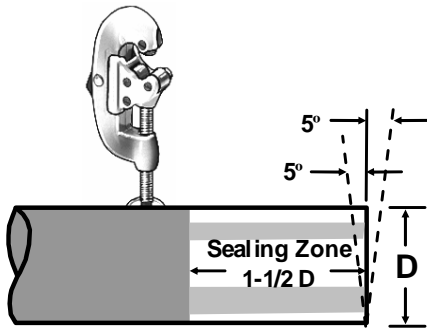


## INSTALLATION PROCEDURE

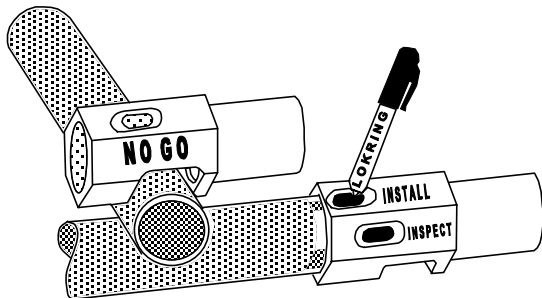
Note: Refer to LOKRING procedure LP-110 for detailed installation instructions

**STEP 1:** Sealing Zone shall be 6" from brazed joint. If necessary, before cutting tube, use a non-shedding abrasive pad to clean surface and remove scratches from tube OD. Care should be taken to not contaminate the inside of the tube. Always clean tube sealing zone in circumferential direction

Cut tube with clean tubing cutter to within 5° square.

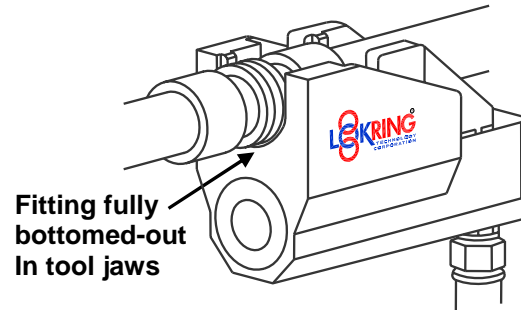
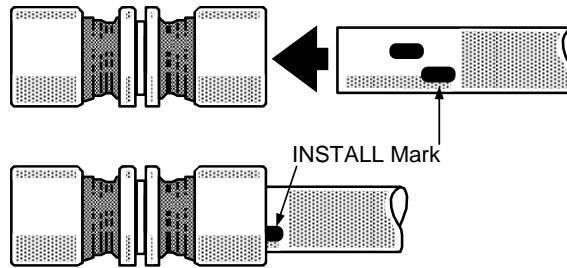


**Step 2:** Using the Multi-Purpose Gauge, verify that the tube OD is correctly sized, and mark the tube ends as shown.



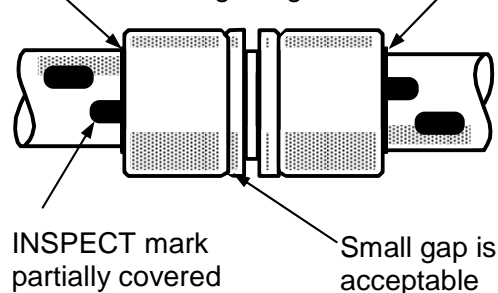
**STEP 3:** Select and assemble required LOKRING tool. Inspect and cycle tool to assure proper function.

**STEP 4:** Position fitting on "INSTALL" mark, fully engage and actuate tool.



**STEP 5:** Carry out visual checks below to verify successful installation.

Fitting body protrudes from underneath swage ring



# LOKRING INSTALLER'S Field Installation Guide

For Series BR  
Brass LOKRING™ Tube  
Fittings. For use with Copper  
Tube in  
Medical Gas and Vacuum  
Applications and B88 (Drawn)  
& B819 Copper Tuing

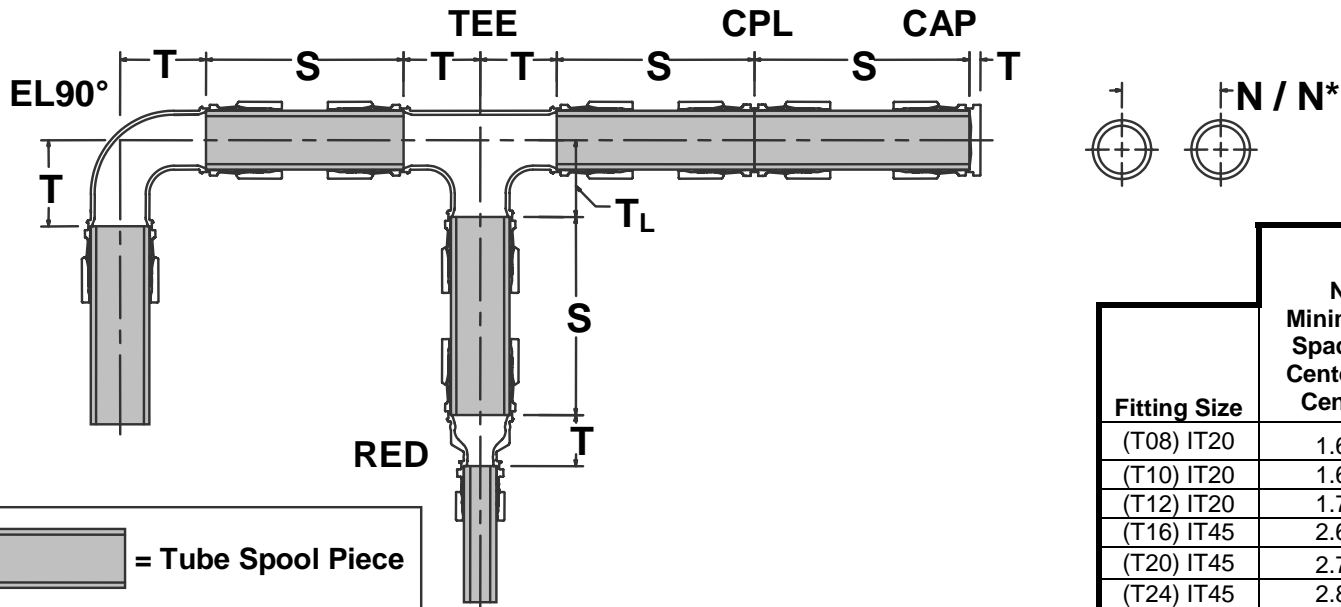


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8.03G Tri-Fold Handout For BR MedGas  
and ASTM B88 (Drawn) & B819 Copper  
Tube (07-02-09)



Fitting Size	N Minimum Spacing Center to Center	N* Minimum Spacing Center to Center, with fittings adjacent each other
(T08) IT20	1.62	1.76
(T10) IT20	1.68	1.82
(T12) IT20	1.74	1.91
(T16) IT45	2.64	2.85
(T20) IT45	2.77	3.01
(T24) IT45	2.89	3.19
(T32) IT50	3.29	3.67

		Fitting Take-Out "T" in 1/16" Increments					Reducers	RED (T)
LOKRING Fitting <sup>1</sup> Size	LOKTOOL Head	"S" Min <sup>2</sup>	CAP (T)	EL90 (EII) (-LR) (T)	TEE (T)	TEE (T <sub>L</sub> )		
1/2" BR-XXX-T08 (0.625" OD)	IT20	3-1/16"	1/4"	*	*	*	5/8" X 1/2" (T10-T08)	3/16"
5/8" BR-XXX-T10 (0.750" OD)	IT20	3-7/16"	1/4"	*	*	*	3/4" X 5/8" (T12-T10)	3/16"
3/4" BR-XXX-T12 (0.875" OD)	IT20	3-11/16"	3/16"	*	*	*	1" X 3/4" (T16-T12)	3/8"
1" BR-XXX-T16 (1.125" OD)	IT45	4-3/4"	5/16"	*	*	*	1-1/4" X 1" (T20-T16)	1/4"
1- 1/4" BR-XXX-T20 (1.375" OD)	IT45	5-7/16"	5/16"	*	*	*	1-1/2" X 1-1/4" (T24-T20)	5/16"
1-1/2" BR-XXX-T24 (1.625" OD)	IT45	6"	5/16"	*	*	*	2" X 1-1/2" (T32-T24)	1/2"
	IT50	6-1/8"						
2" BR-XXX-T32 (2.125" OD)	IT50	7-11/16"	7/16"	*	*	*		

1. For use on positive pressure medical gas tube per B819 and for vacuum copper tube per ASTM B88.
2. Minimum cut spool length "S" listed is for reverse installation. Spool lengths may be decreased slightly if one fitting end can be pulled up prior to positioning the second end and the reverse position of the tool is used for the installation.

\* Consult LOKRING for Take-Out dimension