of the system designer or user.

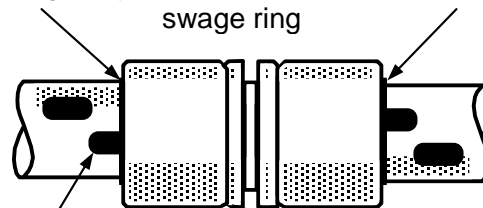
STEP 3: Select and assemble required LOKRING tool. Inspect and cycle tool to assure proper function.

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

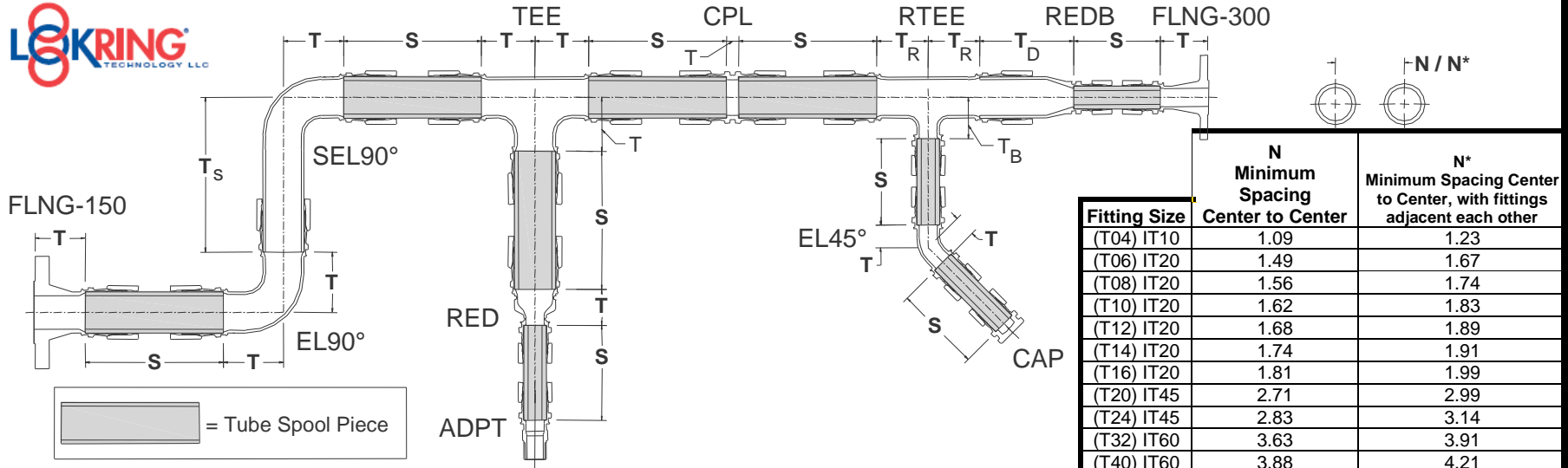


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8.03F Tri-Fold Handout For Tube Fittings in
Automotive Paint Applications (05-03-
19).doc



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"
SS-3000-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"
SS-3000-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"
SS-3000-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"
SS-3000-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"	2"x1-1/2" (T32xT24)	3-3/16"	3-1/4"	1-7/16"
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.