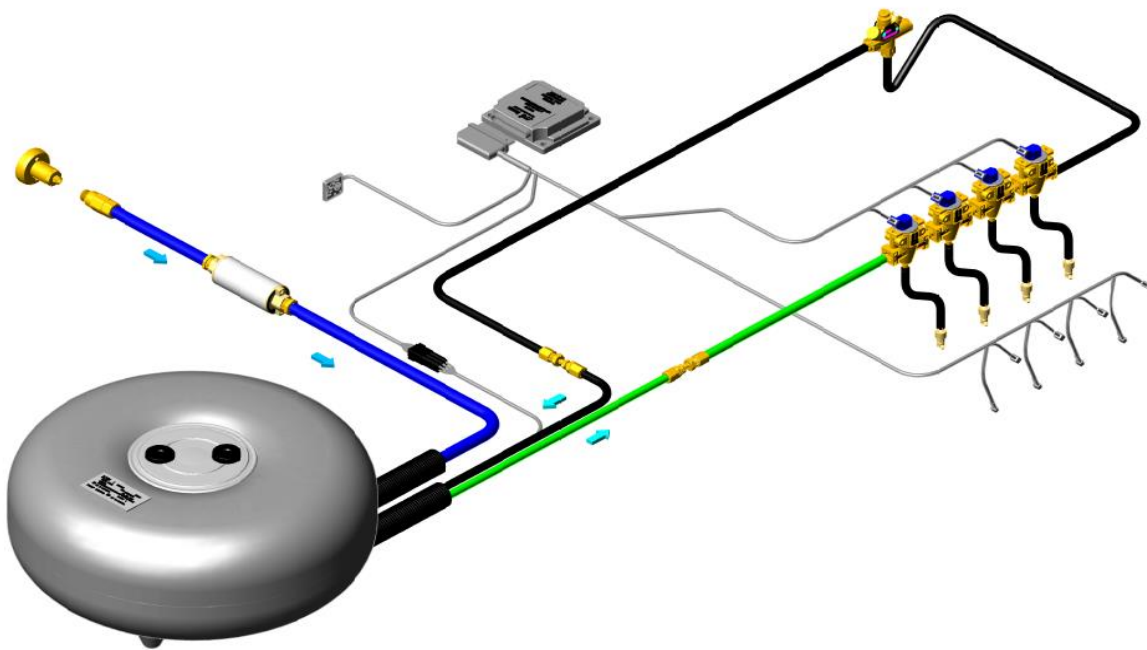
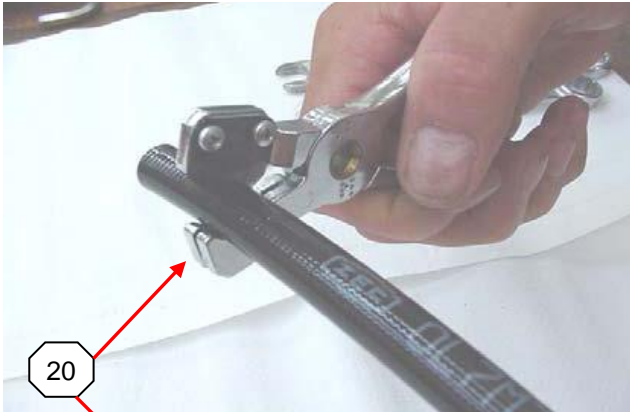




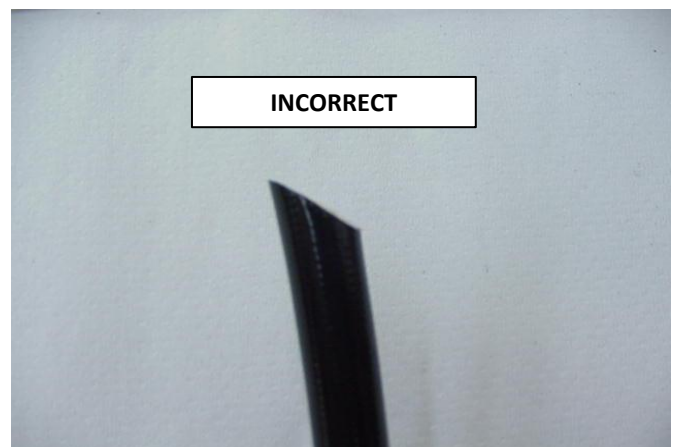
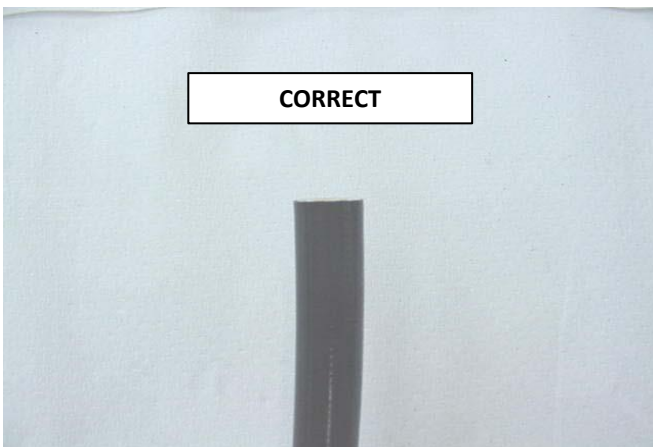
ICOM FIELD ATTACHABLE FITTING ASSEMBLY INSTRUCTIONS



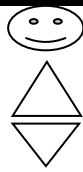
P11X-9203-AD
Revision: D - Dated 5/25/17
Replaces: C - Dated 5/11/12



20) USING THE APPROPRIATE HOSE CUTTER, CUT THE END OF THE HOSE TO THE DESIRED LENGTH.



ITEM	PART NUMBER	QTY	DESCRIPTION	TORQUE		TOOLS	
						STANDARD HOSE CUTTER	
						STEEL BRAID HOSE CUTTER	
						PROCESS NAME	
						FIELD ATTACHABLE FITTING ASSEMBLY INSTRUCTIONS	
						REV	D
						PROCESS NUMBER	
						PAGE	
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						2 OF 8	



INSPECTION
TORQUE
CRITICAL PROCESS



ITEM NUMBER



OPERATION

STEEL BRAIDED HOSE ONLY

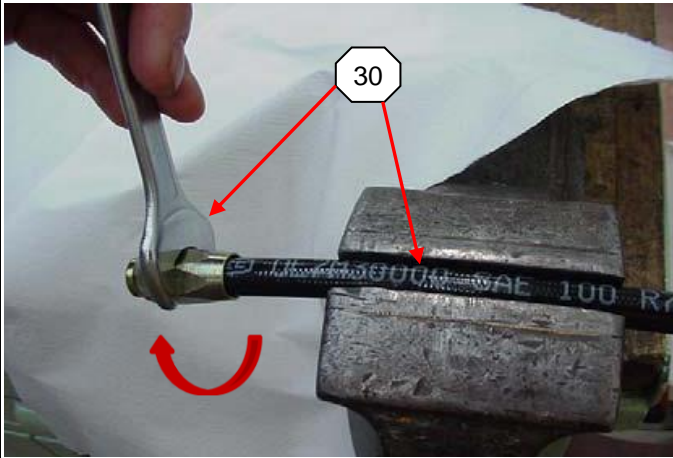


25) USING A PAIR OF PLIERS, CAREFULLY REFORM THE END OF THE HOSE BACK TO IT'S ORIGINAL STATE AFTER THE CUT IS MADE.



26) OBTAIN A FITTING CORRESPONDING TO THE HOSE SIZE; INSERT THE HOSE END OF THE FITTING INTO THE END OF THE HOSE AS SHOWN TO REFORM THE INTERNAL PORTION OF THE HOSE.

ITEM	PART NUMBER	QTY	DESCRIPTION	TORQUE	TOOLS
REF	390320	1	3/16" FIELD ATTACHABLE STRAIGHT FITTING		PLIERS
REF	390390	1	3/16" FIELD ATTACHABLE 90° FITTING		
REF	390420	1	1/4" FIELD ATTACHABLE STRAIGHT FITTING		
REF	390490	1	1/4" FIELD ATTACHABLE 90° FITTING		
REF	390820	1	3/8" FIELD ATTACHABLE STRAIGHT FITTING		
REF	390890	1	3/8" FIELD ATTACHABLE 90° FITTING		
				PROCESS NAME	
				FIELD ATTACHABLE FITTING ASSEMBLY INSTRUCTIONS	
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				PROCESS NUMBER	
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30) PLACE THE HOSE INTO A BENCH VISE AS SHOWN.

APPLY A THIN COAT OF LUBRICANT (GREASE) TO THE OUTER HOSE COVER WHERE THE FERRULE IS TO BE INSTALLED.

INSTALL THE FERRULE ONTO THE END OF THE HOSE BY ROTATING THE FERRULE 'COUNTER CLOCKWISE' WITH AN OPEN END WRENCH; THE INSTALLATION SHOULD BE CONSISTANT WITHOUT EXCESSIVE FORCE.

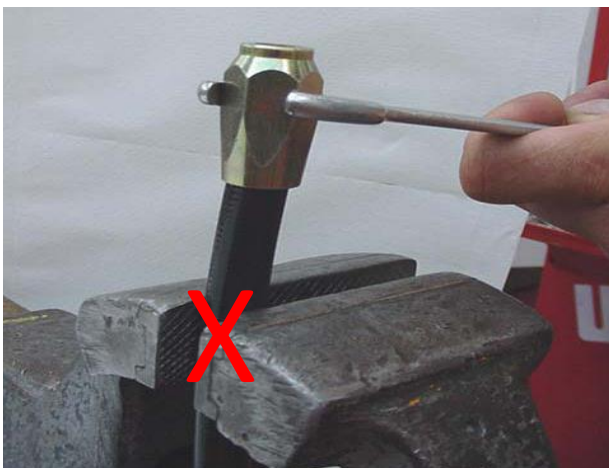


INCORRECT

DO NOT USE HAND TOOLS TO CLAMP HOSE.

THE HOSE WILL BECOME OVALIZED.

THE FERRULE COULD BE SCREWED ON INCORRECTLY, NOT PARALLEL TO THE HOSE.



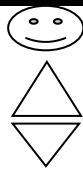
INCORRECT

DO NOT CLAMP THE HOSE INTO THE BENCH VISE AS SHOWN.

THE HOSE WILL BECOME OVALIZED.

THE FERRULE COULD BE SCREWED ON INCORRECTLY, NOT PARALLEL TO THE HOSE.

ITEM	PART NUMBER	QTY	DESCRIPTION	TORQUE	TOOLS
REF	390320	1	3/16" FIELD ATTACHABLE STRAIGHT FITTING		WRENCH
REF	390390	1	3/16" FIELD ATTACHABLE 90° FITTING		LUBRICANT (GREASE)
REF	390420	1	1/4" FIELD ATTACHABLE STRAIGHT FITTING		
REF	390490	1	1/4" FIELD ATTACHABLE 90° FITTING		
REF	390820	1	3/8" FIELD ATTACHABLE STRAIGHT FITTING		
REF	390890	1	3/8" FIELD ATTACHABLE 90° FITTING		
				PROCESS NAME	
				FIELD ATTACHABLE FITTING ASSEMBLY INSTRUCTIONS	
				REV	
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				PROCESS NUMBER	
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INSPECTION

TORQUE

CRITICAL PROCESS

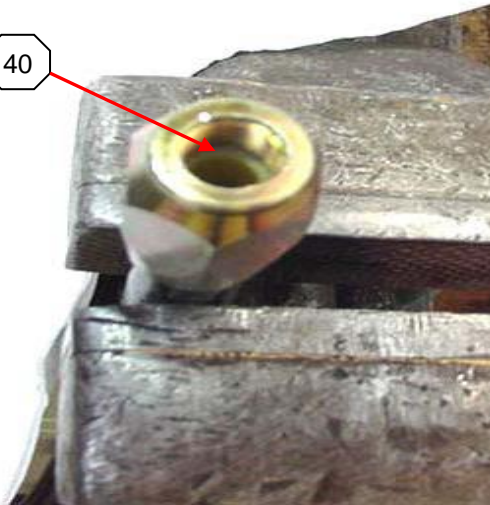


ITEM NUMBER



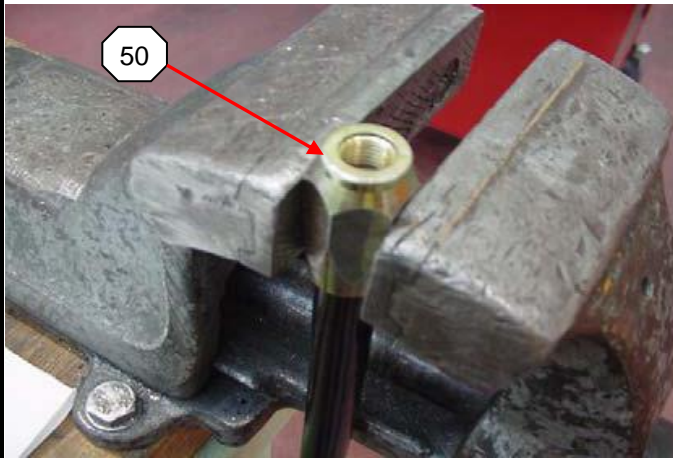
OPERATION

40



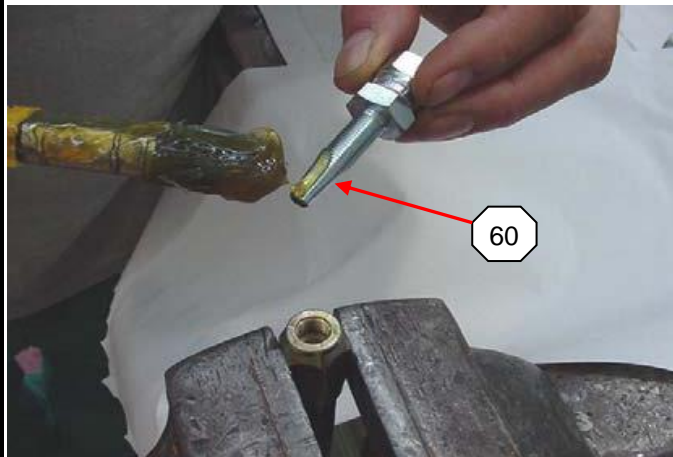
40) ROTATE THE FERRULE ONTO THE HOSE UNTIL THE HOSE REACHES THE COUNTERBORING OF THE FERRULE AS SHOWN.

50



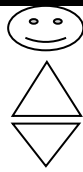
50) INSERT AND TIGHTEN THE FERRULE INTO THE BENCH VISE AS SHOWN.

60



60) LUBRICATE THE HOSE END OF THE FITTING WITH A SMALL AMOUNT OF GREASE AS SHOWN.

ITEM	PART NUMBER	QTY	DESCRIPTION	TORQUE	TOOLS
REF	390320	1	3/16" FIELD ATTACHABLE STRAIGHT FITTING		WRENCH
REF	390390	1	3/16" FIELD ATTACHABLE 90° FITTING		LUBRICANT (GREASE)
REF	390420	1	1/4" FIELD ATTACHABLE STRAIGHT FITTING		
REF	390490	1	1/4" FIELD ATTACHABLE 90° FITTING		
REF	390820	1	3/8" FIELD ATTACHABLE STRAIGHT FITTING		
REF	390890	1	3/8" FIELD ATTACHABLE 90° FITTING		
PROCESS NAME					REV
FIELD ATTACHABLE FITTING ASSEMBLY INSTRUCTIONS					D
PROCESS NUMBER					PAGE
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INSPECTION

TORQUE

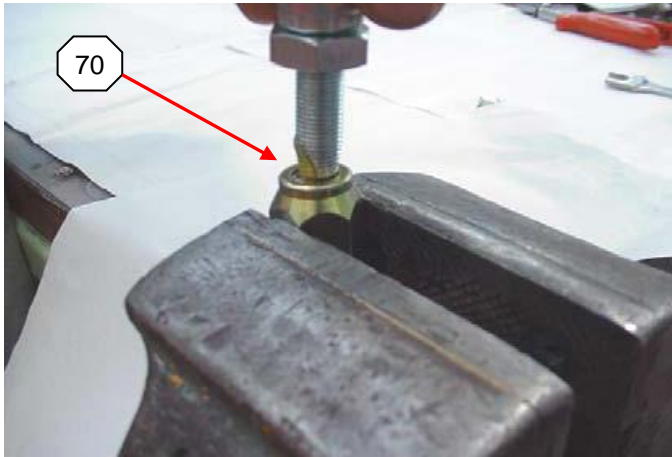
CRITICAL PROCESS



ITEM NUMBER



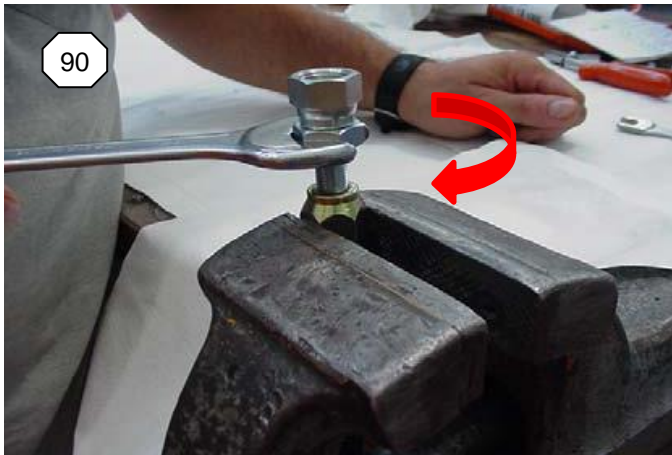
OPERATION



70) ALIGN AND SEAT THE HOSE END OF THE FITTING INTO THE FERRULE AS SHOWN.

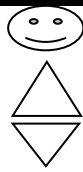


80) HANDTIGHTEN FITTING 'CLOCKWISE' INTO THE FERRULE.



90) CONTINUE TO TIGHTEN FITTING INTO THE FERRULE WITH OPEN END WRENCH AS SHOWN.

ITEM	PART NUMBER	QTY	DESCRIPTION	TORQUE	TOOLS
REF	390320	1	3/16" FIELD ATTACHABLE STRAIGHT FITTING		WRENCH
REF	390390	1	3/16" FIELD ATTACHABLE 90° FITTING		
REF	390420	1	1/4" FIELD ATTACHABLE STRAIGHT FITTING		
REF	390490	1	1/4" FIELD ATTACHABLE 90° FITTING		
REF	390820	1	3/8" FIELD ATTACHABLE STRAIGHT FITTING		
REF	390890	1	3/8" FIELD ATTACHABLE 90° FITTING		
				PROCESS NAME	REV
				FIELD ATTACHABLE FITTING ASSEMBLY INSTRUCTIONS	D
				PROCESS NUMBER	PAGE
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INSPECTION

TORQUE

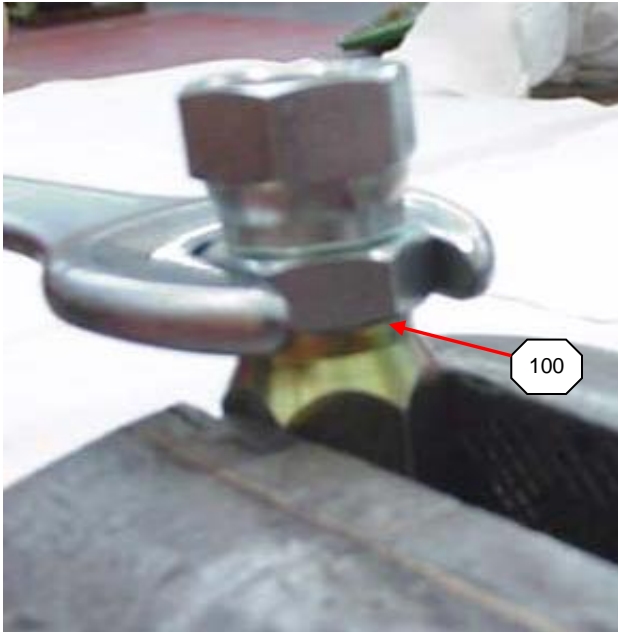
CRITICAL PROCESS



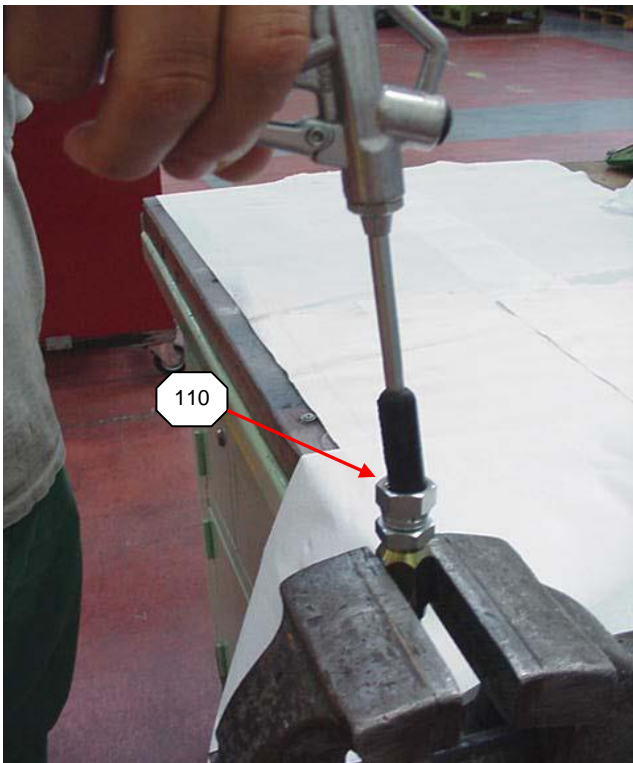
ITEM NUMBER



OPERATION

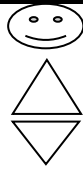


100) TIGHTEN THE FITTING UNTIL THE FERRULE AND FITTING ARE FULLY SEATED TOGETHER.



110) INSERT AIR INTO THE HOSE TO VERIFY NO OBSTRUCTIONS OCCURRED DURING ASSEMBLY.

ITEM	PART NUMBER	QTY	DESCRIPTION	TORQUE	TOOLS
REF	390320	1	3/16" FIELD ATTACHABLE STRAIGHT FITTING		
REF	390390	1	3/16" FIELD ATTACHABLE 90° FITTING		
REF	390420	1	1/4" FIELD ATTACHABLE STRAIGHT FITTING		
REF	390490	1	1/4" FIELD ATTACHABLE 90° FITTING		
REF	390820	1	3/8" FIELD ATTACHABLE STRAIGHT FITTING		
REF	390890	1	3/8" FIELD ATTACHABLE 90° FITTING		
				PROCESS NAME	
				FIELD ATTACHABLE FITTING ASSEMBLY INSTRUCTIONS	
				REV	
				D	
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INSPECTION



TORQUE



CRITICAL PROCESS



ITEM NUMBER



OPERATION

120



120) THE ASSEMBLY IS COMPLETE; USE THIS SAME PROCESS TO ASSEMBLE THE 90° FIELD ATTACHABLE FITTING.

ITEM	PART NUMBER	QTY	DESCRIPTION	TORQUE	TOOLS
				PROCESS NAME FIELD ATTACHABLE FITTING ASSEMBLY INSTRUCTIONS	
				REV D	
				PROCESS NUMBER P11X-9203-AD	
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