

"H" Repair Fitting and Kit



EATON

Powering Business Worldwide

"H" Fitting Installation Procedure and Specifications

Eaton's "H" Fittings are the quick, permanent repair fittings that get military and commercial aircraft off the ground fast!

- Immediate in-field repair capabilities
- Permanent connectivity
- Saves time and money
- No special tooling required for installation
- Accommodates all tubing materials
- Design in accordance with Boeing BACC42W
- Installs within envelope dimensions similar to those of standard flared and flareless union assemblies
- FAA approved
- Passes pressure impulse, fatigue, and burst test requirements of MIL-F-18280 flareless fitting specification
- Also meets or exceeds joint tensile strength of in-line flareless fitting installations

Remove burrs from tube ends. Maximum allowable gap between ends is .250" (6.35 mm). Position arrow on template in center of gap. Wrap tape opposite shaded area. Mark dot on tube opposite template dot.

Position Components

Position fitting components onto tube ends with union against tape.

Tighten Assembly

Start nut onto coupling and tighten with union against tape. Continue tightening until great torque increase is felt as the slide and coupling bottom against union. Check for visibility of mark.

Inspect Joint

Back off nut and assure that slide and coupling are bottomed against shoulder of union. Union must contact tape, and edge of coupling must intersect tube mark.

Retighten

Retighten assembly.

Available Repair Kit Options

Dimensions: inches (mm)

Kit Part Number	Fitting Quantity	Tube Sizes	Boeing Part NO.
HRK 100	4	1/4 (6.3)	BACC42W04T
	4	3/8 (9.5)	BACC42W06T
	4	1/2 (12.7)	BACC42W08T
HRK 101	4	1/4 (6.3)	BACC42W04T
	4	5/16 (7.9)	BACC42W05T
	4	3/8 (9.5)	BACC42W06T
	4	1/2 (12.7)	BACC42W08T
HRK 102	4	1/4 (6.3)	BACC42W04T
	4	3/8 (9.5)	BACC42W06T
	4	1/2 (12.7)	BACC42W08T
	2	5/8 (15.8)	BACC42W10T
	2	3/4 (19.0)	BACC42W12T
	HRK 103	4	1/4 (6.3)
	4	5/16"	BACC42W05T
	4	3/8 (9.5)	BACC42W06T
	4	1/2 (12.7)	BACC42W08T
	2	5/8 (15.8)	BACC42W10T
	2	3/4 (19.0)	BACC42W12T
HRK 104	4	1/4 (6.3)	BACC42W04T
	4	3/8 (9.5)	BACC42W06T
	4	1/2 (12.7)	BACC42W08T
	2	5/8 (15.8)	BACC42W10T
	2	3/4 (19.0)	BACC42W12T
	2	1 (25.4)	BACC42W16T
HRK 105	4	1/4 (6.3)	BACC42W04T
	4	5/16"	BACC42W05T
	4	3/8 (9.5)	BACC42W06T
	4	1/2 (12.7)	BACC42W08T
	2	5/8 (15.8)	BACC42W10T
	2	3/4 (19.0)	BACC42W12T
	2	1 (25.4)	BACC42W16T
HRK 099	THIS KIT CONTAINS:		

- Tubing Lengths
- Tube Cutter
- Deburring Tool
- Installation Templates
- Instruction Manual

Prepare Tubes



"H" Fitting Assembly

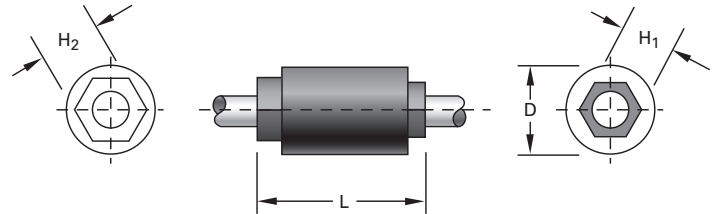
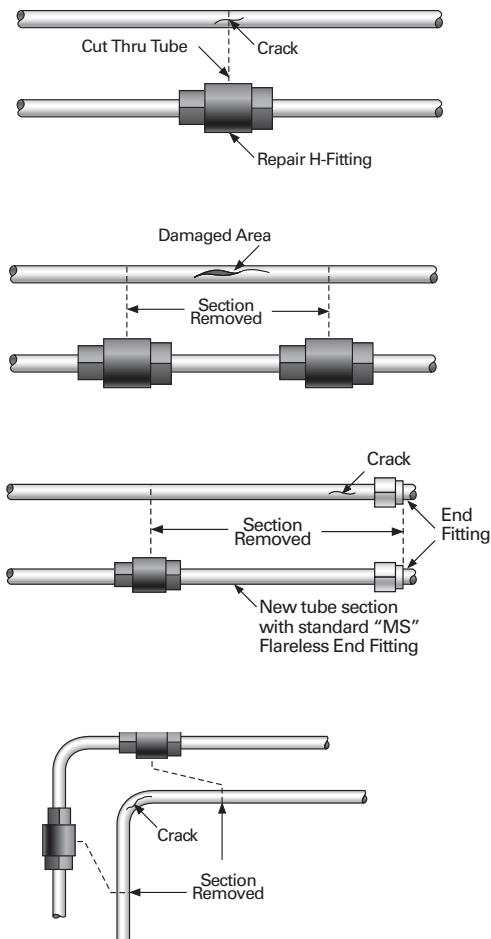
Qualified Tube Combinations

Tube Material

Size	Cres 304 1/8 Hard	Cres 21-6-9	Cres 304 Annealed	Aluminum 6061 - T6	Titanium 3AL - 2.5V
04	X	X	X	X	X
05	X	X			
06	X	X	X	X	X
08	X	X	X	X	X
10	X	X	X	X	X
12	X	X	X	X	
16	X	X	X	X	

Qualified to MIL F-18280 and BPS-F-142. The BACC42W "H" Repair Fitting is qualified for repair of 3000 psi (20685 kPa) hydraulic pressure and return lines.

Typical Repair Installation

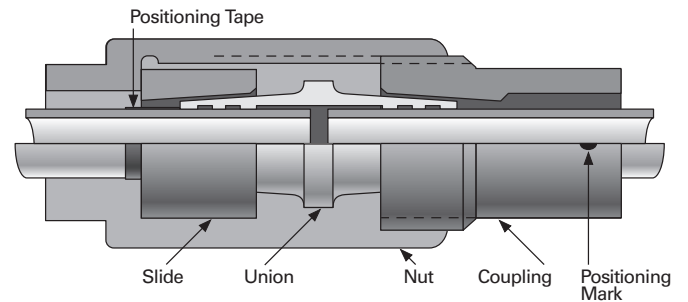


Part Number and Dimensions

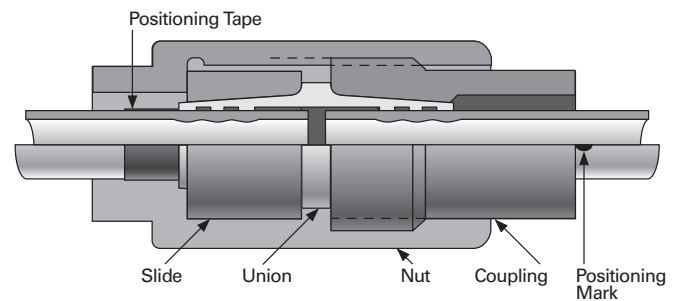
Dimensions: inches/mm

Part No.	Tube O.D.	"D" Dia.	"H1"	"H2"	Assembled Length
36011V04	.250/6.35	.780/19.8	.438/11.1	.688/17.4	2.35/59.6
36011V05	.312/7.9	.900/22.8	.500/12.7	.750/19.0	2.35/59.6
36011V06	.375/9.5	.950/24.1	.625/15.8	.750/19.0	2.35/59.9
36011V08	.500/12.7	1.125/28.5	.750/19.0	.875/22.2	2.35/59.6
36011V10	.625/15.8	1.300/33.0	.875/22.2	1.063/27.0	2.35/59.6
36011V12	.750/19.0	1.420/36.0	.938/23.8	1.250/31.7	2.95/59.6
36011V16	1.000/25.4	1.700/43.1	1.187/47.4	1.500/38.0	2.95/59.6

"H" Fitting Before and After Installation



When the nut, slide, union, and coupling are in position on the tube, the gap between the cut tube ends is in the center of the union. One end of the union rests against the tape.



Once the "H" Fitting has been tightened, the slide and the coupling have "bottomed" onto the union, making a permanent seal. The union still rests against the tape, and the dot is now intersected by the hex-end of the coupling.

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