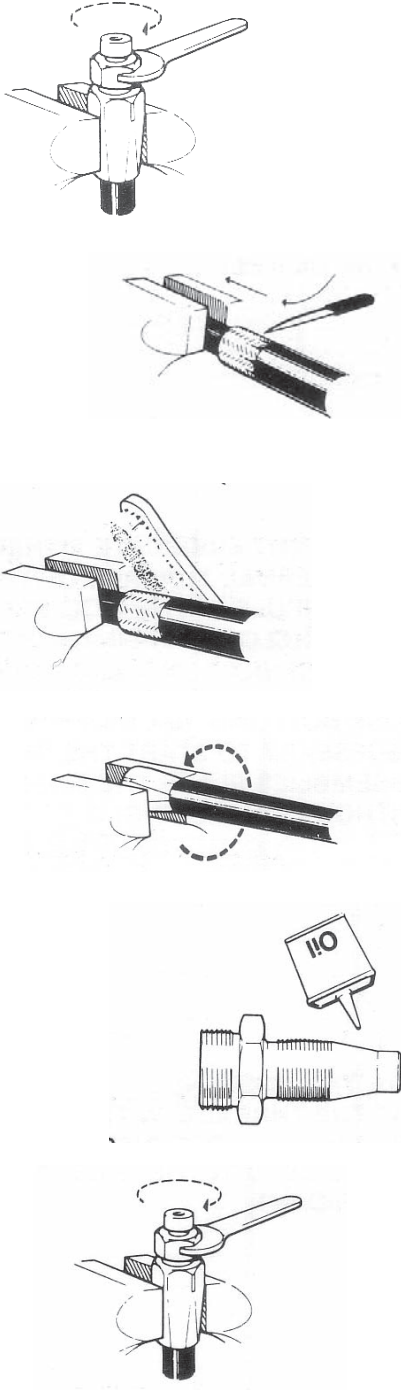




Assemblies of reusable fittings on a non-skived hose
SAE 100 R1T and R2AT.



**ASSEMBLING INSTRUCTIONS
FOR SKIVE AND NON SKIVE HOSES**

1. Cut the hose squarely to the desired length using a fine toothed hacksaw or preferably a cut-off machine, not forgetting to subtract the hose cut-off length 'A' (obtained from the insert dimensions in this catalogue). Remove dirt particles from the bore of the hose. Place the mandrel in the vice and push the hose from the first notch down to the wire braiding.
2. Slit the cover to be removed longitudinally around the diameter of the hose, then slice the unwanted cover off the wire braiding.
3. Finish cleaning with a wire brush to remove any remaining pieces of hose cover from the wire braiding. It is important that steps are taken to ensure that the wire braiding remains oil free.
4. Place the ferrule in the vice. **Do not lubricate either braid or internal threads of the ferrule.** Screw the hose into the ferrule (anticlockwise) until the hose bottoms (on long assemblies place the hose in the vice without flattening).
5. Lubricate the hose insert (the taper area only **not the threads**) with the appropriate fluid in the hose or a compatible lubricant.
6. Screw the insert into the ferrule until it seats. No further tightening is necessary.

NOTE: If a wire brushing machine is available ignore steps 1-3 inclusive and proceed as follows. Set up the machine for the correct diameter hose and the correct length of cover to be removed. Brush down the outer cover of the hose to the steel reinforcement then proceed with steps 4-6 inclusive.