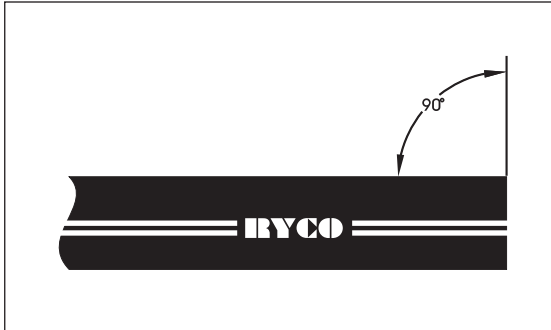


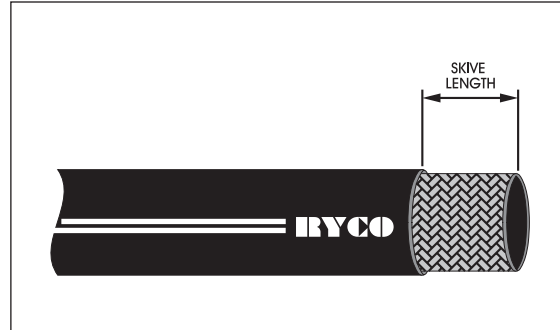
## ASSEMBLY INSTRUCTIONS FOR:

**RYCO BITELOK T200 and T700 SERIES COUPLINGS WITH RYCO SKIVE HOSE.**  
**USE ONLY RYCO AS1D, AS2D, AJ2D, TW1, PW2 and HSPA (SOME) SERIES HOSE.**



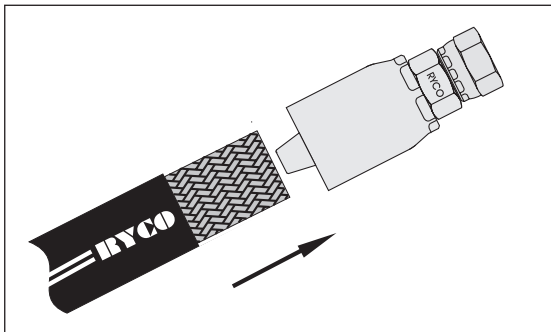
### STEP ONE

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



### STEP TWO

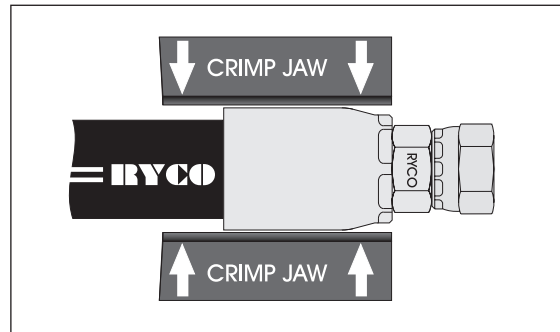
Mark skive length.  
 (Refer to "RYCO Crimp Chart").  
 Cut rubber cover around and down to wire reinforcement.  
 Slit lengthwise. Raise flap and pull off with pliers.



### STEP THREE

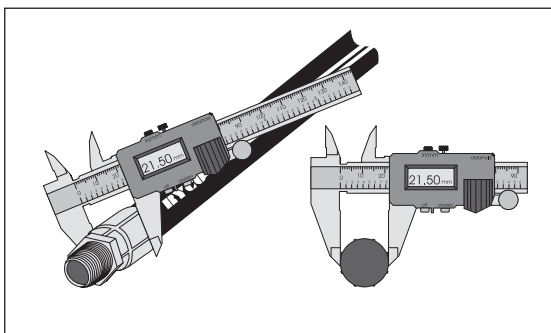
Push hose into fitting (lubricate hose bore if necessary) until the end of the ferrule completely covers the skived part of the hose.

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



### STEP FOUR

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



### STEP FIVE

Open crimp machine and remove assembly.  
 Check crimp diameter with caliper or micrometer.  
 Crimp diameter should be measured halfway along the ferrule.

Measure between the ridges, and make sure that the caliper fingers do not touch the ridges.  
 Check that the ferrule still completely covers the skived part of the hose to ensure coupling has not moved during crimping.

### 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.**

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