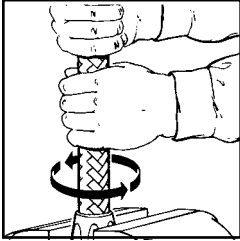


Step 1

Cut the hose so that the end is square. A guillotine blade (FT1258), fine-tooth hacksaw, cut-off wheel, or equivalent means of cutting should be used.

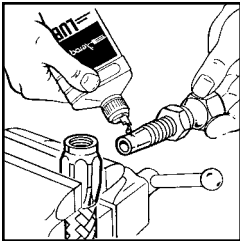


Step 2

With the socket held in a vice or equivalent clamping means, screw the hose counterclockwise into the socket until it bottoms. Next, back the hose out of the socket by 1/4 turn. Care should be taken to avoid unnecessary pressure on the socket while in the vice to avoid deformation of the socket.

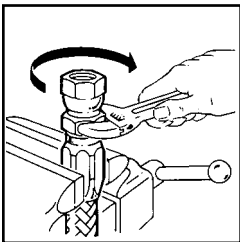
When assembling long lengths of hose, it may be preferred to put the hose in a vise, just tight enough to prevent the hose from turning. Then screw the socket counterclockwise onto the hose until it bottoms. Finally, back the socket off of the hose by 1/4 turn.

Note: Excessive friction between the hose and socket may cause the hose to twist and buckle upon installation of the hose into the socket. In this case, generous amounts of the refrigeration or A/C system's compressor lubricating oil should be applied to the hose cover to aid assembly.



Step 3

Lubricate the nipple nose and threads with a generous amount of the refrigeration or A/C system's compressor lubricating oil.



Step 4

Screw the nipple clockwise into the socket and hose. Leave 1/32" to 1/16" clearance between the nipple hex and the socket.

Note: The installation of the socket onto the hose may have caused the hose inner tube to deform or have an irregular shape. This will cause the insertion of the nipple into the hose to be difficult. If the nipple causes the cut edge of inner tube to be slightly "rolled" back into the hose, there is no need to remove the socket and repeat the assembly process. There will not be a decrease in the performance level of the hose assembly.

Once assembly is complete, the fitting should be inspected. If torn inner tube material can be seen by looking down through the nipple, the fitting should be removed, the hose clean cut and the assembly process repeated. This may be due to a lack of assembly lubricant or deformation of the socket from excessive clamping force.

For recommendations regarding the cleaning of the hose assembly, please consult an Aeroquip Fluid Products Handbook.

Warning: Failure to follow these installation instructions may result in an unstable assembly, which may cause catastrophic failure of the connection with the potential for personal injury.



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