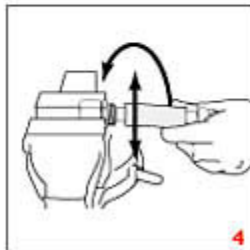
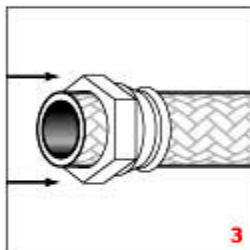
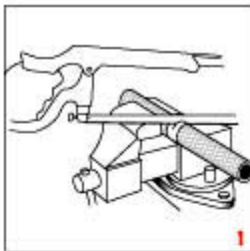




TECHNICAL SECTION

Speed-Flex™ Hose Ends with Speed-Flex Hose Assembly Instruction



Brake lines are critical items. The potential penalties for improper assembly are severe. Although there is nothing complicated about the procedure and no special tools are required, extreme care must be used in assembly. We strongly recommend that the following procedures be used:

1. Cut the hose to the required length. We recommend the use of a radiac wheel but it can be done satisfactorily with a 32 teeth per inch hacksaw blade. In either case, the hose must be tightly wrapped with electrical or masking tape and the cut made through the tape. Do not cut Speed-Flex hose with a chisel, snips, pliers, or a shear as these may crush the PTFE liner.

2. De-burr the PTFE and trim any loose ends of braid with sharp snips or diagonal cutting pliers.

3. Install the socket on the hose with the threaded end of the socket toward the cut end of the hose. This will be a lot easier and you will end up with fewer holes in your hand if you clamp the socket in a vise. Push socket on well beyond end.
4. Place the hex portion of the nipple in the vise. Insert the end of the hose onto the nipple and bottom the hose against the chamfer seat of the nipple with a rotary motion of the hose. This will size the I.D. of the PTFE tube.
5. Separate the braid from the O.D. of the PTFE tube. The best way is to use Earl's special braid spreader tool for sizes 3+4 (see [Plumbing Accessories](#) Section). In the absence of the tool, separate the braid with a small screwdriver or a scribe. Be careful not to scratch or nick the PTFE.
6. Install the sleeve between the braid and the PTFE tube. Make sure that none of the braid is trapped between the PTFE and the sleeve. Bottom the tube against the shoulder of the sleeve and make sure that the sleeve is inserted square.
7. With the nipple held in the vise, push the hose and the sleeve onto the nipple until the sleeve bottoms. Remove the hose and make sure that the PTFE tube is still bottomed against the shoulder of the sleeve and that the sleeve is still square.
8. Push the hose and sleeve back onto the nipple and bottom against the chamfer. Oil the nipple threads. Start the socket onto the nipple threads and hand tighten.
9. Place the socket in the vise and complete the assembly by tightening the nipple onto the socket with a wrench until the gap between the face of the socket and the hex of the nipple .023" to .046" -use a feeler gauge.
10. Blow the assembly clean and pressure test before running the car.

Call 1-800-2HOLLEY for the dealer nearest you.
