

INSTALLATION INSTRUCTION 0001-0778-999

Style 501 SEAL-PLUS™

SEAL-PLUS™ Restraining Ends with Shiled Nuts

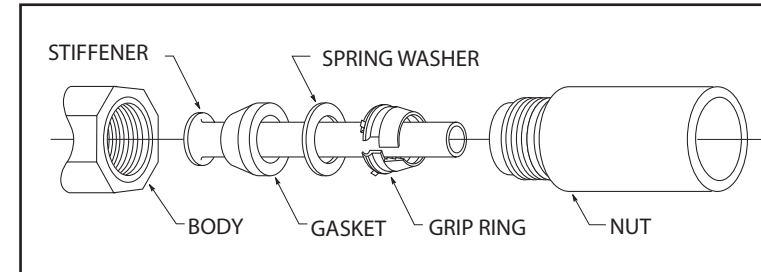
1. Cut tubing square and deburr. Tubing must be clean and free of longitudinal scratches. A slight chamfer approximately 1/16" x 45° on the end of tubing will facilitate insertion into the fitting.
2. If welding is required, remove components prior to welding, then reassemble parts in the sequence and orientation as shown.
3. Make sure nut flange is 1/4" to 5/16" from body contact.
4. Mark tubing for stab depth as follows: 5/8" O.D. 4" length; 7/8" and 1-1/8" O.D. 4-1/8" length; and 1-3/8" O.D. 4-1/4" length.
5. Check stiffener to assure it is for wall thickness of tubing used (See the color code chart).
6. Stab tubing into fitting until it bottoms. If properly stabbed, the tube markings will be inside or not over 1/8" from the UNTIGHTENED nut. **STABBING NOTE:** This fitting does not grip when the tubing is stabbed. If difficulty is encountered in stabbing, withdraw the tubing and try reinserting again. (Be sure nut flange is at least 1/4" from body.) After proper stabbing is determined, **THE NUT MUST BE HAND TIGHTENED TO ACTUATE THE GRIP RING FOR HOLDING THE TUBING IN PLACE DURING FINAL TIGHTENING.**
7. Tighten nut while holding body octagon closest to nut until flange contacts body. (Do not overtighten.)
8. Check stabbing marks on tubing. If mark is over 9/16" from the tightened nut on 5/8" O.D.) thru 1-1/8" O.D. size, and over 5/8" on larger sizes, the end must be disassembled. After disassembly, check if stab mark length is correct. In reassembling an improperly stabbed end, cut off the tubing to eliminate the gripper teeth marks. Discard shrink wrap. Reassemble parts in proper order, remark tubing, and then repeat the connection procedure.

NOTE: The gasket, spring washer and grip ring are held in place with shrink-wrap to facilitate assembly at the factory. The shrink-wrap does not need to be removed and is designed to break away during installation. However, if the fitting is disassembled following an improper installation, the shrink-wrap must be discarded prior to reassembly of the fitting as noted in Step 8 above.



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COLOR CODE CHART

Tubing Wall (Any Diameter)	Stiffener Color
.062	Red
.077	Blue
.090	Silver
.099/.101/.103	Gold
.121	Black



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