

REPAIR PROCEDURE OUTLINE

1. Identify the section requiring repair and clean off all mud and debris.
2. Using the tubing cutter in the Kit remove the section to be replaced, being sure to leave the required amount of tubing length (see Kit instructions).

CAUTION: A tubing cutter must be used to cut the tubes. This is to reduce burrs and to prevent foreign material from entering the open tube.

Do not use a hack saw or other cutting tools.

3. Cut a matching section from the new service part.
4. Prepare all four ends to be joined together with the cleaning pad included in the Kit.

CAUTION: Always clean the ends with a radial motion around the tube.

Do not put linear scratches along the length of the tube.

5. Apply a drop of sealing compound from the Kit onto each tube end.
6. Insert the tube ends into the correct-size connectors and rotate the connector one complete full turn to evenly distribute the sealing compound.
7. Following the instructions in the Kit install the tool over the connector and tubes.
8. Use a 3/8" drive "breaker bar" to prevent the tool body from rotating while turning the forcing screw until both the connector collars have bottomed out.

Do not use power tools on the forcing screw.

- Complete instructions on the repair procedure are given on the printed label affixed to the inner lid of the Tubing Repair Kit box.
- An example of the label in the Kit is on the next page.

J-41425-NIS ALUMINUM TUBE REPAIR KIT

This kit features new style compression fittings for fast, easy and leak free line repairs.

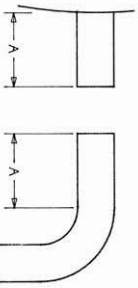


WARNING

Connectors in this kit are intended for Aluminum Tubing repairs only. Their use on any other type of vehicle tubing could cause failures resulting in bodily injury or death.

TUBE LENGTH REQUIREMENT

Check chart for minimum amount of straight tubing required for proper connector installation.

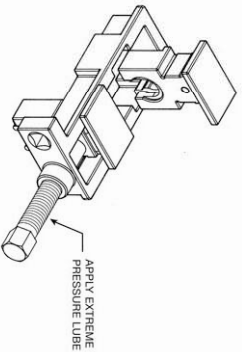
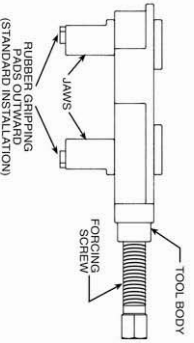


TUBE SIZE	MIN. TUBE LENGTH REQUIRED STANDARD INSTALLATION	MIN. TUBE LENGTH REQUIRED JAW REVERSED INSTALLATION
8mm	29mm	19mm - 29mm
3/8"	1 1/8" MIN.	3/4" - 1 1/8"
1/2"	1 1/8" MIN.	3/4" - 1 1/8"
12mm	29mm	19mm - 29mm
16mm	29mm	22mm - 32mm
19mm	34mm	22mm - 34mm

TOOL ASSEMBLY

Assemble tool by sliding the appropriate size jaws into the tool body.

- A.) For standard installation (see chart above), install the jaws with the rubber gripping pads facing outward.
- B.) For reversed jaw installation (see chart above), remove rubber gripping pad and install jaw with gripping pad area facing inward.



TUBE PREPARATION

- A tube cutter (like the one supplied in the kit) must be used to cut the tubes. This is to reduce burrs and to prevent foreign material from entering the open tube. Do not use a hack saw or other cutting tools.
- Clean 20mm minimum of tube ends with cleaning pad provided. To avoid longitudinal scratches in the tube, work with a rotational motion around the tube. (See Fig. A)
- Apply 1-3 drops of sealing compound (J-41425-3) to the outside of each tube end.
- Insert the tube ends into the connector and rotate the connector a complete turn to evenly distribute the sealing compound. (See Fig. B)

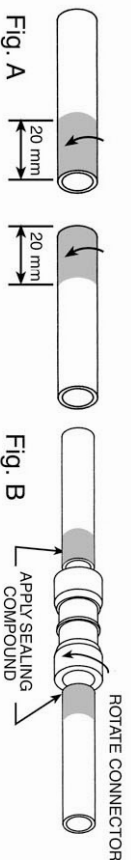


Fig. A

Fig. B

Fig. C

TOOL OPERATION

- Install tool over connector and tubes. Connector ends must be positioned in counter bores of the jaws. (See Fig. C)
- Turn the forcing screw with the appropriate hand tool only. Do not use power tools on the forcing screw or tool body. While holding the tool body with a 3/8" breaker bar. (see above) turn the forcing screw until both of the connector collars have bottomed on the center shoulder of the connector. (See Fig. D)
- Use hand tools only.

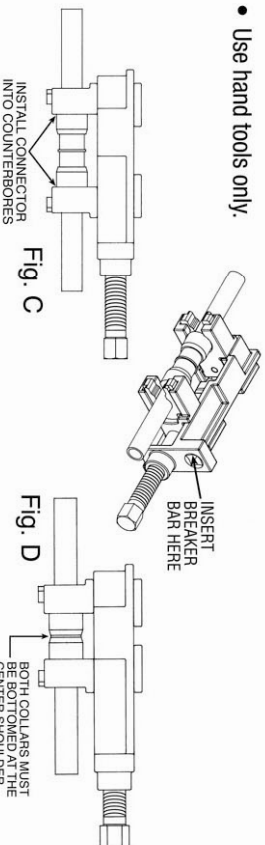


Fig. C

Fig. D

IMPORTANT!
TUBES MUST BE KEPT FULLY INSERTED INTO THE CONNECTOR TO OBTAIN A LEAK FREE JOINT.

TUBE SIZE	A/C CONNECTOR REORDER NO. PACKAGE QTY. (5)	JAW ORDER NO.
8mm	J-41425-NIS-8	J-41425-NIS-2
12mm	J-41425-NIS-12	J-41425-NIS-3
16mm	J-41425-NIS-16	J-41425-NIS-4
19mm	J-41425-NIS-19	J-41425-NIS-5
3/8"	J-41425-375*	J-41425-6*
1/2"	J-41425-500*	J-41425-8*
	SEALING COMPOUND	J-41425-3
	CLEANING PADS	J-41425-23
	MAIN BODY	J-41425-NIS-1
	EXTREME PRESSURE LUBE	280934
	TUBING CUTTER	551415

*Available, not included in essential shipment

CALL 1-800-662-2001 FOR TECHNICAL ASSISTANCE OR REORDERING

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