

Hose assembly method

Campucka couplings

Hose Assembling Methods

1 Preparation

Prepare appropriate hose, coupling cutter, white pen, torque wrench, seal tape, and detachable jig.



CAUTION

If the Campucka is dropped, the nipple part may detach and the hose cannot be inserted. Handle with care.

2 Attaching Campucka to equipment



Type CA
Roll seal tape onto the taper thread and connect it to the taper female thread of the equipment with proper torque.

Type CE
Attach an adapter to the equipment and the Campucka to the adapter with proper torque.

proper torque

(N-m)

Thread size	Taper thread, R thread	Parallel thread, G thread	Thread size	Taper thread, R thread	Parallel thread, G thread
1/8	10~15	15	3/8	45~50	34
1/4	25~30	25	1/2	60~70	59

CAUTION More torque than recommendation may damage the coupling.

CAUTION When using a Campucka coupling, mark the hose to check the inserted length, fitting the hose edge to the groove mark of the socket.

CAUTION The Campucka coupling can be used only for specified hoses.

Hose No.	Hose clamp position
3130-02, F3130-02	200mm以上
1000-04, 1400-04, F3130-04	350mm以上
1000-06, 1400-06, F3130-06	400mm以上
1000-08, F3130-08	500mm以上

3 Hose cutting



WARNING

Do not touch the blade of the cutter.

CAUTION

The slanted cut section may cause pullout of the hose and leakage.

CAUTION

If the blade is blunt, the hose cut section becomes elliptic, causing pullout of the nipple O-ring on insertion and leakage. Change the cutter in this case.

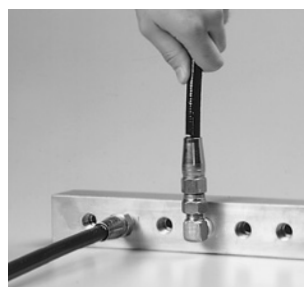
Use the specified hose cutter to cut the hose squarely.

4 Marking the insertion length of the hose



As shown in the figure, mark the hose with a white pen, fitting the hose edge to the groove mark of the socket.

5 Inserting the hose to the Campucka



Insert the hose into the coupling until it meets the marked position. Repeat the same steps 2-5 for the other end of the Campucka.

WARNING If the insertion is insufficient, pullout of the hose or leakage may occur.

CAUTION If the hose is inserted in a tilted position, the inner part (gripper) may be deformed, interfering with the insertion.

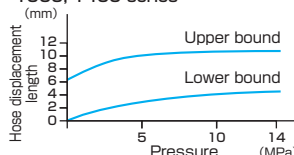
6 Completing hose assembling



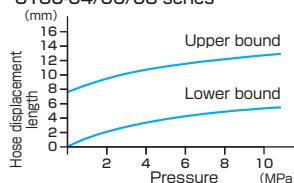
Pressurization swages the hose with an appropriate force according to the pressure.

hose displacement by the pressurization

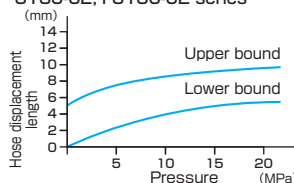
1000, 1400 series



3130-04/06/08 series

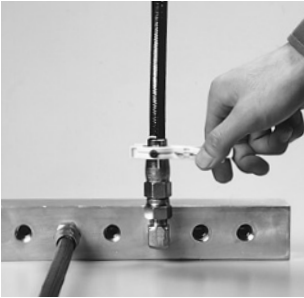


3130-02, F3130-02 series



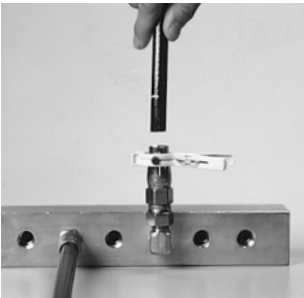
CAUTION Since displacement by the pressurization makes the hose longer, check for interference with the equipment and kinks in the hose.

7 Detaching hose (1)



Detaching method
(detachable only before
pressurization)
Insert the (two) edge pins of
the detachable jig into the
side holes of the socket.

8 Detaching hose (2)



Push the hose toward the
Campucka and then slowly
pull it out.

- CAUTION** The hose cannot be pulled out after pressurization. If it is forced, the inner part of the coupling could be damaged, causing pullout of the hose or leakage.
- CAUTION** The hose and the Campucka are not reusable once pressurized.

* Do not pull the hose before pressurization.