Procedure 2305: Installation of Brass Reusable Fittings

effective 02/08

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 the ferrule from the stem.
☐ 2. Slide the ferrule onto the hose until it contacts the hose end.  Note: The hose must be cut square!
☐ 3. Place a mark on the hose at the junction of the hose and the ferrule.
☐ 4. Place the hose with the ferrule in a vise and tighten the vise on the flats of the ferrule. Make sure that the mark is visible.
   Note: Do not over-tighten the vise. Too much tension will 'egg' the ferrule.
☐ 5. Insert the stem into the hose until the stem threads contact the ferrule.
☐ 6. Tighten the stem as follows:
   a. Turn clockwise two to three turns.
   b. Turn counter-clockwise one turn.
   c. Repeat 'a' and 'b' until the stem hex contacts the ferrule.
☐ 7. With the fitting still in the vise, measure the distance from the mark to the end of the ferrule. If it is:
   a. \( \frac{1}{8}'' \) or less; remove the assembly from the vise. It is properly assembled.
   b. Greater than \( \frac{1}{8}'' \); remove (unthread) the stem from the ferrule. Repeat step 2-6.

Hose Splicers

☐ 1. Unthread both ferrules from the stem.
☐ 2. Slide the ferrule onto one hose until it contacts hose end.  Note: The hose must be cut square!
☐ 3. Place a mark on the hose at the junction of the hose and the ferrule.
☐ 4. Place the hose with ferrule in a vise and tighten the vise on the flats of the 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 the ferrule.
☐ 6. Tighten the stem as follows:
   a. Turn clockwise two to three turns.
   b. Turn counter-clockwise one turn.
   c. Repeat 'a' and 'b' until the stem hex contacts the ferrule.
☐ 7. With the fitting still in the vise, measure the distance from the mark to the end of the ferrule. If it is:
   a. \( \frac{1}{8}'' \) or less; remove the assembly from the vise. It is properly assembled.
   b. Greater than \( \frac{1}{8}'' \), remove (unthread) the stem from the ferrule. Repeat step 2-6.
☐ 8. When the fitting is properly assembled, repeat steps 2 and 3 above for the other hose end.
☐ 9. With the properly assembled fitting in the vise, repeat step 5 above for the other end.
☐ 10. Tighten the ferrule onto stem as per steps 6a through 6c above.  Note: The hose must rotate with ferrule.
☐ 11. Inspect the fitting, as per step 7 above.