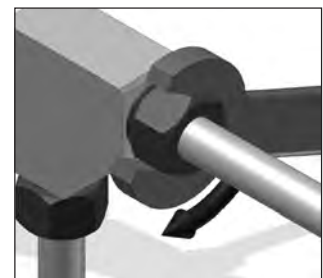
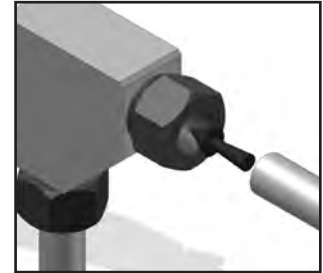


Parker MPI™ Fittings can be assembled by hand but hydraulic preset is recommended for 3/4" and required for 1" to insure proper markup (Required for 2507 Super Duplex Tubing along with using -XF ferrule sets on sizes 12 & 16).

## Assembly

1. Parker MPI™ Fittings are sold completely assembled and ready for immediate use. Simply insert the tube as illustrated until it bottoms in the fitting body. (If the fitting is disassembled, note that the small tapered end of the ferrule(s) go into the fitting body.)
2. Turn the nut to the "finger-tight" position. Hold the fitting body with a second wrench to prevent the body from turning as you tighten the nut. For hand assembly, tighten the nut 1-1/2 turns. For 3/4" and 1" sizes, preset the nut and ferrules and then tighten the nut 1/2 turn only. See page 79 & 80 for more information on preset connections. Parker recommends that you mark the nut (using a scribe or ink) to help you count the turns.



## Gaugeability

Check the gap between the nut and the body hex with the end of the gauge by inserting the gauge (as shown) into the beveled gap between the nut and body hex. Gently turn the gauge (that is, it "twists out"). However, if the gauge slides into the beveled gap, (does not "twist out") the fitting is not properly made up and you must check the entire assembly procedure.



## Remake

For maximum number of remakes, mark the fitting and nut before disassembly. Before retightening, make sure the assembly has been inserted into the fitting until the ferrule seats in the fitting. Retighten the nut by hand. Rotate the nut with a wrench to the original position as indicated by the previous marks lining up. (A noticeable increase in mechanical resistance will be felt indicating the ferrule is being re-sprung into sealing position.)

## Gap Gauge

This one handy gauge works for all MPI™ sizes. The end of the gauge checks the fitting gap after make-up.

Parker Part Number: **MPI GAP GAUGE**



Gap Gauge