

## **ASSEMBLY PROCEDURES - Pneumatic Air Station**

### **Tooling required**

Loctite 2701  
Thread tape  
Bench vice with aluminium jaws  
Ring spanner 14mm  
Ring spanner 17mm  
Ring spanner 30mm  
Ring spanner 58mm  
Allen key no 4

### **Assembly Jigs required**

N/A

### **Testing Jigs required**

Outlet flange testing jig TEST FL 150 (shell 200kPa)  
Outlet flange testing jig TEST FL 124/150 (shell 200kPa)

### **ASSEMBLY PROCEDURE**

Fitment and assembly of main body, 36mm pressure relief valve, gauge, ball valves and regulator

- 1 Thread the thread tape around the thread of the 36mm relief valve (#20), insert into main body M51 socket (#3) and tighten and secure with ring spanner 58mm.
- 2 Thread both nipples (#6) with thread tape and fit the 3/4" ball valves and tighten and secure with ring spanner :
- 3 Thread the thread tape around the bottom entry gauge (#17) thread and fit to the pressure gauge port (#7) and tighten with ring spanner 14mm.
- 4 Remove the outlet mounting block on the pressure regulator (#16). Fit the pressure regulator (#17) to the main body mounting block (#10) and secure with M5 allen cap screw and Loctite 2701 using allen key no 4
- 5 Thread the thread tape around the back entry gauge (#18) thread and fit to the pressure regulator port (#16) and tighten with ring spanner 14mm.

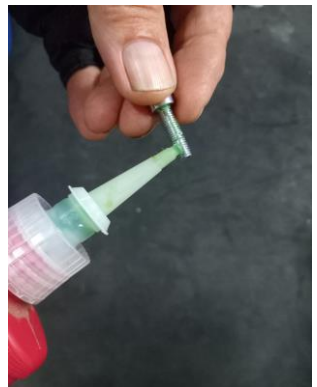
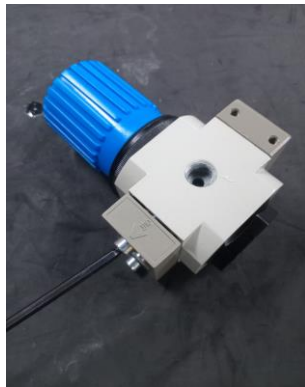
AFTER TESTING - fit and secure PTFE gasket and black flange

- 6 Fit the PTFE gasket (#19) and blank flange (#11) to the body end flange (#3) using M10 x 35mm bolts (#12) followed by the M10 spring washers (#15) and M10 nuts (#13) and tighten and secure with 17mm ring spanner

## **TESTING PROCEDURES - Pneumatic Air Station**

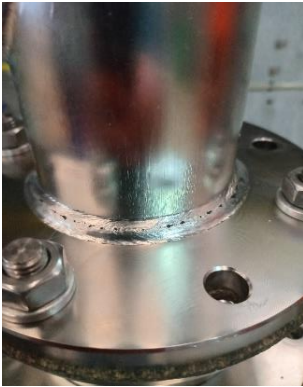
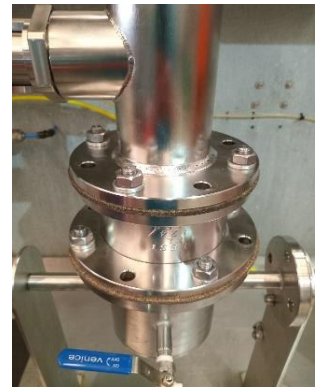
- 1 Fit and secure the "TEST FL 124/150" jig to the "TEST FL 150" jig with washers and nuts, secure the outlet flange of the air station to the "TEST FL 124/150" jig with washers and nuts, ensure nuts are fully - and securely fastened to the jig
- 2 Test the Seat tightness at 200kPa for 5 minutes
- 3 Check for leaks
  - a - all welding
  - b - 36mm pressure relief valve external sealing area
  - c - all threads, gauges, 3/4 nipples, regulator and 36mm pressure relief valve

## **ASSEMBLY & TESTING PROCEDURES - Pneumatic Air Station**

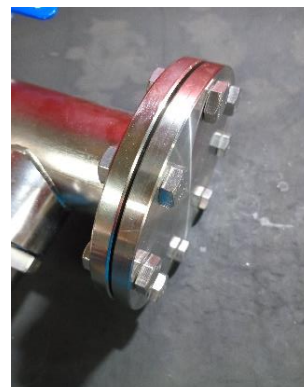


1 - 5 main body, 36mm pressure relief valve, gauge, ball valves and regulator





Test 1: Seat tightness @ 200kPa



6 PTFE gasket and black flange fitment