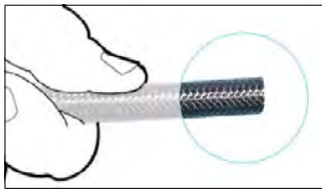

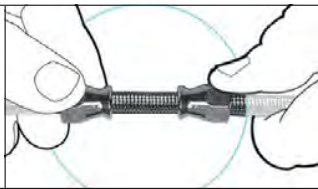
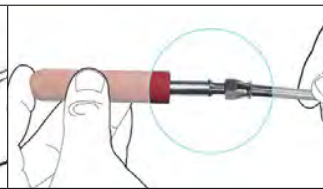
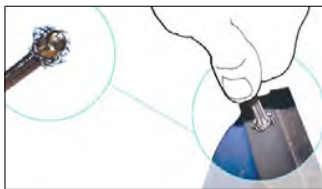





# Assembly Instructions for Re-usable 600 Series (PTFE Smooth Bore) Hose & Fittings

			
<p><b>STEP 1</b></p> <p>Using a fine tooth saw blade or cut off wheel, cut hose to the required length. Clean any loose debris from both the cut ends and inside the hose</p> <p><b>Note:</b> Lubricate threads with Duck Oil before assembly.(or a similar commercial lubricant may be used)</p>	<p><b>STEP 2</b></p> <p>Main fitting body - Olive - Socket On a clean flat surface disassemble the fitting, this consists of 3 parts, the Main fitting body, Olive and Socket.</p>	<p><b>STEP 3</b></p> <p>Push two sockets back to back over the overbraid working from the non flared end</p>	<p><b>STEP 4</b></p> <p>Using an appropriate sized Goodridge mandrel, flare out both ends of the stainless steel overbraid from the PTFE inner tube</p>

			
<p><b>STEP 5</b></p> <p>Push an olive onto each end of the PTFE inner tube under the stainless steel over braid by hand and finish off by pushing against a flat solid surface making sure the PTFE tube is fully home in the olive.</p>	<p><b>STEP 6</b></p> <p>Holding the main fitting body in a smooth jaw vice, lubricate the thread and push the hose over the nipple end and start to thread the socket onto the fitting by hand.</p>	<p><b>STEP 7</b></p> <p>Finish tightening the socket onto the fitting with a good quality spanner until the socket is one full turn from the main fitting hex.</p> <p>PRESSURE TEST.</p>	<p>UNDER NO CIRCUMSTANCES SHOULD THE SOCKET BE LOOSENED IN AN ATTEMPT TO ADJUST THE ALIGNMENT AFTER ASSEMBLY</p>