



THE WORLD LEADER IN AEROSPACE GASKETS SINCE 1969

INSTALLATION PROCEDURES

SECO7 seals are intended for use with 37 degree flared tube fitting ends per AS4395, MS33656, MS33657, MS24385 or MS24386, and JIC Fittings. Conforms to AS3282 & AS4824.

STEP 1: Ensure that your tubing is correctly cut, filed, de-burred, and flared.

STEP 2: Select correct size and type of SECO7 seal from the SECO7 drawing and material selection chart.

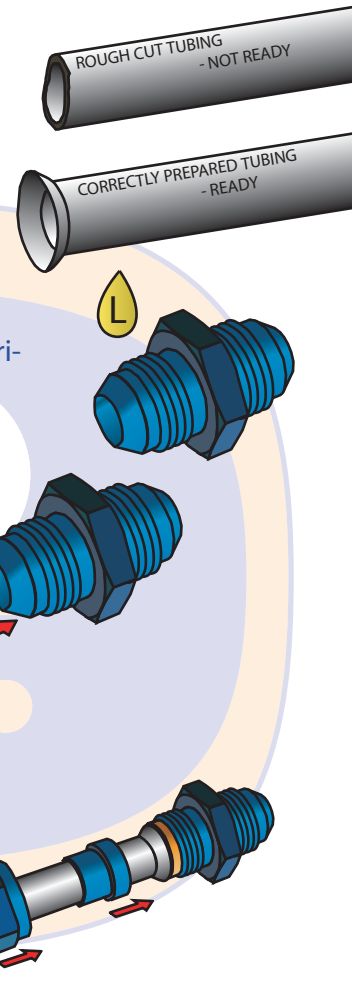
STEP 3: Coat threads at cone end of connector sparingly with lubricant as listed in the lubricant selection chart.

STEP 4: Install SECO7 seal onto male flare portion of fitting

STEP 5: Slide sleeve and tube nut over the flared end of the tube and thread onto the male fitting several turns with fingers until connection is snug. If tube nut cannot be tightened snugly with fingers, disassemble and correct problem to prevent assembly damage to the SECO7 seal.

STEP 6: Tighten tube nut to torque value specified in the torque selection chart. Allow 15 seconds elapsed time for compression of SECO7 seal to occur.

STEP 7: After 15 seconds, retighten tube nut to torque value specified in Table 2 in order to compensate for the compression yielding of the SECO7 seal.



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