

PERFORMANCE TEST REPORT	INTERCHANGEABILITY TEST REPORT	TEST REPORT No: SXLWLINT-01/15 DATE : 09-01-2015
TEST REF : ASTM F1387-99 (2005)	MATERIAL : SS 316	PAGE : 1 of 3
PRODUCT : SEALEXCEL [®] and Swagelok [®] Twin Ferrule Tube Fittings		

PURPOSE : To evaluate the compatibility for component combination of SEALEXCEL[®] and Swagelok[®] Twin Ferrule Tube Fittings tested under Hydrostatic Proof Pressure Test.

TUBE FITTINGS ASSEMBLY

- Each Test Assembly comprising a Male Connector at one end, Union in the Center and a Cap at other end to complete the assembly with tube.

TYPES & SIZE OF TUBE FITTINGS USED IN THE INTERCHANGEABILITY TEST

1) SEALEXCEL[®] Twin Ferrule Tube Fittings

Description	SIZE	QTY.
Male Connector	1/4" ODT x 1/4" NPT	1 No.
	3/8" ODT x 3/8" NPT	1 No.
	1/2" ODT x 1/2" NPT	1 No.
Cap	1/4" ODT	2 Nos.
	3/8" ODT	2 Nos.
	1/2" ODT	2 Nos.
Nut and Ferrule set	1/4" ODT	1 Set.
	3/8" ODT	1 Set.
	1/2" ODT	1 Set.

2) SWAGelok[®] Twin Ferrule Tube Fittings

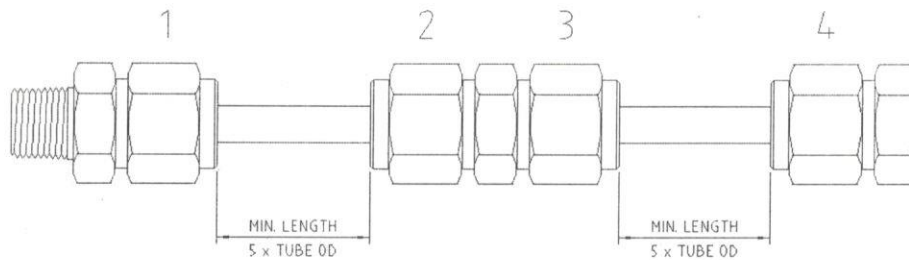
Description	SIZE	QTY.
Male Connector	1/4" ODT x 1/4" NPT	1 No.
	3/8" ODT x 3/8" NPT	1 No.
	1/2" ODT x 1/2" NPT	1 No.
Union	1/4" ODT	2 Nos.
	3/8" ODT	2 Nos.
	1/2" ODT	2 Nos.

- Disassembled and intermixed the components of Sealexcel[®] and Swagelok[®] Twin Ferrule Tube Fittings, arrange and assembled the fittings as shown in below mentioned assembly drawing.
- Assembled the fittings by 1 1/4" turn from the finger tight position according to SEALEXCEL Twin Ferrule Tube Fittings installation instructions.




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CONSTRUCTION OF TEST ASSEMBLY



FOR TEST ASSEMBLY SIZE : 1/4" ODT

TUBE SIZE : 1/4" ODT x 0.035" WT., TUBE HARDNESS: 75 to 78 HRD
MATERIAL : SS316, TOTAL ASSEMBLY : 2 Nos.

TEST ASSEMBLY NO.	DESCRIPTION	1	2	3	4
Comp-250/WL01	NUT	Sealexcel	Sealexcel	Swagelok	Swagelok
	FERRULES	Sealexcel	Swagelok	Sealexcel	Swagelok
	BODY	Sealexcel	Swagelok	Swagelok	Sealexcel
Comp-250/WL02	NUT	Swagelok	Sealexcel	Sealexcel	Swagelok
	FERRULES	Swagelok	Sealexcel	Swagelok	Sealexcel
	BODY	Swagelok	Swagelok	Swagelok	Sealexcel

FOR TEST ASSEMBLY SIZE : 3/8" ODT

TUBE SIZE : 3/8" ODT x 0.049" WT., TUBE HARDNESS: 75 to 78 HRD
MATERIAL : SS316, TOTAL ASSEMBLY : 2 Nos.

TEST ASSEMBLY NO.	DESCRIPTION	1	2	3	4
Comp-375/WL01	NUT	Sealexcel	Sealexcel	Swagelok	Swagelok
	FERRULES	Sealexcel	Swagelok	Sealexcel	Swagelok
	BODY	Sealexcel	Swagelok	Swagelok	Sealexcel
Comp-375/WL02	NUT	Swagelok	Sealexcel	Sealexcel	Swagelok
	FERRULES	Swagelok	Sealexcel	Swagelok	Sealexcel
	BODY	Swagelok	Swagelok	Swagelok	Sealexcel

FOR TEST ASSEMBLY SIZE : 1/2" ODT

TUBE SIZE : 1/2" ODT x 0.065" WT., TUBE HARDNESS: 74 to 77 HRD
MATERIAL : SS316, TOTAL ASSEMBLY : 2 Nos.

TEST ASSEMBLY NO.	DESCRIPTION	1	2	3	4
Comp-500/WL01	NUT	Sealexcel	Sealexcel	Swagelok	Swagelok
	FERRULES	Sealexcel	Swagelok	Sealexcel	Swagelok
	BODY	Sealexcel	Swagelok	Swagelok	Sealexcel
Comp-500/WL02	NUT	Swagelok	Sealexcel	Sealexcel	Swagelok
	FERRULES	Swagelok	Sealexcel	Swagelok	Sealexcel
	BODY	Swagelok	Swagelok	Swagelok	Sealexcel

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PROCEDURE OF HYDROSTATIC PROOF PRESSURE TEST

- Connect the test assemblies with hydrostatic proof pressure test chamber.
- Pressurized the test assemblies to 100 PSI. Keep it for 5 minutes monitor the leakage, if there is no leakage, increase the pressure gradually at an average rate not exceed 172 MPa/min. (25000 psig/min.) to 150% ± 5% of the rated pressure using the hydraulic test fluid.
- Keep it for 5 minutes. Monitor the leakage at all joints.

TEST RESULTS : The test result shown below for the tested above Twin Ferrule Tube Fittings according to above test procedures.

TEST ASSEMBLY SIZE	TEST ASSEMBLY NO.	RATED PRESSURE	TESTED PRESSURE	RESULTS
1/4" ODT	Comp-250/WL01	5100 PSI	7650 PSI	Pass
	Comp-250/WL02	5100 PSI	7650 PSI	Pass
3/8" ODT	Comp-375/WL01	4800 PSI	7200 PSI	Pass
	Comp-375/WL02	4800 PSI	7200 PSI	Pass
1/2" ODT	Comp-500/WL01	5100 PSI	7650 PSI	Pass
	Comp-500/WL02	5100 PSI	7650 PSI	Pass

*Passed = Leakage not detected during the test.

FINAL RESULTS : It is considered that the SEALEXCEL[®] Twin Ferrule Tube Fittings were totally compatible with Swagelok[®] Twin Ferrule Fittings used in the Hydrostatic proof pressure test.



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