Linking Nitrogen Gas Springs

Constructing a SEAL-LOK Hose Assembly

Hose Assembly Construction Tools

Hose Cutter
HC-11

Hose Assembly Clamp
HAC

Hose Assembly Construction

Hose Preparation
1. Measure hose.
2. Cut hose to appropriate length using the HC-11 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 HAC Hose Assembly Clamp in a bench vise by its tab.
2. Insert the hose up through the HAC, leaving enough hose extending up from the clamp to install the appropriate fitting (Figure 1).
3. Pull the lever to close the HAC (Figure 2).
4. Open the HAC, and remove the hose assembly.

Permanent Fitting Installation
MINIFLEX™ 90.700 (Y-700) 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 (Figure 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.

Reusable Fitting Installation
DADCOCLEX™ 90.250 (Y-250) Only
1. Lightly lubricate the OD of the hose end with DADCO’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 a 1/4 turn clockwise (Figure 5).
3. 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.
4. Using DADCO’s assembly oil, lubricate the nipple and hose ID.
5. Using a wrench on the nipple hex, screw nipple into socket clockwise until nipple hex rests against socket shoulder (Figure 6). Do not tighten beyond that point.

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For MINILink™ Systems see bulletin B00109B.