

TEFLON HOSE ASSEMBLIES



Step 1



Step 2



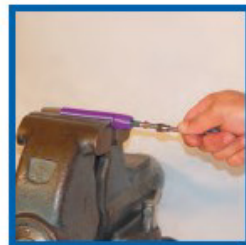
Step 3



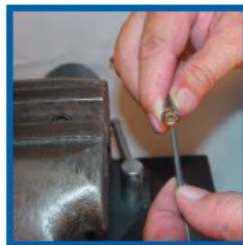
Step 4



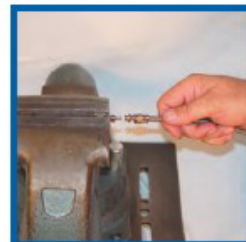
Step 5



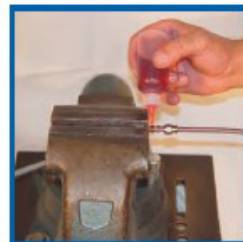
Step 6



Step 7



Step 8



Step 9

1 Wrap hose with tape at cut-off point and cut through the tape with a fine-tooth hacksaw or XRP Cut-Off Blade. **IMPORTANT: Remove tape and deburr the tube.**

2 When braided Teflon® hose is cut, one end will naturally try to flare away from the tube and the other end will remain tighter to the hose. Slip the socket onto the hose over the tighter end. Be sure the threads are facing the cut end as shown.

3 Position Separating Tool, Part No. 821060 as seen on page 42, and clamp horizontally in the vise. Slip the hose on the mandrel of the tool.

4 Move the hose with a twisting motion, allowing the edge of the Separating Tool to get under the braid and begin to flare it away from the tube. This will allow the olive to be installed.

5 Remove the hose from the mandrel and push the olive onto the tube and under the outer braid.

6 Slip the hose with the olive on the tube back on the mandrel of the Separating Tool, still in the vise. Push forward on the tube, allowing the flaring edge of the tool to firmly seat the olive on the tube. The mandrel of the tool will prevent the tube from collapsing inside the olive and keep it sized properly.

7 Remove the hose from the Separating Tool and inspect the tube inside the olive, making sure it is pushed fully forward and that the olive is under the outer braid. Check inside of tube for any debris or damage.

8 Position nipple end in vise and firmly clamp. Slip the hose and olive carefully onto the nipple stem. It should go on easily.

9 Apply an oil or anti-seize lubricant to the nipple threads.

10 While holding the hose, firmly on the nipple in the vise, move the socket on the hose forward over the flared braid and olive. Carefully engage the socket onto the nipple's threads and tighten by hand. Make certain that the threads are engaged correctly and you do not cross-thread them. Continue to tighten by hand.

11 Using a wrench, finish tightening the socket onto the nipple stem. When properly assembled, a small space between the nipple hex and the socket of .030" or less should exist when the socket feels tight. The socket should not tighten easily on up to the nipple's hex shoulder. If this happens, it is an indication that the braid may not be properly retained between the socket and the olive.

12 Clean and test assembly at twice the maximum operating pressure. Recheck assembly for leaks under normal operating conditions.



Step 10



Step 11