Visual Index

The Seal-Lok Braze Sleeve. A second method of sleeve attachment is with the braze sleeve. The sleeve is brazed to the tube end as shown in Fig. A3. The flat, smooth surface of the braze sleeve seals against the O-ring when fully assembled. The holding power is provided by the braze.

The Seal-Lok Trap-Seal™. The Trap-Seal, with its consistently positive retention in the groove, essentially eliminates the possibility of full or partial O-ring pop out. The seal's trapezoidal shaped cross-section leads to improved retention within Seal-Lok's CORG groove and virtually eliminates costly leakage and time consuming pre-assembly handling. The groove design has not changed, so the standard O-ring can be used for seal replacement in the field. Currently, the Trap-Seal is offered in 90-durometer Nitrile (NBR).

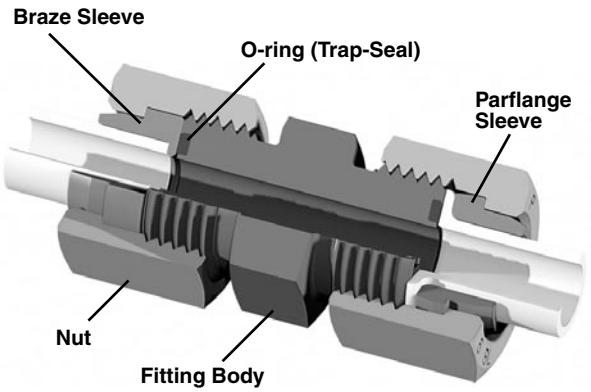

Fig. A3 — Seal-Lok Union cutaway with flanged and brazed assemblies

How Seal-Lok Fittings Work

The Seal-Lok fitting body face contains a high durometer O-ring that is held captive in a precision machined groove. As the nut is tightened onto the fitting body, the O-ring is compressed between the body and flat face of the tube flange or braze sleeve to form a tight, positive seal (see Fig. A3).

As the two faces come in contact, further tightening of the nut produces a sharp rise in assembly torque. A solid pull of the wrench at this point, to recommended assembly torque, completes the assembly. The sharp torque rise gives a "solid feel" at assembly, minimizing the possibility of over tightening.

Because the sealing surfaces are flat and perpendicular to the assembly pull, they remain virtually free of distortion during assembly, giving Seal-Lok fittings practically unlimited remakeability. The O-ring should be inspected at each disassembly and replaced when necessary. **See the O-Rings and Seals section for information on replacement ORFS O-rings.**

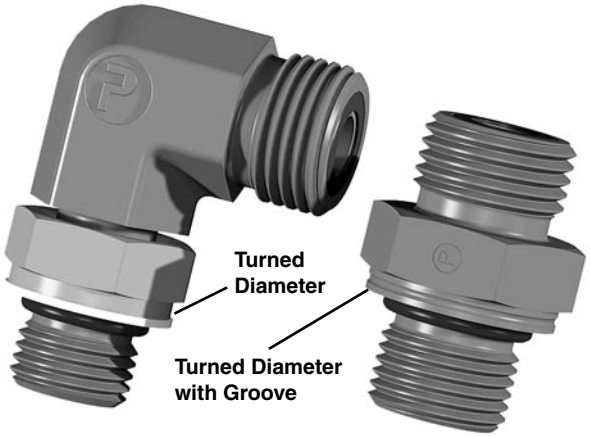

Fig. A4 — Metric Seal-Lok Straight and Shaped Connectors with Identification for use with ISO 6149-1 Port

Assembly and Installation

Please refer to Section T for the assembly and installation instructions for Seal-Lok fittings.

Metric Seal-Lok

The tube/hose end connection for metric Seal-Lok is the same as standard (inch) Seal-Lok. It consists of a body, a flange or braze sleeve, an O-ring and a nut. The difference is at the port end of the fitting. Instead of the SAE straight thread connection, it features a similar connection with metric threads per ISO 6149-2. Additionally, the fitting body, tube nut and locknut are manufactured with metric hexes or forging wrench flats. The metric Seal-Lok fittings meet or exceed all requirements of ISO 8434-3.

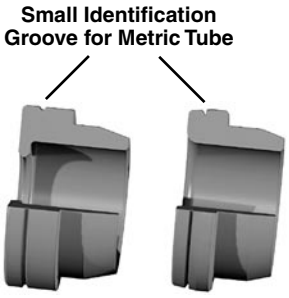

Fig. A5 — Metric (Tube) Seal-Lok Sleeves