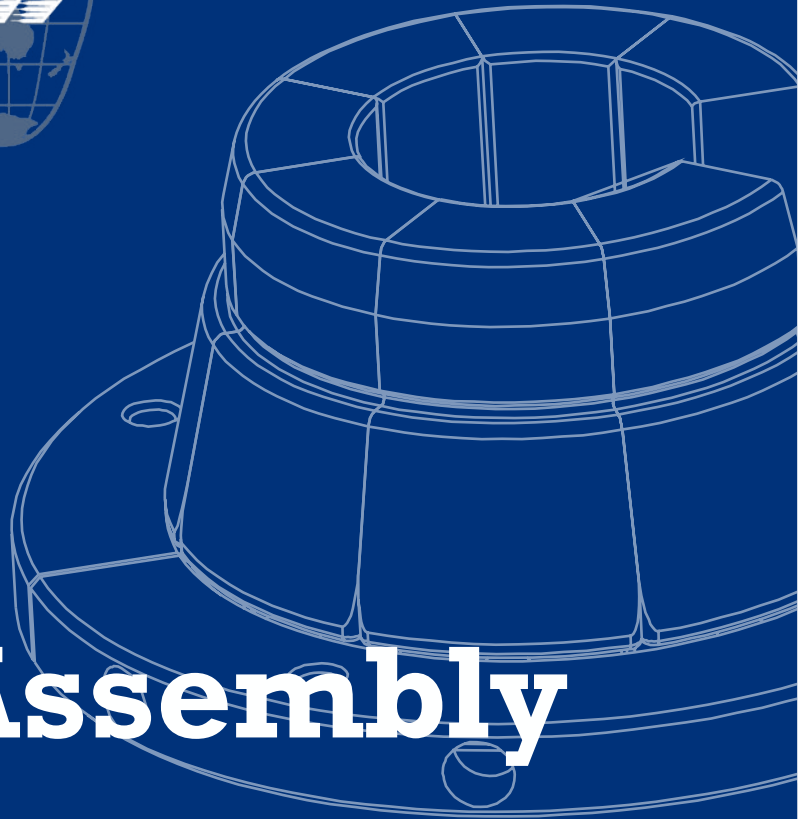


PF681



Swaging and Hose Assembly



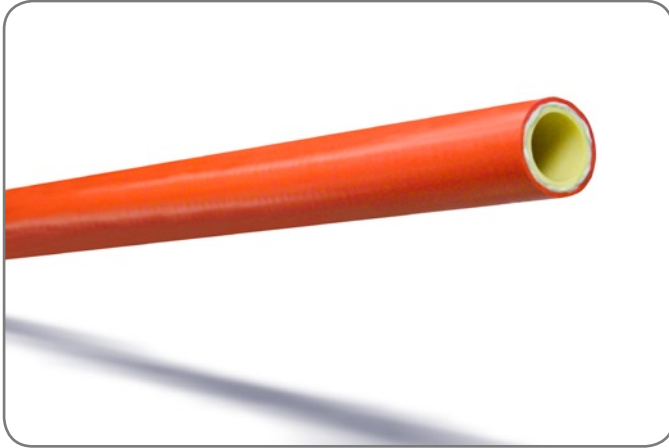
Step



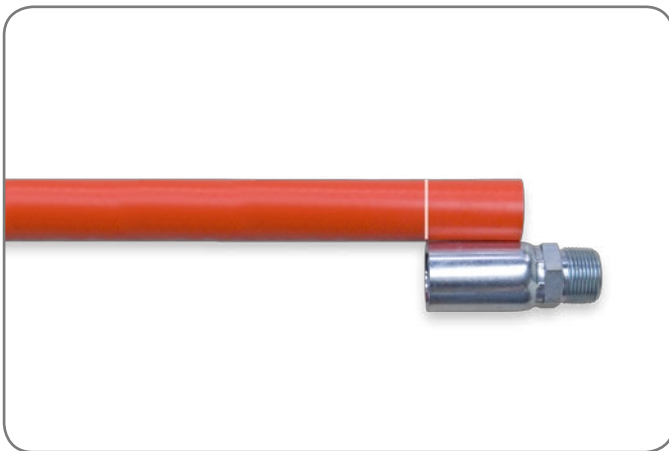
by



Step



1 Cut hose squarely (hand held cutter recommended).



2 Measure and mark hose for proper insertion depth of coupling.



3 Select appropriate swage die referring to swage Specifications.

Clean and lubricate bore of swage die.



4 Install two-piece split die into die bowl.



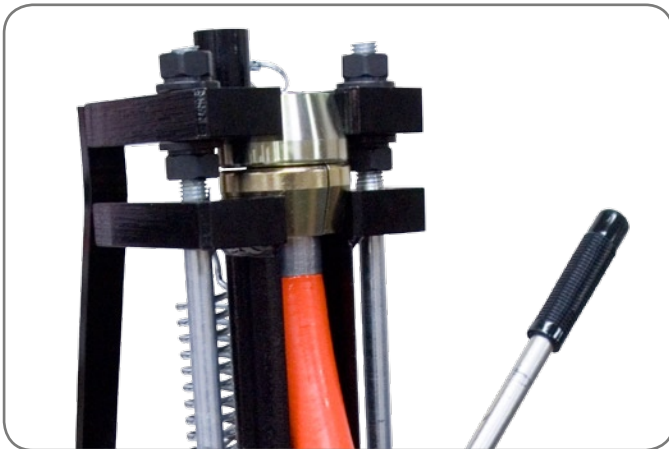
5 Remove or elevate one die segment to allow installation of the hose and coupling.



6 Select appropriate pusher referring to swage specifications.



7 Insert coupling completely into the pusher. Using jack handle advance cylinder upward. As fitting approaches die opening properly align for entry of the coupling by deflecting the hose as required. Exert an upward force to ensure fitting is completely inserted into the pusher.



8 Using jack handle continue to advance cylinder upward until bottom of pusher fully contacts top face of dies.



9 Remove swaged assembly and check finished swage diameter to confirm that it is within swage specifications.