

HOW TO ASSEMBLE NYLON TUBE AIR BRAKE FITTINGS



- Cut tubing cleanly and squarely (maximum 15° angle allowable).
- Check that the port or mating part is clean and free of debris.
- Thread the nut and sleeve onto tubing.
- Insert tubing onto fitting body until the tubing is fully seated.
- Slide sleeve and nut down and tighten in one of two ways:
 - Tighten with a wrench until only one thread remains visible. This will allow for multiple remakes.
 - Tighten nut until finger tight, then using a wrench, continue to tighten according to the table below.



TUBE SIZE	ADDITIONAL TURNS
3/16" O.D.	2-1/2
1/4" O.D.	3
3/8" and 1/2" O.D.	4
5/8" and 3/4" O.D.	3-1/2