Linking Nitrogen Gas Springs

Constructing a SEAL-LOK Hose Assembly

Hose Assembly Construction Tools

Mini Hose Cutter
90.320.7

Hose Assembly Clamp
90.320.6 (HAC)

Hose Assembly Construction

Hose Preparation
1. Measure hose.
2. Cut hose to appropriate length using the 90.320.7 Hose Cutter (a sharp knife can also be used).
   It is important to use a sharp edge, because a clean cut is necessary.
3. No burrs should be present if a clean cut was made. However, if burrs are present remove them with a sharp knife.

Fitting Preparation
1. Inspect the fitting to ensure no damage occurred during shipment.
2. Ensure the swivel nut is properly crimped, and turns freely.

Assembly
1. Secure the 90.320.6 Hose Assembly Clamp in a bench vise by its tab.
2. Insert the hose up through the 90.320.6, leaving enough hose extending up from the clamp to install the appropriate fitting (F.1).
3. Pull the lever to close the 90.320.6 (F.2). See Reusable or Permanent Fitting Installation Instructions.

Permanent Fitting Installation
DADCOflex 90.250 (Y-250), 90.400 (Y-400), & 90.500 (Y-500) Only
1. Lightly tap the fitting onto the hose with a rubber mallet. Ensure the fitting rests snug against the shoulder. The guideline on the outside of the socket indicates the shoulder (F.3).
2. Open the HAC, and remove the hose assembly (hose and fitting).
3. The hose assembly is now ready to be crimped. See the hose information below to determine appropriate crimp die and ring.

Permanent Fitting Installation
MINIFLEX® 90.700 (Y-700) & 90.705 (Y-705) Only
For use with 90.504.943, 90.504.954 and 90.504.959 hose adapters. For MINILink® Systems refer to bulletin B11110B.
1. Screw the ferrule onto the hose. Ensure the hose rests snug against the shoulder. The guideline on the outside of the socket indicates the shoulder (F.3).
2. Open the HAC, and remove the hose assembly (hose and fitting).
3. The hose assembly is now ready to be crimped. See the hose information below to determine appropriate crimp die and ring.

NOTE: 90.700 (Y-700) hose assemblies with 90° hose adapters on each end must be crimped at the factory.

Reusable Fitting Installation
DADCOflex 90.250 (Y-250) Only
1. Lightly lubricate the OD of the hose end with DADCOflex's assembly oil.
2. Using a wrench, screw the socket onto the hose counterclockwise, ensuring the end of the hose rests snug up against the inside shoulder. Back off the socket 1/4 turn clockwise (F.5).
3. Remove the 90.320.6 and hose assembly from the bench vise.
4. Place the hex portion of the fitting socket into the bench vise. Ensure the socket extends past the vise jaws enough to allow for installation of the nipple.
5. Using DADCOflex's assembly oil, lubricate the nipple and hose ID.
6. Using a wrench on the nipple hex, screw nipple into socket clockwise until nipple hex rests against socket shoulder (F.6). Do not tighten beyond that point.

<table>
<thead>
<tr>
<th>Part No.</th>
<th>Crimp Die</th>
<th>Ring</th>
<th>Crimp Diameter (mm/inch)</th>
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</thead>
<tbody>
<tr>
<td>90.700 (Y-700)</td>
<td>Mini-Crimp - 90.710.8</td>
<td>No Ring Required</td>
<td>7.00 - 7.25 / .276 - .285</td>
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<tr>
<td>90.705 (Y-705)</td>
<td>Mini-Crimp - 90.710.8</td>
<td>No Ring Required</td>
<td>7.00 - 7.25 / .276 - .285</td>
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<td>90.500 (Y-500)</td>
<td>80C-P03 Gray Die</td>
<td>82C-R01 Ring</td>
<td>12.19 - 12.70 / .480 - .500</td>
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<td>90.400 (Y-400)</td>
<td>80C-P04 Red Die</td>
<td>82C-R01 Ring</td>
<td>14.22 - 14.73 / .560 - .580</td>
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<tr>
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<td>80C-P04J Red Die</td>
<td>82C-R01 Ring</td>
<td>13.59 - 14.10 / .535 - .555</td>
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