

Assembling Twin Tough Rubber Hose

Required Equipment:

Twin Tough hose, fittings, knife, tape measure, heat shrink sleeve, scissors, grease pencil, heat gun, and calipers.



Hose
A

Fittings
B

Parkrimp
Equipment
C

Accessories
D

Technical
E

Set-up:

Position the bonded rubber hose so that it lies flat on a work surface with out tendency to twist or turn.

Measure hose tear back length: Measure and mark the length that the hoses are to be separated. A minimum of 12 inches is required for crimping the hose ends. An 18 inch tear back is recommended for use with hydraulic tools.



Note: If length of separation/tear back is specified from the threaded or swivel nut end of the coupling, then deduct the cut off allowance dimension for the specific style of coupling used. The cutoff allowance can be obtained from the hose fitting tables in the 4400 Catalog "B" dimension, or can be calculated by subtracting the insertion depth of the shell from the overall coupling length.

Cut hose tear back to length:

Press the bonded hose assembly firmly and flat against the work surface with your free hand so that it does not move.

A.) Using a sharp blade, line up the center of the valley (web) formed by the hoses.



B.) To start the cut, place the blade in the center of that valley (web) drawing the knife toward you with constant pressure.



C.) Once you have a 1 to 2 inch starter cut, firmly pull each hose end apart to your required separation length.



Note: It is important that the knife blade be perpendicular to the hose during this procedure so the blade cuts only the centerline of the valley (web). **EXTREME CARE MUST BE TAKEN TO AVOID CUTTING THROUGH THE COVER OF THE HOSES AND THEREBY EXPOSING THE HOSE REINFORCEMENT.** If this occurs, the hose assembly must be discarded.