

GASKET OILING AND ADAPTOR/BONNET SCREW TIGHTENING ORDER INSTRUCTIONS

Gasket Oiling Instructions

When installing gaskets it is important to apply refrigeration oil to the gasket surfaces prior to installation.

Adding oil will soften the gasket and help to reduce the possibility of leaks by filling the small voids between the gasket and the valve. This will give the gasket time to compress and form a better bond with the valve.

1. Coat the surfaces of the gasket with a thin layer of oil. Do not dip or soak the gasket in oil.

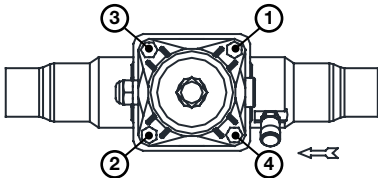


Figure 1: A8A, A81, A8 PORT, A8 SPORT Bodies - Port Sizes $\leq 1\frac{1}{8}$ (11)

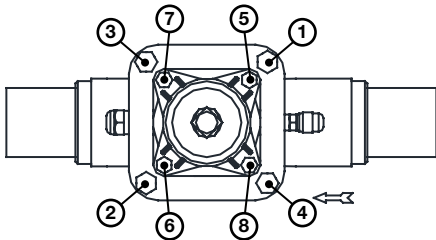


Figure 2: A82, A8 PORT, A8 A8 SPORT Bodies - Port Sizes $\geq 1\frac{1}{8}$ (13)

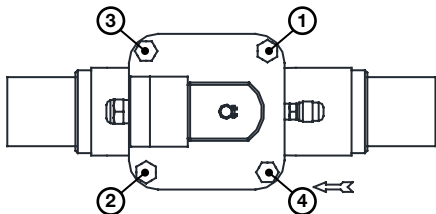


Figure 3: SC, S8 Bodies

Screw Tightening Order Instructions

1. Lubricate bolt threads and (where it contacts the valve body).
2. After bolts have been run down by hand, start wrench tightening following the sequence of the numbers shown in figures 1 thru 3 (marking the number on the valve with a crayon aids in keeping track of the tightening process).

- First time around just snug the nuts with a hand wrench.
- Second time around tighten the bolts firmly with the same wrench.
- Third time around apply approximately 25% recommended torque.
- Fourth time apply approximately 75% of recommended torque.
- Fifth time around, apply 100% of recommended torque.

Valve Bolt Torque Recommendations

Figure	Port / Valve Size	Bolts	Torque
			ft. lb.
1	$\leq 1\frac{1}{8}$ (11)	1,2,3,4	10
	$\geq 1\frac{1}{8}$ (13)	1,2,3,4	26
2	$\geq 1\frac{1}{8}$ (13)	5,6,7,8	10
	SC1, S81	1,2,3,4	10
3	SC2, S82	1,2,3,4	26

Refrigerating Specialties Division

Parker Hannifin Corporation
Refrigerating Specialties Division
 2445 South 25th Avenue
 Broadview, IL 60155-3891 USA
 Phone: (708) 681-6300
 Fax: (708) 681-6306

ISO 9001 CERTIFIED

