ООО "Нижегородские промышленные системы", т. 8 (831) 423-58-23, www.nproms.ru, e-mail: mail@nproms.ru

Gyrolok® Marking Tool

Tube fitting users have long recognized that proper tube and tube fitting system function requires good tubing preparation followed by the use of correct installation procedures. Improper ferrule set in any flareless tube and fitting system may be the result of burrs created during the tube cutting process, improper tube insertion into the fitting, or inadequate tightening of the fitting nut. In order to maximize tube and fitting system performance and safety, HOKE offers several tool options combined with detailed installer training. The Gyrolok® Marking Tool provides the installer with an economical means of ensuring both proper tubing insertion into the fitting and adequate nut tightening.



Usage Instructions

1. Squarely cut tubing, preferably with a tube cutter, and then deburr both inside and outside diameters as necessary.
2. Firmly insert tubing into the tool as far as possible.
3. Mark the tubing, as shown, with a pencil or FINE POINT marker utilizing low chloride ink.
4. Firmly insert the marked tubing into the Gyrolok® fitting to which it will be assembled. Finger-tighten the nut. The mark should NOT be visible at this point. If not visible, continue to step 5. If any part of the mark is visible above the Gyrolok® nut after only finger-tightening, the tubing is either not properly seated within the fitting or a ferrule is missing. Disassemble and determine cause.
5. If the mark is not visible after finger-tightening, continue by following appropriate Gyrolok® assembly instructions for tubing O.D. and wall thickness.

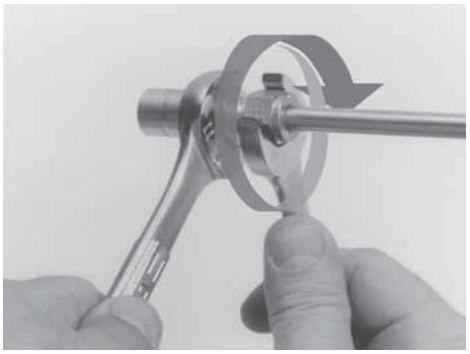
Part Numbers

SIZE	PART NUMBER
⅛″	2GMT
¼″	4GMT
⅜″	6GMT
½″	8GMT
⅝″	10GMT
¾″	12GMT
1″	16GMT

Pre-setting Tool: PST

Used strictly for pre-assembling ferrules to tubing.





Fractional

Part Number*	Tube O.D.	Dimensions — inches Length	Across Flats
1PST	1/16	2.25	3/8
2PST	1/8	1.94	11/16
3PST	3/16	2	1/2
4PST	1/4	1.94	11/16
6PST	3/8	1.97	11/16
8PST	1/2	2	7/8
12PST	3/4	2.50	1 1/8
16PST	1	2.50	1 1/2

Metric

Part Number*	Tube O.D.	Dimensions — mm Length	Across Flats
3PSTMM	3	49.2	17.3
6PSTMM	6	49.0	17.3
8PSTMM	8	50.0	17.3
10PSTMM	10	50.8	17.3
12PSTMM	12	50.8	22.0
14PSTMM	14	50.8	22.0
16PSTMM	16	63.5	28.4
18PSTMM	18	63.5	28.4
20PSTMM	20	63.5	28.4
22PSTMM	22	63.5	37.9
25PSTMM	25	63.5	37.9

Usage Instructions

1. Place PST in vise.
2. Loosely assemble nut and ferrules to PSI. Use HOKE Gyrolok Safety Changer Nut & Ferrule Sets.
3. Follow standard HOKE Gyrolok assembly instructions to set ferrules onto tubing, see page 53.
4. Loosen nut and remove tubing with pre-set ferrules and nut.
5. With pre-set ferrules and nut in permanent location, reassemble tubing by following HOKE Gyrolok reassembly instructions on page 53.

Note: Threads of pre-setting tools should be lubricated the very first time and relubricated every tenth time thereafter.

* [ ] see page 6 for material specifications.