

**4** INSPECT HOSE

HYBRID & THERMOPLASTIC



Visually inspect both ends of hose for squareness.. Remove any burrs on core tube with a sharp knife.

GPH HOSES



Visually inspect both ends of hose. Ensure end of hose is cut squarely, has no loose or frayed reinforcement and core tube is not damaged. Trim hose as required.

PTFE HOSES



Visually inspect both ends of hose for squareness, loose wires and burrs on core tube. Trim any loose wires flush with tube and remove any burrs on tube with a sharp knife.

**SQ SWAGER ASSEMBLY:**

For swaged Predator Hose assemblies using the SQ-101 swager, please proceed to page 251.

**5** INSPECT FITTINGS



Verify fitting part number(s) match work order.

Visually inspect fitting(s) for a through-hole, threads and damage.



Verify fitting and ferrule part number(s) match work order.



Verify fitting part number(s) match work order. Visually inspect fitting(s) for a through-hole, threads and damage.

**PTFE FIELD ATTACHABLES:**

For further instruction on PTFE 90 Series Field Attachable assembly, please proceed to page 246 for steps 6 - 25.

**HYD. FIELD ATTACHABLES:**

For further instruction on Hydraulic Field Attachable assembly, please proceed to page 244 for steps 6 - 14.

**6** ASSEMBLE HOSE



Mark hose end with proper insertion depth line as follows:

Place fitting next to hose and align annular crosshatched ring on fitting with end of hose.

**GPH HOSES:**

Please proceed to page 240 for continued instruction.



Mark hose end with proper insertion depth line. For 919U hoses, use a sharp knife and light pressure to cut back the urethane cover at least the length of the insertion depth of the fitting.

**WARNING:**

Do not use lubricating oil when installing fittings on hose used in oxygen service. When installing fittings on hose used in oxygen service lubricate with a non-oil based soap solution. Failure to do so may result in an explosion and personal injury when hose is used.