

Procedure 2305	Installation of Brass Reusable Fittings	Revision 2-04
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Selection:

- Select the proper fitting using Procedure 1002 (Brass Reusable Fitting Selection).

Preparation:

- Prepare the hose using Procedure 1100 (General Preparation Instructions).

Procedure (Male & Female):

- 1. Unthread ferrule from stem.
- 2. Slide the ferrule onto hose until it contacts hose end. **Note:** Hose **must** be cut square!
- 3. Place a mark on the hose at the junction of hose and ferrule.
- 4. Place the hose with ferrule in a vise and tighten vise on flats of ferrule. Make sure that the mark is visible. **Note:** Do not over tighten vise. Too much tension will "egg" the ferrule.
- 5. Insert the stem into hose until stem threads contact ferrule.
- 6. Tighten stem as follows:
 - a. Turn clockwise two to three turns.
 - b. Turn counter clockwise one turn.
 - c. Repeat "a" and "b" until stem hex contacts ferrule.
- 7. With fitting still in vise, measure the distance from the mark to the end of the ferrule. If it is:
 - a. 1/8" or less, remove the assembly from vise. It is properly assembled.
 - b. Greater than 1/8", remove (unthread) stem from ferrule. Repeat Step 2 through Step 6.
- 8. Test assembly using Procedure 4000 (General Hydrostatic Testing Information) and 4001 (Hydrostatic Testing).

Procedure (Hose Splicers)

- 1. Unthread both ferrules from stem.
- 2. Slide ferrule onto one hose until it contacts hose end. **Note:** Hose **must** be cut square!
- 3. Place a mark on the hose at the junction of hose and ferrule.
- 4. Place the hose with ferrule in a vise and tighten vise on flats of ferrule. Make sure that the mark is visible. **Note:** Do not over tighten vise. Too much tension will "egg" the ferrule.
- 5. Insert the stem into the hose until the stem threads contact ferrule.
- 6. Tighten stem as follows:
 - a. Turn clockwise two to three turns.
 - b. Turn counter clockwise one turn.
 - c. Repeat "a" and "b" until stem hex contacts ferrule.
- 7. With fitting still in vise, measure the distance from the mark to the end of the ferrule. If it is:
 - a. 1/8" or less, it is properly assembled.
 - b. Greater than 1/8", remove (unthread) stem from ferrule. Repeat Step 2 through Step 6.
- 8. When the fitting is properly assembled, repeat Steps 2 and 3 above for the other hose end.
- 9. With properly assembled fitting in vise, repeat Step 5 above for other end.
- 10. Tighten ferrule onto stem as per Steps 6a thru 6c above. **Note:** Hose must rotate with ferrule.
- 11. Inspect fitting as per Step 7 above.
- 12. Test assembly using Procedure 4000 (General Hydrostatic Testing Information) and 4001 (Hydrostatic Testing).

Assembled By: _____ Tested By: _____ Reference No. _____
 Assembled Date: _____ Test Date: _____