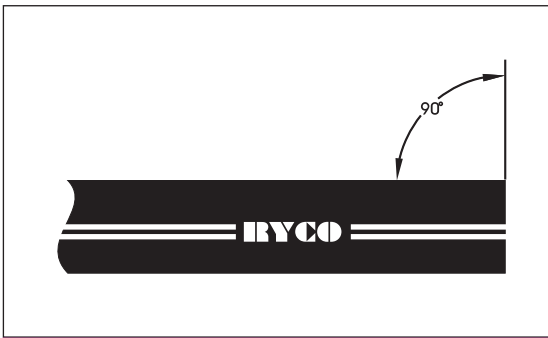


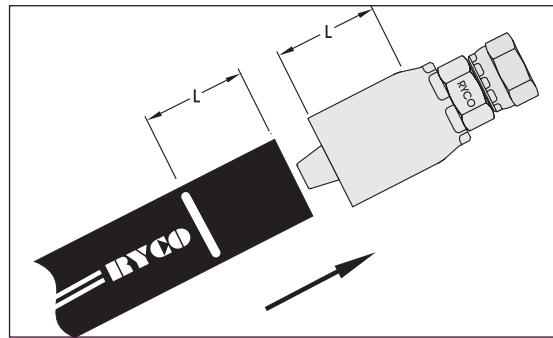
ASSEMBLY INSTRUCTIONS FOR:

1. RYCO BITELOK T200, T700 and T900 SERIES COUPLINGS WITH RYCO NON-SKIVE HOSE. USE ONLY RYCO T1A, T2A, T1D, T2D, TXA2D, TJ2D, T2S, DF2A, RQP1, RQP2, H12A, H12D, H12S, H13A, H13D, H13S, HSPA (SOME), and HSHA SERIES HOSE.
 2. RYCO BITELOK T400 SERIES COUPLINGS WITH RYCO NON-SKIVE HOSE. USE ONLY RYCO M2, MP1, RQP5, RT7, RT7N, RT7T, RT7TN, SR and T5 SERIES HOSE.
- (See page 331 for Additional Instructions for Separating of Ends of RT7T and RT7TN Series.)



STEP ONE

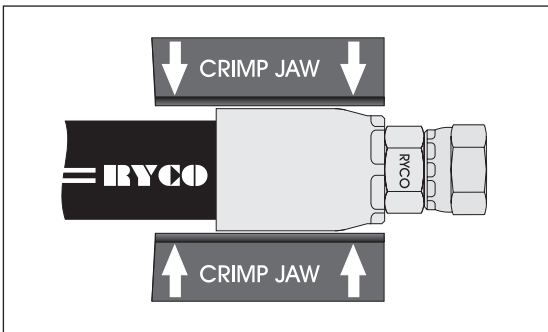
Cut hose to required length using a cut-off saw. Ensure hose is cut squarely. Clean hose bore.



STEP TWO

Mark the Mark Length onto the hose (Mark Length dimension from "RYCO Crimp Chart"). Push hose into the fitting (lubricate the hose bore if necessary) until the mark on the hose is even with the end of the ferrule.

Note: Push the hose all the way into the fitting.

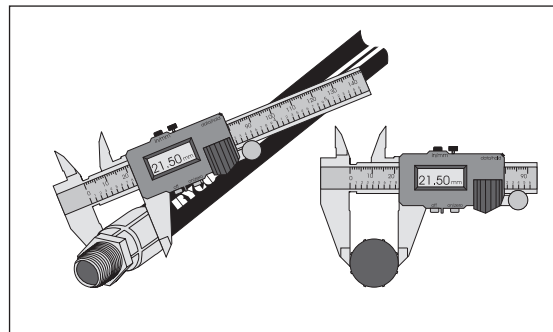


STEP THREE

Place assembled end into the jaws of the crimp machine. Operate the machine to crimp the ferrule to the predetermined diameter. (Refer to "RYCO Crimp Chart").

Note:

Extra special care must be exercised in the preparation, assembly and crimping of these fittings due to the very high pressures and end loads encountered.



STEP FOUR

Open the crimp machine and remove the assembly. Check the crimp diameter with a caliper or micrometer. Crimp diameter should be measured halfway along ferrule. Measure between the ridges, and make sure that the caliper fingers do not touch the ridges. Check that the Mark Length mark is still even with the end of the ferrule to ensure coupling has not moved during crimping.

RYCO Crimp Chart detailing Mark or Skive Length and Crimp Diameter is available from RYCO hydraulics.

HOW TO ORDER BITELOK NON-SKIVE HOSE COUPLINGS

The RYCO Bitelok Non-Skive Coupling is a one piece fitting. Bitelok Non-Skive Couplings do not require the hose to be skived externally or internally. As the Bitelok Non-Skive Coupling is a complete coupling, simply order it by Part No.