

# Red Head Brass, LLC

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## GUIDELINES FOR THE INSTALLATION OF KT-399 THREADED OR SKT-399 STORZ KWIK-TACH™ COUPLINGS

1. Secure the coupling in a vise, a mating fixed coupling half, or similar fixed device.
2. Ensure that the hose is cut square and that there is no foreign or loose material on the inside of the hose in the area to be sealed by the coupling tailpiece.
3. Slide the open end of the hose over the tailpiece until the hose is fully against the shoulder of the coupling. If the hose is too tight on the tailpiece, it may be necessary to brush a soapy solution on the tailpiece or to carefully heat the end of the hose using hot water, a hot air blower, or similar source of heat.
4. Make sure that the collar set is complete. In a complete set, one half of the set is stamped "Red Head" and the other is stamped "For Drafting Only". Align the collar halves over the hose and directly over the tailpiece. The collar halves are "threaded" to match the "thread" of the hose. Ensure that the "threads" of the hose and the collar halves are engaged. It may be necessary to completely disassemble the collar in order to assemble it on the hose. Do not misplace the 1/4-20 screws. The direction that the stamped information faces is not critical. However, it is suggested that it always be done the same for uniformity.
5. Insert the screws into the mating halves and hand tighten using a 3/16" hex wrench. Slowly tighten the screws on each half. Begin by tightening the adjacent screws on one side maintaining a parallel gap between the halves. Then move to the other side and do the same. Continue until the gap between collar halves is the same and the screws are tightened to 180 in.lbs. torque (15 ft.lbs.). For production, a torque adjustable air wrench can be used. *Do not overtighten.*
6. Red Head recommends that all couplings be tested to the hose manufacturers' specifications prior to placing the hose in service. We also suggest that this be done yearly once in service. All testing should be done under controlled conditions in accordance with NFPA 1961, *Fire Hose*, or NFPA 1962, *Fire Hose Care*.
7. If the hose assembly does not hold a vacuum, it may be necessary to further tighten the screws. In extreme cases it may be necessary to disassemble the coupling from the hose and apply a compatible sealant, such as silicone sealant, to the tailpiece before reassembly. Allow sealant to cure before retesting. (Red Head couplings are designed to match the specifications supplied by the hose manufacturers. The tolerances on hose dimensions allowed by those specifications are liberal. Thus, hose may be tight or loose on the tailpiece. If too loose, the clamp collar may not be able to make up for the size difference and sealant may be required.)

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