

**0-1/2" (12mm)  
MANUAL ASSEMBLY**

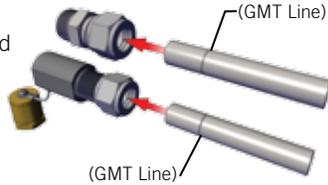
**1/2" – 1" (12mm-25mm)  
MANUAL OR HPST ASSEMBLY**  
*based on installation conditions*

**Above 1" (25mm)  
HPST ASSEMBLY REQUIRED**  
*Consult factory as needed*

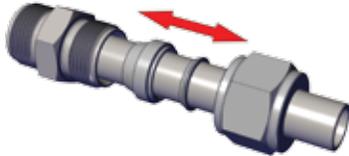
## Manual Assembly Instructions

Use of a PST (Manual Pre Setting Tool) is **recommended**. GYROLOK® Marking Tool (GMT) is **strongly recommended**.

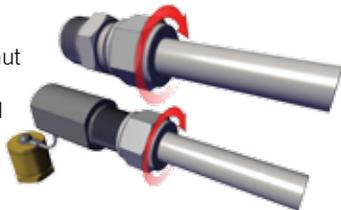
Fully insert a correctly cut, deburred tube into the PST or fitting body until the tube rests on the sizing angle.



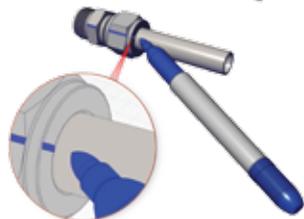
Holding the tube in the PST or Body, extract the nut and ferrules to visually ensure both ferrules are correctly oriented.



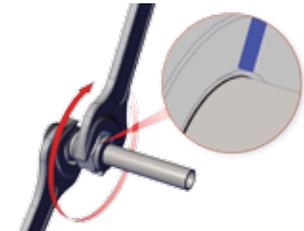
Once correct ferrule orientation is confirmed, thread & rotate the nut onto the PST or Body until hand-tight. The GMT witness line should **NOT** be visible.



Establish a reference point for wrench tightening by marking both the fitting body and nut.



While supporting the PST or fitting body, tighten the nut with a wrench 1 1/4 turns. The pre-set or make-up is now complete. Confirm that the GMT witness line is now visible.



## GYROLOK® MARKING TOOL (GMT) INSTRUCTIONS

Insert the correctly cut and deburred tube into the GMT as far as possible.



Mark the tubing as shown with an Ultra-Fine Point, Chloride-Free pen (recommended Sharpie Model 37001). Take care to position the marker perpendicular to the GMT, or insufficient ferrule set could occur.

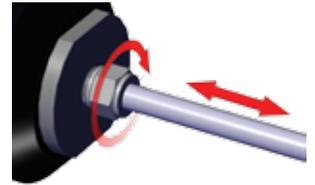


## HPST Assembly Instructions

GYROLOK® Marking Tool (GMT) is **strongly recommended**.

**Ensure the HPST Tooling Set is installed with the proper indicator nut.**

Fully insert a correctly cut, deburred tube into the HPST head. Visually ensure both ferrules are correctly oriented. Thread & rotate the nut until hand-tight.



Set the indicator arm in the operating position by rotating the Indicator Nut counter-clockwise until it stops.

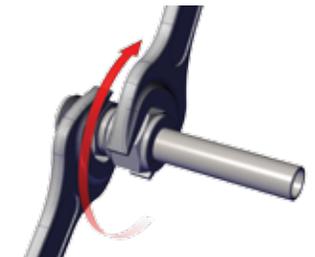


Pump the handle until the indicator arm releases.

**CAUTION:** Stop pumping immediately after the arm releases, as over-pumping may cause the tube to swell and stick. Pre-setting is now complete.

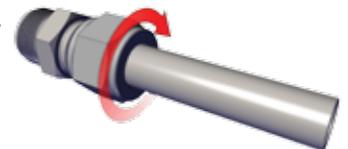


Insert the end with pre-set ferrules and nut into the fitting. Thread and rotate the nut until hand-tight. While supporting the fitting body, tighten the nut with a wrench 1/2 turn for tubing up to 1" (25mm). For tubing greater than 1" (25mm) 3/4 turn is required. The initial fitting make-up is now complete.



## REMAKE INSTRUCTIONS

Firmly insert end with the correctly set ferrules & nut into the fitting. Thread & rotate the nut until hand-tight. The GMT witness line should **NOT** be visible.

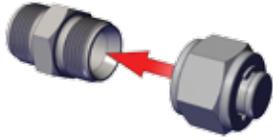


While supporting the fitting body, tighten the nut with a wrench 1/4 turn.



## PLUGS & PORT CONNECTORS

Remove and discard ferrules. Firmly insert the plug or port connector into the end connection and hand-tighten the nut.

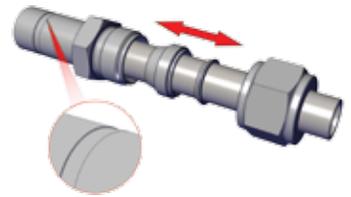


While supporting the fitting body, tighten the nut with a wrench ¼ turn.



## TUBE ADAPTERS & REDUCERS

For this type of fitting please follow the Manual Assembly Instructions.



**We Care About Your Safety**

### WARNING

***Improper selection or use of products described herein can cause Personal injury or property damage***

**Product information described herein is offered for use by the system designer and user.**

It is solely the responsibility of the system designer and user to select products suitable for their specific application requirements and to ensure proper installation, operation and maintenance of these products. Material compatibility, product ratings, and application details should be considered in the selection.

Always contact your local HOKE® Distributor with any questions you may have before pressurizing and operating the product.

## Safety Instructions

1. Do not tighten or loosen any part of a fitting or valve when the system is pressurized. Make sure the system is un-pressurized when tightening or loosening a fitting or valve connection.
2. Do not loosen GYROLOK® nut or any product component in order to relieve or bleed down system pressure.
3. Do not exceed pressure-temperature specifications stated in the appropriate catalog.
4. When the application involves use of a toxic or hazardous fluid, exercise extra caution during operation and maintenance.
5. Before assembling new, unused GYROLOK® tube fitting ends, loosen the GYROLOK® nut before inserting the tube to allow full insertion of the tube to the base of the body bore.
6. Always use tubing that is compatible with the fitting or valve material. Tubing appropriate for use with HOKE® products is described in Tubing Data Charts. For example, use 316 Stainless Steel fittings with 316 Stainless Steel tubing.
7. Always leave a length of straight tube between the tube bend and the fitting. A tube bent too close to the fitting connection may be a source of leakage.
8. During assembly of the GYROLOK® tube end, always hold the fitting or valve body with one wrench while separately wrench tightening the GYROLOK® nut. Follow the same precaution when disassembling.
9. Always use a HOKE® tube insert (basic part number "TI") when assembling a GYROLOK® fitting to soft, pilable plastic tubing.
10. Always use proper thread lubricants or sealants on tapered pipe threads. Note that thread sealants may have lower temperature ratings than the basic fitting.
11. When installing an NPT ended valve, hold the valve body near the connection with one wrench, while separately wrench tightening the mating pipe. Turn the pipe, not the valve. Follow the same precaution when disconnecting.
12. Do not hold the valve handle when tightening an end connection.
13. Do not use excessive force to open or close a ball valve e.g. do not use a handle extension.
14. On initial installation, valves may require an adjustment of the packing nut due to storage variations, systems parameters, and cold flow properties of TFE.

## SAFETY WARNING:

GYROLOK® products are designed for installation only by professional suitably qualified licensed system installers experienced in the applications and environments for which the products are intended. These products are intended for integration into a system. Where these products are to be used with flammable or hazardous media, precautions must be taken by the system designer and installer to ensure the safety of persons and property. Flammable or hazardous media pose risks associated with fire or explosion, as well as burning, poisoning or other injury or death to persons and/or destruction of property. The system designer and installer must provide for the capture and control of such substances from any vents in the product(s). The system installer must not permit any leakage or uncontrolled escape of hazardous or flammable substances. The system operator must be trained to follow appropriate precautions and must inspect and maintain the system and its components including the product(s) and at regular intervals in accordance with timescales recommended by the supplier to prevent unacceptable wear or failure.