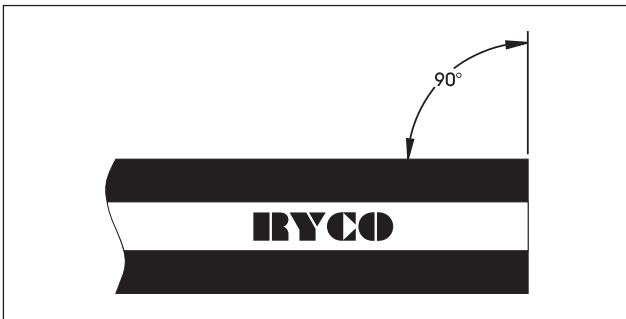


ASSEMBLY INSTRUCTIONS FOR:

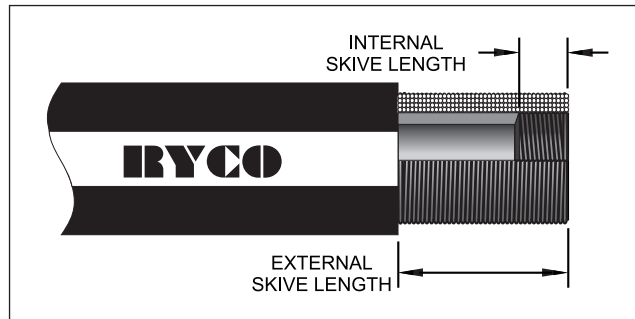
6900N SERIES BITELOK INTERLOK TWO PIECE INTERNAL AND EXTERNAL SKIVE COUPLINGS. USE ONLY RYCO H15D SERIES HOSE.

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



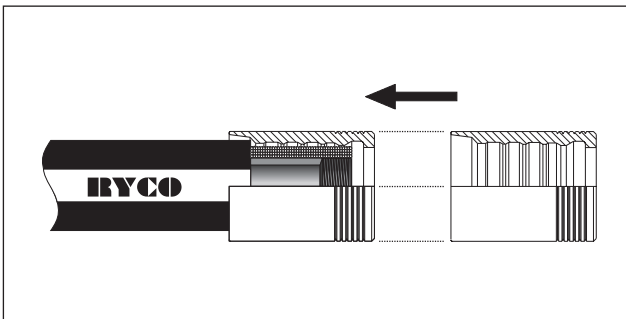
STEP ONE

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



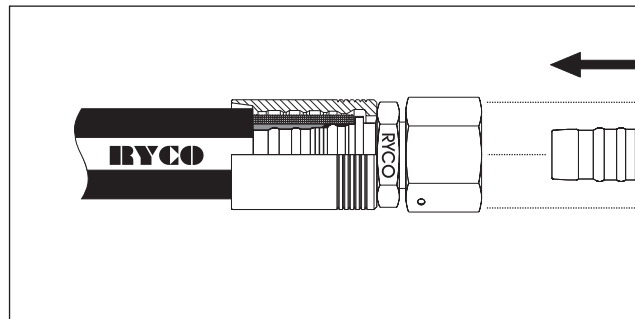
STEP TWO

Use RYCO Internal and External Skive Tool to skive the cover and the tube. Check that External Skive length is correct. Check that Internal Skive length is correct. (Refer to "RYCO Crimp Chart"). Clean hose bore, and skived area of cover.



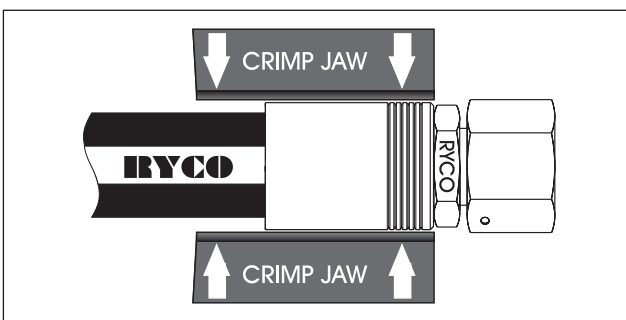
STEP THREE

Mount ferrule onto hose.



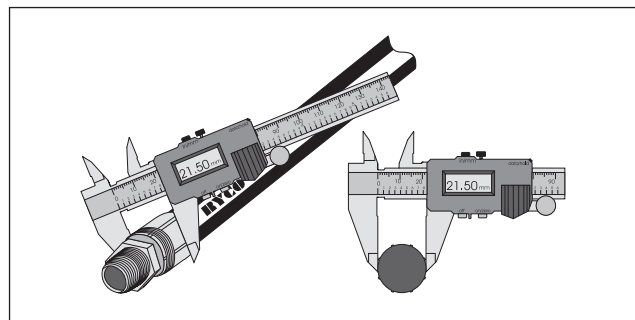
STEP FOUR

Push hose tail of fitting into the hose bore (lubricate hose bore if necessary). The raised collar on the hose tail must abut the end of the hose. Ensure that the locking collar of the ferrule is aligned with and will lock into the collar on the hose tail. Check that the ferrule completely covers the skived part of the hose cover.



STEP FIVE

Place assembled end into jaws of crimp machine. Operate machine to crimp ferrule to predetermined diameter. (Refer to "RYCO Crimp Chart"). Open crimp machine and remove assembly. Ensure that the locking collar of the ferrule is locked into the collar on the hose tail.



STEP SIX

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 cover to ensure coupling has not moved during crimping.

RYCO Crimp Chart detailing Internal and External Skive Length and Crimp Diameter is available from RYCO hydraulics.