INSTALLATION PROCEDURE
Note: Refer to LOKRING procedure LP-110 for detailed installation instructions

STEP 1: Sealing Zone shall be 6" from brazed joint. If necessary, before cutting tube, use a non-shedding abrasive pad to clean surface and remove scratches from tube OD. Care should be taken to not contaminate the inside of the tube. Always clean tube sealing zone in circumferential direction.

Cut tube with clean tubing cutter to within 5° square.

Step 2: Using the Multi-Purpose Gauge, verify that the tube OD is correctly sized, and mark the tube ends as shown.

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
1. For use on positive pressure medical gas tube per B819 and for vacuum copper tube per ASTM B88.
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.

* Consult LOKRING for Take-Out dimension