

General Description: The Ferulok fitting design and performance capabilities exceed the strict requirements of (SAE J514) and Military Standards (MILF18866). The Ferulok fitting is a flareless fitting that consists of a body, a one-piece precision machined ferrule, and a nut. On assembly, the ferrule “bites” into the outer surface of the tube with sufficient strength to hold the tube against pressure, without significant distortion of the inside tube diameter.

The ferrule also forms a pressure seal against the fitting body. Ferulok fittings have a visible bite, allowing the fitting assembler to visually inspect the bite quality, thus significantly minimizing the risk of improper assembly and related service problems. Ferulok fittings are suitable for use with tube wall thickness ranging from medium to extra heavy.

The Ferulok Body – Ferulok fitting bodies are available in over thirty configurations. The shaped products (i.e. elbows, tees, crosses) are hot forged, then machined to the stringent Ferulok fitting specifications. Straight products are made from cold drawn bar stock.

The Ferulok Ferrules – Ferulok fitting ferrules are precision machined, then heat-treated.

The Ferulok Nuts – Ferulok fitting nuts are either cold formed to size and shape, or machined from cold drawn material.

Features:

- Visible bite
- Distributed stresses
- Ferrule with rear bevel
- Tube wall range
- Remakeability
- Metal-to-metal seal
- No flaring or flanging required
- Protected sealing surface

Specifications

Ferulok Fittings	Steel		Stainless Steel	
	ASTM	Type	ASTM	Type
Cold Formed Bodies	A576	C1010/C1008	—	—
Forged Bodies	A576	1214/1215	A182	316
Bar Stock Bodies	A108	12L14	A479	316
Cold Formed Tube Nuts	A576	C1010	A479	316L
Bar Stock Tube Nuts	A108	12L14	A479	316
Tube Ferrules	A108	12L14	A564	630

Note: On request, Ferulok can be furnished in materials other than those shown above.
Finish: Zinc with yellow chromate (being changed to Zinc Chromium 6 Free) is used on all standard steel products.

Recommended Tube Wall Thickness

Size		Steel/Stainless Steel	
O.D. Inches	Dash Number	Minimum Wall Thickness	Maximum Wall Thickness
1/8	-2	0.010	0.035
3/16	-3	0.020	0.049
1/4	-4	0.028	0.065
5/16	-5	0.028	0.065
3/8	-6	0.035	0.095
1/2	-8	0.049	0.120
5/8	-10	0.058	0.120
3/4	-12	0.065	0.120
7/8	-14	0.072	0.120
1	-16	0.083	0.148
1 1/4	-20	0.095	0.188
1 1/2	-24	0.095	0.220
2	-32	0.095	0.220