

## 23 Series

### Mandrel Assembly Instructions

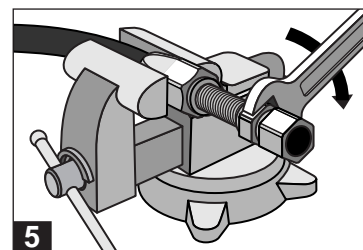
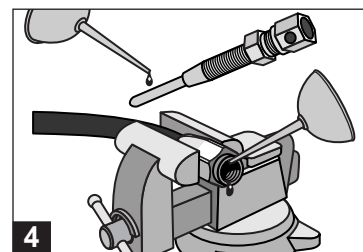
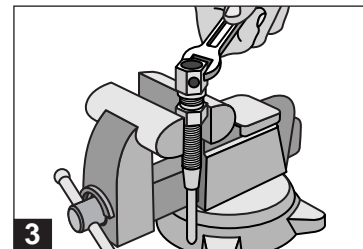
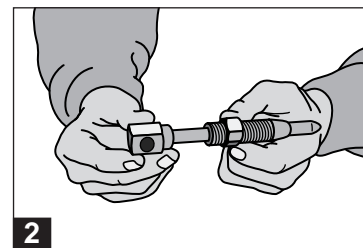
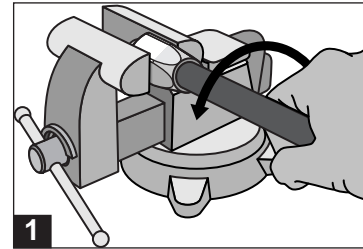
1. Identify over all length (OAL) of hose assembly and the cut off allowance (COA) length of fitting(s) on hose ends by use of the fitting data table. Properly measure, mark and cut hose to desired length using fine tooth hacksaw or a cutoff machine. Care should be taken to ensure a square, clean cut is obtained. Air or solvent flush cut end of hose as necessary to produce a clean hose ID prior to assembly. Place socket in vice and screw in hose counter clockwise until hose bottoms. Back hose out 1/2 turn.
2. When assembling male pipe ends, slide nipple onto mandrel.
3. When assembling swivel ends, slide swivel nut over nipple. Slide nut and nipple onto mandrel. Screw mandrel threads into nipple and wrench tighten.
4. Oil inside of hose and nipple threads liberally with Hoze-Oil. (See Section C). Do not oil hose cover.
5. Push nipple into socket.
  - Male ends: Thread nipple in until it bottoms against socket.
  - Swivel ends: Apply wrench to hex of assembly mandrel. Thread nipple clockwise into socket until clearance between nut and socket is approximately 1/32" (.794mm) to allow nut to swivel.**Remove mandrel.**

**Note:** Disassemble in reverse order.

**Caution: Do Not Attempt to Assemble These Fittings to the Hose Without Using a Mandrel.**

**Inspection.** Examine hose assembly internally for cut or bulged tube, obstructions and cleanliness. Clean ID of hose as necessary. Swivel nuts should turn freely. Check the layline of the hose to be sure the assembly is not twisted. Cap the ends of the assembly to keep clean.

**Special Instructions for Refrigerant Hose.** Oil inside of hose and nipple threads liberally with the same oil used in refrigeration system. Do not oil hose cover. Do not allow hose to contact any petroleum base fluids.



Hose  
**A**

Fittings  
23 Series  
**B**

Equipment  
**C**

Accessories  
**D**

Technical  
**E**