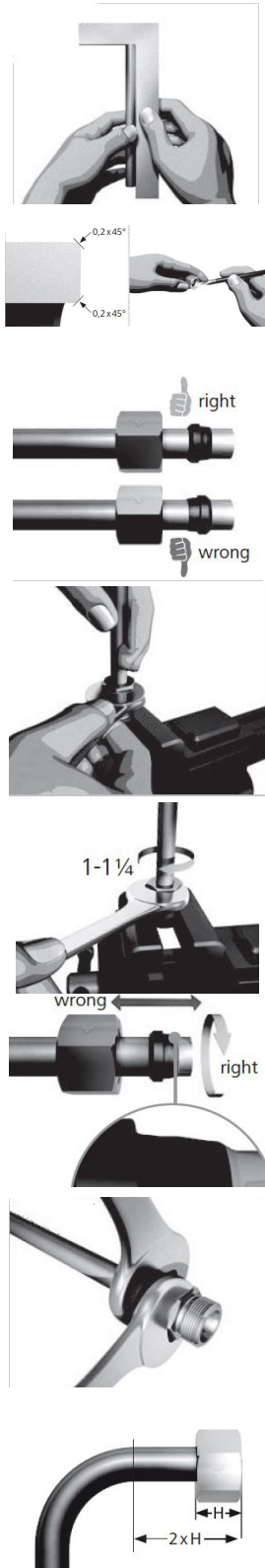


# ASSEMBLY INSTRUCTIONS



<p>1. Saw the tube off square. An angular deviation of <math>0.5^\circ</math> relative to the tube axis is permissible. Please note!! Do not use pipe cutters. Use reinforcing sleeve with thin wall tubes.</p>
<p>2. Lightly debur the tube ends and clean the tube thoroughly The tube end within the assembly length must be free from swarf, dirt and paint.</p>
<p>3. Assembly of cutting ring Place nut and cutting ring on tube as shown. Please note!! ensure that the cutting ring edge is facing the tube end.</p>
<p>4. Find point of resistance Push pipe completely into the connector. Tighten nut until the ring makes contact with the tube surface - this point can be felt by an increase in the torque. (Torque increase point)</p>
<p>5. Final assembly After the ring has contacted the tube, mark position of the nut. Tighten the nut by <math>1-1/4</math> turn*. Ensure to use wrench extension as required. Please Note!!! Fitting body to be used one time only. If pre-assembling is required please visit <a href="http://www.brennaninc.com/literature">www.brennaninc.com/literature</a> for instructions. *For carbon steel, tighten the nut by 1 turn.</p>
<p>6. Control Check penetration of cutting edge. A visible ring of material should fill the space in front of the cutting ring end face. Cutting ring may turn on tube but should not be capable of moving in an axial direction.</p>
<p>7. Repeated Assembly Each time the fitting has been loosened, re-assembly must be performed with the same torque as initial assembly. Hold the body rigid. Threads must be lubricated. Recommended to use wrench extension.</p>
<p>8. Minimum length of straight tube end for tube bends For tube bends, the length of the straight tube end up to the start of the bend radius must be at least twice the nut length. The straight segment of the tube up to <math>2 \times H</math> must not be oval or tapered.</p>

If you would like a short assembly training, our application engineers would be pleased to accommodate you. Please contact us for further information. Assembly instructions for use with dies and presetting machines, pressure ratings and other info can be found at [brennaninc.com](http://brennaninc.com).