

Procedure 2303: Installation of MIL H 29210C Steam Hose Assemblies

effective 02/08

Select

- Select Boss™ clamp using Procedure 1000: Boss™ Clamp Selection (page 5).

Preparation

- Prepare the hose using Procedure 1100: General Preparation Instructions (pages 9-10).

Process

- 1. Cut liner the same length as the hose.
- 2. Remove sharp edges from both ends.
- 3. At one end of the liner, create a hole in the first spiral.
- 4. Cut a length of wire 2' to 3' longer than the hose.
- 5. Insert one end of the wire into the hole and secure.
- 6. Feed the other end into the hose until it comes out the opposite end.
- 7. Begin twisting the liner clockwise to reduce its diameter.
- 8. Lubricate the first 1' to 2' of the OD (Outside Diameter) of the liner with talcum powder.
- 9. Insert the liner into the hose.
- 10. Pull the wire through the hose while simultaneously twisting and lubricating the liner.
- 11. Continue inserting the liner until 1½" to 2" are visible at both ends.
- 12. Disconnect the wire from the liner.
- 13. Thread the spiraled end of the coupling into the liner fully.
- 14. Insert the coupling into the hose until it contacts the stem collar. Refer to step 9 of Procedure 1100: General Preparation Instructions (pages 9-10).
- 15. Repeat steps 13 and 14 for the other end of hose.
- 16. Place the stem in a vise. For male stems, tighten vise on hex. For female stems (wing nut), place a spud in a vice, tighten and then thread the wing nut onto the spud.
Note: Always secure the stem in a vise before tightening the clamp bolts. Failure to do so may result in separation of the stem and the metal liner, damage to the metal liner or the hose tube and/or an assembly that leaks.
- 17. Installing the Boss™ clamp on a MIL H 29210C hose assembly requires:
 - a. 4 bolt clamps for a hose with an ID (Inside Diameter) of 1" and above.
Use Procedure 2001: Installation of Boss™ 4 Bolt Clamps (page 16).
 - b. 2 bolt clamps for a hose with a ID less than 1".
Use Procedure 2000: Installation of Boss™ 2 Bolt Clamps (page 15).
- 18. Test assembly using Procedure 4000: General Hydrostatic Testing Information (page 60) and Procedure 4001: Hydrostatic Testing (page 61).
- 19. Prepare for shipment. When coiling the assembly, never coil the hose smaller than the hose manufacturer's recommended minimum bend radius. Doing so can cause the stem and liner to separate and damage the hose.
Tip: To "ball park" minimum band radius, multiply the hose ID x 12.
Example: 2" ID hose x 12 = 24" min band radius.