

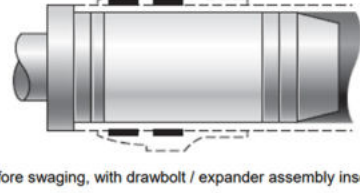
Catalog

Swaging ToolKits-

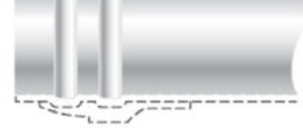
2025/26

BOM OF RLK PERMANENT AXIAL SWAGE TOOL KIT

The internal elastomeric swage fittings were developed to provide a simple, yet reliable method to attach separable end fittings to rigid tubes for the demanding aerospace environment. These fittings provide a lightweight and cost effective alternative to welding, brazing, or other mechanically attached methods.

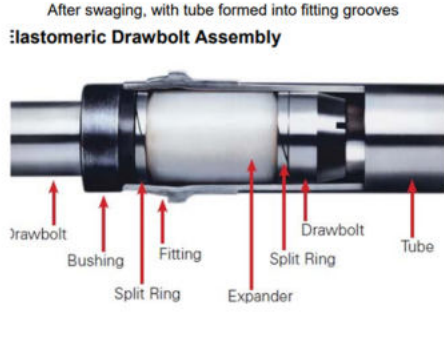


Before swaging, with drawbolt / expander assembly inserted



After swaging, with tube formed into fitting grooves

Elastomeric Drawbolt Assembly



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Main Specification

- Tube Material: Aluminum, Stainless steel

DimensionWeightSwage Capacity:

Model	Dimension	Weight	Swage Capacity(Tube OD)
5175	650X500X350mm	30KG	0.25/0.3125/0.375/0.5"
5720	800X620X450mm	60KG	0.625/0.75/1.125/1.5"

Electric Pump

Model	Dimension	Weight	Power input	Pressure output
PW1200E	800X620X450mm	36KG	AC110V/220V	0-70Mpa 0-10,000psi

Swage Fitting

Description	EATON/Harrison PIN	Boeing PIN	Airbus PIN
2 Groove Flareless Sleeve	35235	BAC513BX	NSA855034
2 Groove Flareless Union	35056	BACU24AB	-
2 Groove Flareless Union	35066	-	NSA855010

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TITLE	TUBE SIZE	QTY	PART NUMBER	DESCRIPTION	3000	3001	3004	3007	3008	3009	3028A	6SPSKT3000	6SPSKT3002	10PSKT3002	20PSKT3000	30PSKT3000	40PSKT3000	40PSKT3007
HEAD ASSEMBLY	-3	1EA	RTS18-01-03	SWAGE HEAD SIZE -3	-4	-4	-4	-4	-4	-4	-4	-4	-4	-4	-4	-4	-4	-4
	-4	1EA	RTS18-01-04	SWAGE HEAD SIZE -4	-4	-4	-4	-4	-4	-4	-4	-4	-4	-4	-4	-4	-4	-4
	-5	1EA	RTS18-01-05	SWAGE HEAD SIZE -5	-4	-4	-4	-4	-4	-4	-4	-4	-4	-4	-4	-4	-4	-4
	-6	1EA	RTS18-01-06	SWAGE HEAD SIZE -6	-4	-4	-4	-4	-4	-4	-4	-4	-4	-4	-4	-4	-4	-4
	-8	1EA	RTS18-01-08	SWAGE HEAD SIZE -8	-4	-4	-4	-4	-4	-4	-4	-4	-4	-4	-4	-4	-4	-4
	-10	1EA	RTS18-01-10	SWAGE HEAD SIZE -10	-4	-4	-4	-4	-4	-4	-4	-4	-4	-4	-4	-4	-4	-4
	-12	1EA	RTS18-01-12	SWAGE HEAD SIZE -12	-4	-4	-4	-4	-4	-4	-4	-4	-4	-4	-4	-4	-4	-4
	-16	1EA	RTS18-01-16	SWAGE HEAD SIZE -16	-4	-4	-4	-4	-4	-4	-4	-4	-4	-4	-4	-4	-4	-4
	-20	1EA	RTS18-01-20	SWAGE HEAD SIZE -20	-4	-4	-4	-4	-4	-4	-4	-4	-4	-4	-4	-4	-4	-4
	-24	1EA	RTS18-01-24	SWAGE HEAD SIZE -24	-4	-4	-4	-4	-4	-4	-4	-4	-4	-4	-4	-4	-4	-4
CUTTING TOOL	-3/4-5/8	1EA	D12530-001	CHPLLESS CUTTER 3/8	-3/4-5/8	-3/4-5/8	-3/4-5/8	-3/4-5/8	-3/4-5/8	-3/4-5/8	-3/4-5/8	-3/4-5/8	-3/4-5/8	-3/4-5/8	-3/4-5/8	-3/4-5/8	-3/4-5/8	-3/4-5/8
	-8-10-12	1EA	D12531-001	CHPLLESS CUTTER 8-12	-8-10-12	-8-10-12	-8-10-12	-8-10-12	-8-10-12	-8-10-12	-8-10-12	-8-10-12	-8-10-12	-8-10-12	-8-10-12	-8-10-12	-8-10-12	-8-10-12
DEBURRING TOOL BODY	-16-20-24	1EA	D12532-001	CHPLLESS CUTTER 16-24	-16-20-24	-16-20-24	-16-20-24	-16-20-24	-16-20-24	-16-20-24	-16-20-24	-16-20-24	-16-20-24	-16-20-24	-16-20-24	-16-20-24	-16-20-24	-16-20-24
	-4-5/8	1EA	D9851-14	DEBURRING TOOL 3/8	-4-5/8	-4-5/8	-4-5/8	-4-5/8	-4-5/8	-4-5/8	-4-5/8	-4-5/8	-4-5/8	-4-5/8	-4-5/8	-4-5/8	-4-5/8	-4-5/8
DEBURRING TOOL STEM	-8-10-12	1EA	D9850-16	DEBURRING TOOL 8-12	-8-10-12	-8-10-12	-8-10-12	-8-10-12	-8-10-12	-8-10-12	-8-10-12	-8-10-12	-8-10-12	-8-10-12	-8-10-12	-8-10-12	-8-10-12	-8-10-12
	-16-20-24	1EA	D9849-15	DEBURRING TOOL 16-24	-16-20-24	-16-20-24	-16-20-24	-16-20-24	-16-20-24	-16-20-24	-16-20-24	-16-20-24	-16-20-24	-16-20-24	-16-20-24	-16-20-24	-16-20-24	-16-20-24
	-3	1EA	D10210	SOLID SPIRAL FLUTE	-3	-3	-3	-3	-3	-3	-3	-3	-3	-3	-3	-3	-3	-3
	-4	1EA	D9851-13-04	STEM ASSY SIZE 04	-4	-4	-4	-4	-4	-4	-4	-4	-4	-4	-4	-4	-4	-4
	-5	1EA	D9851-13-05	STEM ASSY SIZE 05	-5	-5	-5	-5	-5	-5	-5	-5	-5	-5	-5	-5	-5	-5
	-6	1EA	D9851-13-06	STEM ASSY SIZE 06	-6	-6	-6	-6	-6	-6	-6	-6	-6	-6	-6	-6	-6	-6
	-8	1EA	D9850-13-08	STEM ASSY SIZE 08	-8	-8	-8	-8	-8	-8	-8	-8	-8	-8	-8	-8	-8	-8
	-10	1EA	D9850-13-10	STEM ASSY SIZE 10	-10	-10	-10	-10	-10	-10	-10	-10	-10	-10	-10	-10	-10	-10
	-12	1EA	D9850-13-12	STEM ASSY SIZE 12	-12	-12	-12	-12	-12	-12	-12	-12	-12	-12	-12	-12	-12	-12
	-16	1EA	D9849-13-16	STEM ASSY SIZE 16	-16	-16	-16	-16	-16	-16	-16	-16	-16	-16	-16	-16	-16	-16
	-20	1EA	D9849-13-20	STEM ASSY SIZE 20	-20	-20	-20	-20	-20	-20	-20	-20	-20	-20	-20	-20	-20	-20
	-24	1EA	D9849-13-24	STEM ASSY SIZE 24	-24	-24	-24	-24	-24	-24	-24	-24	-24	-24	-24	-24	-24	-24

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Swaging Sequence

1. Identify tube (material, O.D. and wall thickness.)
Identify jaws and anvil P/N's (tube O.D.)
Identify drawbolt P/N (tube O.D. and wall thickness)
Unscrew nut, anvil retainer.
Check adapter for drawbolt to be used, insert anvil.
Replace nut, anvil retainer, finger tight only.



2. Screw drawbolt assembly into the adapter through the bore of the anvil.
Tighten finger tight only, but make certain the drawbolt bottoms in the adapter.
Lightly lubricate the expander and seal rings.



3. Place the sleeve on the tube to be swaged. Make certain that the coupling nut for sleeve has been slipped onto tubing before sleeve installation. (Keep the tube O.D. free of lubricant)
Place the tube and sleeve over the drawbolt assy. and push it into the anvil until the sleeve and tube seat against their respective stops.
Place the jaws around the anvil, tube and sleeve as shown.



4. Position the retainer ring firmly over the jaws.
If the tube being swaged is in the aircraft and only one end is accessible, place the retainer ring over the tube before inserting the drawbolt in the tube.



5. Close the pump valve.
Apply required pressure.
Release pressure by opening pump valve.
Remove external tooling (retainer ring and jaws)
Remove swaged tube.
Check depth of swaged grooves in tube I.D.

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