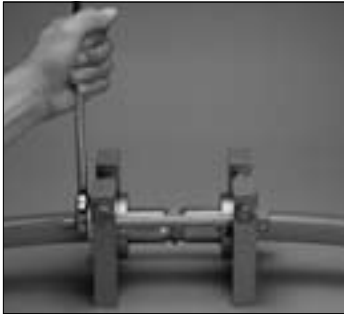


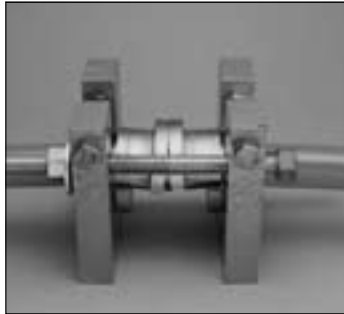
SEWER HOSE

17 ASSEMBLE HOSE



Align swager plates in parallel and tighten nuts on swaging bolts uniformly until dies touch.

18 ASSEMBLE HOSE



Loosen swaging bolts to release pressure on dies.

19 ASSEMBLE HOSE



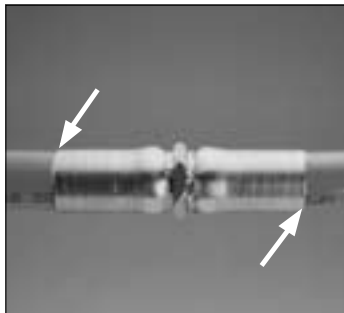
Remove die securing bolts and nuts, and remove dies.

20 ASSEMBLE HOSE



Lift out hose assembly.

21 MEASURE & INSPECT



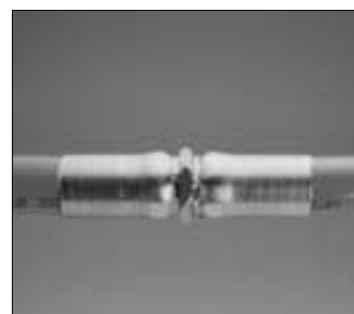
Inspect depth insertion mark at fitting ends. Insertion mark must be visible and within 1/8" of bottom of fitting shell.

22 MEASURE & INSPECT



Measure swage diameter of each end of fitting at top, middle and bottom of shell. Take measurements at a minimum of three places around shell circumference. Verify swage diameter is within tolerances. (Refer to Swage Specification & Tool Selection Chart for proper swage diameters.)

23 MEASURE & INSPECT



Pressure test hose if required.

SWAGER TOOLING

Part Number	Description
SQ-101-SW	Swager/Mender
SQ-101-12S6/S9	Size S612/S912 die
SQ-101-16S6	Size S616 die
SQ-101-16S9	Size S916 die
SQ-101-20S6	Size 20 die
SQ-101-12P	Size 12 pusher
SQ-101-16P	Size 16 pusher
SQ-101-20P	Size 20 pusher

S624, HFS212 & HFS216 cannot be swage mended.