# Preswaging Tool PS



### Fractional Dk-Lok

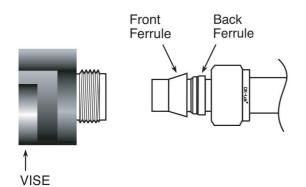
Part No.	Tube O.D. (in.)
DPS-4-C	1/4
DPS-5-C	5/16
DPS-6-C	3/8
DPS-8-C	5/8
DPS-12-C	3/4

## metric Dk-Lok

Part No.	Tube O.D. (mm)
DPS-3M-C	3
DPS-6M-C	6
DPS-8M-C	8
DPS-10M-C	10
DPS-12M-C	12
DPS-16M-C	16
DPS-18M-C	18
DPS-20M-C	20

# **Operation Instructions**

### Pre-swaging Tool (DPS)



## **Assembly on Fitting**

- 1. Insert the ferrule pre-swaged tubing into the fitting body until the front ferrule seats.
- 2. Hand-tighten the nut.
- 3. Wrench-tighten the nut to the previously pulled-up position; at this point, a sharp rise in torque is felt.
- 4. Tighten slightly with a wrench.

## **Operation on Pre-Swaging Tool**

- 1. Clamp the DPS on the VISE steadily.
- 2. Install the Dk-Lok nut, ferrules onto the tubing.
- 3. Insert the loose ferrules and loose nut installed tubing end into the DPS until it is bottomed on the shoulder of the DPS.
- 4. Finger-tighten the nut.
- 5. Scribe the nut at the 6 o'clock position.
- 6. Wrench-tighten the nut 1 1/4 turns to the 9 o'clock position.
  - Tighten the nut 3/4 turn to the 3 o'clock position for 1/16, 1/8, and 3/16 in.; 2, 3, and 4 mm tube fittings.
- 7. Un-thread the nut.
- 8. Remove the tubing with pre-swaged ferrules from the DPS.
  - In case the tubing is difficult to remove from DPS, gently rock the tubing back and forth. Do not rotate the tubing.