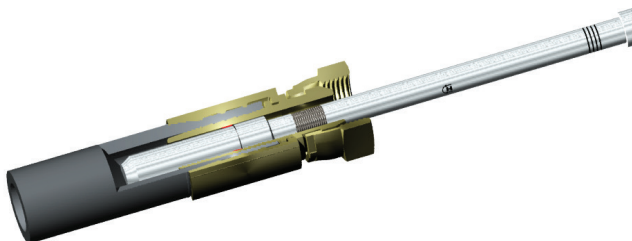
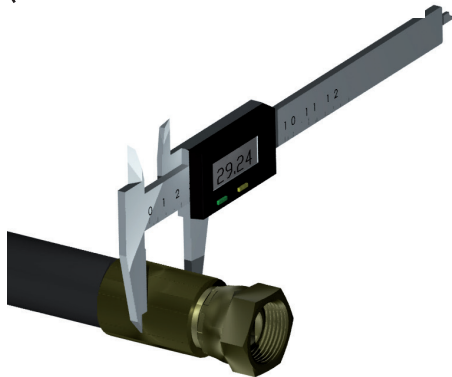
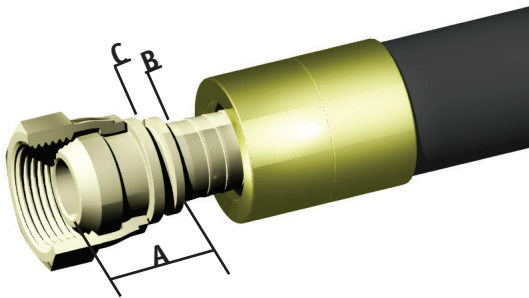
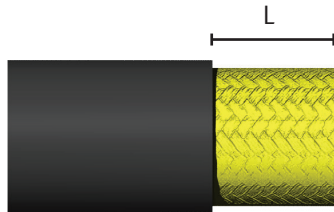


ASSEMBLY INSTRUCTIONS FOR CROSS OVER FITTINGS



1. Cut the hose transversely. Remember that all fittings have a cut-off length "A".

2. If using a skive ferrule, the hose should be skived to the steel wire. The skiving length "L" is noted in the Swaging Manual. Be careful not to damage the steel wire when skiving. If you are using non-skived ferrules you do not need to skive the hose. Clean the hose end from dirt and particles.

3. Push the ferrule onto the hose until it stops. Lubricate the insert and push it into the hose until the stop "B" meets the hose end. Thereafter, pull out the ferrule towards "C".

4. Swage the ferrule and the fitting according to the required swage diameter (see the Swaging Manual). Use a caliper to check the swage diameter.

5. Make sure that the correct internal collapse (see the Swaging Manual) has been achieved by using the Hydroscand control pin (9015-xx-xx).

The GO part should pass into the fitting to make sure the swaging is not overdone. The STOP part, on the other hand, should not be able to pass to make sure the swaging is not underdone.

The Hydroscand control pins (9015-xx-xx) are equipped with one side applicable for braided hoses (knurled), and one side for spiral hoses (four grooves).

NOTE!

It is important to use hoses and fittings that are adjusted to fit together. Hydroscand's hoses and fittings have been tested for a perfect fit.