

# Hose Assembly Instructions

**1 - Select the correct hose tail series for the intended hose:**

100R1	"D" reusables & "K" series permanent crimp
100R2	"D" reusables & "K" series permanent crimp
100R5	"DF" reusables "F" series permanent crimp
100R6	"A" series imperial eastman style permanent crimp
100R7	"A" series imperial eastman style permanent crimp
100R8	"A" series imperial eastman style permanent crimp
100R9	"K" series one piece permanent crimp
100R12	"L" series one piece permanent crimp
100R13	"M" series one piece permanent crimp
100R14	"C" series one piece permanent crimp
100R15	"N" series one piece permanent crimp

**2 - Mark insertion depth on hose with suitable marker**

Hose dash size	Insertion depth in MM				
	A	K	L	M	N
-4	37	21			
-5		24			
-6	40	29	27		
-8	40	33	32		
-10	40	40	33	47	
-12	40	38	37	48	56
-16	43	44	44	51	59
-20		48	46	64	71
-24		37	59	62	
-32		46	62	73	



**3 - Lubricate if necessary with either Rubber Grease Castrol GRR(B) or clean SAE30 engine oil**

**Do not use lubricant on multispiral hose**

**4 - Insert hose into fitting to depth indicated above**

**5 - Set press to dimension required (refer to AHF Crimp Chart) Page 204 of this catalogue**

**6a - For K,L,M & N series fittings, insert hose and tail into press so entire shell is inside the die set**

crimp to desired dimension

Remove and check final crimp size (must be within  $\pm 0.25$ mm of designated dimension)

(Diameter is to be measured at the centre of the shell)

**6b - For A & C series require a bump to be left on the top closest to the nut**

**A series to be inserted into the press with the following shell lengths to be crimped**

-4, -6, -8	32mm
-10, -12	34mm
-16	40mm
-20	47mm

**C series**

-3, -4	15mm
-6, -8, -10, -12	17mm

**7 - Clean hose using Polyshot or similar cleaner and ensure there are no foreign objects left in the hose.**

**For D & DF series reusables**

Cut hose to length

Screw socket onto hose in counter clockwise direction until hose bottoms out

back off 1/2 turn

Dip hose end into SAE30 engine oil or similar heavy oil, Rubber grease may also be used

Screw tail into shell until the Hex on the nipple rests against the shoulder on the shell

*Note: for stainless steel Dow Corning Molykote G-N or equivalent lubricant must be used or thread will seize.*