

Reusable coupling

Assembling method

1 Preparation



Prepare appropriate hose, coupling, hose cutter, holding die, lubricant*, adjustable wrench, scale, and white pen.

* lubricant...
Steel coupling : Nihon Kosakuyu PG3740
Stainless coupling :
size O2-12 : JX Nippon Oil & Energy CFH68
size 16 : JX Nippon Oil & Energy DPX100

⚠ CAUTION

If the recommended lubricant is not applied, coating damage and/or socket buckling may occur.

2 Hose cutting



Determine the cutting length of the hose based on the hose assembling length and cut the hose squarely using the special hose cutter.

⚠ **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, correct assembly is not possible. Change the hose cutter in this case.

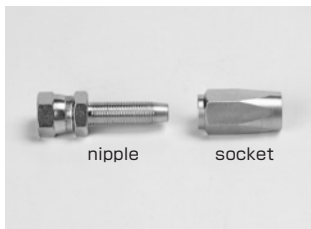
3 Marking the insertion length of the hose



Measure the insertion length of the hose with a scale and mark the hose at the insertion length with the white pen.

📏 It is recommended to draw a marking line with a width of about 2 mm in order to check it after swaging.

4 Disassembling of coupling



Disassemble the reusable coupling into socket and nipple.

nipple

socket

5 Preparation to insert coupling



Nip the hose with the holding die, leaving the length of hose end to be inserted into the socket, and fix it in the vice. For easy screwing, apply lubricant to the surface of the hose end.

6 Insertion of socket



Insert the socket into the hose end and tighten it anti-clockwise with your hand.

Then use the adjustable wrench to screw the socket to the position marked on the hose. Check that there is about a 2-3 mm space between the inner end of the socket and the hose end.

⚠ CAUTION

Stop screwing before the inner end of the socket reaches the hose end, otherwise damage to the core tube will occur and cause leakage.

7 Insertion of the nipple (1)



Remove the assembly from the vice and the holding die. Nip the socket with the vice and apply lubricant to the nipple thread and the inner surface of the hose.

8 Insertion of the nipple (2)



Tighten the nipple clockwise with your hand and use an appropriate adjustable wrench to slowly screw the nipple until its hexagonal part touches the socket.

⚠ CAUTION

Do not screw further, once the nipple touches the socket. It may cause damage to the coupling.

⚠ CAUTION

Using a machine to quickly screw the nipple may cause damage to the core tube or the coupling, leading to pullout of the hose or leakage.

9 Completion of hose assembling



After finishing the tightening of the nipples, check for deformation of the core tube by inserting a checking stick into the coupling.

10 Check of hose assembly



- (1) Check the mark position of the hose insertion length.
- (2) Check the appearance of the coupling. (Check for any damage.)
- (3) Check the appearance of the hose. (Check for any kink or cut.)

Should problems occur, do not use the hose assembly.

📖 For details such as maintenance, please read the instruction manual that comes with the product.

[Reusable coupling]

* For any couplings which are not introduced in the catalogue, please contact us.

A Coupling deduction length

The cutting length of a hose is obtained by the hose-coupling assembly length minus the coupling deduction length*.

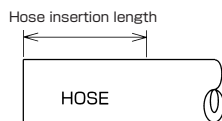
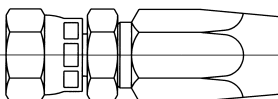
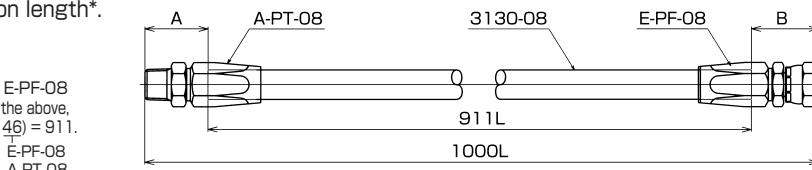
* Coupling deduction length :

A (SA coupling) and B (SE, SF coupling) in the figure.

Ex. 3130-08 × 1000L SA-PT-08 × E-PF-08

If you wish to make a hose assembly using the above,

cut the hose at the length of $1000 - (43 + 46) = 911$.



B Hose insertion length

Hose insertion lengths are presented in the list below.

A shortage of hose insertion length will cause oil leakage or pullout of the hose. So mark the hose at the hose insertion length given in the list and insert the coupling into the hose to meet the marked position.

Table of hose screwing length

Hose series	Hose size	Reusable coupling part No.	A	B
			Coupling deduction length (mm)	Hose insertion length (mm)
3130	02	A-PT-02	25.5	16
		E-PF-02	31.5	
		F-PF-02		
3130 · 3000	03	A-PT-03	30.0	21
		E-PF-03	32.5	
		F-PF-03		
	04	A-PT-04	31.5	25
		E-PF-04	34.0	
		F-PF-04		
3130	05	A-PT-05	35.5	29
		E-PF-05	37.0	
		F-PF-05		
3130 · 3000	06	A-PT-06	37.5	30
		E-PF-06	40.0	
		F-PF-06		
	08	A-PT-08	43.0	36
		E-PF-08	46.0	
		F-PF-08		
	12	A-PT-12	46.5	38
		E-PF-12	47.5	
		F-PF-12		
3000	16	A-PT-16	49.5	42
		E-PF-16	50.0	
		F-PF-16		