

**f. Hose and Tube Fitting Assembly Procedures.** (Figure 1-4.)

**g. Decimal Equivalent Conversions.** (Figure 1-5.)

**h. Dimensions and Tolerances.**

(1) Dimensions in this manual are normally in inches, unless otherwise specified, and decimal fractions thereof. Common fractions are used to refer to rivets, cables, raw stock, and other items supplied in fractional sizes, and sometimes for an estimated or nominal dimension which cannot or need not be more precise. Angles are stated in degrees and common fractions.

(2) Tolerances on dimensions in decimal fractions of an inch can be determined by the number of decimal places unless otherwise specified as shown below. Tolerances on angles are in common fractions of a degree.

**1-29. Reuse of Self-Locking Nuts.** The following information provides application and reuse procedures for self-locking nuts. For additional information refer to TM 1-1500-204-23 series.

**WARNING**

**Self-locking nuts shall not be reused in applications where failure could cause loss of the aircraft or endanger life.**

**a. General.** New self-locking nuts or bolts provide tight connections which will not loosen under vibration. Self-locking nuts or bolts approved for use

**FITTINGS INTO COMPONENT BOSSES**

1. Assemble the fitting by first running the nut over the thread relief between the two threaded sections, and on to the upper thread so that the nut recess faces the thread relief and projects about 1/32 inch over it.
2. Grasp the backup ring by the O.D. and squeeze between thumb and forefinger. Thread the end of the fitting into the inside diameter so that the bevel shaped backup ring has the bowed-out position toward the nut. Do not use any lubricant. Thread the fitting all the way through backup ring until washer is free at the relief section. Pick off any slivers of plastic material that may be cut free by this process.
3. Press the backup ring into the nut recess. Bring the nut down to meet the backup ring at the relief section so that the fitting threads will not interfere with placement of the backup ring.
4. Lubricate the male threads of fitting and packing. Assemble the packing to the fitting and position the nut so that the packing is pressed against the lower threaded section.
5. Install the bulkhead fitting assembly into the boss until packing contacts the boss countersink. Then, holding the nut in position, turn the fitting in from 1-1/2 - 2-1/2 turns, according to the outlet position desired. Tighten the nut to the proper torque.

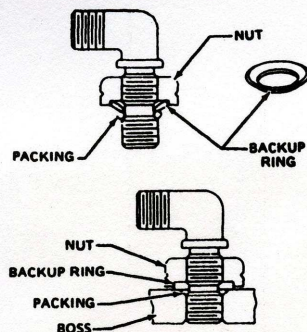


Figure 1-2. Hose and Tube Fitting— Assembly Procedures (Sheet 1 of 2)