

Put nut (1) over the tube and push the tube into the counterbore of the fitting body as far as possible. Turn the nut with a wrench until a small decrease in torque is felt. The small decrease in torque indicates that the sleeve (1A) has been broken off the nut. Hold the tube in order to prevent the tube from turning. Tighten the nut for an additional 1 1/2 turns.

## SAE Flareless Fittings

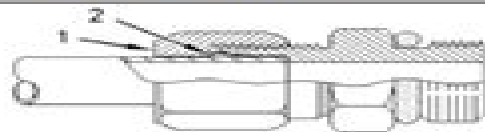


Illustration 20

g00906047

### Installing a New Flareless Fitting

Put nut (1) and sleeve (2) over the tube. The head end of the sleeve should be next to the nut. The head end has a shoulder. The nut will be seated against this shoulder when the nut is tightened. Push the tube into the counterbore of the fitting body as far as possible. Turn nut (1) clockwise until the sleeve grips the tube. The sleeve must prevent all movement of the tube. Tighten the nut for an additional 1 1/4 turns. The sleeve should be seated and the sleeve should give a locking action.

### Installing a Used Flareless Fitting

Less turns are required for a used fitting. Put nut (1) and sleeve (2) over the tube. The head of the sleeve should be next to the nut. Push the tube into the counterbore of the fitting body as far as possible. Tighten the nut until a sudden increase in torque is felt. Next, tighten the fitting for an additional 1/6 to 1/3 turn in order to seat the sleeve.

## Flex Fittings

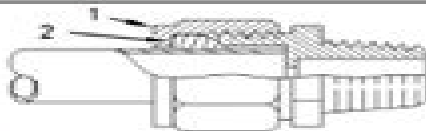


Illustration 21

g00906045

Put nut (1) and sleeve (2) over the tube and push the tube into the counterbore of the fitting body as far as possible. Tighten the nut until the nut is against the hex part of the fitting body.

## Hose Clamps

SMCS Code: 7553

### Worm Drive Band Type Clamps



Illustration 22

g00910017

Table 28

| Width (A) of Clamp           | Torque for New Hose                   |
|------------------------------|---------------------------------------|
| 7.5 mm (0.3 inch) or greater | 1.4 ± 0.3 N·m (12 ± 3 lb in)          |
| 12 mm (0.5 inch) or greater  | 4.5 ± 0.7 N·m (40 ± 6 lb in)          |
| 14 mm (0.6 inch) or greater  | 7.5 ± 1 N·m (66 ± 9 lb in)            |
| Width (A) of Clamp           | Torque for Reused Hose <sup>(1)</sup> |
| 7.5 mm (0.3 inch) or greater | 0.8 ± 0.3 N·m (7 ± 3 lb in)           |
| 12 mm (0.5 inch) or greater  | 3.0 ± 0.5 N·m (27 ± 4 lb in)          |
| 14 mm (0.6 inch) or greater  | 4.5 ± 0.7 N·m (40 ± 6 lb in)          |

(1) Use this value when the hose is reused. The clamp may be new or reused.

### Constant Torque Hose Clamps

Use a constant torque hose clamp in place of any worm drive band type clamp. Ensure that the constant torque hose clamp is the same size as the worm drive band type clamp. Due to extreme temperature changes, the hose will heat set. Heat setting can cause worm drive band type clamps to loosen. Loose hose clamps can result in leaks. There have been reports of component failures that have been caused by worm drive band type clamps that have loosened. The constant torque hose clamp will help prevent these failures.

# Hill Inspection Torque Spec Manual

**K Payea**



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