

Dk-Lok Tube Fittings

INSTALLATION INSTRUCTIONS

This instruction applies to Dk-Lok Tube Fittings as well as Dk-Lok Z series Tube Fittings.

Dk-Lok is supplied finger-tight and ready for immediate use. Therefore fitting disassembly is not necessary for installation.

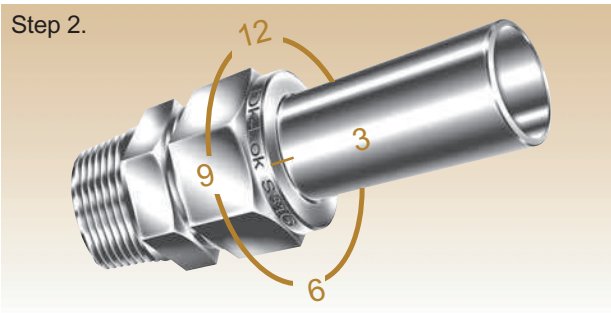
Step 1.



Insert the tubing into the Dk-Lok tube fitting until the tubing end bottoms on the shoulder of the fitting body.

- Make sure the nut finger-tight.

Step 2.



Scribe the nut at the 6 o'clock position and wrench-tighten the nut 1 1/4 turns to the 9 o'clock position, holding the body with a back up wrench.

- Tighten the nut 3/4 turn to the 3 o'clock position for 1/16, 1/8, and 3/16 in.; 2, 3, and 4mm tube fittings.

Dk-Lok Installation for High Pressure or High Safety Applications

1. Insert tubing on the Dk-Lok tube fitting until the tubing end bottoms on the shoulder of the fitting body.
2. Wrench-tighten the nut until the tubing does not rotate by hand or moves axially in the fitting.
3. Scribe the nut at 6 o'clock position.
4. Wrench-tighten the nut to the 9 o'clock position, holding the body with a back up wrench.
 - Only 3/4 turn to the 3 o'clock position is required for 1/16, 1/8, and 3/16 in.; 2, 3 and 4mm tube fittings.

Inspection of Gaugeable Dk-Lok fitting initially pulled-up

Dk-Lok tube fittings are gaugeable. This allows installer to inspect that the make-up distance is sufficiently pulled-up on initial assembly.

Refer to page on 77 for Gap Gauge Operation Instructions.

- Dk-Lok Gap Gauge is applicable to those Dk-Lok fittings made out of SS316, Carbon steel, Brass, and Exotic alloy materials.

Re-assembly Instructions

Dk-Lok can be used many times.

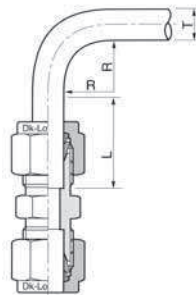
Prior to re-assembly, ensure the components are clean and free of defects.

1. Insert the ferrules swaged tubing into the body until the front ferrule seats firmly.
2. Hand-tighten the nut.
3. Wrench-tighten the nut to the previously pulled-up position; at this point, a sharp rise in torque is felt.
4. Tighten slightly with a wrench.

Tube handling during installation

1. Do not force the tubing into the fitting when it does not smoothly go in. It may be a deformed oval.
2. Use proper tube cutter and maintain a sharp cutting wheel on it.

Tube installation



T : Tube O.D.

R : Radius

L : Straight tube length

In case tube bend is too close to a fitting, the bend section shall enter the fitting. This may not allow the tube to be bottomed in the fitting, resulting in leaks.

Keep the proper straight length of tube as shown in the tables.

- Do not bend a tube in the fitting. Use tube bender prior to installation onto fitting.

Fractional tube, in.	
T	L
1/16	1/2
1/8	23/32
3/16	3/4
1/4	13/16
5/16	7/8
3/8	15/16
1/2	1 3/16
5/8	1 1/4
3/4	1 1/4
7/8	1 5/16
1	1 1/2
1 1/4	2
1 1/2	2 13/32
2	3 1/4

Metric tube, mm	
T	L
3	19
6	21
8	23
10	25
12	31
14	32
15	32
16	32
18	32
20	34
22	34
25	40
28	46
30	50
32	54
38	63
50	80