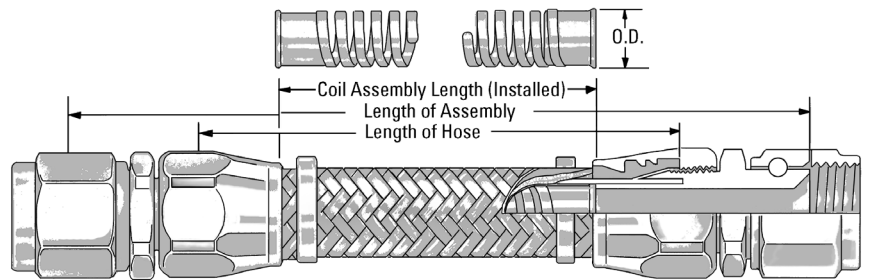


Eaton's Aeroquip part number 900780 Internal Support Coil is used to help prevent damage to hoses which are subject to mishandling, vacuum application, or tight installation.

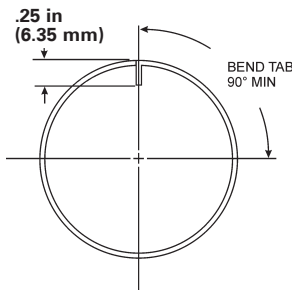
Part number 900800A Internal Sleeve is to be used in conjunction with the Internal Support Coil. It acts as an anchor point for the coil and prevents fluids of high viscosity or extreme flow rates from forcing the Internal Support Coil out through the end fittings.

The Internal Support Coil is a flat, helically wound, stainless steel reinforcing coil of 302 type- AMS-5516.

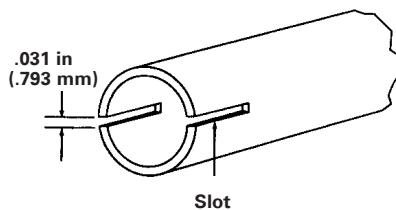


Installation Instructions

- Step 1.** Determine the proper size and style of hose and fittings for the application.
- Step 2.** Cut the hose to the proper length ("J" factor).
- Step 3.** Select the proper size internal support coil and internal sleeve (2 required) from Table 1.
- Step 4.** Determine the correct length of coil to be cut using the applicable formula from Table 1.
- Step 5.** Cut by any convenient method and remove all sharp edges and corners.
- Step 6.** Both ends of the internal support coil should then be bent into tabs as shown below.



- Step 7.** To install the internal support coil in the hose, use a rod or a piece of tubing slightly longer than the cut length of the hose. Slot the end with a hacksaw as shown below. Insert the slotted rod into the coil and place the tab in the slot, "coil down", until the support coil is approximately 6 inches (152.39 mm) longer than the cut length of the hose and the O.D. of the coil is smaller than the I.D. of the hose. Slide the "coiled down" piece inside the hose using care not to damage the inner tube. Position the coil so that equal lengths protrude from either end. Then slowly release the coil from the slotted tool.



- Step 8.** To attach the internal sleeve, place the coil end tab through the hole in the sleeve. Push the internal sleeve into the hose by winding slightly. The internal sleeve must be inserted into hose to a depth slightly greater than the depth of the end fitting to be attached.
- Step 9.** Assemble the hose end fittings in accordance with the hose assembly procedures reference on the hose assembly drawing.
- Step 10.** Position the Internal Sleeve so that it is within .25 inch (6.35 mm) from the nipple end of the fitting.
- Step 11.** Select the proper clamping size from Table 1. Position the clamp over the bent tab area of the coil, .50-.62 inch (12.70-15.75 mm) from the socket to the clamp, and tighten clamp. Refer to Eaton Service Bulletin, ASB-69.
- Step 12.** Inspect the completed hose assembly for the location of the coil tab in the Internal Sleeve, for the relationship of the sleeve to the nipple.



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To determine coil length (number of coils) required for a specific hose assembly length:

1. Obtain J dimension in inches for hose assembly being fabricated from hose assembly standard drawing.
2. Determine applicable formula for size and type of hose from Table 1, below.
3. Computer length of coil needed as shown:

Example: Hose 601-16

Cut length of hose ("J" factor) of 20 inches.

Formula: 3.4 (J-2.4)

3.4 (20-2.4)

3.4 (17.6)

3.4 x 17.6 = 59.8

Coil length in number of coils = 59.8 coils

Table 1

Hose No.	Dash Sizes	900800A Sleeve Size	900780 Coil Size	Coil Formula	900591B Clamp Size
302A	-16	14C	14C	3.5 (J-2.7)	3C
	-20	15C	15C	2.7 (J-3.1)	4C
	-24	17C	17C	2.8 (J-3.2)	4C
	-32	18C	18C	2.8 (J-4.1)	5C
303	-12	13C	13C	5.2 (J-3.3)	3C
601 and AE701	-12	21C	13C	5.2 (J-2.2)	2C
	-16	14C	14C	3.4 (J-2.4)	3C
	-20	15C	15C	2.6 (J-2.7)	4C
	-24	17C	17C	2.7 (J-2.9)	4C
	-32	31C	18C	2.6 (J-3.3)	5C
666	-12	13C	13C	5.3 (J-1.6)	3C
	-16	14C	14C	3.5 (J-1.7)	3C
667	-20	15C	15C	2.8 (J-2.1)	4C
	-24	17C	17C	2.8 (J-2.2)	5C