

Procedure 2305: Installation of Brass Reusable Fittings

effective 02/08

Selection

- Select the proper fitting using Procedure 1002: Brass Reusable Fitting Selection.

Preparation

- Prepare the hose using Procedure 1100: General Preparation Instructions.

Procedure (*Male and Female*)

- 1. Unthread ferrule from stem.
- 2. Slide the ferrule onto hose until it contacts hose end. *Note:* Hose must be cut square!
- 3. Place a mark on the hose at the junction of hose and ferrule.
- 4. Place the hose with ferrule in a vise and tighten vise on flats of 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 hose until stem threads contact ferrule.
- 6. Tighten stem as follows:
 - a. Turn clockwise two to three turns.
 - b. Turn counter clockwise one turn.
 - c. Repeat 'a' and 'b' until stem hex contacts ferrule.
- 7. With fitting still in vise, measure the distance from the mark to the end of the ferrule. If it is:
 - a. 1/8" or less, remove the assembly from vise. It is properly assembled.
 - b. Greater than 1/8", remove (unthread) stem from ferrule. Repeat step 2 through step 6.
- 8. Test assembly using Procedure 4000: General Hydrostatic Testing Information and 4001: Hydrostatic Testing.

Procedure (*Hose Splicers*)

- 1. Unthread both ferrules from stem.
- 2. Slide ferrule onto one hose until it contacts hose end. *Note:* Hose must be cut square!
- 3. Place a mark on the hose at the junction of hose and ferrule.
- 4. Place the hose with ferrule in a vise and tighten vise on flats of 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 ferrule.
- 6. Tighten stem as follows:
 - a. Turn clockwise two to three turns.
 - b. Turn counter clockwise one turn.
 - c. Repeat 'a' and 'b' until stem hex contacts ferrule.
- 7. With fitting still in vise, measure the distance from the mark to the end of the ferrule. If it is:
 - a. 1/8" or less, it is properly assembled.
 - b. Greater than 1/8", remove (unthread) stem from ferrule. Repeat step 2 through step 6.
- 8. When the fitting is properly assembled, repeat steps 2 and 3 above for the other hose end.
- 9. With properly assembled fitting in vise, repeat step 5 above for other end.
- 10. Tighten ferrule onto stem as per steps 6a through 6c above. *Note:* Hose must rotate with ferrule.
- 11. Inspect fitting as per step 7 above.
- 12. Test assembly using Procedure 4000: General Hydrostatic Testing Information and 4001: Hydrostatic Testing.