

## Preparing and assembling stainless tube and Discharge tubes

- 1) When shortening WON SS tube only use a suitable rotary pipe cutter and not a hacksaw or grinder.



- 2) Use a number 2 starter drill bit (preferably by hand), to remove the internal burrs from the tube end – aim to make the chamfer depth equal on all tube ends.



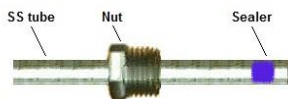
- 3) Use some abrasive paper to remove any external burrs.

## Fitting the retaining nuts & olives (ferrules) to stainless tube & Discharge tubes

- 1) Slide the retaining nut approx. an inch up the tube



- 2) Apply a very small amount of sealing/locking fluid round the tube approx. ¼" from the end.



- 3) Slide the olive (ferrule) on to the tube while rotating it, to smear the sealing fluid evenly over both surfaces.



- 4) When fittings are used inside a manifold (as with Killer Scorpion Discharge tubes), apply a very small amount of locking fluid to the retaining nut thread, before screwing in to place.



- 5) Avoid applying excess sealer, as it could run in to the fitting causing a blockage.