



## INTERLOCK ASSEMBLY INSTRUCTIONS

**1.** Cut hose square using an appropriate cut off saw. Hose MUST be cut squarely.

**2.** Remove the hose cover completely to the length indicated in the crimp chart, using a hand skiver or powered skive machine. Be careful not to dislodge wires. Check the skive length.

**3.** Remove the hose tube completely to the length indicated in the crimp chart, using an internal hand skiver or powered skive machine. Be careful not to dislodge wires. Check the skive length.

**4.** Clean the hose bore. Air, or a brush may be used, but preferable a foam projectile shot through the entire length of the hose.

**5.** Mount the stem in a vice, and lubricate the nipple stem or inside of hose with hydraulic oil. DO NOT USE ANYTHING THAT WILL CONTAMINATE THE HYDRAULIC SYSTEM.

**6.** Place the ferrule over the end of the hose, and push the hose onto the stem until the hose bottoms against the stem shoulder. There may be some resistance when the hose reaches the inter-lock area - be sure that the hose is fully inserted over the interlock area. Make sure that no skived area appears on the hose that would also indicate incomplete hose insertion.

**7.** Pull the ferrule back towards the hose so that the collar aligns correctly over the groove in the stem. You should feel the fitting butting against the hose, indicating that the hose is all the way on, over the interlock area.

**8.** Position the fitting in the crimper so that it will crimp the full length of the ferrule, without damaging the hex or thread, and crimp to the correct dimension provided in the crimp chart, or the My Crimp App.

**9.** Verify the crimp dimensions by measuring at the midpoint of the crimp between the flats. DO NOT MEASURE ON THE RIDGES LEFT BY GAP BETWEEN CRIMP DIES.



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