

REUSABLE ASSEMBLY INSTRUCTIONS

For KURT R1R, R2R, and R5R Reusable Hydraulic Fittings

This procedure applies to assembly of KURT R1R, R2R, and R5R reusable hydraulic fittings. The three different categories apply to the hose type that will be used for your assembly. It is important to note that inserts and shells are NOT interchangeable between each series. It is also important to use clean, square cut, and debris free hose for every assembly by removing burrs, loose wire, and cleaning the I.D. of the hose from cut debris.

MINIMUM TOOL REQUIREMENTS:

- Two open end wrenches. One for the shell size, and the other for the hex on the insert.
- A vise to hold the shell in place during assembly.
- A paint pen or marking tool to measure and mark insertion depth.
- Lubricating oil (~SAE 20 weight or similar)

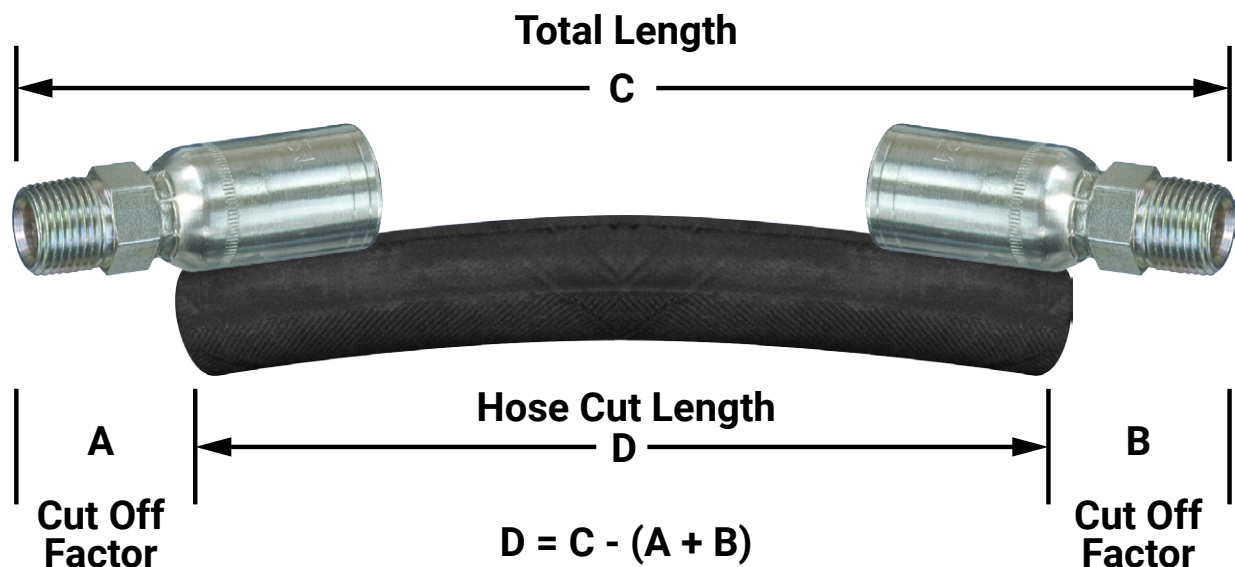
OPTIONAL TOOLS:

- Deep impact sockets and driver.

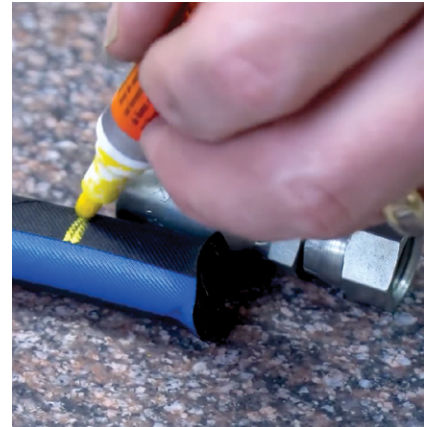
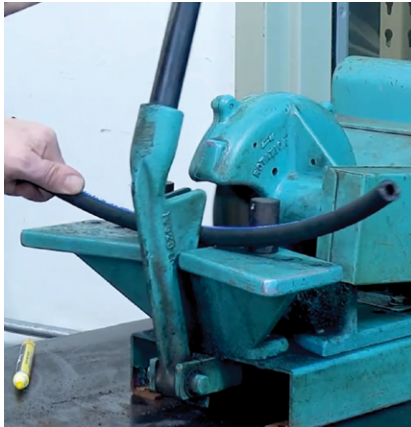
ASSEMBLY STEPS:

1. Identify your hose length required:

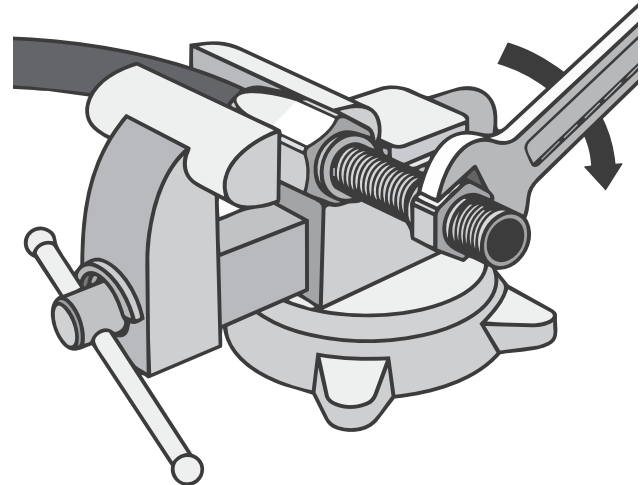
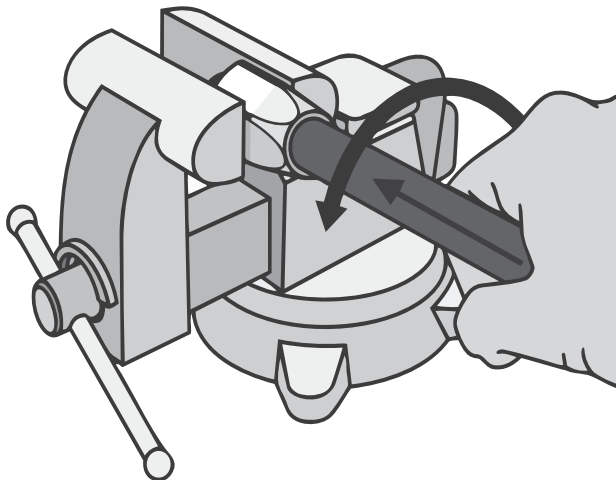
$$\text{Hose Cut Length} = \text{Total Length} - (\text{Cut Off Factor A} + \text{Cutoff Factor B})$$



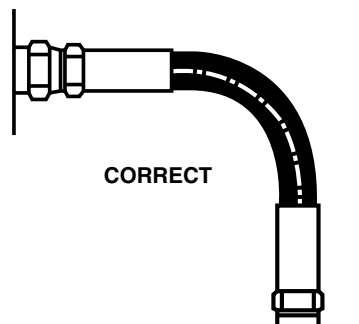
2. Squarely cut the hose length required, clean the I.D. of the hose, and remove loose wires etc. from cut ends. Then using the reusable shell, mark the insertion depth required on the O.D. of the hose using the paint marker or marking tool.



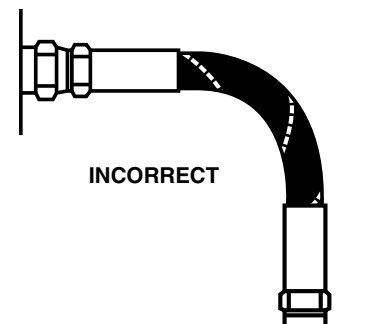
3. Place the reusable shell into a vise and lubricate the O.D. of the hose with the lubrication oil up to the insertion mark made in Step 2. Then install the hose into the shell by pressing the hose in and turning the hose COUNTER-CLOCKWISE until the hose bottoms out in the shell. Then back out 1/2 a turn.
4. Lubricate the insert from the stem end to the hex covering all of the threads on the stem with a coat of lubricating oil. Then install the stem into the shell and hose and turn CLOCKWISE until the shell contacts the hex. A 1/32" and 1/16" gap from contacting the hex on the stem to the shell is acceptable.



5. Inspect the hose assembly and clean off any excess lubrication on the outside. View the hose internally for cut(s), bulge(s), or any other obstructions before putting into service. Make sure swivel nuts turn freely, and the hose lay-line is not twisted between ends. Cap assembly to maintain cleanliness until in use.



CORRECT



INCORRECT

**Find this and other instructions/manuals/tips on our website <https://www.kurthydraulics.com/support/>.
As always you can contact technical support with any questions at 308-787-0127.**