

# 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. Tubing should only extend approximately 1/8" past sleeve.
- Insert tubing onto fitting body until the tubing is fully seated.
- Slide sleeve and nut down. Hold the tubing in place and tighten the nut until finger tight. Then, using a wrench, continue to tighten according to the table below.



TUBE SIZE	ADDITIONAL FULL 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