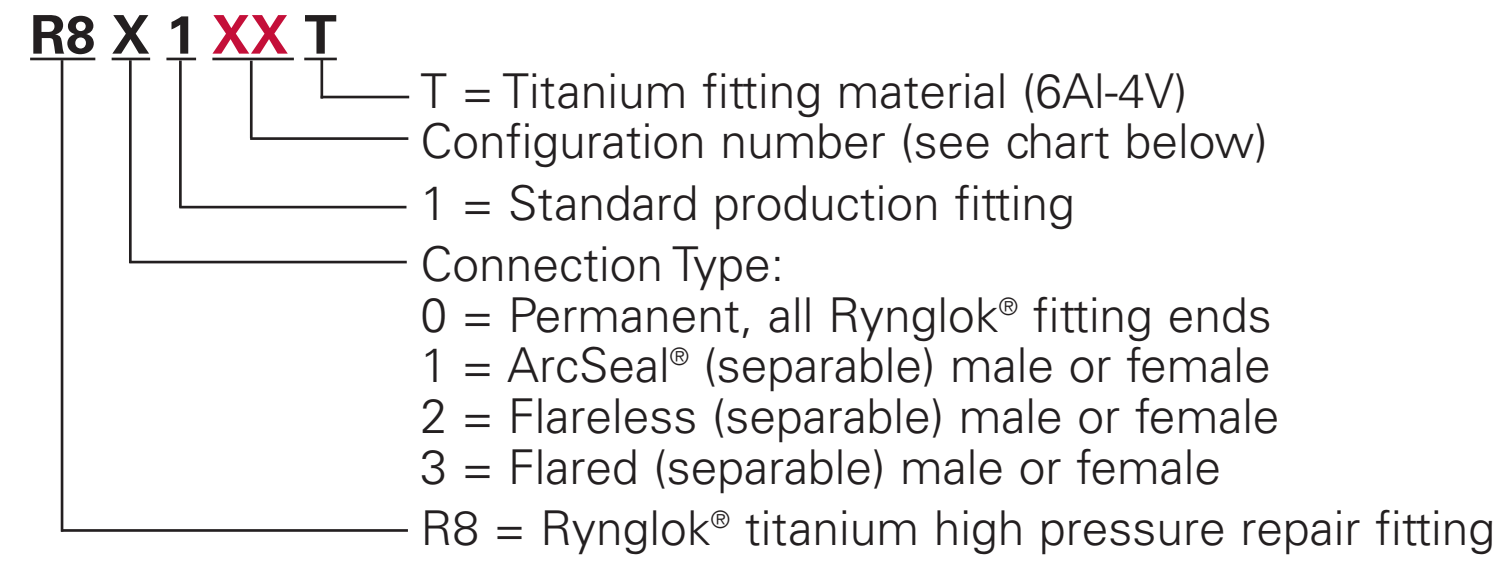


Eaton | Aerospace

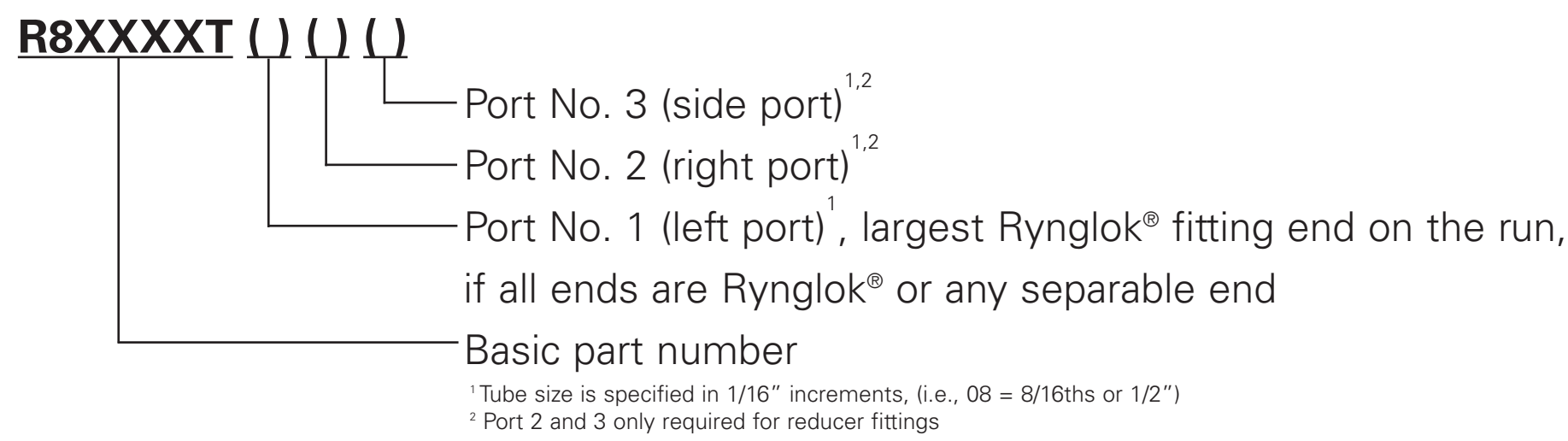
Aeroquip® Brand Rynglok® Tube Repair System

AE61731-0605 BULKHEAD
 2X NAS1351C3-11 SCREW
 2X NAS1149C0363R WASHER
 2X MS21043-3 NUT
 TORQUE TO 30-45 IN-LB

Rynglok® Basic Part Number Designation



How To Order



| | PERMANENT TO ARCSEAL® | | | PERMANENT TO "MS" FLARELESS | | | PERMANENT TO "AN" FLARED | | | |
|--------------------------------|------------------------|-----------------------------------|----------------------------|---|-----------------|--------------------------|--------------------------------|-----------------------------|--------------------------------------|------------------|
| | PERMANENT TO PERMANENT | MALE AS85421/1 OR AS85720/1 | MALE BULKHEAD AS85421/2 | FEMALE MATES WITH AS85421 & AS85720 | MALE MS33514 | MALE BULKHEAD MS33515 | FEMALE NAS 1760 MODIFIED | MALE AS4395 (MS33656) | MALE BULKHEAD AS4396 (MS33657) | FEMALE AS1708 |
| UNION | | | | | | | | | | |
| Non-Reducer | R80101T() | R81121T() | R81141T() | R81101T() | R82121T() | R82141T() | R82101T() | R83121T() | R83141T() | R83101T() |
| Reducer | R80151T()() | R81171T()() | R81191T()() | R81151T()() | R82171T()() | R82191T()() | R82151T()() | R83171T()() | R83191T()() | R83151T()() |
| 45° ELBOW | | | | | | | | | | |
| Non-Reducer | R80102T() | R81122T() | R81142T() | R81102T() | R82122T() | R82142T() | R82102T() | R83122T() | R83142T() | R83102T() |
| Reducer | R80152T()() | R81172T()() | R81192T()() | R81152T()() | R82172T()() | R82192T()() | R82152T()() | R83172T()() | R83192T()() | R83152T()() |
| 90° ELBOW | | | | | | | | | | |
| Non-Reducer | R80103T() | R81123T() | R81143T() | R81103T() | R82123T() | R82143T() | R82103T() | R83123T() | R83143T() | R83103T() |
| Reducer | R80153T()() | R81173T()() | R81193T()() | R81153T()() | R82173T()() | R82193T()() | R82153T()() | R83173T()() | R83193T()() | R83153T()() |
| TEE (Separable on Run) | | | | | | | | | | |
| Non-Reducer | R80104T() | R81124T() | R81144T() | R81104T() | R82124T() | R82144T() | R82104T() | R83124T() | R83144T() | R83104T() |
| Reducer | R80154T()() | R81174T()() | R81194T()() | R81154T()() | R82174T()() | R82194T()() | R82154T()() | R83174T()() | R83194T()() | R83154T()() |
| TEE (Separable on Side) | | | | | | | | | | |
| Non-Reducer | | R81126T() | R81146T() | R81106T() | R82126T() | R82146T() | R82106T() | R83126T() | R83146T() | R83106T() |
| Reducer | | R81176T()() | R81196T()() | R81156T()() | R82176T()() | R82196T()() | R82156T()() | R83176T()() | R83196T()() | R83156T()() |

Rynglok® Fitting System Installation Sequence

1. Mark the Tube



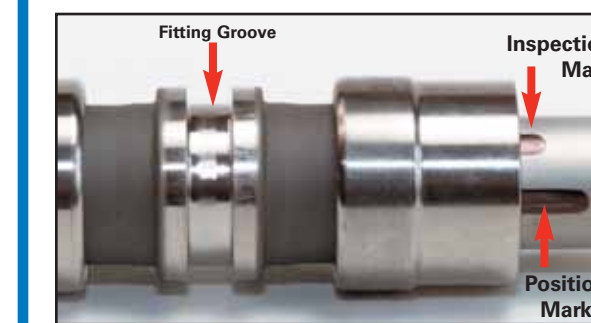
Position the Rynglok® Marking Gage (P/N: RTSG0-01-XX) on the end of the cut tube. Use a suitable marking pen to make the position and inspection marks.

4. Swaging the Fitting



To swage the fitting, apply pressure. Upon completion of swaging, release the pressure, the moveable jaw will return to the original position.

2. Position the Fitting



Place the fitting on the tube within the limits of the positioning mark.

5. Inspect the Installation



Visually inspect that the ring is fully advanced onto the fitting using the Rynglok® Inspection Gauge (P/N: RTSG0-51-XX). Be sure to verify that the edge of the fitting is within the limits of the inspection mark.

3. Position the Tool



When using the tool in the forward mode as shown, position the tool onto the fitting with the tube side of the ring nested into the moveable jaw. If positioned properly, the front end of the tool will be in the fitting groove. Make sure that the fitting is bottomed into the tool.

The fitting can also be positioned with the center of fitting nested on the moveable jaw (operation in Reverse mode).

The above steps are repeated for each leg of the Rynglok® fitting.

For a more detailed outline of the Rynglok® installation sequence see our installation bulletin.

Other Helpful Rynglok® Products



Rynglok® Hose Fittings (AE30705X) available for joining Aeroquip® brand 246 hose to tubing for 3000-psi applications.



Optional Multi-Axis Swivel can be added to tool for easier connection to hose.



Rynglok® Extended Length Unions (R80501TXX) are capable of joining two tube sections when a longer span is required.