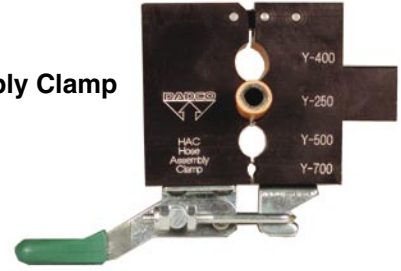


Hose Assembly Construction Tools

**Hose Cutter
HC-11**



**Hose Assembly Clamp
HAC**



Hose Assembly Construction

Hose Preparation

1. Measure hose.
2. Cut hose to appropriate length using the HC-11 Hose Cutter (a sharp knife can also be used). It is important to use a sharp edge, because a clean cut is necessary.
3. No burrs should be present if a clean cut was made. However, if burrs are present remove them with a sharp knife.

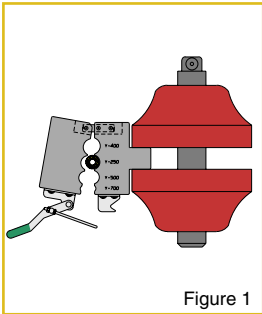


Figure 1

Fitting Preparation

1. Inspect the fitting to ensure no damage occurred during shipment.
2. Ensure the swivel nut is properly crimped, and turns freely.

Assembly

1. Secure the HAC Hose Assembly Clamp in a bench vise by its tab.
2. Insert the hose up through the HAC, leaving enough hose extending up from the clamp to install the appropriate fitting (Figure 1).
3. Pull the lever to close the HAC (Figure 2). **See Reusable or Permanent Fitting Installation Instructions.**

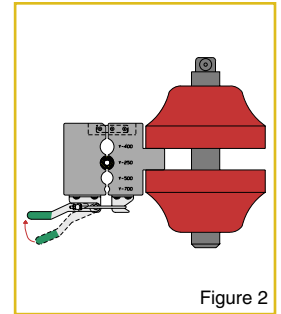


Figure 2

Permanent Fitting Installation

DADCOFLEX™ 90.250 (Y-250), 90.400 (Y-400), & 90.500 (Y-500) Only

1. Lightly tap the fitting onto the hose with a rubber mallet. Ensure the fitting rests snug against the shoulder. The guideline on the outside of the socket indicates the shoulder (Figure 3).
2. Open the HAC, and remove the hose assembly (hose and fitting).
3. The hose assembly is now ready to be crimped. See the hose information below to determine appropriate crimp die and ring.

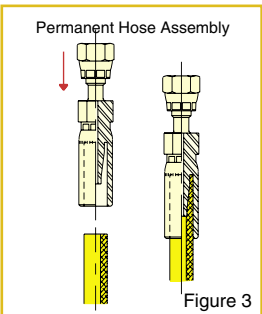


Figure 3

Permanent Fitting Installation

MINIFLEX™ 90.700 (Y-700) Only

1. Screw the ferrul onto the hose. Ensure the hose rests snug against the shoulder.
2. Lightly lubricate the swivel nipple with DADCO's assembly oil.
3. Tap the nipple with a rubber mallet until the hose end bottoms onto the hose (Figure 4).
4. Open the HAC, and remove the hose assembly.
5. The hose assembly is now ready to be crimped. See the hose information below to determine appropriate crimp die and ring.
6. For MINILink™ Systems see bulletin B00109B.

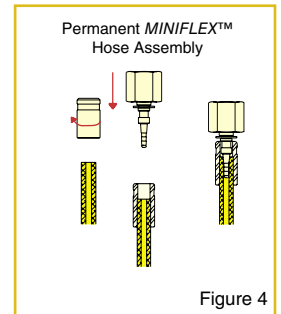


Figure 4

Reusable Fitting Installation

DADCOFLEX™ 90.250 (Y-250) Only

1. Lightly lubricate the OD of the hose end with DADCO's assembly oil.
2. Using a wrench, screw the socket onto the hose counterclockwise, ensuring the end of the hose rests snug up against the inside shoulder. Back off the socket a 1/4 turn clockwise (Figure 5).
4. Remove the HAC and hose assembly from the bench vise.
5. Place the hex portion of the fitting socket into the bench vise. Ensure the socket extends past the vise jaws enough to allow for installation of the nipple.
6. Using DADCO's assembly oil, lubricate the nipple and hose ID.
7. Using a wrench on the nipple hex, screw nipple into socket clockwise until nipple hex rests against socket shoulder (Figure 6). Do not tighten beyond that point.

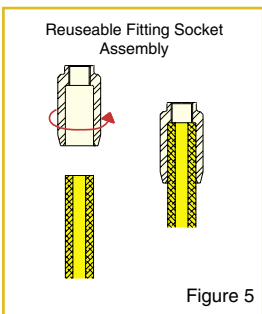


Figure 5

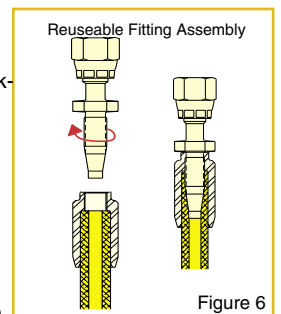


Figure 6

HOSE	CRIMP DIE	RING	CRIMP DIAMETER mm inch
90.250 (Y-250)	80C-P04J RED DIE	82C-R01 RING	13.59 – 14.10 .535 – .555
90.400 (Y-400)	80C-P04 RED DIE	82C-R01 RING	14.22 – 14.73 .560 – .580
90.500 (Y-500)	80C-P03 GRAY DIE	82C-R01 RING	12.19 – 12.70 .480 – .500
90.700 (Y-700)	MINI-CRIMP-90.710.1(MC-1)	NO RING REQUIRED	7.04 – 7.29 .277 – .287