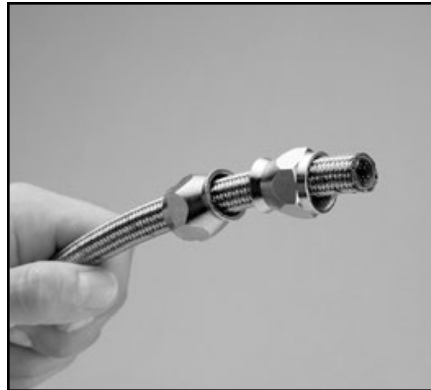




# ASSEMBLY INSTRUCTIONS FOR #919 PTFE HIGH HEAT HOSE FITTINGS



1. Verify all fittings match. Visually inspect all sockets, nipples & sleeves.



2. Slide two sockets over end of hose with bottom of sockets back to back. **Note:** When installing sockets on hose, check hose ends to determine if wire braid "necks down" (bends inward). If one end "necks down" use this end to slide sockets onto hose.



3. Position sockets at each end of hose.



4. Mount nipple hex in vise. Ensure nipple end extends beyond vise jaws sufficiently to allow installation of hose.



5. Push hose bore onto nipple to size tube and to aid in separating braid before fitting sleeve.



6. Remove hose from nipple.



7. By hand, push sleeve over end of PTFE core tube and under wire braid.



8. To complete positioning of sleeve, push hose end with sleeve, against a solid flat surface.



9. Verify tube butts against inside shoulder of ferrule.

Instructions by



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10. Using a tapered punch, push punch into end of sleeve and tube to set sleeve barbs into tube.



**WARNING:**

Do not use lubricating oil when installing fittings on hose used in oxygen service. When installing fittings on hose used in oxygen service lubricate with a non-oil based soap solution. Failure to do so may result in an explosion and personal injury when hose is used.

Installation of Reusable Fittings is the responsibility of the user and not the distributor.



11. Using SAE 20 weight lubricating oil, lubricate nipple and socket threads. For stainless steel fittings use Parker ThreadMate™ or a molybdenum type lubricant. For hose used in oxygen service lubricate using a non-oil based soap solution.



12. Using a twisting motion, push hose over nipple until hose is seated against nipple chamfer.



13. Push socket forward and hand-start threading of socket to nipple. **Caution:** When tightening socket in vise, do not over tighten vise jaws. Over tightening vise jaws will distort internal threads of socket.



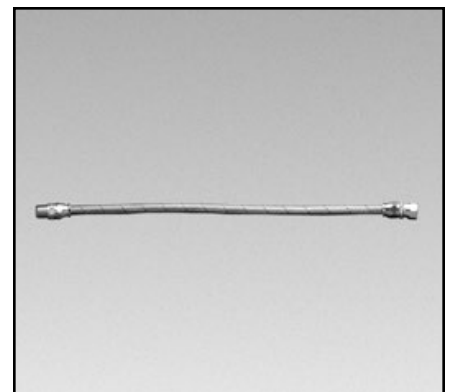
14. Remove assembly from vise and reposition with socket in vise jaws. Ensure socket extends beyond vise jaws far enough to allow nipple to be completely tightened.



15. Wrench tighten nipple hex until clearance between hex and socket hex is 1/32" or less.



16. Tighten further to align corners of nipple and socket hexes if necessary. Repeat Steps 4 through 16 for other end of hose.



17. Measure and verify hose assembly length matches work order. Pressure test hose assembly if required.



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