

## Preswaging Tool DPS



### Fractional Dk-Lok

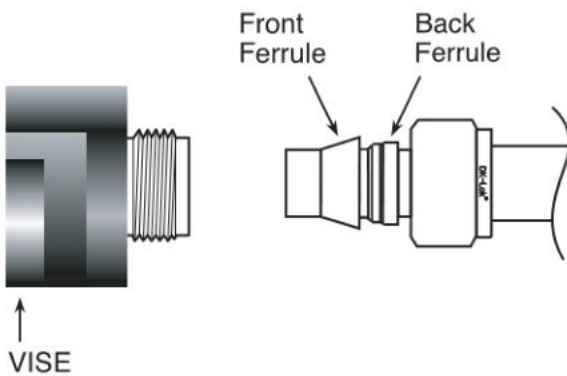
Part No.	Tube O.D. (in.)
DPS-4-C	1/4
DPS-5-C	5/16
DPS-6-C	3/8
DPS-8-C	5/8
DPS-12-C	3/4

### 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.