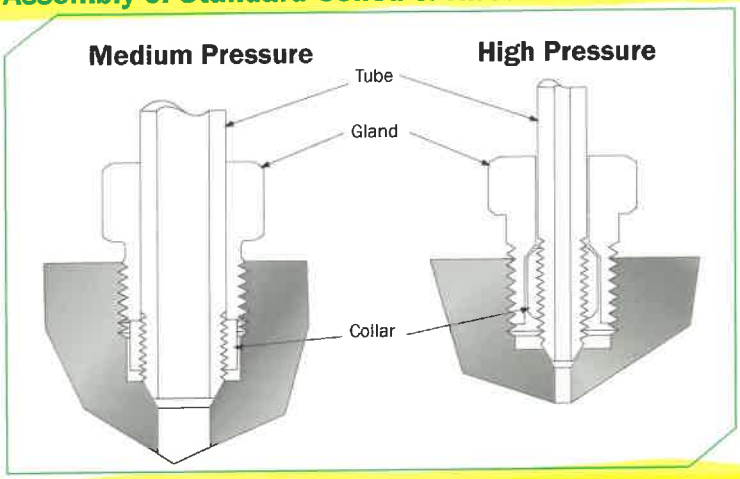
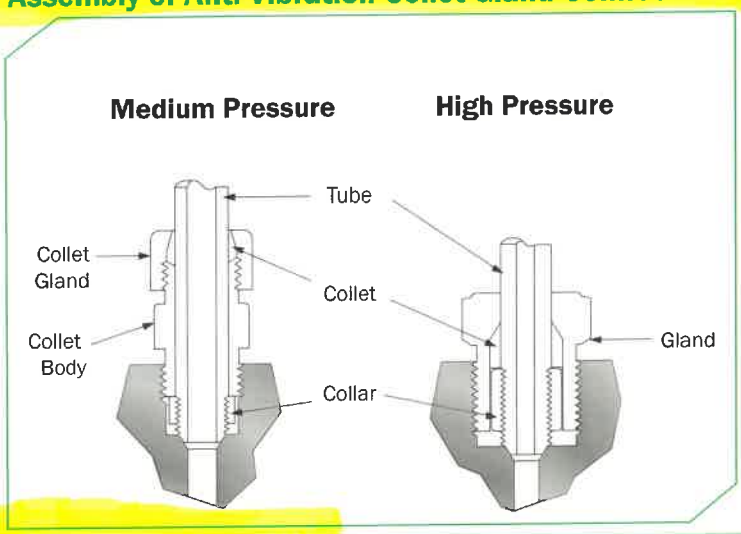
Assembly of Standard Coned & Threaded Connections



Assembly Instructions:

1. Insert the gland onto the tubing. Thread the left handed collar onto the tube until one or two threads are exposed from the tapered coned end.
2. Apply a compatible lubricant to the gland threads and the back side of the collar where it comes in contact with the gland. Also lubricate the tapered cone portion of the tube with a system compatible lubricant. This will help protect the sealing surfaces from galling during the assembly process.
3. Insert the tubing into the connection and tighten the assembly hand tight. Then use a torque wrench to tighten the connection to the appropriate value in the table below. It is good practice to use an additional wrench to prevent the opposite connection from turning.

Assembly of Anti-Vibration Collet Gland Connections



Assembly Instructions

1. The High Pressure Anti-Vibration Collet Gland Assembly can be installed using the same procedure as the standard coned and threaded connection. (see above steps 1 through 3) The high pressure collet grips the tube when the connection gland is tightened.
2. When using the Medium Pressure Anti-Vibration Collet Assembly, the procedure is the same as that of the standard coned and threaded connection (see above steps 1 through 3) with the additional step below.
3. Once the Collet Body has been tightened to the approriate torque value in the table below, the Collet Gland can be turned 1 - 1/4 turns past hand tight. This will compress the collet against the tube. After the initial compression of the collet, any additional retightening would only require 3/4 of a turn past hand tight.

Torque Values

Tubing Size O.D. x I.D. (in.)	Tubing Pressure (psi @ R.T.)	Connection Type	Tube Gland Hex Size (in.)	Required Torque (ft-lbs.)
1/4 x .109	22,500	4M	1/2	20
3/8 x .203	22,500	6M	5/8	30
9/16 x .312	22,500	9M	15/16	55
9/16 x .359	15,200	9M	15/16	55
3/4 x .438	22,500	12M	1-3/16	90
3/4 x .516	15,200	12M	1-3/16	90
1 x .562	22,500	16M	1-3/8	150
1 x .688	15,200	16M	1-3/8	150
1-1/2 x .937	15,200	24M	1-7/8	200
1/4 x .083	65,000	4H	5/8	25
3/8 x .125	65,000	6H	13/16	50
9/16 x .188	65,000	9H	1-3/16	110
9/16 X 250	40,000	9H	1-3/16	60
1 X .438	43,000	16M	1-3/8	150
1/4 x .083	101,000	4U	5/8	35
3/8 x .125	101,000	6U	13/16	65
9/16 x .188	101,000	9U	1-3/16	145
5/16 x .062	152,000	5U	3/4	70

All dimensions are for references only and are subject to change.