

Skiving Procedure

Hose Cut-Off Factor

Select the proper hose and ends and cut hose to length. The cut length of the hose is determined by subtracting the cut-off factor for each end from the overall length of the assembly. See individual catalog listings for hose cut-off factors.



Skiving Weatherhead Hose

(When using H470 hose with 470 'E' and 570 'S' series hose ends)

The outer protective covering of wire-wrapped hose must be carefully removed (skived) to the wire to allow proper installation of crimped hose ends and to assure the best possible hose service.

When skiving a hose, it is advisable to skive a practice piece of hose to determine:

- That covering is properly removed and that the hose wire-wrap reinforcements are not displaced, damaged or cut in the process.
- The hose should be checked for correct skive length.
- The hose should be checked for 100% cover removal.

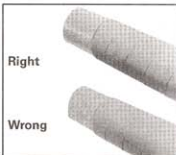
HOSE H470

HOSE I.D.	SKIVE LENGTH	CUTTING HEAD
1/2	1-1/4	T-410-50
3/4	1-13/16	T-410-52
1	2-1/8	T-410-53
1-1/4	2-7/8	T-410-54
1-1/2	3-1/8	T-410-55
2	3-3/8	T-410-56
T-410-36	Handle	
T-410-37	Replacement cutting blades	

Hand-Tool Method

Skiving heads are shipped preset for proper skive length. Depending on hose cover thickness, the skiving blade may require adjustment. The skiving blade may need periodic adjustment. Directions are packed with the skive tool.

1. Clamp hose in a vise or other suitable holding device. Be sure not to clamp so tight as to damage hose.
2. Lubricate hose I.D. and skiving tool mandrel with oil/soap solution.
3. Carefully align mandrel with hose I.D.; apply steady pressure and start mandrel into hose.
4. When cutting head contacts hose end, slowly rotate skiving tool clockwise. Cutting head will remove hose covering while threading itself to a preset skive length when bottomed against hose end. Continue to rotate skiving tool clockwise to remove excess rubber from wire wrap while slowly pulling tool from hose. (See illustration to right.)
5. Wire-brush hose end to remove any remaining cover from wire wrap.
6. Inspect skive for 100% cover removal.



⚠ IMPORTANT: Clean hose I.D. by brushing, blowing compressed air, or by flushing. By doing so, contaminants are kept out of operating systems.

⚠ WARNING - Failure to completely remove the cover may result in serious personal injury or property damage due to hose ends blowing off, hose leakage, and other failures.

Equipment

Skiving Tools and Wrenches

Hand Skiving Tool

(For H430, H439 and H470 Hose)



Order hand skiving tool components by the individual catalog numbers listed below.

See page 26 for skiving instructions.

HOSE SIZE	SKIVING TOOL CUTTING HEAD H470
1/2" I.D.	T-410-50
3/4" I.D.	T-410-52
1" I.D.	T-410-53
1-1/4" I.D.	T-410-54
1-1/2" I.D.	T-410-55
2" I.D.	T-410-56

T-410-36: Handle

T-410-37: Replacement Cutting Blades

Rapid Wrenches



The Rapid Wrench is a heavy-duty, high quality wrench that ratchets for quick installation and removal of tube fittings and hose ends. These wrenches have jaws that snap open and close completely around the fitting giving 6-point contact. Needing only 30° of rotation to ratchet, they allow easy access to tight locations. Available individually or in a set with pouch, these wrenches are a welcome addition to any tool box.

T-139: 7-Piece Set with Pouch – 1/2" through 7/8"

T-139P: Pouch for 7-Piece Set

T-152: 11-Piece Set with Pouch

T-152P: Pouch for 11-Piece Set

CATALOG NUMBER	WRENCH HEX SIZE
T-140	3/8"
T-141	7/16"
T-142	1/2"
T-143	9/16"
T-144	5/8"
T-145	11/16"
T-146	3/4"
T-147	13/16"
T-148	7/8"
T-151	15/16"
T-149	1"