



## Assembly Instructions

U2-twin ferrule fittings are supplied assembled, clean and dust free, packed and ready to use. Nuts and ferrules are assembled fingertight and an instant assembly is guaranteed. Avoid any contamination with dirt swarf etc. as that can cause leaks.

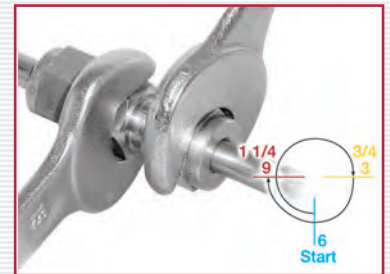
### ■ Tube Recommendations (size 6 mm-1/4" to 25 mm-1")

**We recommend the use of seamless stainless steel tube.** Cut the tube square using a cutting fixture or pipe cutter. Deburr the tube but do not chamfer. Please make sure that the tube is clean and **free of swarf**. Push the tube upto the stop in the coupling. Ensure that the tube sits proper in the fittings. Especially with bigger sized tube you may need more force to push it to the bottom of **the fittings**. **Hand tighten nut.**

### ■ Assembly

That is your **"Starting Position"**. **Mark** the nut at the **6 o'clock** position and complete assembly by turning **1 1/4 turns** to the **9 o'clock position**. In this way a sealed connection is reached after 1 1/4 turn of the nut. Following this procedure guarantees a quality connection.

**Assembly for high pressure applications and applications with a high security factor:** Hand tighten tube with nut on to the fitting body. Counterhold the fittings body with a second spanner. Turn the nut approx. **1/8** of a turn. Tube can not turn anymore in the fitting. That is your **"Starting Position"**. **Mark** the nut at the **6 o'clock** position and complete assembly by turning **1 1/4 turns** to the **9 o'clock position**. In this way a sealed connection is reached after 1 1/4 turn of the nut. Following this procedure guarantees a quality connection.



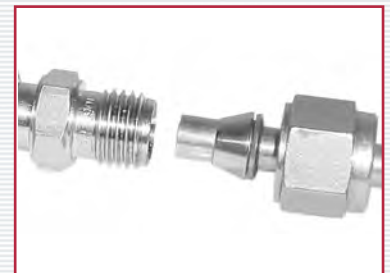
**Attention:** Fittings for the use of **1/16"-3/16"** and **2 mm – 4 mm tube the final assembly is achieved after 3/4 of a turn.** On larger sizes above 25 mm – 1" a hydraulic **pre-assembly machine** is needed.

### ■ Re-Assembly

U2-twin ferrule couplings can be **re-assembled several times**. A leak free connection is guaranteed if the con shows no damage and is free of contamination. The coupling is dismantled.

The assembled tube has to be pushed into the fitting up to the point where the front ferrule sits solid in the cone of the body.

Handtighten the nut. Tighten the nut with a spanner back to the original position. Counterhold the body and tighten till you feel an increase in resistance. **DO NOT overtighten the connection!**



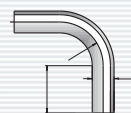
### ■ Assembly with an assembly stud

The use of a pre-assembly stud is recommended in the case of restricted workspace. Fix the pre-assembly stud in a vice and assemble nut and ferrules as described under point 2.



### Pre-assembly machine PATM:

Tube OD mm	Part number	Tube OD mm	Part number	Tube OD mm	Part number
2	PATM2	10	PATM10	18	PATM18
3	PATM3	12	PATM12	20	PATM20
4	PATM4	14	PATM14	22	PATM22
6	PATM6	15	PATM15	25	PATM25
8	PATM8	16	PATM16		



### The minimum straight length before the bend

D	mm	3	6	8	10	12	16	18	25
L recommend		18	21	22	23	28	30	32	35
L minimum		15	17	18	19	25	27	28	33
R	Bendradius as recommended by the manufacturer of bending machine								