
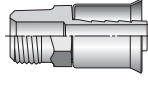
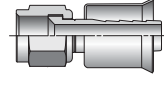
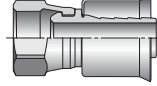
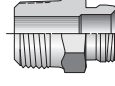
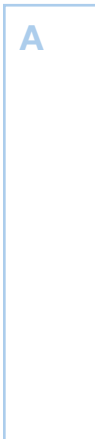
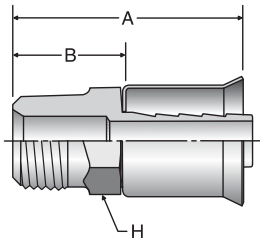


|  |   |  |   |   |  |
|--|---|--|---|---|--|
|  <p><b>Flange</b></p> | <p>10125      B-6</p>  <p><i>Rigid</i></p> | <p>10825      B-6</p>  <p><i>Swivel</i></p> | <p>17B25      B-6</p>  <p><i>Swivel</i></p> | <p>017M      B-6</p>  <p><i>Swivel</i></p> | <p>B-7</p> <p><i>Assembly Instructions</i></p> |
|--|---|--|---|---|--|



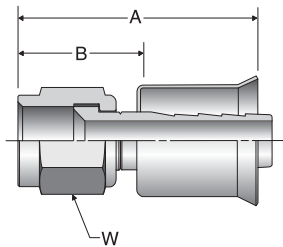
A



### 10125 Male NPTF Pipe - Rigid

| #<br>Part Number | Thread<br>inch | Hose I.D.<br>inch | A    |    | H<br>inch | B    |    |
|------------------|----------------|-------------------|------|----|-----------|------|----|
|                  |                |                   | inch | mm |           | inch | mm |
| 10125-6-6B-VS    | 3/8X18         | 3/8               | 1.72 | 44 | 11/16     | 1.00 | 25 |
| 10125-6-8B-VS    | 3/8X18         | 1/2               | 1.72 | 44 | 11/16     | 1.00 | 25 |
| 10125-8-6B-VS    | 1/2X14         | 3/8               | 2.05 | 52 | 7/8       | 1.33 | 34 |
| 10125-8-8B-VS    | 1/2X14         | 1/2               | 2.05 | 52 | 7/8       | 1.33 | 34 |

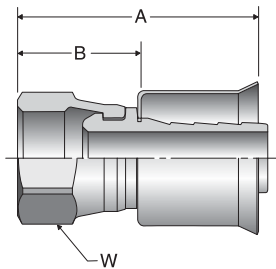
B



### 10825 Female SAE 45° - Swivel

| #<br>Part Number | Thread<br>inch | Hose I.D.<br>inch | A    |    | H<br>inch | B    |    |
|------------------|----------------|-------------------|------|----|-----------|------|----|
|                  |                |                   | inch | mm |           | inch | mm |
| 10825-6-6B       | 5/8X18         | 3/8               | 1.82 | 46 | 3/4       | 1.10 | 28 |
| 10825-8-6B       | 3/4X16         | 3/8               | 1.80 | 46 | 7/8       | 1.08 | 27 |
| 10825-8-8B       | 3/4X16         | 1/2               | 1.95 | 50 | 7/8       | 1.22 | 31 |

C

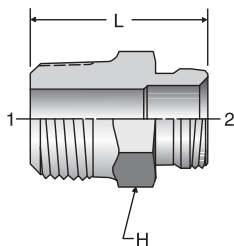


### 17B25 Female Air Brake Jounce Line - Swivel - Straight

| #<br>Part Number | Thread<br>inch | Hose I.D.<br>inch | A    |    | H<br>inch | B    |    |
|------------------|----------------|-------------------|------|----|-----------|------|----|
|                  |                |                   | inch | mm |           | inch | mm |
| 17B25-8-6B       | 3/4X20         | 3/8               | 1.59 | 40 | 7/8       | 0.87 | 22 |
| 17B25-8-8B       | 3/4X20         | 1/2               | 1.59 | 40 | 7/8       | 0.87 | 22 |

D

### 017M Air Brake Adapter



| #<br>Part Number | Thread End 1<br>NPTF inch |        | Thread End 2<br>UNEFinch |        | L    |    | H<br>inch |
|------------------|---------------------------|--------|--------------------------|--------|------|----|-----------|
|                  | inch                      | mm     | inch                     | mm     | inch | mm |           |
| 017M-6-8B        | 6                         | 3/8X18 | 8                        | 3/4X20 | 1.13 | 29 | 3/4       |
| 017M-8-8B        | 8                         | 1/2X14 | 8                        | 3/4X20 | 1.33 | 34 | 7/8       |

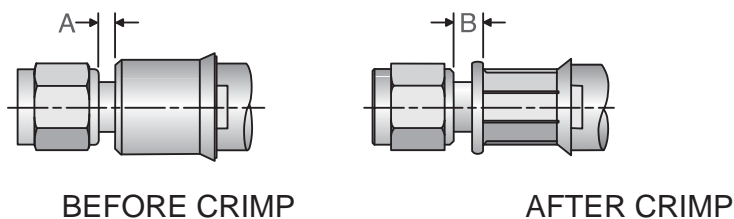
E

## Assembly Instructions

1. On the 08 end configurations only, the use of a mandrel is required. This mandrel is designed to set the proper gap between the nut and the shell. To match the correct fitting with the proper mandrel part number refer to the table below.



2. The assembly mandrels can be used with a common bench vise or on the TH2-7 push-on stand. Refer to Bulletin 4480-T13-USA for push-on stand instructions.
3. When using a common bench vise, place the mandrel in the vise, put the fitting on the mandrel (nut first) then push on the hose until it bottoms. Visually check the sight hole on the side of the shell to assure that the hose is fully inserted.
4. Remove mandrel from fitting and check for proper gap between nut and shell. (See table below).
5. Now crimp the fitting onto the hose. Refer to CrimpSource for correct crimp dies and crimping dimensions.
6. Check for proper gap between nut and shell after crimp. (See table below)



NOTE: B dimension is measured from the back of the fully-seated nut to the start of the crimp length. The nut must be free to swivel after crimping of the shell.

| Fitting Part Number | A Length |       | B Length |       | Required Assembly Mandrel |
|---------------------|----------|-------|----------|-------|---------------------------|
|                     | mm       | inch  | mm       | inch  |                           |
| 10625-6-6B          | 3.80     | 0.150 | 8.00     | 0.315 | TH2-7M25-6                |
| 10825-6-6B          | 5.80     | 0.230 | 11.80    | 0.465 |                           |
| 10625-8-8B          | 3.80     | 0.150 | 8.00     | 0.315 | TH2-7M25-8                |
| 10825-8-8B          | 5.80     | 0.230 | 11.80    | 0.465 |                           |

NOTE: The "Required Assembly Tool" must be used to assemble all fittings listed above.

7. For all other 25 series fittings, use of mandrel is not necessary. Push fitting onto hose until it bottoms. Visually check sight hole on the side of the shell to assure that the hose is fully inserted.

A

B

C

D

E