Convoluted Hose Assembly Instructions

FC363, FC364, 8000 series and 8500 series

Step 1 - Cut the Hose

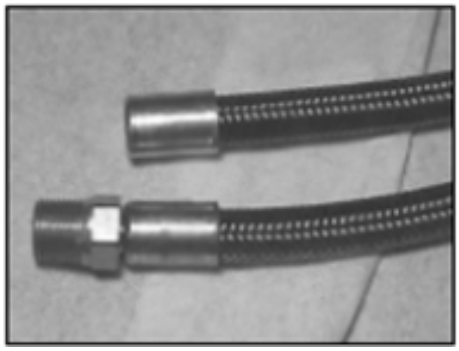
Place 1 to 2 wraps of fiberglass reinforced Mylar tape around the area to be cut. In the center of the taped area, cut the hose squarely and to the proper length using a suitable cut-off saw similar to the S1104. When complete, the angle of cut must not exceed 5°. Read the saw operation manual for cutting instructions and blade applications.

Step 2 – Clean the Hose Bore

Using a hose compatible solvent, bottle brush, or compressed air, flush contaminants from the hose bore. Follow shop safety rules.

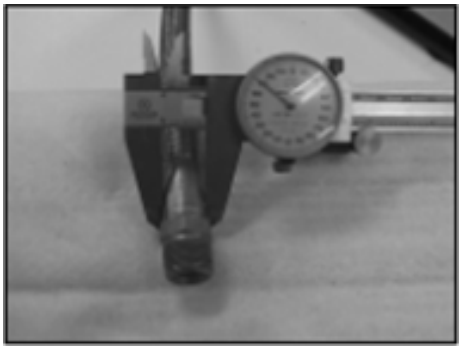
Step 3 – Insert the Fitting into the Hose (Convoluted PTFE)

Insert the hose into the socket until the cut hose end bottoms out inside the socket on the internal retaining shoulder. Apply an appropriate lubricant and insert the nipple into the hose by threading the nipple counter-clockwise into the hose and socket combination. NOTE: It is important to apply inward pressure on the nipple as it is threaded into place. The nipple is completely assembled when the nipple shoulder comes in contact with the hose. NOTE: It is important to not over assemble the nipple into the hose as damage to the liner may occur. Slide the socket up over the shoulder and flush with the nipple. Place a mark on the hose at the bottom of the socket to ensure that the fitting and socket do not move during crimping.



Step 4 – Crimp the Fitting

Crimp the fitting and check the crimp diameter, ovality dimension, and inspect the nipple/socket position. If hose mark is not within 1/8" of the socket skirt, reject the assembly. PTFE hose requires a crimp machine with a positive backstop. Refer to Bulletin JA55 Crimp Specifications and your crimp machine owner's manual for die selection, finished crimp diameter, ovality measurements and operating and crimping instructions.



Step 5 – Plug or Cap the Fitting Ends

Use 23055 dust plugs and caps to protect the fitting threads and seal out contamination until hose assembly is installed.

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