



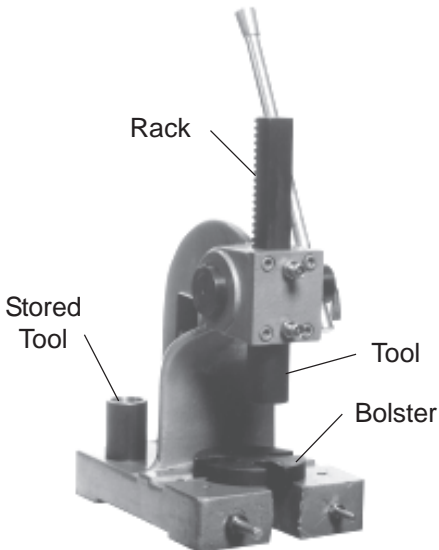
# TRAMEC

## THE HA300 BENCH TOP ASSEMBLY FIXTURE

Now you can build both 3/8 and 1/2 inch heavy duty air brake hose assemblies right in your shop ...

### Air Brake Hose End Kits & Assemblies

- Meets the requirements of DOT 106 and SAE J1402.
- Swivel Ends reduce residual torque in hose for longer life — No need to disconnect both ends to service the brake system.
- Reduce hose assembly inventory, make it “when and how” needed.
- Components in contact with the air are made of corrosion resistant brass and nylon to improve air system life.
- Assembly integrity can be checked by visual inspection.

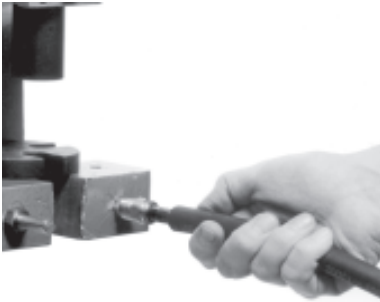


**HA300**  
**Hose Assembly Fixture**

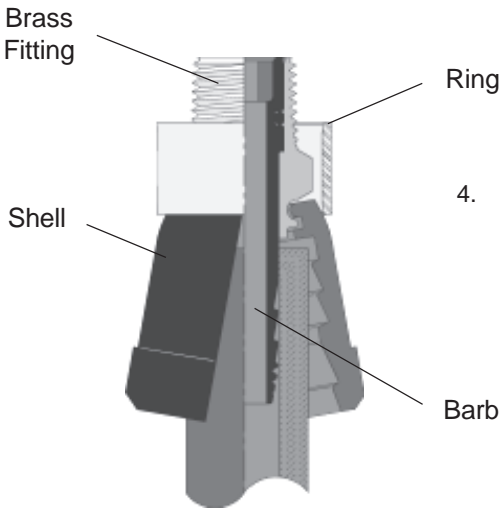
### FIXTURE SETUP

1. Securely attach the fixture to the work bench. Be sure that the arms of the fixture base overhang the edge of the bench sufficiently to allow a hose assembly to hang freely beneath the fixture during assembly.
2. The fixture is supplied with tools for 3/8" and 1/2" I.D. air brake hose assemblies. The tool marked "A" is for use with 3/8" I.D. hose. The tool marked "B" is for use with 1/2" I.D. hose. Select the tool for the hose size desired and insert the shank into the hole in the end of the press rack. Tighten the set screw to secure the tool in place.
3. Dial the slot in the bolster plate which is marked with the letter matching the selected tool, so that it is aligned with the space between the arms of the fixture base.

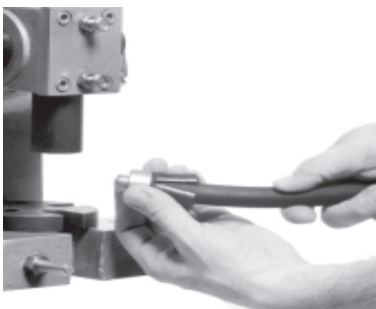
## ASSEMBLY INSTRUCTIONS



1. Using a sharp cutting device (we have found some styles of pruning shears to be good for cutting hose), cut the hose to the desired length. The cut end should be clean and square.
2. Place the fitting and barb onto the left stud if using 1/2" I.D. hose fittings, or the right stud if using 3/8" I.D. fittings.
3. Push the barb into the cut end of the hose until the hose material lightly touches the brass fitting.



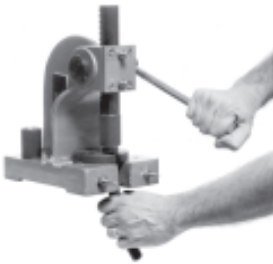
4. Position the shells so that the ridge on the brass fitting engages the grooves in the nylon shells, as shown.



5. Squeeze the shells firmly so that the shells are evenly spaced around the hose, and the ridge on the brass fitting is seated in the grooves in the shells.
6. Start the ring onto the shells. The cross sectional drawing illustrates the relative position of the components prior to placing them into the press fixture.



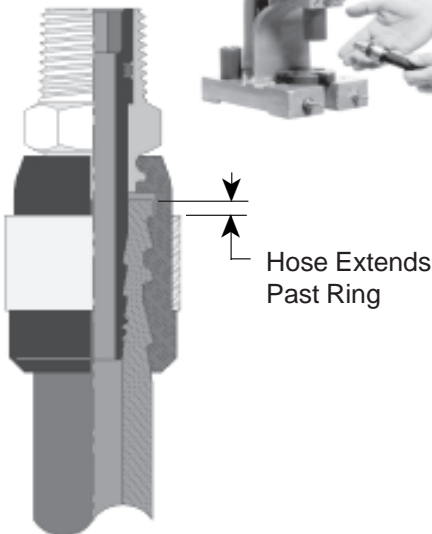
7. Place the ring up into the bottom opening of the tool.
8. Place the hose into the notch in the bolster plate, so that the shells rest on top of the plate as shown, with the tool resting on the fitting assembly.



9. Pull firmly down on the handle at a steady rate to force the ring over the shells. (It is not unusual for some of the plastic material to be shaved from the exterior surface.)
10. Continue to press the ring down until it is seated against the step on the outside of the shell.



11. Remove the completed assembly from the fixture for inspection.



## INSPECTION PROCEDURE

1. Verify that the ring has been moved completely against the seat. If not, remove any plastic shavings, place the assembly back into the fixture, and repeat steps 9, 10, and 11.
2. Looking into the gap between the two shells, verify that the cut end of the hose is still in position. The cut end of the hose must extend past the edge of the retaining ring, as shown.

## Bulk Packaged Hose Fitting

HOSE I.D.	NPTF	PART NO.
3/8"	3/8"	31302
3/8"	1/2"	31303
1/2"	3/8"	31305
1/2"	1/2"	31306

- To order pre-coated pipe threads add prefix "P" to part number.
- When using with gladhands, add the suffix "B" to the part number to specify a brass barb.

## Bulk Hose, Dot 106, SAE J1402

HOSE I.D.	DESCRIPTION	PART NO.
3/8" I.D.	Box, 50'	31102
3/8" I.D.	Reel, 250'	31002
3/8" I.D.	Reel, 500'	3160001
1/2" I.D.	Box, 50'	31105
1/2" I.D.	Reel, 250'	31005
1/2" I.D.	Reel, 500'	3180001

## Replacement Parts

HOSE I.D.	DESCRIPTION	PART NO.
3/8" I.D.	Tool A	HA301
1/2" I.D.	Tool B	HA302
3/8" & 1/2" I.D.	Bolster Plate	HA303

See the full catalog for other air brake hose related products.



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