Title
SWAGING COPPER SQUARE TUBING ROUND

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DEFLECTING MAGNET

SWAGING COPPER SQUARE TUBING ROUND

Anneal square tubing ends 1.00/1.50 inches from the end by heating to 700° to 1000°F (red) for 1/2 to 1 minute. Air cool before swaging (NOTE: Do not use lubricant).

![Diagram of swaging process]

Fig. 1.

Insert tool (Fig. 1) into square tube and hit using a 24 oz. ball-pein head hammer. Repeat until 3/8 inch diameter has penetrated end by 1/8 to 1/4 inch. Remove swaging tool (heat tube, as required to loosen). Extract using vise-grip or equal. Tap as needed with same hammer.

REMOVE FLUTES WITH FILE SO THAT TUBE FITS INTO FITTING OR VALVE.
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