

# STEEL PIPE FITTINGS FEMALE SWIVEL (SPIPEFSW)

## Applications:

Water, Oil, Air.

Pipe threads must be sealed using approved thread sealant.

## NPSM Swivel Union Assembly Instructions

1. Inspect male pipe fitting connecting to swivel and confirm that it has an internal 30-degree chamfer. Do not install into union if chamfer is missing.
2. Lubricate the threads and the entire chamfered area of male fitting with hydraulic fluid or other light weight lubricant.
3. Install lubricated pipe fitting into swivel nut and turn nut until finger tight.
4. Place wrench on hex of male pipe fitting and consider this wrench in the 12 o'clock position.
5. Lightly wrench tighten the swivel union nut until there is firm resistance.
6. Place second wrench on swivel union nut so that the wrench is as near the 3 o'clock position as possible.
7. Rotate wrench in 3 o'clock position counter-clockwise to no less than the 1 o'clock position, but no more

**CAUTION:** When torquing swivel nut on straight swivel union fittings, it may be necessary to also place a third wrench on the fitting wrench pad to prevent the fitting from backing out of its port while torquing the swivel nut.

## Working Temperature:

-65°F (-54°C) to 250°F (120°C)

