

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

effective 02/08

### **Select**

- Select Boss clamp using Procedure 1000: Boss Clamp Selection.

### **Preparation**

- Prepare the hose using Procedure 1100: General Preparation Instructions.

### **Process**

- 1. Cut liner same length as 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 O.D. (Outside Diameter) of liner with talcum powder.
- 9. Insert 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 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.
- 15. Repeat steps 13 and 14 for 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, then thread wing nut onto spud.  
*Note:* Always secure stem in a vise before tightening clamp bolts. Failure to do so may result in separation of the stem and metal liner, damage to the metal liner or 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 hose with an I.D. (Inside Diameter) of 1" and above.  
Use Procedure 2001: Installation of Boss 4 Bolt Clamps.
  - b. 2 bolt clamps for hose less than 1" I.D.  
Use Procedure 2000: Installation of Boss 2 Bolt Clamps.
- 18. Test assembly using Procedure 4000: General Hydrostatic Testing Information and 4001: Hydrostatic Testing.
- 19. Prepare for shipment. When coiling assembly, never coil hose smaller than hose manufacturer's recommended minimum bend radius. Doing so can cause stem and liner to separate and damage hose.