
DIN / JIS Tube Fittings

Assembly User Manual

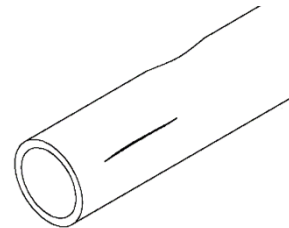
S-LOK® 한선엔지니어링(주)
HANSUN ENGINEERING CO., LTD.



1 Tube preparation

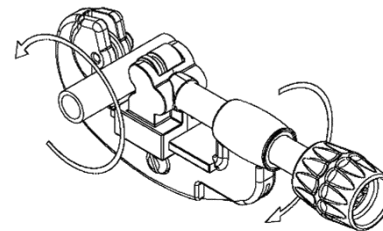
1.1 Tube treatment

- Be careful not to cause any defects such as scratches, notches, etc. when transporting the tubes.
- Check for foreign substances inside and outside the tube.
- Check the roundness.



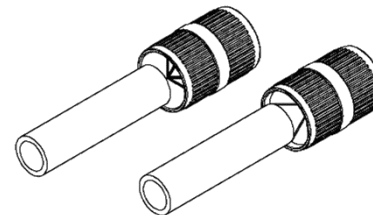
1.2 Tube cutting

- Tighten the tube securely.
- Turn the tube cutter and knob until they are cut.
- Stainless steel and steel tube rotate 1/8 turn after Tube Cutter 2 turns.
- Flexible tube is 1/8 turn of handle after 1 turn of Tube Cutter.
- Tube cutting angle tolerance is $90^\circ \pm 0.5^\circ$



1.3 Tube Burr remove

- Tube is tightly attached to the outer diameter deburring tool, and the outer diameter burr is removed.
- Tube is tightly attached to the inner diameter deburring tool and the inner diameter burr is removed by turning it

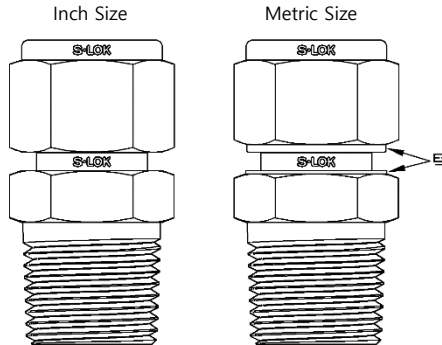


2 DIN / JIS Tube Fittings prepare

2.1 DIN / JIS Tube Fittings visual inspection

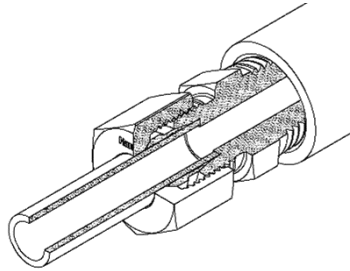
- Make sure you see two lines.
- Make sure the sleeve is in place.

※ The product is provided in an assembled condition and can be used immediately after tightening by hand.
Be careful that foreign materials or dust may enter the product when disassembling, which may interfere with the seal.

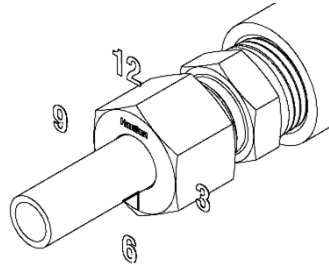


3 DIN / JIS Tube Fittings direct assembly

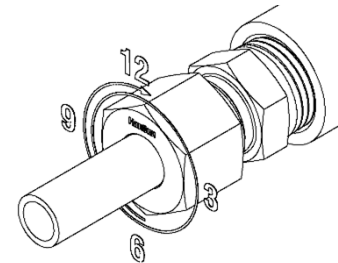
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Until the tube touches the jaw of the fitting body and tighten the nut firmly by hand.

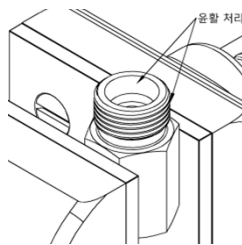


Good location for both Tube and Nut
Display the starting point

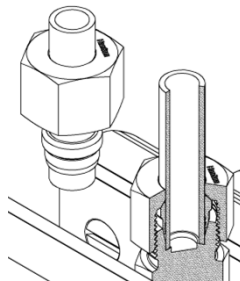


Tighten the nuts 1-1/2 turns..

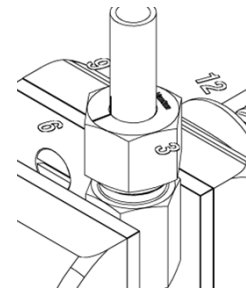
4 DIN / JIS Tube Fittings Preswaging



Secure the pre-swaging tool to Vise and lubricate the screw and body taper part.



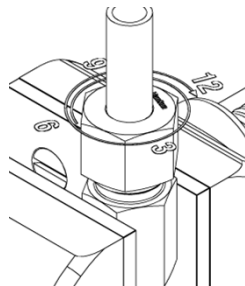
Insert the nut and sleeve into the tube (directional) and insert the tube until the tube touches the body jaw of the Pres-waging Tool.



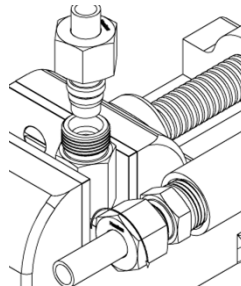
Both the tube and the nut display the starting point in a good position



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Tighten the nuts 1-1/2 turns.



When you tighten a nut, there is a sudden increase in torque.
At this point, turn it about 1/4 to 1/2 turn further.

Sometimes the tubes may not come out well. In this case, do not use any other tools, just gently shake it back and forth.