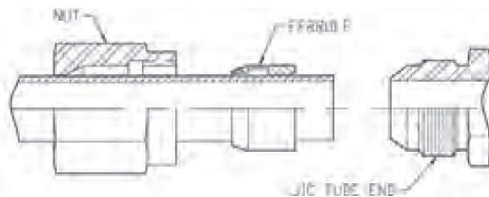


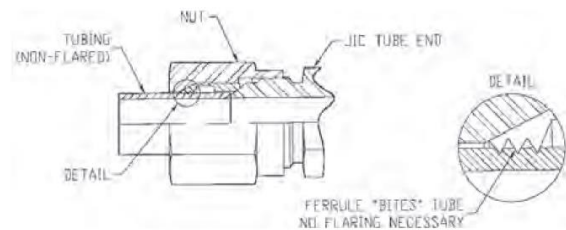


Nut & Ferrule (JCN / JCS) converts any 37° JIC into Flareless WITHOUT flaring the tube

Components



Assembled



Convert-A-Flare Nuts and Ferrules allow you to convert any male 37° JIC fitting into a flareless tube fitting. Assembly is simplified because no special tools are required. Not even a flaring tool is needed since there is no need to flare the tube. Errors are minimized because the ferrule cannot be assembled in the wrong direction. All the sizes assemble in the same manner and on different tube wall thickness', although the tubing used should not be harder than Rockwell B65. You will effectively be able to reduce your inventory, because you will be utilizing your standard 37° that you already have in stock. Save time and money by not ordering or stocking flareless fittings.

Convert-A-Flare Torque Values

Dash	-	Turns	Dash	-	Turns
-04	-	1 1/4	-12	-	1 1/2
-05	-	1 1/4	-16	-	1 1/2
-06	-	1 1/4	-20	-	1 1/2
-08	-	1 1/4	-24	-	1 1/2
-10	-	1 1/4	-32	-	1 1/2

The Turns Method assumes that the threads are lubricated with 10W hydraulic oil.

Assembly Steps With a Visual Check

- 1) Tubing must be cut square and deburred inside and out. No Flaring required.
- 2) Clean the tubing and threads and lubricate all mating surfaces with 10W hydraulic oil.
- 3) Hand tighten the nut/ferrule (approx. 30 lb-in.).
- 4) Make alignment marks on the nut and fitting.
- 5) Proceed to tighten to the Turns value for the JIC.
- 6) When fully tightened make a 2nd set of alignment marks at the fully tightened position.

This completes a Convert-A-Flare connection with visual marks for a quick reference.

