ASSEMBLY INSTRUCTIONS

1. Select the hose (A), ferrules (B) and inserts (C)
2. Cut the hose squarely using a rotary steel blade to the required length.
3. If skiving is required, remove all rubber cover to the 'skiving length' specified in the table, avoiding damage to the steel wire reinforcement.
4. Place the ferrule fully onto the hose. Push the insert fully into the hose. Select the 'COLLAPSE CONTROL MANDREL' Insert the MANDREL into the insert bore. The 'NO GO' part of the MANDREL must fully go into the insert bore. Remove the MANDREL.
5. Crimp the ferrule to the diameter specified in the table.
6. Inspect the crimp diameter by measuring it on each die impressions. All measurements must be taken in the centre of ferrule length. All measurements must be according to the specified crimping diameters, within a tolerance +0,01-0,2mm.
7. Insert the 'COLLAPSE CONTROL MANDREL
8. If the 'NO GO' part of the MANDREL stops in the bore, the crimping diameter and the bore collapse are correct.
9. If the 'NO GO' part of the MANDREL goes through the bore, the crimping diameter must be reduced by increments of 0.1mm
10. If the 'GO' part of the MANDREL does not go through the bore, the crimping diameter must be increased.

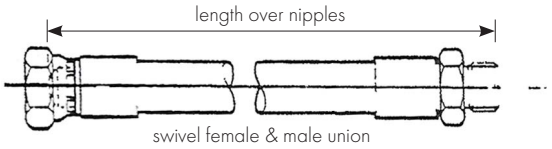
HOSE ASSEMBLY FABRICATION

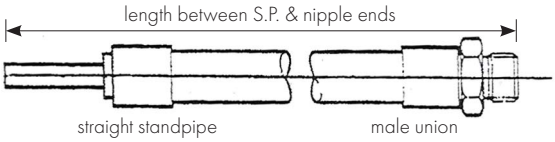
Those fabricating hose assemblies should be trained in the correct use of equipment and materials. Properly assembled fittings are vital to the integrity of a hose assembly. Incorrectly assembled fittings can separate from the hose and may cause serious injury or damage to property from whipping hose, fire explosion or vapour expelled from the hose.

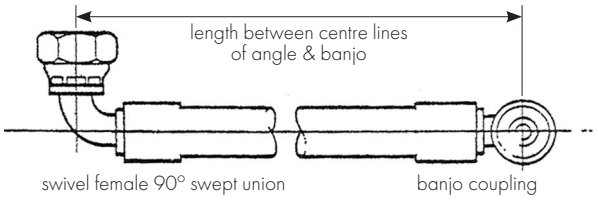
COMPONENT INSPECTION

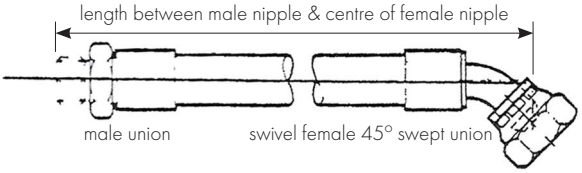
- **Prior to assembly, examine components for:**
- **Configuration & types - Clean**
- **Damage on cover**
- **Nicks**
- **Diameters**
- **Obstruction of the tubes within - More visible defects**
- **Damage in general**
- **Lengths suitable**
- **Swelling**
- **Matching burrs**
- **Corrosion**

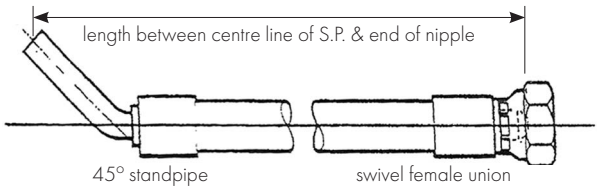
HOW TO MEASURE

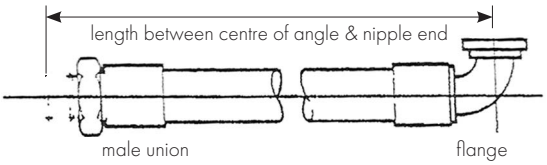




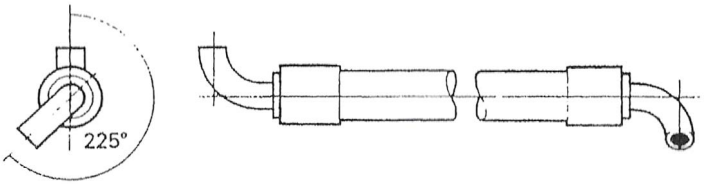








ANGULAR RELATIONSHIPS



Hold the assembly so that you can look along the length of the hose, with the fitting furthest away from you in the vertical position. Measure the angle between the vertical fitting and the one nearest to you in a clockwise direction. Relationships can then be expressed from 0° to 360°. If angle not given elbows are positioned at 0°.

HOSE FITTING COMPATIBILITY

Always pay attention to the compatibility of hose and fittings.

Safety Equipment

During fabrication, use the correct safety equipment, including eye and respiratory protection, also ensure adequate ventilation.

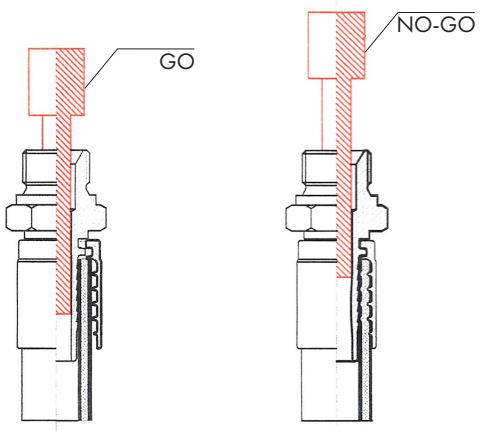
Do not reuse:

a. Field attachable fittings that have blown or pulled off hose.

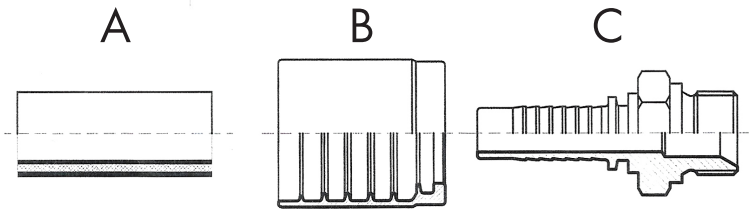
b. Any part of hose fitting that was permanently crimped or swaged to hose.

c. Hose that has been in service after system checkout.

STANDARD TOLERANCES			
Assembly length	0	305mm	+3mm
	305mm	457mm	+4mm
	457mm	914mm	+6mm
Elbow angle	+3°		



COLLAPSE CONTROL MANDREL



Printed data is indicative and could change without prior notice. For more information not present in this chart and for other technical data, please contact our sales office.

Crimp dimensions are a guideline only. You are advised to confirm with NO GO gauges (optional).

17.11.25