How to Assemble Rubber Hose Assemblies

Low & Medium Pressure Straight Fittings

Low pressure MS27404 fittings with MIL-DTL-5593 hose
Medium pressure MS24587 fittings with MIL-DTL-8794

1. After cutting hose squarely to proper length (Do NOT remove cover), screw hose into socket (left hand thread) until it bottoms. Back out hose 1/4 turn.

2. Assemble insert and nut on adapter and slide onto mandrel. Tighten nut until assembly is rigid. (Sizes 16 and over do not require a mandrel).

3. Lubricate hose I.D. and the insert of the sub-assembly (step 2) with lubricating oil or light grease.

4. Screw sub-assembly (step 2) into hose and socket (step 1). Leave 1/16” clearance so nut is free to swivel.

Clean, Inspect and Test. Clean hose assembly by blowing out with air. Inspect hose by looking through assembly for any possible obstructions or foreign matter. Pressure test at proof pressure shown on page 5.

Medium Pressure Elbow Fittings

For use with MIL-DTL-8794 hose

1. After cutting hose squarely to proper length with hacksaw or cutting wheel (Do NOT remove cover), screw hose into socket (left hand thread) until it bottoms. Back out hose 1/4 turn.

2. FLANGE TYPE ENDS ONLY. Assemble flange over threaded end of insert. Insert shoulder must seat in counter bore of flange.

Note: Step 2 not required for flared/flareless fittings.

3. Lubricate hose I.D. and insert threads with lubricating oil or light grease.

4. Using hex on elbows, screw insert sub-assembly into hose and socket (step 1) until insert hex bottoms against socket.

Note: On size -32 screw insert into hose and socket until binding occurs. Un screw and re-lubricate and continue screwing until insert bottoms against socket.

Clean and Test. Clean hose assembly by blowing out with air. Pressure test at proof pressure shown on page 8.

High Pressure All Fittings

For field attachable MS28760 and MS28761 fittings on MIL-DTL-8788 hose

1. Cut hose as squarely as possible to proper length with hacksaw or cutting wheel. Match end of hose with notch in hex of socket, measuring back from end of hose the same distance. Cut around hose through cover to wire braid, away from notch in socket.

2. Cut lengthwise from cut (step 1) to end of hose.

3. Pry up cover at intersection of two cuts with a screw driver.

4. Strip off cover with pliers or vise.

5. Screw hose into socket until hose bottoms. (Socket has a left hand thread). Back out 1/4 turn.

6. Lubricate insert and hose I.D. with oil. Insert is then threaded into socket and hose until the hex of the insert just touches the socket.

Clean and Test. Clean hose assembly by blowing out with air. Pressure test at proof pressure shown on page 13.

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