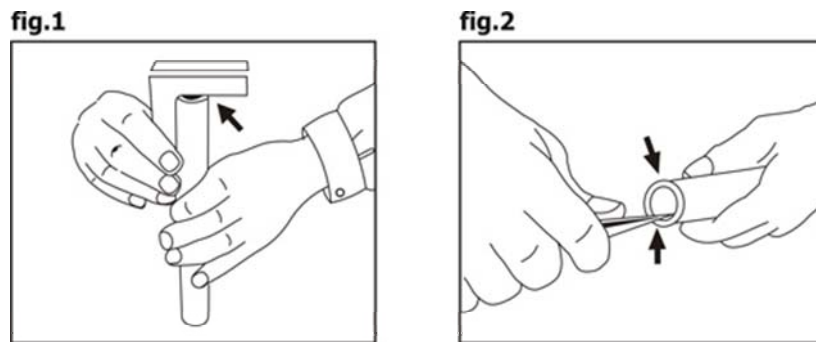


Assembled Brennan Metric Bite Type Tube Fittings are shipped finger tight and are ready for immediate use. Disassembly before use can result in dirt or foreign material getting into the fitting, which can cause leaks and/or system contamination.

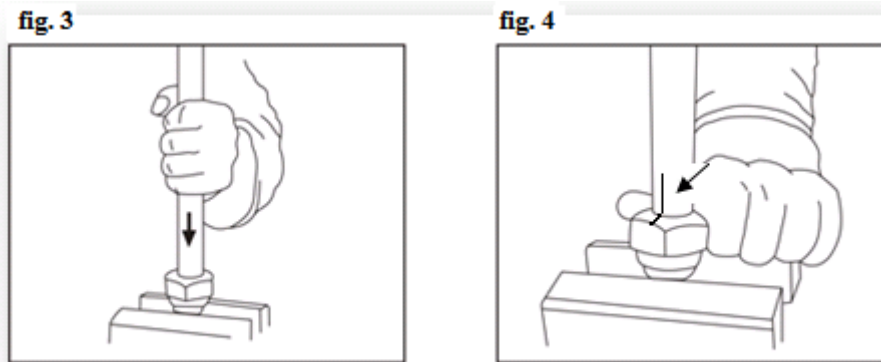
Brennan bite type Fittings for Metric OD tube sizes meet or exceed the requirement of DIN standard 2353 and are classified in to three (3) broad categories: **LL** Series (Light or Low Pressure), **L** Series (Medium) & **S** Series (for High Pressure Applications).

P R E A S S E M B L Y P R O C E D U R E

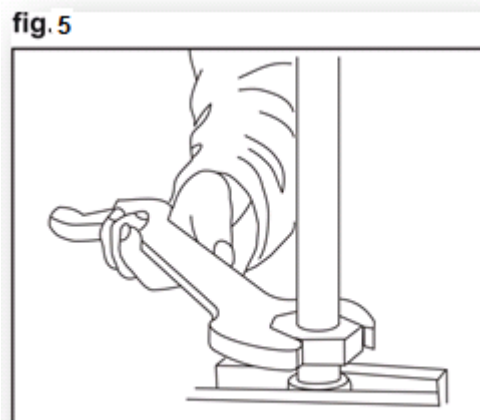
- 1) Using a sawing machine (do not use a tube cutter or cutting wheel), saw off tube square to the tube axis. An angular gap of 0.5° is allowable (as shown in **fig. 1**)



- 2) Lightly de-burr both the inside and outside edges of the tube.
A bevel up to $0.2 \times 45^{\circ}$ permissible (**Fig. 2**)
- 3) Slip the nut and cutting ring over the tube end. Ensure that the cutting ring's cutting edge faces toward the pipe end.
- 4) Insert the tube assembly into pre-lubricated fitting body and screw nut manually on to the pre-lubricated fitting body until finger tight. Hold tube against the shoulder in the cone of the fitting body. (**Fig. 3**)



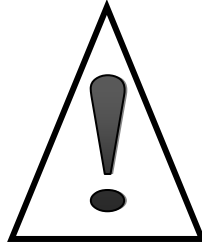
- 5) To assist in measuring the proper and complete rotation of the nut, scribe the nut and tube. **(fig 4)**
- 6) Tighten nut approximately $1\frac{1}{2}$ turns from finger tight using a wrench. **(Note-** tube must not rotate with nut). Cutting ring's stop edge limits over tightening by increasing tightening torque. **(Fig 5)**.



Final Assembly Procedure

After pre-assembly, loosen the nut and note a visible “bite” mark on tube in front of the cutting ring. A properly set cutting ring may rotate but will not travel axially along tubing.

Finger tighten nut once again until perceptible resistance is met. Positioned within a vice or by using a wrench, hold the fitting body steady and tighten the nut approximately $\frac{1}{4}$ to $\frac{1}{2}$ turns from finger tight.



SAFTEY INSTRUCTIONS

1. When the system is pressurized, do not tighten or loosen any part of the fitting. Make sure the system is un-pressurized before attempting to do so.
2. Pressure-temperature specifications as stated in the appropriate catalog must not be exceeded.
3. When the tube is bent, ensure that there is a length of straight tube between the tube bend and the fitting. This will ensure that the joint is leak-proof.
4. When assembling the Brennan Tube Fitting, hold the fitting body with a wrench. Use a separate wrench for tightening the Brennan Nut. The same procedure should be used for disassembling the Brennan Tube Fitting.
5. When using lubricants/sealants, be aware that they may have lower temperature ratings than the Brennan Tube Fittings.
6. All threads should be torqued in accordance with industry standards. When retightening a Brennan Fitting, note that additional tightening may be required.

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