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 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' 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 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 (pages 9-10).
- 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 ID (Inside Diameter) of 1" and above.
  b. 2 bolt clamps for hose less than 1" ID
- 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.

Tip: To “ball park” minimum band radius, multiply the hose ID x 12
example: 2" ID hose x 12 = 24" min band radius.