

# Tech Bulletin

## Special Assembly & Crimping Instructions for Dragon Breath Steam Coupling Series 7610-12BWGJF & 7613-12BWGJF

Date: December 15, 2004

The 7610-12BWGJF or 7613-12BWGJF Dragon Breath Steam Coupling (wing nut and knurled style nuts) are supplied as a 3-piece coupling to assist in the ease of crimping.

The following are the crimping procedures:

1. When utilizing the 7610-12BWGJF or 7613-12BWGJF coupling on Parker's steam hose, skive the hose to the proper specifications if required, which can be found on Parker's Crimpsource.
2. Slide the nut over the hose, making sure the threaded side of the nut faces toward the end of the hose to be crimped.
3. Slide the un-crimped steam/ferrule into the hose making sure the ferrule is bottomed out on the end of the hose.
4. Select the appropriate crimp specification and crimp the stem/ferrule utilizing standard procedures for Parker BW couplings.
5. Measure the crimp OD to insure proper crimp has been achieved.
6. Slide the nut up over the crimped ferrule and hold in place with the retaining ring. You now have a permanently attached Dragon Breath Steam Coupling.
7. Repeat the above procedures if utilizing a 7610-12BWGJF or 7613-12BWGJF for the opposing end.

If there are any questions please contact IHP Customer Service toll-free at: (866) 810-4673.

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