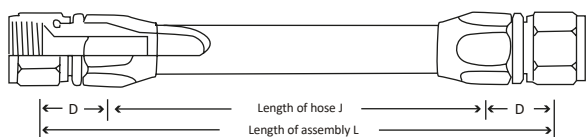


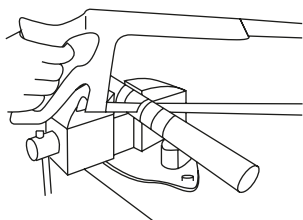
Hose Assembly Instructions

Aeroquip FC333 racing hose, G210 hose, GRH hose and StartLite hose

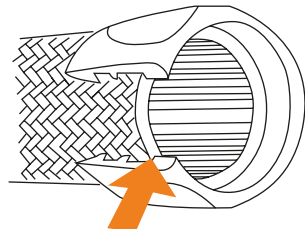


STEP 1. Determine assembly length

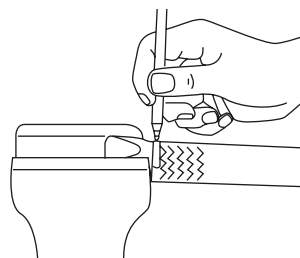
Type of union	Dimension 'D' in mm					
	-6	-8	-10	-12	-16	-20
Straight	30.73	34.04	37.08	39.12	43.94	49.28
45°	30.48	30.48	34.29	42.16	43.43	51.31
90°	26.67	26.42	29.97	38.86	43.18	49.53
120°	19.56	19.30	21.59	29.21		
150°	36.58	10.41	11.18	16.51		
180°	3.30	2.54	1.52	3.81		



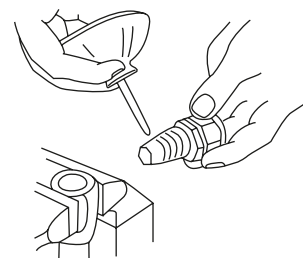
STEP 2. Cut hose squarely to length using a fine tooth hacksaw. To minimise wire braid flare out, wrap hose with masking tape before cutting.



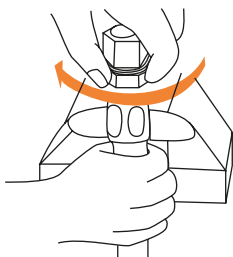
STEP 3. Remove tape. Insert hose in socket with twisting, pushing motion until hose is in line with back of socket threads.



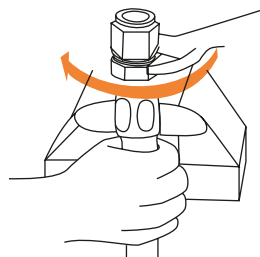
STEP 4. **IMPORTANT** - Mark position around hose at rear of socket with a grease pencil, paint or tape



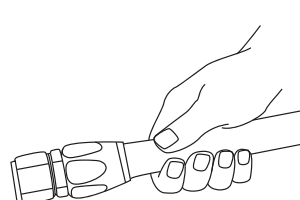
STEP 5. Lubricate inside of hose and nipple threads liberally using S.A.E. 30 lubricating oil.



STEP 6. Carefully insert nipple and engage nipple and socket threads while holding hose in position with other hand. Make sure hose does not push out of socket by observing mark made in step 4.



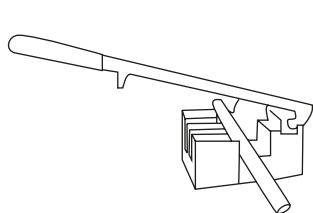
STEP 7. Complete assembly using spanner while continuing to hold hose in position. Maximum allowable gap is 0.031 inches.



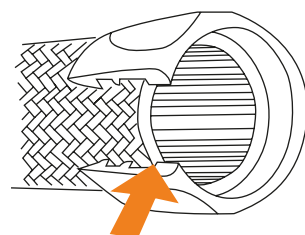
STEP 8. **IMPORTANT** - Check hose for push out by observing hose position mark. None should be evident.

Aeroquip Performance Products FBM3553 Hose Assembly Lube is a specially compounded lubricant superior to any other lubricant used in hose assembly work. Available in pint containers. Use for either hand or machine assembly.

StartLite Racing Hose (with reuseable fittings)



STEP 1. Cut hose square to length with Aeroquip Performance Products Cut Off Tool (FT1258) or similar cutting device.



STEP 2. Insert hose in socket with twisting, pushing motion until hose is in line with back of socket threads.

Continue as steps 4-8 above.

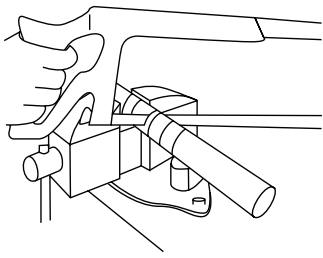
StartLite® Hose Routing Procedure

In most vibration applications, it may be necessary to restrain, protect, or guide the hose to protect it from damage caused by unnecessary flexing or contact with other mechanical components. Care must be taken to ensure such restraints do not introduce additional stress or wear points. StartLite® hose, when used with reuseable fittings in high vibration applications, should be supported approximately every 12 to 14 inches.

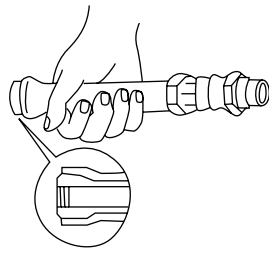
Notes

- Greater resistance can be expected as compared to Aeroquip Performance Products AQP® Racing Hose.
- To disassemble, reverse steps
- It is recommended that all hose assemblies be proof pressure checked at twice the operating pressure using a proof test stand such as the Aeroquip Performance Products FT1058 stand.

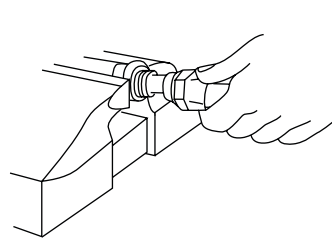
Aeroquip 2807 and TFE hose



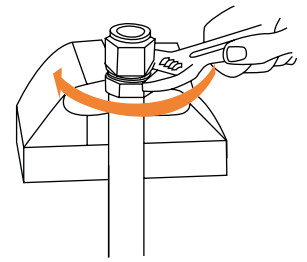
STEP 1. Wrap hose with masking tape at cut-off point and cut squarley through tape to length using a fine tooth hacksaw. Remove tape and trim loose wire flush with tube. Burrs on bore of tube should be removed with a knife. Clean the hose bore. One end of the hose will flare out, slide the sockets (nuts) back to back over the other end, then this end can be more easily be flared using a braid separating tool.



STEP 2. Push the sleeve over the end of the tube and under the wire braid by hand. Complete positioning of the sleeve by pushing the hose end against a flat surface. Inspect to see that the tube butts against the inside shoulder of the sleeve.

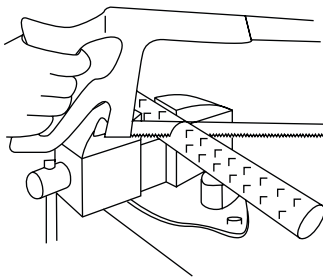


STEP 3. Lubricate nipple and socket threads. Use a molydisulphide based lubricant for stainless steel fittings (e.g. Molykote Type G). Lubricants containing chloride are not recommended. Other material combinations use standard petroleum lubricants. Hold the nipple with hex in the vice. Push hose over nipple with twisting motion until seated against nipple chamfer. Push socket forward and start threading of socket to nipple.

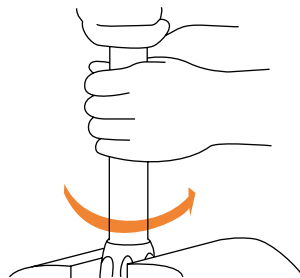


STEP 4. Spanner tighten hex until clearance with socket hex is 1/32" or less. Tighten further to align corners of nipple and socket hexes. To disassemble: Unscrew and remove nipple; slide socket back on hose by tapping against a flat surface, remove sleeve with pliers.

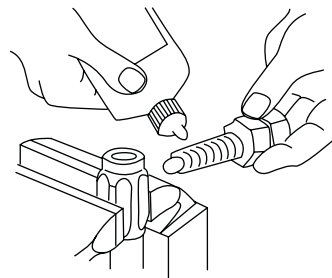
AQP FC300 7 FC234 Hose



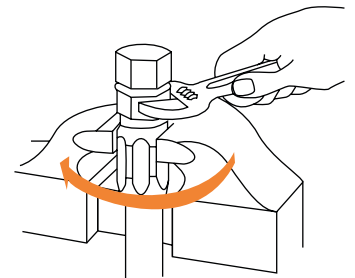
STEP 1. Cut hose square with a fine tooth hacksaw.



STEP 2. Put socket in vice, screw hose anti clockwise until it bottoms, back off 1/4 turn.

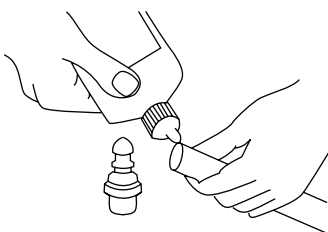


STEP 3. Lubricate with light oil. Brass fittings only push assembly mandrel through nipple to guide into hose without cutting.

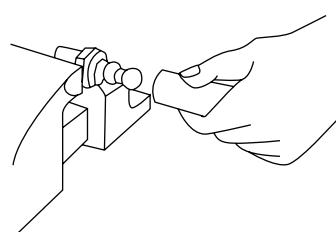


STEP 4. Screw nipple clockwise into hose and socket, leave 1/32" (0.8mm) clearance between nipple hex and socket.

AQP FBN & FBV Push-lock hose Socketless Hose

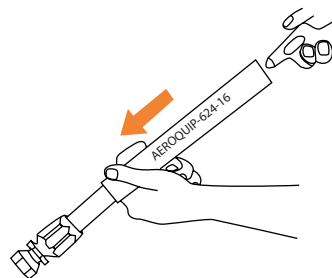


STEP 1. Cut hose to required length with a sharp knife. Oil inside of hose and outside of nipple liberally.



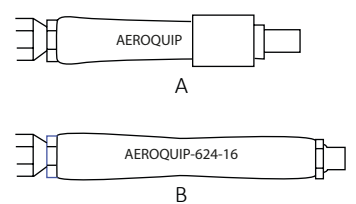
STEP 2. Push hose on fitting until hose end bottoms underneath protective cap as shown. Clean, proof test to twice operating pressure and inspect all assemblies. This is easier if the hose is warmed in hot, max 86°C, not boiling, water.

Firesleeve



STEP 1. Follow the appropriate hose assembly instructions through the assembly of one end fitting. Cut firesleeve to same length as hose. Start firesleeve over cut end of hose.

Note: If applying sleeve over Teflon* or stripped cover assemblies, wrap exposed wire with tape. Grasp Sleeve and slip over the hose assembly as illustrated.



STEP 2. Skin sleeve back from cut end of hose enough to allow assembly of second end fitting.

Then centre sleeve so that it completely covers both sockets.

STEP 3. Position nylon wire tie or band clamp over sleeve on each end of the hose assembly and draw tight.