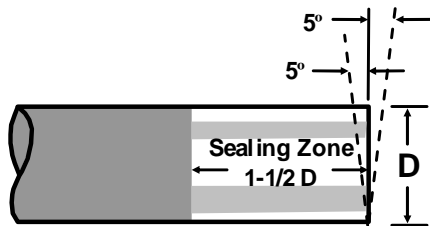


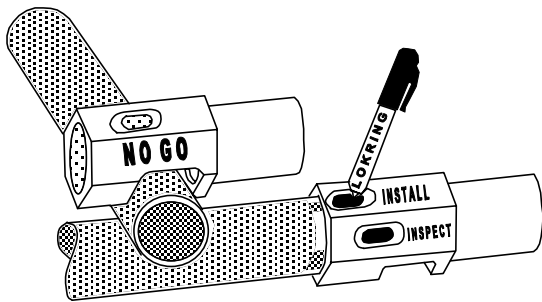
INSTALLATION PROCEDURE

Note: Refer to LOKRING procedures LP-105 or LP-101 for detailed installation instructions

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

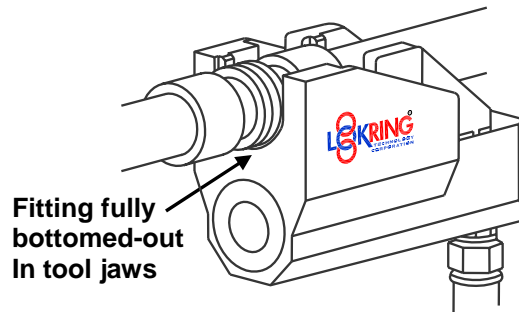
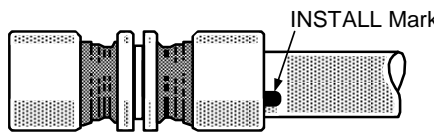
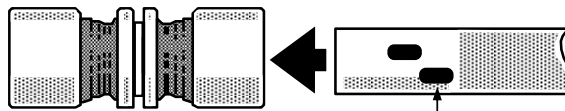


Step 2: Using Multipurpose Gage, verify that pipe OD is correctly sized, and mark pipe ends as shown.



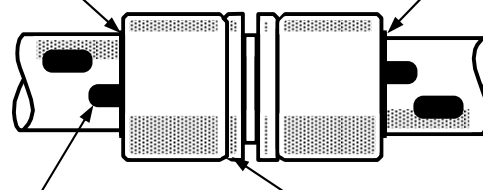
STEP 3: Select and assemble required LOKRING tool. Inspect and cycle tool to assure proper function.

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

LOKRING INSTALLER'S Field Installation Guide

For Series CN-700 70/30
Copper Nickel
LOKRING™ Pipe and Tube
Fittings

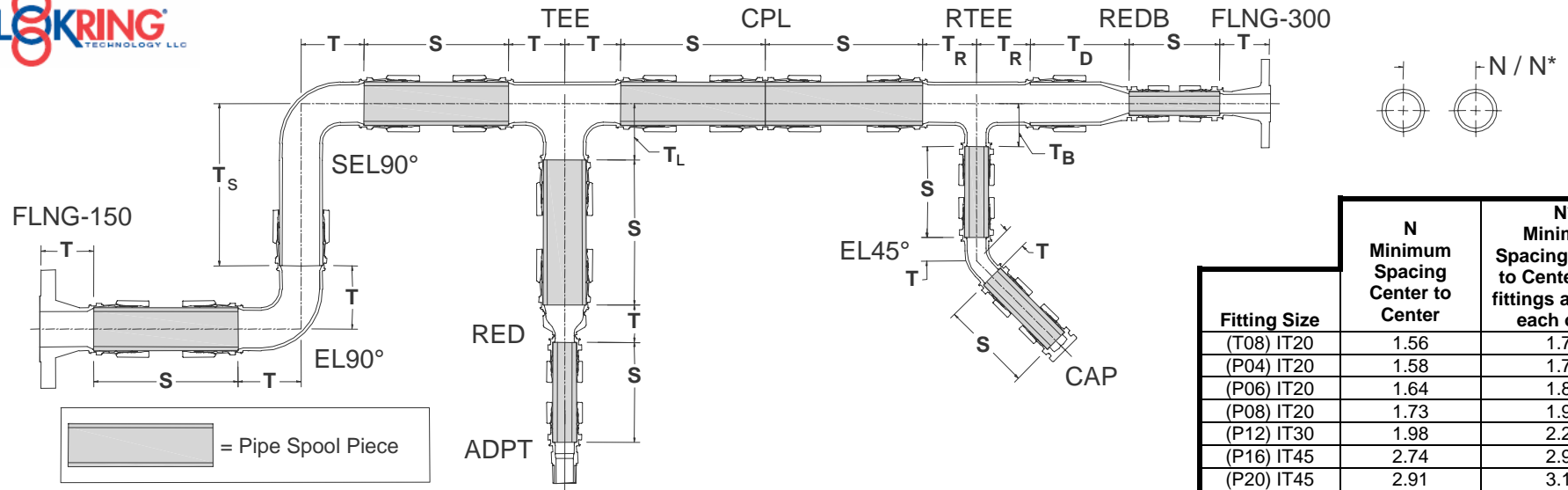


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8.03D Tri-Fold Handout For CN-700 Pipe
Fittings (07-02-09)



Fitting Size	N Minimum Spacing Center to Center	N* Minimum Spacing Center to Center, with fittings adjacent each other
(T08) IT20	1.56	1.73
(P04) IT20	1.58	1.73
(P06) IT20	1.64	1.83
(P08) IT20	1.73	1.94
(P12) IT30	1.98	2.20
(P16) IT45	2.74	2.98
(P20) IT45	2.91	3.13
(P24) IT60	3.58	3.88
(P32) IT60	3.82	4.19

Fitting Take-Out "T" in 1/16" Increments

LOKRING Fitting ¹ (NPS)	LOKTOOL Head	"S" Min ²	Fitting Take-Out "T" in 1/16" Increments										Reducing Fittings		
			TEE (T)	TEE (T _L)	EL90 (-LR)	EL90 (-SR)	SEL 90 (LR) (T _s)	SEL 90 (LR) (T)	SEL 90 (SR) (T _s)	SEL 90 (SR) (T)	EL45	REDB T _D			
CN-700-XXX-T08 (1/2" OD)	IT20	3-3/16"	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	N/A	3/8"x1/4" (P06-P04)	2-3/16"
CN-700-XXX-P04 (1/4" NPS)	IT20	3-3/16"	1"	1"	N/A	1"	N/A	N/A	N/A	N/A	N/A	N/A	N/A	1/2"x3/8" (P08-P06)	2-1/4"
CN-700-XXX-P06 (3/8" NPS)	IT20	3-3/8"	1-1/16"	1-1/16"	N/A	1-1/16"	N/A	N/A	N/A	N/A	N/A	N/A	N/A	3/4"x1/2" (P12-P08)	2-7/8"
CN-700-XXX-P08 (1/2" NPS)	IT20	3-13/16"	1-3/16"	1-3/16"	N/A	1-3/16"	N/A	N/A	N/A	N/A	N/A	1-1/8"	N/A	1"x3/4" (P16-P12)	3-3/16"
CN-700-XXX-P12 (3/4" NPS)	IT30	4-5/16"	1-1/2"	1-1/2"	N/A	1-1/2"	N/A	N/A	N/A	N/A	N/A	1-1/8"	N/A	1-1/4"x1" (P20xP16)	3-7/16"
CN-700-XXX-P16 (1" NPS)	IT45	5"	1-1/2"	1-1/2"	2"	1-1/2"	10-5/8"	2"	10-1/8"	1-1/2"	1-1/8"	1-1/8"	N/A	1-1/2"x1-1/4" (P24-P20)	3-7/8"
CN-700-XXX-P20 (1-1/4" NPS)	IT45	5-7/8"	1-7/8"	1-7/8"	2-7/16"	1-3/4"	11"	2-7/16"	N/A	N/A	1-3/8"	1-3/8"	N/A	2"x1-1/2" (P32-P24)	3-13/16"
CN-700-XXX-P24 (1-1/2" NPS)	IT60	6-13/16"	2-1/4"	2-3/16"	2-15/16"	2"	N/A	N/A	10-9/16"	2"	1-5/8"	1-5/8"	N/A		
CN-700-XXX-P32 (2" NPS)	IT60	7-5/8"	2-1/2"	2-1/2"	3-3/4"	2-1/2"	N/A	N/A	N/A	N/A	2"	2"	N/A		

1. Copper pipe to MIL-T-16420 (class 200, 90/10, class 200 70/30, and class 700 70/30).
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.