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ASSEMBLY PROCEDURES - 65mm Dry Break Coupling

Tooling required
Ring spanner 13mm

Assembly Jigs required
Spider tool

Testing Jigs required
Main body TEST FL 150 jig (seat tightness 150kPa)

ASSEMBLY PROCEDURE

Fitment and assembly of sealing disc; spider and main body

1 Fit the 3,53 x 55,55 Viton encapsulated o-ring (#3) on to the piston groove (#4)
2 Insert the PTFE spider bush (#9) into the stainless steel spider centre (#7) - slots facing outwards
3 Fit the spring (#12) over the sealing disc shaft, followed by the spider assembly
4 Use the "Spider tool" and clamp it over the spider assembly with the three spider tool slots over the three legs of the spider, line the spider legs up with the three groove openings on the main body flange
5 Press the spider tool down into the groove and twist in an clockwise direction to lock the spider legs into its final position
6 Secure the sealing disc rod into place with washer (#10) and nuts (#11)

TESTING PROCEDURES - 65mm Dry Break Coupling

1 Fit and secure the outlet flange of the coupling to the "TEST FL 150" jig with washers and nuts - ensure nuts are fully and securely fastened to the jig
2 Test the Shell tightness at 150kPa for 5 minutes
3 Check for leaks
a - all welding
b - external sealing area - sealing disc/main body sealing area

As per EN12266-1:2012 and EN1266-2:2012 testing regulations Table A.3 and Annex A.3.4 acceptance criteria:

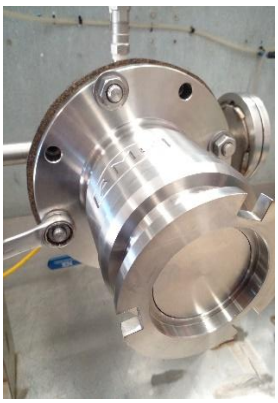
"A" No visually detectable leaks for the duration of the test

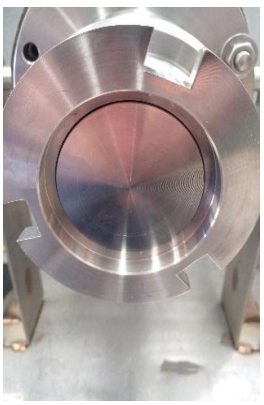
ASSEMBLY & TESTING PROCEDURES - 65mm Dry Break Coupling






1 - 6 Sealing disc, spider and main body assembly



Test 1: Shell tightness @ 150kPa