

## 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.
- 8. Test assembly using Procedure 4000: General Hydrostatic Testing Information (page 60) and Procedure 4001: Hydrostatic Testing (page 61).

#### *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, 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.
- 12. Test assembly using Procedure 4000: General Hydrostatic Testing Information (page 60) and Procedure 4001: Hydrostatic Testing (page 61).