



How to Assemble Type K & KR Hose Fittings

Important Notice - A Mandrel must be used in assembly on fitting series 112,111,101,116 and 118 to prevent hose failure.

The bore of the mandrel permit full-flow, giving the assemblies less restriction. No skiving of the hose is necessary.

Hose fittings for type K & KR Hose are shown pages (3f through 11f). Each fitting Series is given in complete detail, dimensions, and specification tables. The bore of the mandrel fittings permit full flow giving assemblies less restriction No skiving of hose is necessary. All fittings shown pages 3f through 11f may be ordered or separately or in factory made-up assemblies. Mandrel Type Fittings will be used whenever possible unless Non-Mandrel Type Fittings are specified. All the fittings are machined from steel and are zinc plated (RoHS compliant), or special order black phosphate. **These fittings conform to J.I.C. and S.A.E. standards.**

MANDREL ASSEMBLY TOOLS

(Use for Assembling Full Flow Fittings to K or KR Hose)

WHY MANDRELS ARE USED

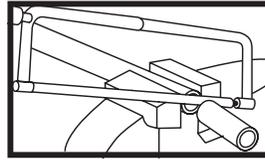
Full flow fittings for type K and KR hose mandrel type assembly tools. These tools when installed in a hose nipple prevent cutting of the hose inner tube. On swivel nut hose nipples, the threads tighten in the nut and provide a way to drive the nipple.

Size 16 and larger does not require mandrels for assembly.

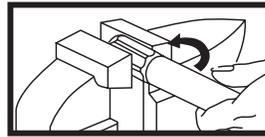


J.I.C MANDRELS (Threaded for 111 Series) PART NO.	S.A.E MANDREL (Threaded for 111 Series) PART NO.
2851-4	2851-4
2851-5	2851-5
3851-6 J.I.C. ONLY	2851-6
2851-8	2851-8
2851-10	2851-10
3851-12 J.I.C. ONLY	2851-12

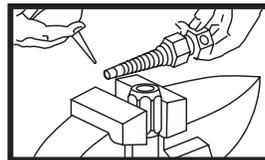
Either of the above types is satisfactory for assembly of the 112 or 116 series fittings, as the thread on the mandrel is not used when assembling these fittings



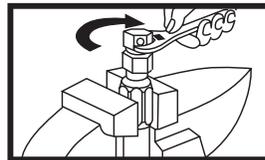
1. Cut hose square to desired length using fine tooth hacksaw or cut-off wheel. Remove any loose particles with wire brush.



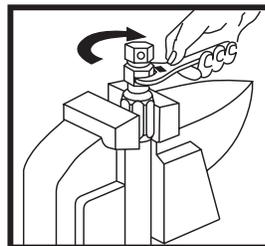
2. Place socket in the vise and screw hose in counter-clockwise. Tighten until hose bottoms, and then back off 1/4 turn.



3. Wrench-tighten nut and nipple on assembly tool. Lubricate inside of hose and nipple threads. Work assembly mandrel in hose to move freely.



4. **Swivel Ends:** Screw nipple clockwise inside socket and hose. Leave 1/32" to 1/16" clearance between nut and socket so nut swivels.



5. **Male Ends:** Screw nipple clockwise into the socket and hose. Tighten nipple snugly against socket.

After assembled, remove mandrel and blow out with air pressure to remove any loose particles and inspect.