

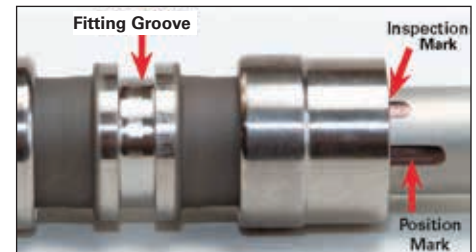
Step 1

Select the proper RTSGO-01-Size marking gauge. Position the gauge on the end of the cut tube. Use a suitable marking pen to make the positioning marks. Remove the gauge.



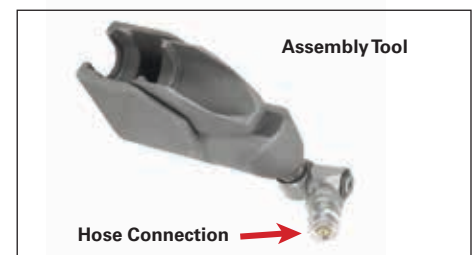
Step 2

Install fitting on tube and use the positioning mark to position the edge of the unwaged fitting ring over the mark. The edge of the fitting ring may be anywhere along the length of the positioning mark.



Step 3

Select the correct size assembly tool. Attach the flexible hose with the mating quick disconnect coupling to the nipple at the bottom of the tool, and the nipple end of the hose to the mating quick disconnect coupling on the pump.



Step 4

Position the tool onto the fitting, with the ring nested into the movable jaw of the tool and the front opening of the tool bottomed into the fitting. Make sure that the fitting is bottomed into the tool.

Pressurize the tool to advance the fitting ring. Adequate pressure should be used to move the ring to its full forward position (approximately 8000-8500 psi). Release pressure. The movable jaw of the assembly tool will return to the original position.



Step 5

The fitting installation should be verified by visual inspection that the ring is fully advanced onto the fitting using the inspection gauge RTSGO-51-Size, which should fit over the ring after swaging. Also verify that the edge of the fitting is touching or over the inspection mark.

For detailed information on how to install Rynglok® fittings, please see the installation guide, Form No. TF100-67.



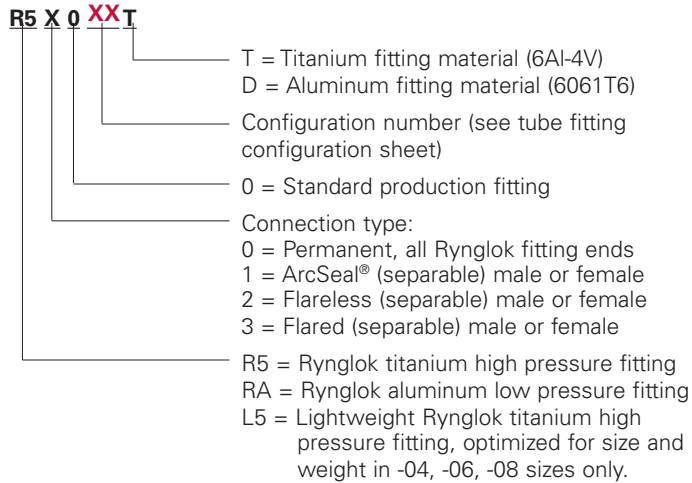
Powering Business Worldwide

Rynglok tube fitting configuration

	PERMANENT TO ARCSEAL™				PERMANENT TO "MS" FLARELESS				EXTRA FINE THREAD, HIGH PRESSURE FLARELESS <small>—Fittings for use on the Airbus A380 5000 psi high-pressure fluid delivery systems</small>				PERMANENT TO "AIN" FLARED			
	PERMANENT TO PERMANENT	MALE AS65421/1 OR AS65720/1	MALE BULKHEAD AS95421/2	FEMALE MATES WITH AS85421 & AS65720	MALE M533514	MALE BULKHEAD M533515	FEMALE NAS 1760 MODIFIED	MALE EN6123 & AS5827	MALE BULKHEAD AS5828	FEMALE	MALE AS4396 (M533656)	MALE BULKHEAD AS4396 (M533657)	FEMALE AS1708	MALE AS4396 (M533656)	MALE BULKHEAD AS4396 (M533657)	FEMALE AS1708
UNION																
Non-Reducer	R80101(T)	R81121(T)	R81141(T)	R81101(T)	R82121(T)	R82141(T)	R82101(T)	R82421(T)	R82401(T)	R83121(T)	R83141(T)	R83101(T)	R83121(T)	R83141(T)	R83101(T)	
Reducer	R80151(T, H)	R81171(T, H)	R81191(T, H)	R81151(T, H)	R82171(T, H)	R82191(T, H)	R82151(T, H)	R82471(T, H)	R82451(T, H)	R83171(T, H)	R83191(T, H)	R83151(T, H)	R83171(T, H)	R83191(T, H)	R83151(T, H)	
45° ELBOW																
Non-Reducer	R80102(T)	R81122(T)	R81142(T)	R81102(T)	R82122(T)	R82142(T)	R82102(T)	R82422(T)	R82402(T)	R83122(T)	R83142(T)	R83102(T)	R83122(T)	R83142(T)	R83102(T)	
Reducer	R80152(T, H)	R81172(T, H)	R81192(T, H)	R81152(T, H)	R82172(T, H)	R82192(T, H)	R82152(T, H)	R82472(T, H)	R82452(T, H)	R83172(T, H)	R83192(T, H)	R83152(T, H)	R83172(T, H)	R83192(T, H)	R83152(T, H)	
90° ELBOW																
Non-Reducer	R80103(T)	R81123(T)	R81143(T)	R81103(T)	R82123(T)	R82143(T)	R82103(T)	R82423(T)	R82403(T)	R83123(T)	R83143(T)	R83103(T)	R83123(T)	R83143(T)	R83103(T)	
Reducer	R80153(T, H)	R81173(T, H)	R81193(T, H)	R81153(T, H)	R82173(T, H)	R82193(T, H)	R82153(T, H)	R82473(T, H)	R82453(T, H)	R83173(T, H)	R83193(T, H)	R83153(T, H)	R83173(T, H)	R83193(T, H)	R83153(T, H)	
TEE (Separable on Run)																
Non-Reducer	R80104(T)	R81124(T)	R81144(T)	R81104(T)	R82124(T)	R82144(T)	R82104(T)	R82424(T)	R82404(T)	R83124(T)	R83144(T)	R83104(T)	R83124(T)	R83144(T)	R83104(T)	
Reducer	R80154(T, H)	R81174(T, H)	R81194(T, H)	R81154(T, H)	R82174(T, H)	R82194(T, H)	R82154(T, H)	R82474(T, H)	R82454(T, H)	R83174(T, H)	R83194(T, H)	R83154(T, H)	R83174(T, H)	R83194(T, H)	R83154(T, H)	
TEE (Separable on Side)																
Non-Reducer	R81126(T)	R81126(T)	R81146(T)	R81106(T)	R82126(T)	R82146(T)	R82106(T)	R82426(T)	R82406(T)	R83126(T)	R83146(T)	R83106(T)	R83126(T)	R83146(T)	R83106(T)	
Reducer	R81176(T, H)	R81176(T, H)	R81196(T, H)	R81156(T, H)	R82176(T, H)	R82196(T, H)	R82156(T, H)	R82476(T, H)	R82456(T, H)	R83176(T, H)	R83196(T, H)	R83156(T, H)	R83176(T, H)	R83196(T, H)	R83156(T, H)	

Rynglok fitting part number system and how to order

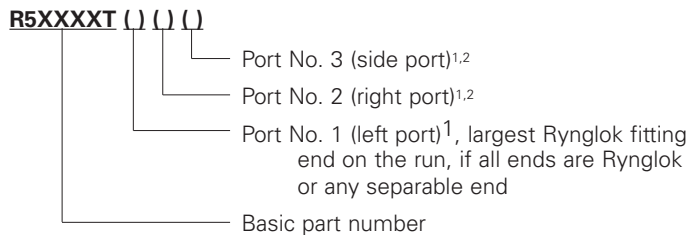
Basic part number designation



Example: R51003T10

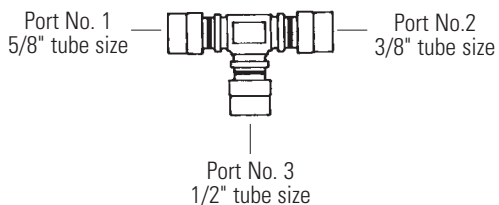
Rynglok fitting, female ArcSeal (separable) to Rynglok fitting in the 90° elbow configuration.

How to Order



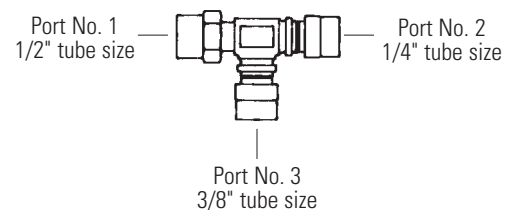
Example: RA0054D100608

Rynglok fitting, reducing tee, all legs permanent.



Example: L51054T080406

Lightweight Rynglok reducing tee, with female ArcSeal separable.



¹ Tube size is specified in 1/16" increments, (i.e., 08=8/16ths or 1/2")

² Port 2 and 3 only required for reducer fittings

NOTE: Port numbering system is in accordance with AIR 1590.

For additional information contact Eaton, Aerospace Group, Fluid & Electrical Distribution Division, 300 S. East Ave., Jackson, Michigan 49203 **Ph:** (517) 787-8121 **Fax:** (517) 789-2947.

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