

Dk-Lok Tube Fittings

INSTALLATION INSTRUCTIONS

This instruction applies to Dk-Lok Tube Fittings as well as Dk-Lok Z series Tube Fittings.

Dk-Lok is supplied finger-tight and ready for immediate use. Therefore fitting disassembly is not necessary for installation.

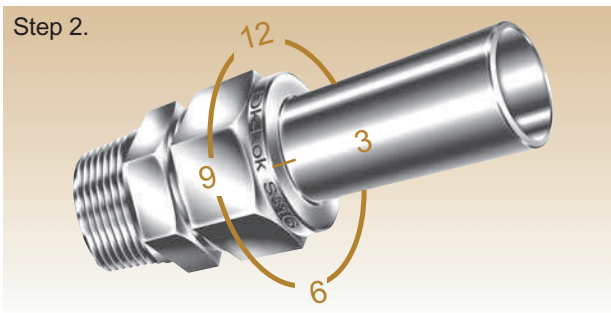
Step 1.



Insert the tubing into the Dk-Lok tube fitting until the tubing end bottoms on the shoulder of the fitting body.

- Make sure the nut finger-tight.

Step 2.



Scribe the nut at the 6 o'clock position and wrench-tighten the nut 1 1/4 turns to the 9 o'clock position, holding the body with a back up wrench.

- Tighten the nut 3/4 turn to the 3 o'clock position for 1/16, 1/8, and 3/16 in.; 2, 3, and 4mm tube fittings.

Dk-Lok Installation for High Pressure or High Safety Applications

1. Insert tubing on the Dk-Lok tube fitting until the tubing end bottoms on the shoulder of the fitting body.
2. Wrench-tighten the nut until the tubing does not rotate by hand or moves axially in the fitting.
3. Scribe the nut at 6 o'clock position.
4. Wrench-tighten the nut to the 9 o'clock position, holding the body with a back up wrench.
 - Only 3/4 turn to the 3 o'clock position is required for 1/16, 1/8, and 3/16 in.; 2, 3 and 4mm tube fittings.

Inspection of Gaugeable Dk-Lok fitting initially pulled-up

Dk-Lok tube fittings are gaugeable. This allows installer to inspect that the make-up distance is sufficiently pulled-up on initial assembly.

Refer to page on 77 for Gap Gauge Operation Instructions.

- Dk-Lok Gap Gauge is applicable to those Dk-Lok fittings made out of SS316, Carbon steel, Brass, and Exotic alloy materials.

Re-assembly Instructions

Dk-Lok can be used many times.

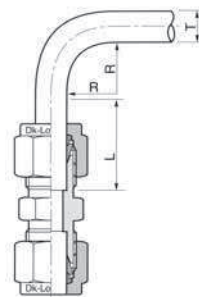
Prior to re-assembly, ensure the components are clean and free of defects.

1. Insert the ferrules swaged tubing into the body until the front ferrule seats firmly.
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.

Tube handling during installation

1. Do not force the tubing into the fitting when it does not smoothly go in. It may be a deformed oval.
2. Use proper tube cutter and maintain a sharp cutting wheel on it.

Tube installation



T : Tube O.D.

R : Radius

L : Straight tube length

In case tube bend is too close to a fitting, the bend section shall enter the fitting. This may not allow the tube to be bottomed in the fitting, resulting in leaks.

Keep the proper straight length of tube as shown in the tables.

- Do not bend a tube in the fitting. Use tube bender prior to installation onto fitting.

Fractional tube, in.	
T	L
1/16	1/2
1/8	23/32
3/16	3/4
1/4	13/16
5/16	7/8
3/8	15/16
1/2	1 3/16
5/8	1 1/4
3/4	1 1/4
7/8	1 5/16
1	1 1/2
1 1/4	2
1 1/2	2 13/32
2	3 1/4

Metric tube, mm	
T	L
3	19
6	21
8	23
10	25
12	31
14	32
15	32
16	32
18	32
20	34
22	34
25	40
28	46
30	50
32	54
38	63
50	80



Quality System Certifications

ISO 9001:2000	AP1149
ISO 14001:2004	HSBRK
OHSMS 18001	HSBSK-S006
API	6D-0593
KEPIC	MN-227

Nuclear System and Product Certifications

ASME N	N-3185
ASME NPT	N-3186
ASME NS	N-3342
ASME NB	N-3185, 3186, 3342

Directive 97/23/EC

TUV NORD	07-202-3537 WZ-0941/09
RWTUV	K1005/04

CNG/NGV

TUV SUD	07-000026-PA-GBM-00
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Vacuum Test Certificate TA LUFT 2002

TUV Rheinland	973-10014584
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CRN

CRN	0A4788.2
CRN	0C07988.2
CRN	0C09275.2
CRN	0C5191.2
CRN	0C07988.2

GOST

GOST	POCC KR.MX05.B00226
GOST	POCC KR.MX05.B00227

Type Approval Certifications

ABS	BK720958-X
BV	14034/A1 BV
DNV	P-11926, P-12490
GL	47 924-03HH 47 925-03HH 40 504-01HH 40 505-01HH
KR	CWN80397-PE001
LR	01/10047 01/10048
NK	06FV101B

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The accuracy of information is not the liability of our company.

Safe Component Selection

The Selection of component for any applications or system design must be considered to ensure safe performance. Component function, material compatibility, component ratings, proper installation, operation and maintenance remain the sole responsibility of the system designer and the user. DK Tech accepts no liability for any improper selection, installation, operation or maintenance.



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