



AE51731-0605 BULKHEAD F  
2X NAS1351C3-11 SCREW  
2X NAS1149C0363R WASHER  
2X MS21043-3 NUT  
TORQUE TO 30-45 IN-LBS

# Aeroquip® Brand Rynglok™ Tube Repair System

## Rynglok™ Basic Part Number Designation

**R8 X X XX T**

- T = Titanium fitting material (6Al-4V)
- Configuration number (see chart below)
- 1 = Standard production fitting
- 4 = Extra-fine thread for High Pressure Flareless
- Connection Type:
  - 0 = Permanent, all Rynglok fitting ends
  - 1 = ArcSeal™ (separable) male or female
  - 2 = Flareless (separable) male or female
  - 3 = Flared (separable) male or female
- R8 = Rynglok titanium high pressure repair fitting

## How To Order

**R8XXXXT ( ) ( ) ( )**

- Port No. 3 (side port)<sup>1,2</sup>
- Port No. 2 (right port)<sup>1,2</sup>
- Port No. 1 (left port)<sup>1</sup>, largest Rynglok fitting end on the run, if all ends are Rynglok or any separable end
- Basic part number

<sup>1</sup> Tube size is specified in 1/16" increments, (i.e., 08 = 8/16ths or 1/2")  
<sup>2</sup> Port 2 and 3 only required for reducer fittings

|                                | PERMANENT TO PERMANENT | PERMANENT TO ARCSEAL™       |                         |                                     | PERMANENT TO "MS" FLARELESS |                       |                          | EXTRA FINE THREAD, HIGH PRESSURE FLARELESS |                      |                     | PERMANENT TO "AN" FLARED |                                |                     |
|--------------------------------|------------------------|-----------------------------|-------------------------|-------------------------------------|-----------------------------|-----------------------|--------------------------|--|----------------------|---------------------|--------------------------|--------------------------------|---------------------|
|                                |                        | 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 EN6123 & AS5827                       | MALE BULKHEAD AS5828 | FEMALE              | MALE AS4395 (MS33656)    | MALE BULKHEAD AS4396 (MS33657) | FEMALE AS1708       |
| <b>UNION</b>                   |                        |                             |                         |                                     |                             |                       |                          |  |                      |                     |                          |                                |                     |
| <b>Non-Reducer</b>             | R80101T ( )            | R81121T ( )                 | R81141T ( )             | R81101T ( )                         | R82121T ( )                 | R82141T ( )           | R82101T ( )              | R82421T ( )                                | R82441T ( )          | R82401T ( )         | R83121T ( )              | R83141T ( )                    | R83101T ( )         |
| <b>Reducer</b>                 | R80151T ( ) ( )        | R81171T ( ) ( )             | R81191T ( ) ( )         | R81151T ( ) ( )                     | R82171T ( ) ( )             | R82191T ( ) ( )       | R82151T ( ) ( )          | R82471T ( ) ( )                            | R82491T ( ) ( )      | R82451T ( ) ( )     | R83171T ( ) ( )          | R83191T ( ) ( )                | R83151T ( ) ( )     |
| <b>45° ELBOW</b>               |                        |                             |                         |                                     |                             |                       |                          |  |                      |                     |                          |                                |                     |
| <b>Non-Reducer</b>             | R80102T ( )            | R81122T ( )                 | R81142T ( )             | R81102T ( )                         | R82122T ( )                 | R82142T ( )           | R82102T ( )              | R82422T ( )                                | R82442T ( )          | R82402T ( )         | R83122T ( )              | R83142T ( )                    | R83102T ( )         |
| <b>Reducer</b>                 | R80152T ( ) ( )        | R81172T ( ) ( )             | R81192T ( ) ( )         | R81152T ( ) ( )                     | R82172T ( ) ( )             | R82192T ( ) ( )       | R82152T ( ) ( )          | R82472T ( ) ( )                            | R82492T ( ) ( )      | R82452T ( ) ( )     | R83172T ( ) ( )          | R83192T ( ) ( )                | R83152T ( ) ( )     |
| <b>90° ELBOW</b>               |                        |                             |                         |                                     |                             |                       |                          |  |                      |                     |                          |                                |                     |
| <b>Non-Reducer</b>             | R80103T ( )            | R81123T ( )                 | R81143T ( )             | R81103T ( )                         | R82123T ( )                 | R82143T ( )           | R82103T ( )              | R82423T ( )                                | R82443T ( )          | R82403T ( )         | R83123T ( )              | R83143T ( )                    | R83103T ( )         |
| <b>Reducer</b>                 | R80153T ( ) ( )        | R81173T ( ) ( )             | R81193T ( ) ( )         | R81153T ( ) ( )                     | R82173T ( ) ( )             | R82193T ( ) ( )       | R82153T ( ) ( )          | R82473T ( ) ( )                            | R82493T ( ) ( )      | R82453T ( ) ( )     | R83173T ( ) ( )          | R83193T ( ) ( )                | R83153T ( ) ( )     |
| <b>TEE (Separable on Run)</b>  |                        |                             |                         |                                     |                             |                       |                          |  |                      |                     |                          |                                |                     |
| <b>Non-Reducer</b>             | R80104T ( )            | R81124T ( )                 | R81144T ( )             | R81104T ( )                         | R82124T ( )                 | R82144T ( )           | R82104T ( )              | R82424T ( )                                | R82444T ( )          | R82404T ( )         | R83124T ( )              | R83144T ( )                    | R83104T ( )         |
| <b>Reducer</b>                 | R80154T ( ) ( ) ( )    | R81174T ( ) ( ) ( )         | R81194T ( ) ( ) ( )     | R81154T ( ) ( ) ( )                 | R82174T ( ) ( ) ( )         | R82194T ( ) ( ) ( )   | R82154T ( ) ( ) ( )      | R82474T ( ) ( ) ( )                        | R82494T ( ) ( ) ( )  | R82454T ( ) ( ) ( ) | R83174T ( ) ( ) ( )      | R83194T ( ) ( ) ( )            | R83154T ( ) ( ) ( ) |
| <b>TEE (Separable on Side)</b> |                        |                             |                         |                                     |                             |                       |                          |  |                      |                     |                          |                                |                     |
| <b>Non-Reducer</b>             |                        | R81126T ( )                 | R81146T ( )             | R81106T ( )                         | R82126T ( )                 | R82146T ( )           | R82106T ( )              | R82426T ( )                                | R82446T ( )          | R82406T ( )         | R83126T ( )              | R83146T ( )                    | R83106T ( )         |
| <b>Reducer</b>                 |                        | R81176T ( ) ( ) ( )         | R81196T ( ) ( ) ( )     | R81156T ( ) ( ) ( )                 | R82176T ( ) ( ) ( )         | R82196T ( ) ( ) ( )   | R82156T ( ) ( ) ( )      | R82476T ( ) ( ) ( )                        | R82496T ( ) ( ) ( )  | R82456T ( ) ( ) ( ) | R83176T ( ) ( ) ( )      | R83196T ( ) ( ) ( )            | R83156T ( ) ( ) ( ) |

## Rynglok™ Fitting System Installation Sequence

### 1. Mark the Tube



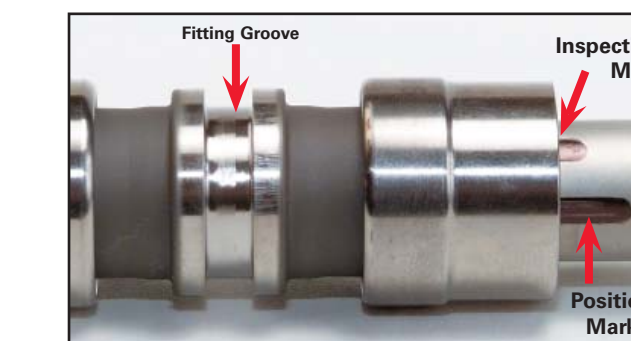
Position the Rynglok Marking Gage (P/N: RTSG0-01-XX) on the end of the cut tube. Use a suitable marking pen to make the position and inspection marks.

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

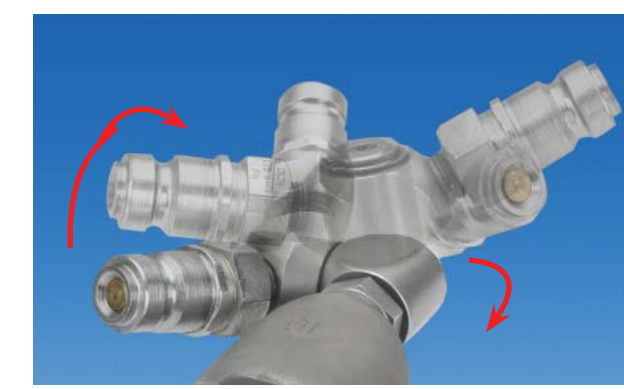
For a more detailed outline of the Rynglok installation sequence see our installation bulletin.

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

## 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 (R80501TX) are capable of joining two tube sections when a longer span is required.