| Procedure 2303 | **Installation of MIL H 29210C Steam Hose Assemblies** | Revision 4-04 |
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**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 sharps 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 - 3 feet 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 feet of the O.D. 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 1 1/2 to 2 inches 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.
- ❑ 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 assemble that leaks.
- ❑ 17. Install the Boss Clamp. MIL H 29210C requires:
  a. 4 bolt clamps for hose with an I.D. 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.

Assembled By: _____ Tested By: _____ Reference No. _____
Assembled Date: _____ Test Date: _____

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