

STC® Press-Fit Adapter Installation Instructions

Assembly Steps

The following sequence of steps should be followed when assembling the press-fit adapter into the port. **Improper assembly of these adapters may result in leakage or the adapter coming out of the port once pressurized. Serious personal injury or death may result in the event the adapter comes out of the port after pressurization.**

1. Lubricate O-ring

Thoroughly apply DC200 or equivalent silicon-based lubricant to the o-ring so that it is visibly wet to touch.



2. Hand Install Adapter

Insert the press-fit adapter into the port until the first rib of the adapter makes contact with the port ID. Solid resistance will be felt. Note that a shaped adapter (45° or 90° configuration) should now be rotated to its proper orientation toward the direction of the hose connection for ease of assembly.



3. Press Operation

The press-fit adapter should finally be inserted completely into the port by some means of a press. The pressing action should supply a force along the centerline of the press-fit adapter end and mating port. **Shaped adapters will require holding tools designed for pressing the adapter into the port without damage to the adapter.** Note that rotation of shaped adapters is not permitted after the press operation.



4. Inspection

The shoulder of the press-fit adapter should be flush with the face of the port. **Adapters should not be removed after assembly and reused.**