Procedure 2305: Installation of Brass Reusable Fittings

Selection
☐ Select the proper fitting using Procedure 1002: Brass Reusable Fitting Selection (page 6).

Preparation
☐ Prepare the hose using Procedure 1100: General Preparation Instructions (pages 9-10).

Procedure (Male and 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. ⅛” or less, remove the assembly from vise. It is properly assembled.
   b. Greater than ⅛”, remove (unthread) stem from ferrule. Repeat step 2 through step 6.
☐ 8. Test assembly using Procedure 4000: General Hydrostatic testing Information (page 50) and 4001: Hydrostatic Testing (page 51).

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. ⅛” or less, it is properly assembled.
   b. Greater than ⅛”, 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 through 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 (page 50) and 4001: Hydrostatic Testing (page 51).