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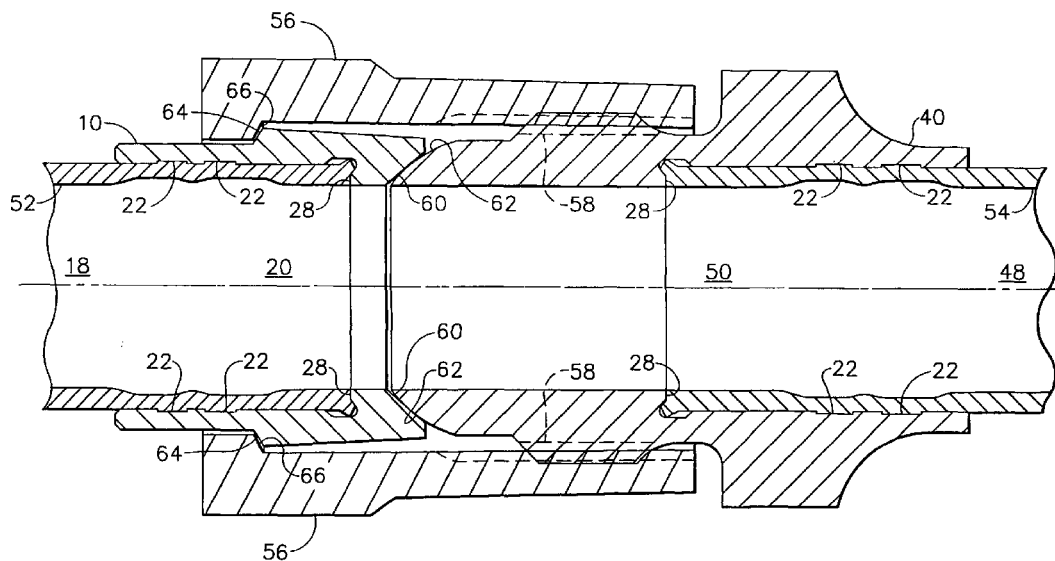
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(54) Title: INTERNAL SWAGE FITTING



(57) Abstract: An internal swage fitting (10, 40) for swaging a tube. The fitting (10, 40) includes a tube connection region (20, 50) with one or more radial grooves (22) and an expansion cavity (26) at the end adjacent to the end of the tube to be swaged. The expansion cavity (26) accommodates flowing tube material during the swaging process with minimal axis pressure on the fitting (10, 40). The expansion cavity (26) also includes a stop wall (26) to fix the location of the tube in the fitting (10, 40). The expansion cavity (26) enables swaging of tube materials of relatively high ductility without accounting for setback. It therefore eliminates the need for a collar to establish setback during swaging.