

ASSEMBLY PROCEDURES - Vapour Transfer Adaptor

Tooling required

Ring spanner 17mm

Assembly Jigs required

Spider tool

Testing Jigs required

Main body TEST FL 150 jig (seat tightness 20kPa)

Main body TEST FL 150 jig (shell tightness 500kPa)

ASSEMBLY PROCEDURE

Fitment and assembly of sealing disc, spider and main body

- 1 Fit the BS343 Viton encapsulated o-ring (#9) on to the sealing disc groove (#6)
- 2 Insert the PTFE spider bush (#11) into the stainless steel spider centre (#10) - slots facing outwards
- 3 Fit the spring (#13) 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

TESTING PROCEDURES - Vapour Transfer Adaptor

- 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 Seat tightness at 20kPa for 5 minutes
- 3 Check for leaks
 - a - external sealing area - sealing disc/main body sealing area
- 4 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
Test the Shell and Seat tightness at 500kPa for 5 minutes
Check for leaks
 - a - all welding
 - b - external sealing area - sealind disc/main body sealing area

As per EN12266-1:2012 testing regulations Table A.5.

criteria:

"A"

No visually detectable leaks for the duration of the test

ASSEMBLY & TESTING PROCEDURES - Vapour Transfer Valve



1 - 5 Sealing disc, spider and main body assembly



Test 1: Seat tightness @ 20kPa



Test 2: Shell tightness @ 500kPa and Seat tightness @ 500kPa