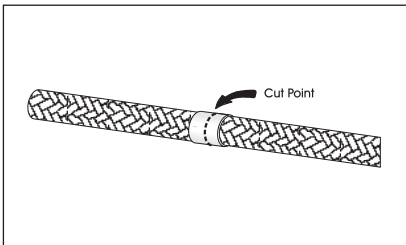


## ASSEMBLY INSTRUCTIONS FOR:

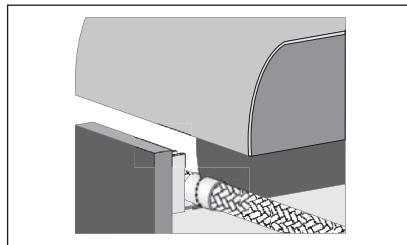
**1RT200 SERIES TWO PIECE COUPLINGS. USE ONLY RYCO RTH1 SERIES HOSE.**

**7RT200-03 TWO PIECE COUPLINGS. USE ONLY RYCO RT73 HOSE.**



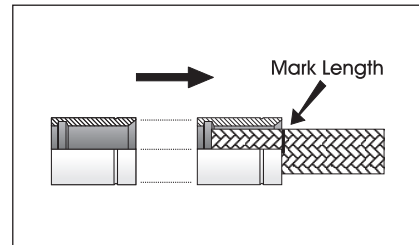
### STEP ONE

**RTH1:** Tape with masking tape at the cut position to prevent wire braid flaring.  
**RT73:** Step 1 is not required for RT73 Hose.



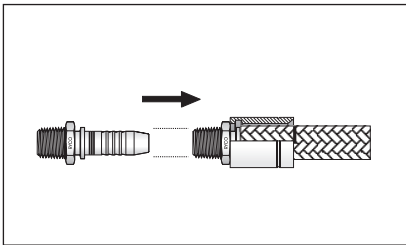
### STEP TWO

Cut hose to length. Ensure hose is cut squarely. Clean hose bore.  
**WARNING:** Do not smoke in the vicinity when cutting **RTH1** because fumes created may mix with smoke and can become toxic.  
**NOTE:** **RT73** may be cut to length with a sharp knife.



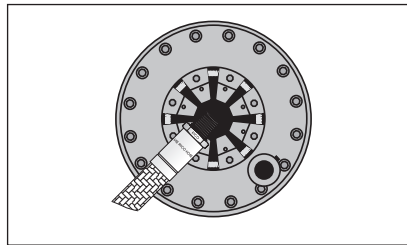
### STEP THREE

Refer to "RYCO Crimp Chart" for Mark Length of Ferrule.  
 Mark outer cover with Mark Length. Slide ferrule onto hose. Chamfered inside edge of 1RT200 ferrule assists feeding RTH1 braid into ferrule.



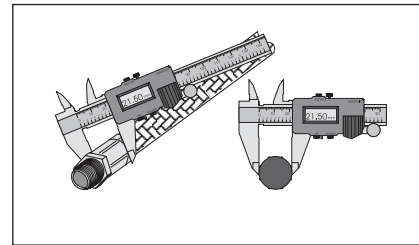
### STEP FOUR

Push insert all the way into hose. Hose tube must abut shoulder collar of insert. End of ferrule must abut back of hex of fitting. Other end of ferrule must be in line with "Mark Length" mark.



### STEP FIVE

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

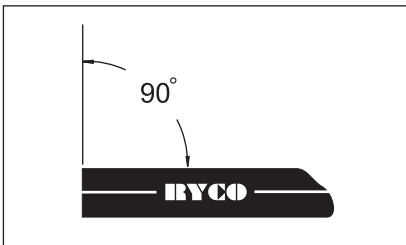


### STEP SIX

Check that ferrule has not moved during crimping and that it has locked over shoulder collar. Check that full length of ferrule has been crimped. 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 ridges.

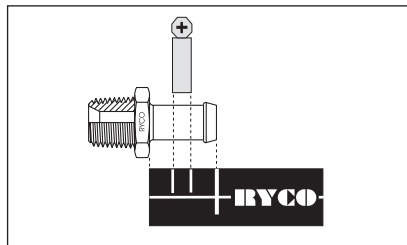
## ASSEMBLY INSTRUCTIONS FOR:

**3300 SERIES SERIES SUCTION HOSE COUPLINGS. USE ONLY RYCO SR SERIES HOSE.**



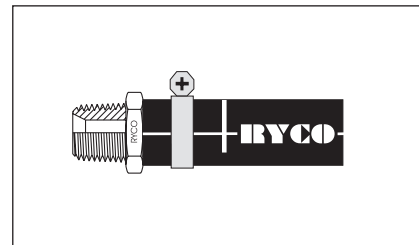
### STEP ONE

Cut hose to required length using cut-off saw. Ensure helix wires are not protruding. Ensure hose is cut squarely.



### STEP TWO

Mark the cover of the hose to ensure that Clamp will be correctly located.



### STEP THREE

Slide Clamp over hose. Push the coupling into the hose bore until hex or collar abuts end of hose. Position Clamp, and tighten bolt to recommended torque.