

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

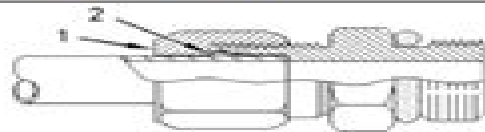


Illustration 20

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

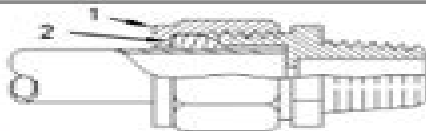


Illustration 21

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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 ⁽¹⁾
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.

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Table of Contents Hill Inspection Torque Spec Manual

1. Understanding the eBook Hill Inspection Torque Spec Manual
 - The Rise of Digital Reading Hill Inspection Torque Spec Manual
 - Advantages of eBooks Over Traditional Books
2. Identifying Hill Inspection Torque Spec Manual
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Hill Inspection Torque Spec Manual
 - User-Friendly Interface
4. Exploring eBook Recommendations from Hill Inspection Torque Spec Manual
 - Personalized Recommendations
 - Hill Inspection Torque Spec Manual User Reviews and Ratings
 - Hill Inspection Torque Spec Manual and Bestseller Lists
5. Accessing Hill Inspection Torque Spec Manual Free and Paid eBooks
 - Hill Inspection Torque Spec Manual Public Domain eBooks
 - Hill Inspection Torque Spec Manual eBook Subscription Services
 - Hill Inspection Torque Spec Manual Budget-Friendly Options
6. Navigating Hill Inspection Torque Spec Manual eBook Formats

- ePub, PDF, MOBI, and More
- Hill Inspection Torque Spec Manual Compatibility with Devices
- Hill Inspection Torque Spec Manual Enhanced eBook Features
- 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Hill Inspection Torque Spec Manual
 - Highlighting and Note-Taking Hill Inspection Torque Spec Manual
 - Interactive Elements Hill Inspection Torque Spec Manual
- 8. Staying Engaged with Hill Inspection Torque Spec Manual
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Hill Inspection Torque Spec Manual
- 9. Balancing eBooks and Physical Books Hill Inspection Torque Spec Manual
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Hill Inspection Torque Spec Manual
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine Hill Inspection Torque Spec Manual
 - Setting Reading Goals Hill Inspection Torque Spec Manual
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Hill Inspection Torque Spec Manual
 - Fact-Checking eBook Content of Hill Inspection Torque Spec Manual
 - Distinguishing Credible Sources
- 13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
- 14. Embracing eBook Trends
 - Integration of Multimedia Elements
 - Interactive and Gamified eBooks

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