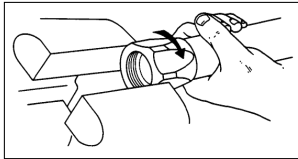


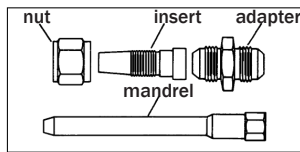
How to Assemble Rubber Hose Assemblies

Low & Medium Pressure Straight Fittings

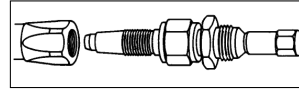
Low pressure MS27404 fittings with MIL-DTL-5593 hose. Medium pressure MS24587 fittings with MIL-DTL-8794 hose.



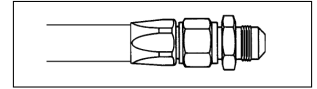
1. After cutting hose squarely to proper length (**DO NOT remove cover**), screw hose into socket (*left hand thread*) until it bottoms. Back out hose $\frac{1}{4}$ turn.



2. Assemble insert and nut on adapter and slide onto mandrel. Tighten nut until assembly is rigid, (sizes 16 and over do not require a mandrel).



3. Lubricate hose ID and the insert of the sub-assembly (*step 2*) with lubricating oil or light grease.

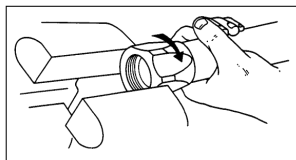


4. Screw sub-assembly (*step 2*) into hose and socket (*step 1*). Leave $\frac{1}{16}$ inch clearance so nut is free to swivel.

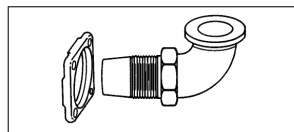
Clean, Inspect and Test. Clean the hose assembly by blowing out with air. Inspect the hose by looking through the assembly for any possible obstructions or foreign matter. Pressure test at proof pressure, see *Aerospace Catalog page 12 or 14*, as applicable.

Medium Pressure Elbow Fittings

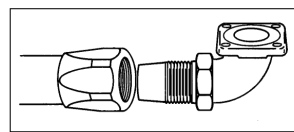
For use with MIL-DTL-8794 hose.



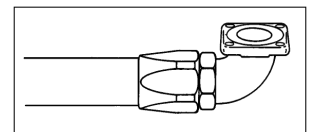
1. After cutting hose squarely to proper length with hacksaw or cutting wheel (**DO NOT remove cover**), screw hose into socket (*left hand thread*) until it bottoms. Back out hose $\frac{1}{4}$ turn.



2. **Flange Type Ends Only.** Assemble flange over threaded end of insert. Insert shoulder must seat in counter bore of flange. **Note:** Step 2 not required for flared/flareless fittings.



3. Lubricate hose ID and the insert threads with lubricating oil or light grease.

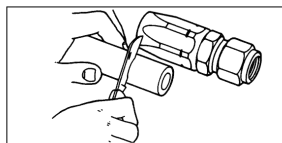


4. Using hex on elbows, screw insert sub-assembly into hose and socket (*step 1*) until insert hex bottoms against socket. **Note:** On size -32 screw insert into hose and socket until binding occurs. Unscrew and re-lubricate and continue screwing until insert bottoms against socket.

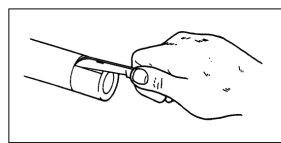
Clean and Test. Clean hose assembly by blowing out with air. Pressure test at proof pressure, see *Aerospace Catalog page 14*.

High Pressure All Fittings

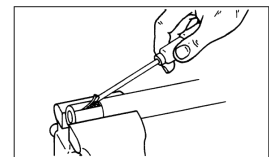
For use with MIL-DTL-8788 hose.



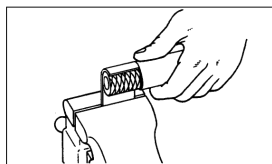
1. Cut hose squarely to proper length with hacksaw or cutting wheel. Match end of hose with notch in hex of socket, measuring back from end of hose the same distance. Cut around hose through cover to wire braid, away from notch in socket.



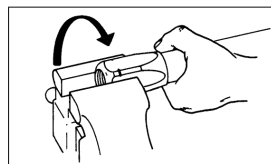
2. Cut lengthwise from cut (*step 1*) to end of hose.



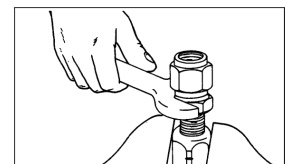
3. Pry up the cover at intersection of the two (2) cuts with a screw driver.



4. Strip off the cover with pliers or vise.



5. Screw the hose into the socket (*left hand thread*) until the hose bottoms. Back out hose $\frac{1}{4}$ turn.



6. Lubricate insert and hose ID with oil. Insert is then threaded into socket and hose until the hex of the insert just touches the socket.

Clean and Test. Clean hose assembly by blowing out with air. Pressure test at proof pressure, see *Aerospace Catalog page 19*.