








NOTES:

1. PTFE hose is suitable for use with all types of automotive fluids including fuel, oil, brake fluid, coolant etc.
2. It is imperative that the hose is assembled correctly to ensure best performance.
3. Radium Engineering does not offer a warranty on hoses that are assembled by the installer.

STEP	TOOLS NEEDED	INSTRUCTIONS	PHOTO
1	Tape	Measure carefully to determine appropriate hose length. Be sure to accommodate for hose end fittings. Once the cut length has been determined, tightly wrap tape around the area of the cut. As shown, mark the cut line. NOTE: The tape will prevent the hose from fraying when cut.	
	Marker		
2		PTFE hose uses stainless steel braiding for strength. The best tool for cutting PTFE hose is a toothless chop saw blade. However, the following are effective when used properly. -Band saw with small tooth blade -Large heavy duty cable cutting shears -Rotary Tool with abrasive cut-off wheel (shown) NOTE: Other tools can be used as long as the result is a clean cut without fraying or deformation of the hose.	
3	Cutting Tool	Carefully cut all the way around the hose completely through all layers.	
	Safety Glasses	Clean any debris from the cut end of the hose.	
4		Disassemble the hose-end by unscrewing the B-nut. Next, locate the silver-colored "olive" inside the hose-end. Push the hose into the B-nut from the fitting that will be installed. NOTE: If the hose frays too much, this will be very difficult and a new cut may be necessary.	

5		As the hose starts to insert into the B-nut, remove the tape.	
6		Slide the B-nut up the hose about 1" (25mm).	
		Prevent the black polyester from fraying. However, if this happens, the hose can still be used if the fray is not too bad. If the fray is very bad, the hose will have to be re-cut or the black polyester can be completely removed from the entire hose and the assembly can continue.	
7		Push the olive onto the end of the hose so that it goes underneath the stainless steel braiding. The braiding may need to be frayed slightly.	
		There is a shoulder inside the olive that the PTFE liner should sit against when fully inserted.	
8		Insert the hose-end into the end of the PTFE hose until it is fully seated, as shown. Check to make sure the hose end is sliding correctly into the PTFE hose lining and not folding it over.	
		If the black polyester has frayed, now is a good time to trim back loose strands that may get caught in the threads.	
9	Silicone Spray	Slide the B-nut down towards the hose end.	
		Apply lubrication to the threads.	
		Begin threading the B-nut to the hose-end while applying pressure to ensure the first few threads engage correctly.	
		Once a few threads are engaged, pressure is no longer needed.	
		NOTE: It is very easy to strip these threads, so be very careful.	
10	Wrench	Clamp the B-nut in a vise. Be careful not over-tighten and distort the B-nut.	
	Vice	Tighten the hose-end into the B-nut until there is no gap left between the two.	
		NOTE: It is recommended to use aluminum vise jaws and a non-marring wrench to prevent surface finish marring.	

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Hose assembly is complete.
Pressure testing is recommended to ensure proper installation. If not possible, carefully inspect the hose during first use.

