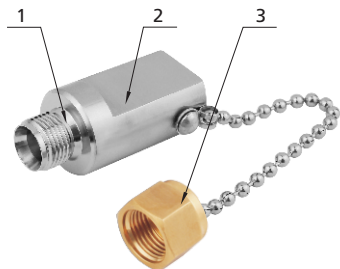


Manual Presetting Tool Instructions

Introduction

For tube fitting installations in close quarters, the presetting tool can make installation easier and more reliable when paired with the table vice.



1. Body 2. Die Head 3. Nut

■ Application

For installing 1/4" to 1" and 6 mm to 25 mm carbon steel, stainless steel and alloy steel tube fittings.

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■ Operation

1. Clamp the presetting tool in the table vice;
2. Remove the presetting tool nut;
3. Insert the tubing into the corresponding fitting. Loosen the fitting nut and install it with front and rear ferrules onto the tubing. Direction of nut, front and rear ferrules refers to Fig. 1;

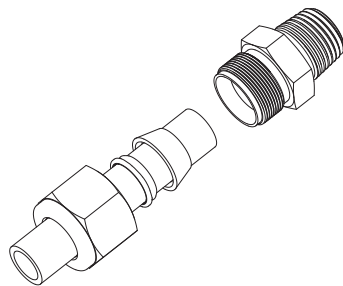


Fig. 1

4. Insert the tube into the die head. Make sure the tubing rests firmly on the shoulder of the die head and finger tight the nut;
5. Mark the nut at 6 o'clock position;
6. Tighten the nut 1-1/4 turns clockwise with a wrench to 9 o'clock position;
7. Loosen the nut counterclockwise, take out the tubing with preset ferrules, tighten the presetting tool nut back to the die head;
8. Insert the tubing with preset ferrules into the fitting body until the front ferrule seats against the fitting body. Install the tubing to the fitting as stated in the reassembly instructions of tube fittings.

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