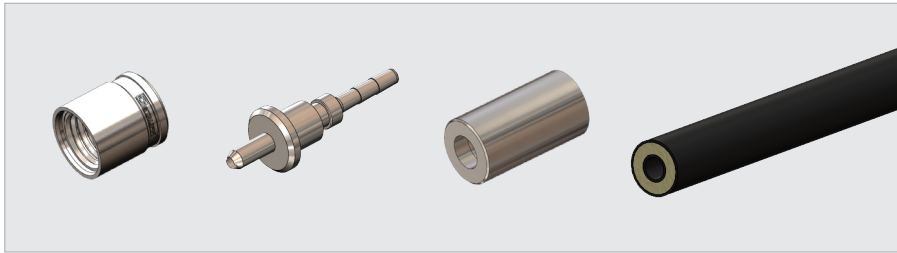


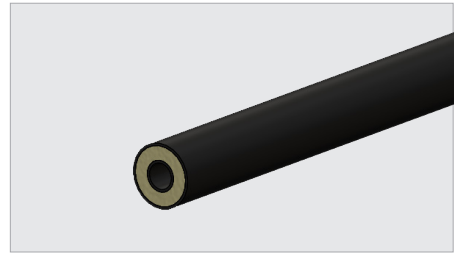
Assembly Instructions for STAUFF Test DN2 and DN4 test hose fittings

1. Select required componentry



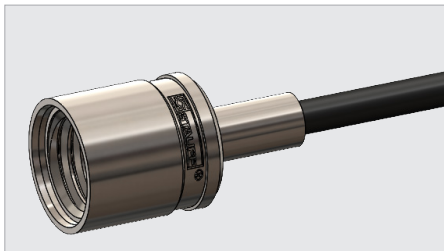
Ensure components are of matched size and appropriate ratings for intended service. Consult Catalogue 7 - STAUFF Test or consult STAUFF if in doubt.

2. Hose Preparation

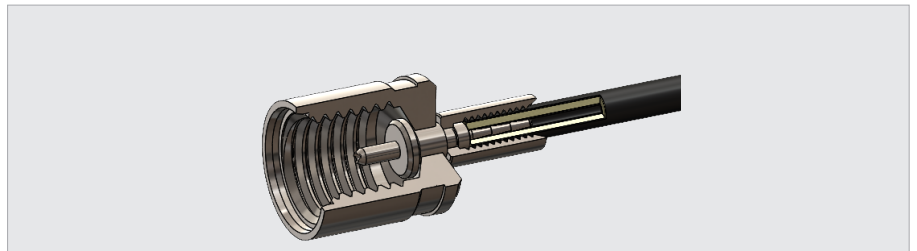


Cut hose to desired length. Ensure hose is cut square and retains a circular profile. Hose end should not be compressed or deformed.

3. Assemble loose components

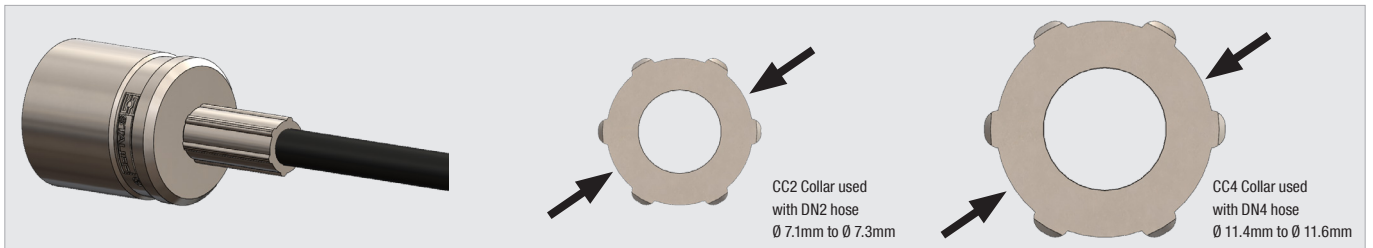


Assemble loose components, ensure to insert collar over hose first.



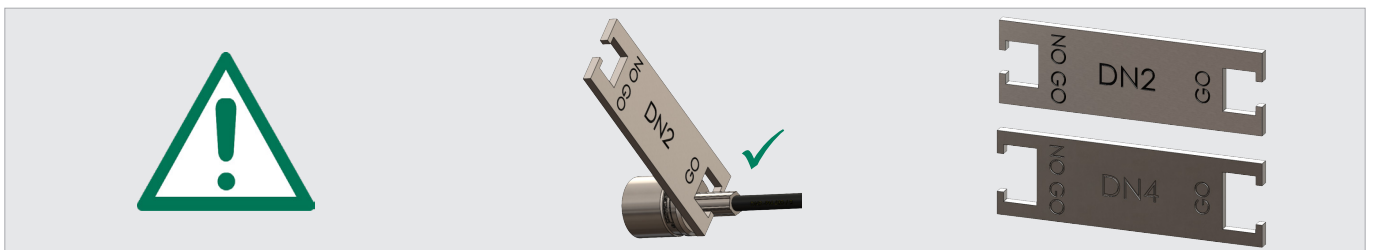
Ensure hose is fully inserted into fitting until it abuts the test fitting insert collar. Ensure insert has properly entered hose without damage to hose bore. Softly blow a stream of air through assembly to ensure that bore is clear.

4. Crimping process



Crimping of assembly is performed using a 6 die swaging press. Measure the final crimp diameters across the flats of the crimped collar. The final crimp diameters should be within values shown in diagram above.

5. Validate Assembly Result - Step 1



CAUTION: Failure to properly assemble Hydraulic Hose can create serious hazards, including unintended release of fluids under high pressure, and possible personal injury or damage to equipment.

STAUFF Corporation recommends STAUFF GO / NO GO gauges for confirmation of crimping process.

Slide GO portion of gauge over complete length of crimp collar flats to prove that crimp is sufficient.

If the NO GO portion of the gauge will fit over crimp collar flats - the crimp is excessive and the assembly must be discarded.

STAUFF GO / NO GO gauges are manufactured from long lasting AISI 316 material and are available for purchase under the following codes:

Item No.	Designation
1230021023	HOSE CRIMP GAUGE DN2 GO/NO GO
1230021024	HOSE CRIMP GAUGE DN4 GO/NO GO

6. Validate Assembly Result - Step 2 - Refer to Page 2 for continued instruction

Assembly Instructions for STAUFF Test DN2 and DN4 test hose fittings continued..
6. Validate Assembly Result - Step 2

Hose Assemblies must be subjected to final inspection according to the following procedures prior to operation.

Test Criteria	Testing interval	Test Equipment	Description	Specification
Hose Length	First piece Then every 25 th piece	Tape Measure	Measure assembly	± 5mm
Crimp Diameter	First piece of order Last piece of order	Calliper gauge	Measure crimp diameter according to step 4	CC2 = $\varnothing 7.2 \pm 0.1$ CC4 = $\varnothing 11.5 \pm 0.1$
Flow	First piece Every 10th piece 100% with elbow fittings	Hose testing station	Visual control	Confirm through flow
Pressure Testing	First piece Every 10th piece 100% with elbow fittings	Hose testing station	Application of test pressure for prescribed times as shown in table Table 5.1 Pressure Table 5.2 Test Duration	No leakage, bursting or bulging
Final Testing	100%		Visual	Crimping meets order spec Label identified and correct

Table 5.1 - Pressure

Hose Designation	Testing Pressure (Bar)
A	630
B	1,000
C	600
Gas hoses	Nitrogen 60 Bar

Table 5.2 - Test Duration

Hose length (L) mm	Time to build pressure seconds	Test duration seconds	Blow through time seconds
L < 800	5	15	10
800 > L < 2,000	6	15	10
2,000 > L < 4,000	7	15	12
L > 4,000	8	15	15