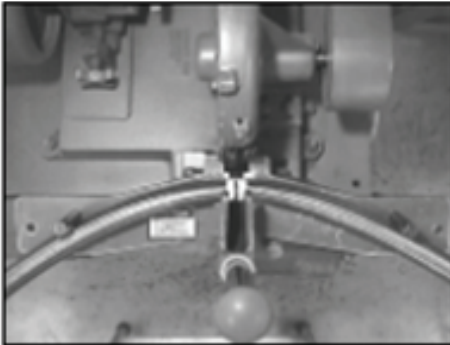


Convolved Hose Assembly Instructions

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.



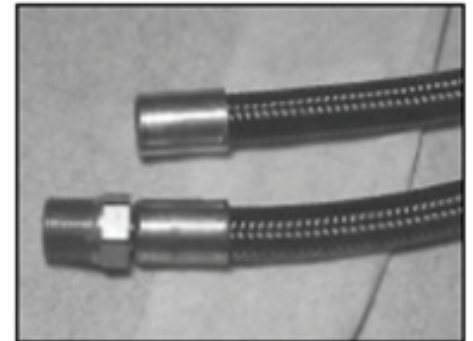
Step 2 – Clean the Hose Bore

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



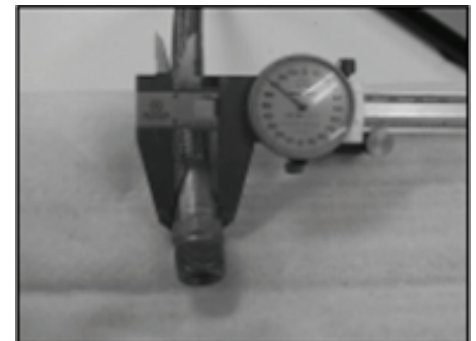
Step 3 – Insert the Fitting into the Hose (Convolved PTFE)

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 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 the Crimp Specs section of PowerSource for the up to date crimp information for these convoluted PTFE hoses.



Step 5 – Plug or Cap the Fitting Ends

Use the FT1555 CapSeal System to cover the fitting ends and seal out contamination until hose assembly is installed.

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