Capillary Flow Technology Device Ferrule Preswaging Tool User Instructions

G3440-80227: column preswaging tool for capillary CFT
G3440-80247: column preswaging tool for metal CFT

Preswaging instructions

1. Thread the column through the internal nut (G2855-20530), then through the Flexible Metal ferrule.

2. Score, then break the end of the column. Inspect for a clean, even cut.

3. Insert the assembly into the preswaging tool.

4. Gently push the column until it bottoms on the rubber stopper in the fitting. Be careful not to force the column in the fitting.

5. Hold the column in the fitting so that it is bottomed against the rubber stopper, tighten the nut to the necessary angle as called out by Table 1 until the ferrule just grips the column.

6. Using a wrench, tighten the nut an extra 30° to 45° to complete the swaging process.

7. See document G3188-90001 (Flexible Metal Ferrule Swaging Guide) for additional information.

8. Loosen the nut and remove the assembly from the tool. If the ferrule is stuck in the tool, insert a small needle/wire through the hole in front of the tool to loosen the ferrule.

9. Inspect the length of column from the tip of the ferrule; it should be less than 0.5 mm.

Table 1. Degrees to tighten the internal nut for proper swaging.

UM+ FMF Part Number	Gold-Plated FMF Part Number	Degrees to Tighten Internal Nut
G3188-27501	G2855-28501	50 – 100 degrees
G3188-27502	G2855-28502	30 – 70 degrees
G3188-27503	G2855-28503	20 – 50 degrees
G3188-27504	N/A	60 degrees
G3188-27505	G2855-28505	40 – 90 degrees
G3188-27506	G2855-28506	20 – 50 degrees

Tool maintenance

If the length of column becomes too long (>0.5 mm):

1. Remove the old rubber stopper.
2. Use compressed air to clean the holes and the new stopper.
3. Align the new rubber stopper in the hole on the top face of the preswaging tool.
4. Screw the stopper into the tool until it bottoms.

If the tool stops swaging the ferrule, replace the swaging tool.

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