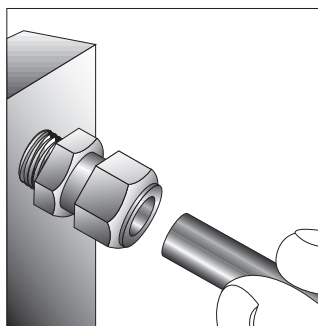
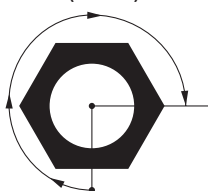


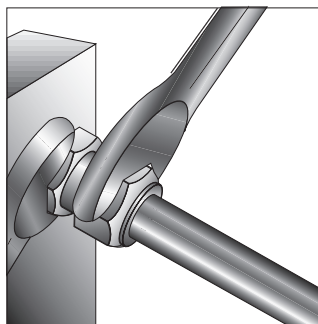
## Assembly and Remake Instructions



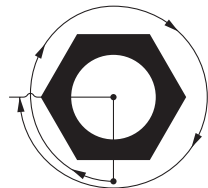
INCH SIZE 1 thru 3  
(1/16" - 3/16")  
METRIC SIZE 2 thru 4  
(2-4mm)



Only 3/4 turn from finger tight is necessary to seal and will result in additional remakes of the fitting



INCH SIZE 4 thru 16  
(1/4" - 1")  
METRIC SIZE 6 thru 25  
(6-25mm)



1-1/4 Turns from Finger Tight

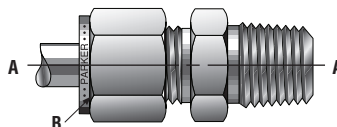
1. Parker instrument tube fittings are sold completely assembled and ready for immediate use. Simply insert the tube as illustrated until it bottoms in the fitting body. (If the fitting is disassembled, note that the small tapered end of the ferrule(s) go into the fitting body.)

2. Tighten nut finger tight. Then tighten nut with wrench an additional 1-1/4 turns indicated below. Hold fitting body with a second wrench to prevent body from turning. It is helpful to mark the nut to facilitate counting the number of turns.

For maximum number of remakes, mark the fitting and nut before disassembly. Before retightening, make sure the assembly has been inserted into the fitting until the ferrule seats in the fitting. Retighten the nut by hand. Rotate the nut with a wrench to the original position as indicated by the previous marks lining up. (A noticeable increase in mechanical resistance will be felt indicating the ferrule is being re-sprung into sealing position.)

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

**For Sizes above 16 (1"), the Parker ICD Hydraulic Presetting Tool or Rotary Wrench Tool should be used. Cat. 4290-INST.**



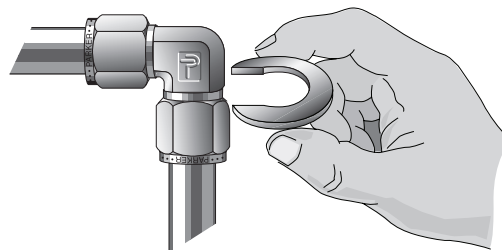
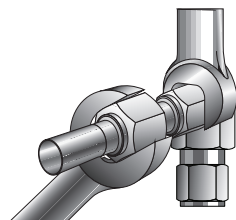
Parker A-LOK® Tube Fitting part numbers use symbols to identify the size, style, and material. Tube and pipe thread sizes begin with a number indicating their size in sixteenths of an inch. For example, 4=4/16" or 1/4"; 16=16/16" or 1.

**NOTE:** 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

For additional information please contact your local authorized Parker Instrumentation distributor or call Parker Instrumentation Connectors Division and ask for Bulletin 4230-B10.

## Gaugeability Instructions



1. From "finger tight" position, wrench 1-1/4 turns for 1/4" to 1" size fittings (6mm to 25mm) (1/16", 1/8", 3/16", 2mm 3mm and 4mm size tube fittings only wrench 3/4 turn from finger tight position). Hold fitting body hex with second wrench to prevent body from turning as you tighten. It is a good idea to mark the nut (scribe or ink) to help you count the turns.

2. Now select the proper size inspection gauge and try to place it, as shown, between the nut and the body hex. If gauge **DOES NOT FIT AT ANY POINT** 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.

For additional information please contact your local authorized Parker Instrumentation distributor or call Parker Instrumentation Connectors Division and ask for Bulletin 4230-B15.2.