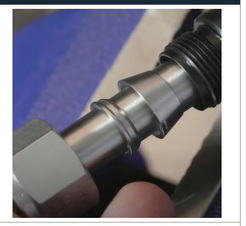
A-LOK® TUBE FITTINGS
Assembly & Remake Instructions

Assembly Instructions

1 Insert the square cut and deburred tube end into the fitting until it is fully bottomed.

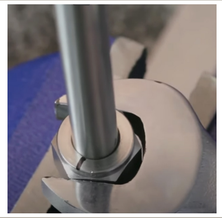
Rotate the nut until it is finger tight.

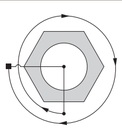
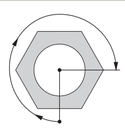


2 For a reference point, mark the nut at the 6 o'clock position.

3 Using a suitable wrench, tighten the nut an additional **1-1/4 turns** ending at the 9 o'clock position.

*For sizes below 6mm/ 1/4" use a **3/4 turn** only.*



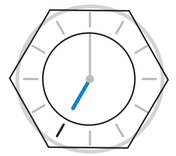
1-1/4 TURN From the marked position	**3/4 TURN** From the marked position
	
1/4" - 1" (6 - 25mm)	1/16" - 3/16" (2 - 4mm)

Remake Instructions

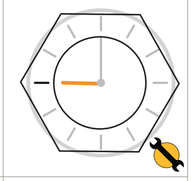
Parker tube fittings can be disassembled and re-made many times and the same reliable, safe, leak-proof connection obtained.

1 Re-insert the tube back into the fitting body. Ensure it is fully seated and rotate the nut until it is finger tight.

Example: Original installation mark on the nut is at the 7 o'clock position when finger tight.



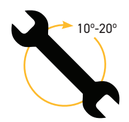
2 With a wrench, turn the nut to the original 9 o'clock position. A noticeable increase in mechanical resistance will be felt, indicating the front ferrule is being sprung to its original sealing position.



3 Only after several remakes will it become necessary to advance the nut slightly past the original 9 o'clock position. This advance need only be 10°-20° (less than 1/3 of a hex flat).

REMAKE IS COMPLETE!

NOTE: For sizes above 16 (1"), the Parker IPD Hydraulic Presetting Tool should be used.



Parker A-LOK® Double Ferrule Compression Tube Fitting

Notes:

Lubrication of the nut is REQUIRED for proper assembly on all LARGER size fittings in both inch and metric sizes. This requirement applies to:

- inch sizes of 20 and higher
- metric sizes of 25 and higher

CAUTION: Do not make up Parker fittings or any instrumentation tube fitting by torque or 'feel' since variables in all fitting connections such as tubing and fitting tolerances, wall thickness of the tubing, and lubricity of nut lubricants can result in improperly assembled tubing connections.

Parker A-LOK® Assembly Video

SMALL BORE TUBING SYSTEMS SAFETY TRAINING

Learn to specify, assemble and install efficient, safe and leak-free small bore tubing systems.

Contact your local Distributor for more information.

Gaugeability: Proper Inspection

Use Parker Inspection Gauge to ensure that correct turns of the nut are made.

4 Place the gauge between the nut and the body hex. If gauge does not fit between them, you have correctly tightened the nut. If you can slip the gauge into the space, the fitting is not properly made up, and you must repeat the assembly procedure.

NOTE: Parker Inspection Gauge should only be used on original make up.

Special Assembly: Plugs and Port Connectors Only

For Plugs and this end of Port Connectors, only **1/4 turn** from finger tight is necessary.

Tighten this end of Port Connector **1-1/4 turns** from finger tight.

PLUG PORT CONNECTOR

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