



# PRODUCT APPLICATION NOTES

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TO: All Gates Field Personnel

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SUBJECT: **General Operating Procedure – Field Attachable - Assembly Instructions**

Traditionally, when installing a field attachable coupling, there has been a possibility of unintentionally skiving the tube of a hydraulic hose. The Gates Rubber Company has developed a **General Operating Procedure** addressing this issue. This new General Operating Procedure has been reviewed and approved by Manufacturing and Quality Groups within Gates production facilities.

## **General Operating Procedure – Field Attachable – Assembly Instructions**

Field attachable couplings (formerly referred to as re-usable couplings), which means no crimping equipment is needed to attach the couplings. Below are the basic procedures to follow in the assembly of field attachable couplings. Installation procedures of Gates field attachable couplings should be as follows:

1. Cut the hose square with fine-tooth hacksaw or cut-off saw. Be sure to blow out the hose to remove any rubber or metal dust. If a customer specifies a specific level of cleanliness, refer to their appropriate cleanliness specification.
2. Turning counterclockwise, thread the hose into the socket until the hose bottoms on inside shoulder of the socket. Then turn the hose back one-half turn. A vice can be used to hold the socket if necessary.



3. Be sure to **thoroughly oil the stem and the inside of the hose**. This is critical to ensure that the stem slides into the hose tube and does not skive off a portion of the inside tube.



4. In clockwise motion, thread the stem into the hose and socket, using a wrench or a Gates field attachable machine, until the stem hex shoulders against the ferrule.



5. Clean the assembly by blowing out with clean compressed air and examine the assembly to see if any particles remain. If there are particles present or if the assembly is too long for visual inspection, a secondary cleaning operation is recommended.