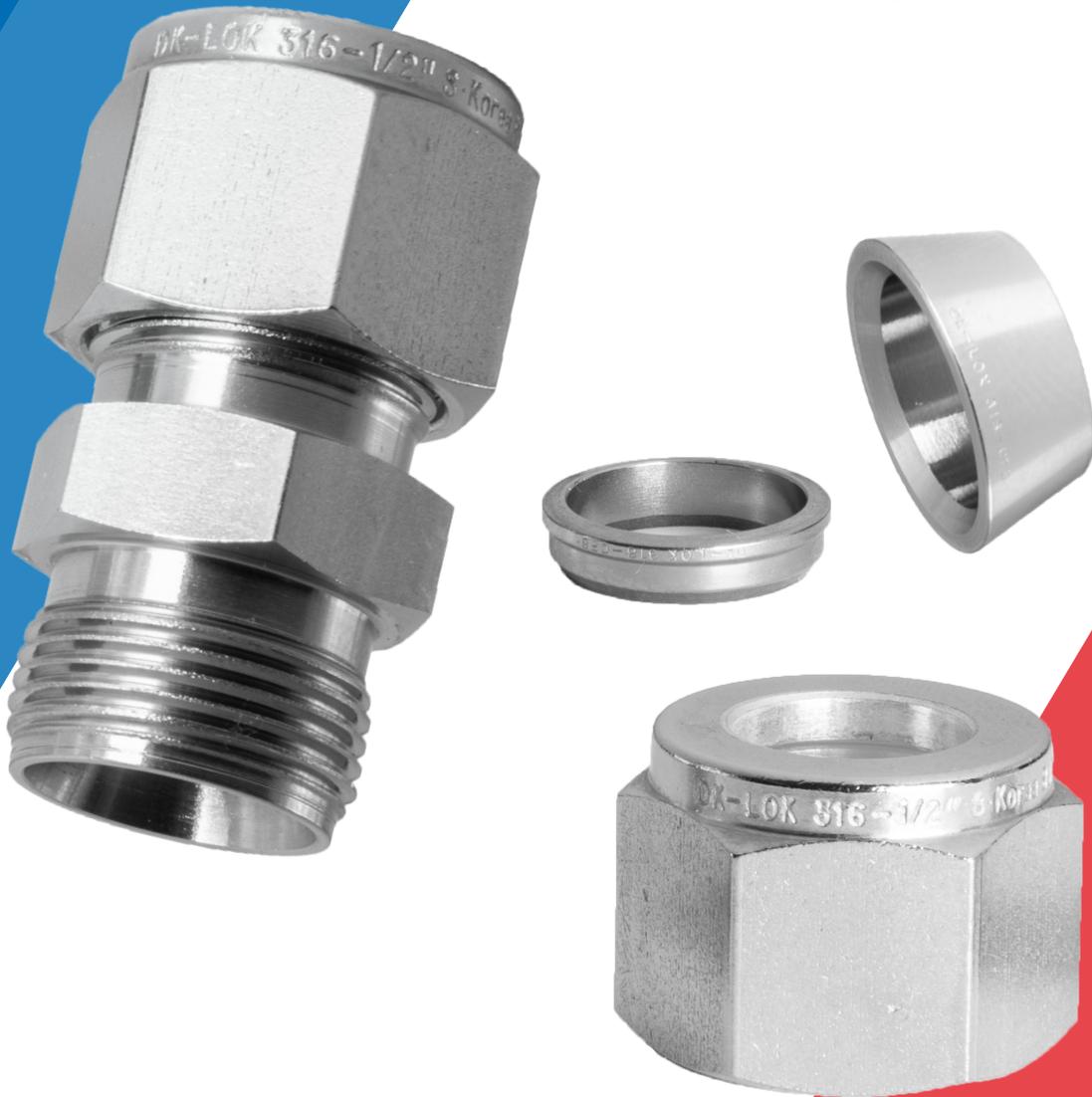




## ASTM F-1387 INTERMIX TESTING

The purpose of this test procedure is to establish that any intermixed combination of DK-LOK® and Swagelok® individual components will provide leak-free performance synonymous with pure assemblies when subjected to various conditions inherent to the environments for which compression tube fittings are commonly exposed in practical every day installations.



- Mobile, AL
- Houston, TX
- Salt Lake City, UT
- [www.dklokusa.com](http://www.dklokusa.com)
- (800) 328-5803



## About the Company

DK-LOK® strives to ensure customer satisfaction by providing products of the highest quality. We expanded the customer base with the world's leading companies in CNG & NGV, Offshore & Onshore, Shipbuilding & Marine Engine, Chemical, Petrochemical & Refinery, Semiconductor, Railway Vehicles, and Power Plant industries in 47 countries across the globe.

Here at DK-LOK®, we continue to bolster our growth through aggressive investment in production, continual employee training, and research for the development of new technologies that pioneer the future of our industry. For superior product and process quality, we acquired the certifications of ASME N, NPT, and NS stamps. Moreover, we have received product certifications from global certification agencies such as: LR, GL, ABS, DNV, RWTUV, NK, and KR. As a result, we are able to ensure high quality products and services that meet the specific needs of our global customers.

## Certifications for DK-LOK



## Testing Specifications

### Tube Outside Diameter by Wall Thickness Combinations

Tube Size (inch)	Tube Rate Pressure (psig / bar)	Tube Hardness (HRB)
1/4 x 0.049	7,500 / 517	75 ~ 78
3/8 x 0.049	4,800 / 331	75 ~ 78
1/2 x 0.065	4,700 / 324	70 ~ 77
3/4 x 0.095	4,900 / 338	75 ~ 80
1 x 0.109	4,200 / 290	75 ~ 79

### Intermix Matrix for Swagelok® & DK-LOK®

	#1	#2	#3	#4	#5	#6	#7
<b>DK Nut - DKN</b>	SN	DKN	DKN	DKN	SN	DKN	DKN
<b>DK Back Ferrule - DKBF</b>	DKBF	SBF	DKBF	DKBF	SBF	SBF	DKBF
<b>DK Front Ferrule - DKFF</b>	DKFF	DKFF	SFF	DKFF	DKFF	SFF	SFF
<b>DK-Body - DKB</b>	DKB	DKB	DKB	SB	DKB	DKB	SB
	1A - 1E	2A - 2E	3A - 3E	4A - 4E	5A - 5E	6A - 6E	7A - 7E
	#8	#9	#10	#11	#12	#13	#14
<b>Swagelok Nut - SN</b>	SN	DKN	SN	SN	DKN	SN	SN
<b>Swagelok Back Ferrule - SBF</b>	DKBF	SBF	DKBF	SBF	SBF	SBF	DKBF
<b>Swagelok Front Ferrule - SFF</b>	SFF	DKFF	DKFF	SFF	SFF	DKFF	SFF
<b>Swagelok-Body - SB</b>	DKB	SB	SB	DKB	SB	SB	SB

### Tests Based on ASTM F1387 – Mandatory Tests

ASTM 1387 Section No.	Procedure	Comments
A2	Examination of Specimen	Done
A3	Pneumatic Proof Test	Done
A4	Hydrostatic Proof Test	Done
A5	Impulse Test	Done
A6	Flexure Fatigue Test	Done
A7	Tensile Test	Done
A8	Hydrostatic Burst Test	Done
A9	Repeated Assembly Test	Done
A10	Rotary Flex Test	Done
A11	Mercurous Nitrate Test	-

### Tests Based on ASTM F1387 – Supplemental Tests

ASTM 1387 Section No.	Procedure	Comments
S2	Thermal Cycling Test	Done
S3	Elevated Temperature Soak Test	-
S4	Stress-Corrosion Test	-
S5	Torsion Test	-
S6	Shock Test	-
S7	Fire Test	-
S8	Vibration Test	Done

ASTM (American Society of Testing and Materials) F1387 establishes the performance characteristics required for mechanically attached fittings (MAF) for use in piping and tubing systems.

All tests witnessed by TUV Rheinland. No failure observed.

## Pneumatic Proof Test Results

All test data was measured and recorded with calibrated gauges in accordance with ASTM F-1387 requirements.

1. Each spool containing specimens was submerged under water.
2. Each spool was pressurized to 100 psi using **Nitrogen(N2)** for 5 minutes.
3. The first minute allowed for the dissipation of surface bubbles.
4. After 5 minutes observing no leakage, the pressure was gradually increased to **125% of the rated working pressure of the tube**, and held for 5 minutes.
5. No leakage was observed.
6. After completing the first Pneumatic Proof, each specimen was disassembled and reassembled two times.
7. Steps 1 through 6 were repeated a second and third time with no leakage.
8. The Pneumatic Proof test was conducted three times. ASTM F-1387 only requires one run. Additionally, the test was conducted at **125% of the rated working pressure of the tube**. ASTM F-1387 only requires 125% of the rated working pressure of the tube or 500 PSI – **WHICHEVER IS LOWER**.

### Pressure Ratings

- 1/4" T x .049" Test Pressure – 7,500 PSI x 125% = 9,375 PSI
- 3/8" T x .049" Test Pressure – 4,800 PSI x 125% = 6,000 PSI
- 1/2" T x .065" Test Pressure – 4,700 PSI x 125% = 5,875 PSI
- 3/4" T x .095" Test Pressure – 4,900 PSI x 125% = 6,125 PSI
- 1" T x .109" Test Pressure – 4,200 PSI x 125% = 5,250 PSI



## Hydrostatic Proof Test Results

All test data was measured and recorded with calibrated gauges in accordance with ASTM F-1387 requirements.

1. Each spool containing specimens was mounted in the test chamber with one end free to move.
2. Each spool was filled with water.
3. Each spool was pressurized to 100 PSI for 5 minutes.
4. After observing no leakage, the pressure was gradually increased to **150% of the rated working pressure of the tube**, and held for an additional 5 minutes.
5. After observing no leakage, the spool was depressurized and drained.
6. Each specimen was disassembled and reassembled two times.
7. Steps 1 through 6 were then repeated with no leakage.
8. Steps 1 through 4 were then repeated. The Hydrostatic Proof test was conducted three times. After the third run, no make and break was conducted as the spools were then subjected to the Hydrostatic Burst Test.

### Pressure Ratings

- 1/4" T x .049" Hydro Pressure – 7,500 PSI x 150% = 11,250 PSI
- 3/8" T x .049" Hydro Pressure – 4,800 PSI x 150% = 7,200 PSI
- 1/2" T x .065" Hydro Pressure – 4,700 PSI x 150% = 7,050 PSI
- 3/4" T x .095" Hydro Pressure – 4,900 PSI x 150% = 7,350 PSI
- 1" T x .109" Hydro Pressure – 4,200 PSI x 150% = 6,300 PSI



## Hydrostatic Burst Test Results

All test data was measured and recorded with calibrated gauges in accordance with ASTM F-1387 requirements.

1. The spools, having completed the third Hydrostatic Proof, were immediately subjected to the Hydrostatic Burst.
2. The spool pressure was gradually increased from 150% of the rated working pressure of the tube to 4 times the rated working pressure of the tube and held for 1 minute.
3. After observing no leakage for 1 minute at 4 times the rated working pressure of the tube, the test pressure was gradually increased until the spool ruptured.
4. All ruptures took place in the tube sections.
5. All specimens held as promoted and expected to the rupture of the tube.

### Pressure Ratings

1/4" T x .049" Hydro Pressure	– 7,500 PSI x 4 = 30,000 PSI
3/8" T x .049" Hydro Pressure	– 4,800 PSI x 4 = 19,200 PSI
1/2" T x .065" Hydro Pressure	– 4,700 PSI x 4 = 18,800 PSI
3/4" T x .095" Hydro Pressure	– 4,900 PSI x 4 = 19,600 PSI
1" T x .109" Hydro Pressure	– 4,200 PSI x 4 = 16,800 PSI

## Tensile Pull Test Results

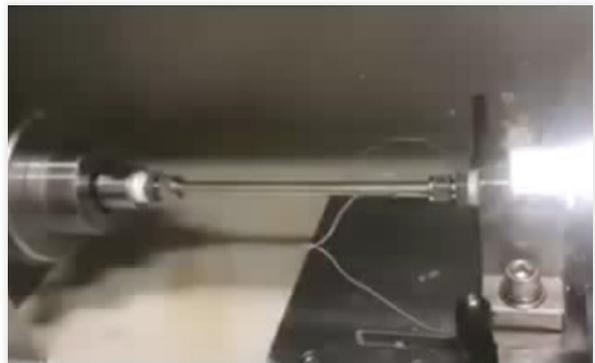
1. The significance of this test is to apply a tensile load at a controlled separation speed to establish how much load is needed to separate the test specimen.
2. The amount of tensile load applied depends upon the cross-section area and the yield strength of the tube.
3. Calculated tensile load =  $(K_t) \times (A_p) \times (S_y)$ 
  - a. Where  $K_t$  = tensile constant of 1.0;
  - b. Where  $A_p$  = actual cross-section area of the tube, mm<sup>2</sup> (in.<sup>2</sup>) based on wall thickness;
  - c. Where  $S_y$  = minimum specified yield strength of the tube.
4. The specimens pass this test when the calculated tensile load is achieved without separation of the joint. Movement within the area of the joint is acceptable as long as actual separation does not occur. This test is useful in determining the strength of the tube or MAF joint. Based upon the strength of the joint, the tube material and wall thickness can be tailored to withstand failure within the adverse environments present in fluid systems for which MAF is designed.



## Rotary Flex Test Results

All test data was measured and recorded with calibrated gauges and properly located strain gauges in accordance with ASTM F-1387 requirements.

1. The test spool containing specimens filled with water.
2. A bending moment equivalent to a minimum of 35% of the ultimate tensile strength (of the tubing material) was introduced and locked into place.
3. Each spool was pressurized to 500 PSI.
4. The specimen was flexed in a rotary motion at a minimum of 1750 rpm for 1,000,000 cycles while maintaining the bending moment and 500 PSI pressure rating.
5. After 1,000,000 cycles were completed with no leakage, the specimens were then subjected to a Hydrostatic Proof test. With no leakage after completion of the Hydrostatic Proof Test, the specimens passed the Rotary Flex Test.



## Flex Fatigue Test Results

All test data was measured and recorded with calibrated gauges and properly located strain gauges in accordance with ASTM F-1387 requirements.

1. Each spool containing specimens was filled with water.
2. Each spool was subjected to flexure while pressurized to the maximum rated working pressure of the tube.
3. The specimen was subjected to a bi-directional flexure in the same plane for 30,000 cycles to a distance range derived from the formula provided in ASTM F-1387 Section A6.3.5.
4. A complete cycle consisted of travel from neutral (zero strain) to the maximum positive strain position in one direction, to the maximum negative strain position in the opposite direction, and return to neutral.
5. At each 7,500 cycles, the spool was depressurized with the specimen being rested was disassembled and reassembled two times.
6. After 30,000 cycles were completed with no leakage, the specimens were then subjected to a Hydrostatic Proof test. With no leakage after completion of the Hydrostatic Proof Test, the specimens passed the Flexure Fatigue Test.

### Pressure Ratings

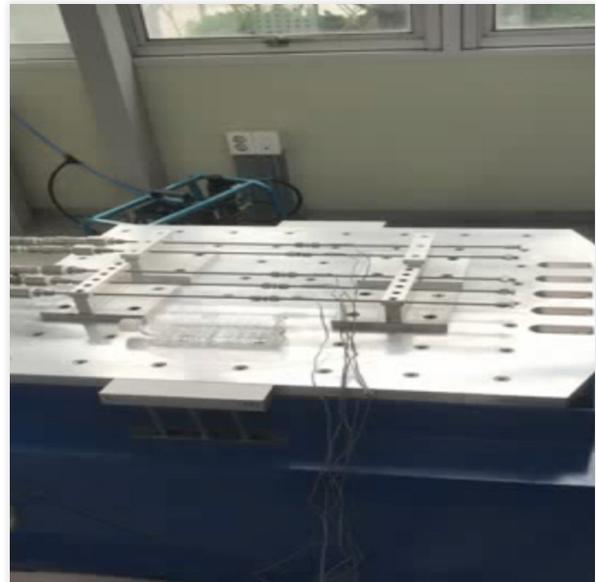
- 1/4" T x .049" Hydro Pressure – 7,500 PSI
- 3/8" T x .049" Hydro Pressure – 4,800 PSI
- 1/2" T x .065" Hydro Pressure – 4,700 PSI
- 3/4" T x .095" Hydro Pressure – 4,900 PSI
- 1" T x .109" Hydro Pressure – 4,200 PSI



## Vibration Test Results

All test data was measured and recorded with calibrated gauges and properly located strain gauges in accordance with ASTM F-1387 requirements.

1. The test spool containing specimens was filled with water.
2. The test fixture was equipped with supports, to be attached to the test specimen during testing. The supports were spaced in accordance with ASTM F-1387 requirements per OD size.
3. The test was conducted in each of the three principle directions (X, Y, and Z).
4. Each spool was pressurized to the maximum rated working pressure of the tube.
5. Perform the following tests: Exploratory Vibration test, Variable Frequency test, and Endurance test.
6. The specimens successfully passed the Vibration Test after meeting the test requirements and passing the subsequent Hydrostatic Proof Test.
7. No leakage was observed.



# Proven Results


  
**3<sup>rd</sup> party witnessing intermix test report for DK-Lok Corporation**

**Report No.:** 13300164  
**Name of test:** Intermix test of DK-Lok & Swagelok tube fittings

**Client:** DK-Lok Corporation  
 7, Godeok-ro16, 123beong-gil, Jachon-myeon, Gimhae-si, Gyeongsangnam-do, Korea  
**ZIP-CODE:** 69669

**Trade mark:**  Corporation

**Manufacturer:** As above  
**Test location:** As above  
**Test date:** April 09 ~ 18, 2016 / April 25 ~ December 18, 2017

**Products tested:** DK-Lok & Swagelok Tube Fittings  
 - Size : 1/4", 3/8", 1/2", 3/4", 1"

**Requirements:**

- ASTM F1387-99 Standard Specification for Performance of Piping and Tubing Mechanically Attached Fittings
  - A3 for Pneumatic Proof Test
  - A4 for Hydrostatic Proof Test
  - A5 for Fatigue Test
  - A6 for Repeated Assembly Test
  - A7 for Tensile Test
  - A8 for Repeated Burst Test
  - A9 for Repeated Assembly Test
  - A10 for Rotary Fatigue Test
  - A11 for Thermal Cycling Test
  - A12 for Vibration Test
- Test Condition
 

Material	#1	#2	#3	#4	#5	#6	#7
DK Nut-DIN	SS	DN	DN	DN	SS	DN	DN
DK Back Ferrule -DNF	DNF						
DK Front Ferrule -DNFF	DNFF						
DK Ring -SR	SR						
Swagelok Nut -SN	SS	SS	#12	#11	#12	#13	#14
Swagelok Back Ferrule -SBF	DNF						
Swagelok Front Ferrule -SFF	SFF						
Swagelok Ring -SR	SR						

#1 ~ #14 show all possible intermix combinations between DK-Lok and Swagelok fittings. Five different sizes (1/4", 3/8", 1/2", 3/4", 1") of the fourteen combinations (#1 ~ #14) make 70 intermix fittings to be tested.



**Report No.:** 13300164

**Documentation & Tests carried out:**

- Pneumatic Proof Test and Hydrostatic Proof Test and Hydrostatic Burst Test  
 Test report: DKTR-INT-17-001 Reference ASTM F1387 Annex A3, A4, A6
- Impulse Test  
 Test report: DKTR-INT-17-002 Reference ASTM F1387 Annex A5
- Repeated Assembly Test ( Insulated Ferrule Fatigue & Impulse Test )  
 Test report: DKTR-INT-17-003 Reference ASTM F1387 Annex A6
- Tensile Test  
 Test report: DKTR-INT-17-002 Reference ASTM F1387 Annex A7
- Flare Fatigue Test  
 Test report: DKTR-INT-17-004 Reference ASTM F1387 Annex A8
- Rotary Fatigue Test  
 Test report: DKTR-INT-17-003 Reference ASTM F1387 Annex A9
- Thermal Cycling Test  
 Test report: DKTR-INT-17-006 Reference ASTM F1387 Annex S2
- Vibration Test  
 Test report: DKTR-INT-17-001 Reference ASTM F1387 Annex S8

**Test results:**

Requirements	Results
No leakage from the above tests.	There was no observable leakage during the above tests.

**Final decision:** All the test specimens meet the above requirement of ASTM F1387-99.

Changwon, Korea / Dec. 18, 2017

TÜVRheinland Korea  
 Industrial Service/Pressure Equipment & Plant Testing

## Warranty Letter

**Subject: DK-Lok® Liability Statement with Intermixed Swagelok® components**

August 18, 2016  
 To Whom It May Concern

DK-Lok warrants that DK-Lok fittings are free from defects in materials and workmanship.

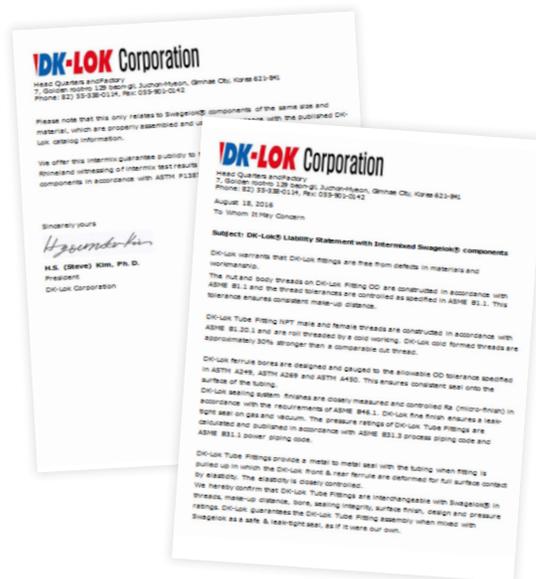
The nut and body threads on DK-Lok Fitting OD are constructed in accordance with ASME B1.1 and the thread tolerances are controlled as specified in ASME B1.1. This tolerance ensures consistent make-up distance.

DK-Lok Tube Fitting NPT male and female threads are constructed in accordance with ASME B1.20.1 and are roll threaded by a cold working. DK-Lok cold formed threads are approximately 30% stronger than a comparable cut thread.

DK-Lok ferrule bores are designed and gauged to the allowable OD tolerance specified in ASTM A249, ASTM A269 and ASTM A450. This ensures consistent seal onto the surface of the tubing.

DK-Lok sealing system finishes are closely measured and controlled Ra (micro-finish) in accordance with the requirements of ASME B46.1. DK-Lok fine finish ensures a leak-tight seal on gas and vacuum. The pressure ratings of DK-Lok Tube Fittings are calculated and published in accordance with ASME B31.3 process piping code and ASME B31.1 power piping code.

DK-Lok Tube Fittings provide a metal to metal seal with the tubing when fitting is pulled up in which the DK-Lok front & rear ferrule are deformed for full surface contact by elasticity. The elasticity is closely controlled. We hereby confirm that DK-Lok Tube Fittings are interchangeable with Swagelok® in threads, make-up distance, bore, sealing integrity, surface finish, design and pressure ratings. DK-Lok guarantees the DK-Lok Tube Fitting assembly when mixed with Swagelok as a safe & leak-tight seal, as if it were our own.



Please note that this only relates to Swagelok® components of the same size and material, which are properly assembled and used in accordance with the published DK-Lok catalog information.

We offer this intermix guarantee publicly to the marketplace based upon TÜV Rheinland witnessing of intermix test results between DK-Lok and Swagelok® components in accordance with ASTM F1387-99(2005)

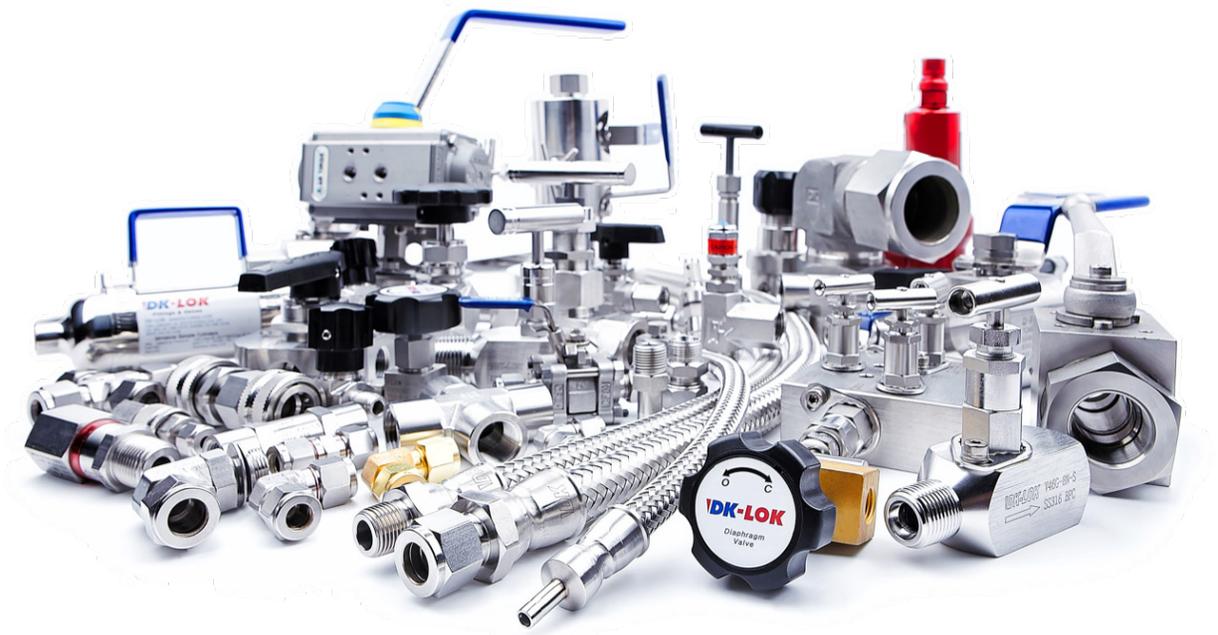
Sincerely yours

  
**H.S. (Steve) Kim, Ph. D.**  
 President  
 DK-Lok Corporation

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# DK-LOK®

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- Houston, TX
- Salt Lake City, UT
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