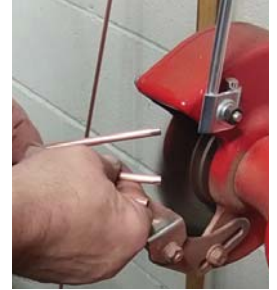
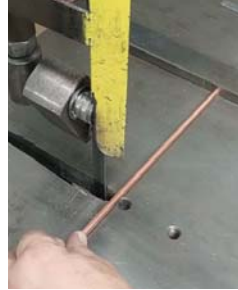
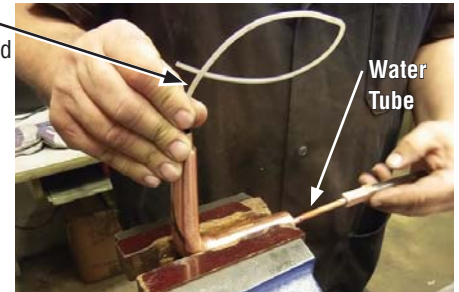
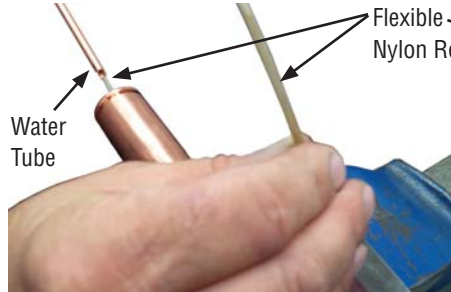


The following instructions should be followed to replace a water tube in a bent adapter.

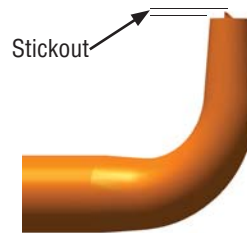
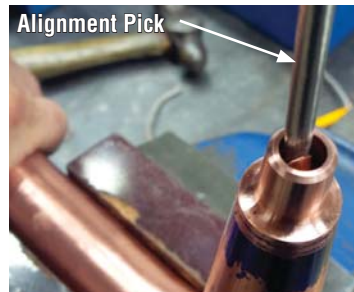
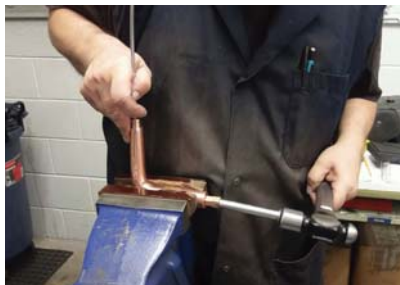
1. Measure the stickout or recess of the existing water tube. This measurement may also be shown on the part print.



2. Remove the old water tube completely and ensure that the through hole is clear. Next, insert a flexible nylon rod through the adapter to determine the overall length; add 1.5" to this length to determine the required overall length of the water tube.
3. Measure and cut the raw water tube to the required overall length.
4. Cut the non-flared water tube end on an angle to specifications or as shown on the print. If available, an angle fixture is recommended; otherwise, use appropriate measures to ensure accuracy.
5. Use wire wheel to remove burrs from the cut end.



6. Solder the rear insert on the tube (if required). For bent adapters, soften the tube by heating to a cherry red color and quenching it in water.
7. Apply a small amount of oil to the outside surface of the water tube to facilitate installation in the adapter.
8. To facilitate installation of the water tube, feed the flexible nylon rod through the adapter. Insert cut angle of the water tube onto the flexible nylon rod which will help guide the water tube through the bends in the adapter. Using an appropriate size punch, gently hammer in the water tube on the flared end.



9. Continue to lightly tap the end of the water tube to push it through the adapter until it comes up to the end of the taper. Remove the flexible plastic rod.
10. Insert an alignment pick to adjust the water tube so that it is straight, centered and round.
11. Make minor adjustments to ensure the angled end stickout (see image) or recess is appropriate. Use the measurement in item 1, the part print or customer specifications.
12. Lastly, cut the flared end to print or customer specifications.

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