

KIT ITEM

IMPORTANT! After maintenance or reassembly, use new fasteners and torque fasteners as follows:

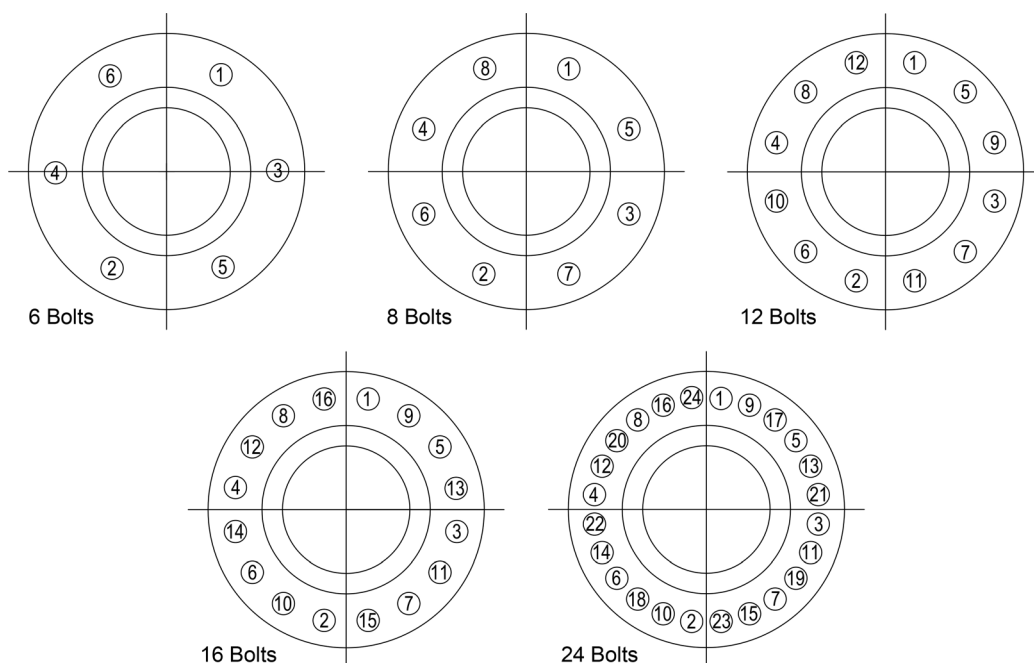
_____ FT LBS _____ IN LBS _____ Nm

Torque specifications are based on the replacement kit ordered. Check torque specifications to dampener tag. Consult factory if specifications do not match dampener tag or tag is missing.

- ◆ Read and observe all safety warnings and instructions in the Installation and Operation Manual before dampener installation, operation or repair.
- ◆ **WARNING!** Remove all pressure from dampener AND pumping system before disassembly, removal or maintenance.
- ⚠ **CAUTION!** Replace nut and bolt fasteners at each reassembly with fasteners of equal grade/strength value. **DO NOT** reuse old nuts and bolts. Fasteners may lose strength when re-torqued. Warranty voided for failure to replace both nuts and bolts when reassembling.
- △ To avoid possible damage to bellows from a system pressure test:
Adjustable and Chargeable models — charge dampener to 80% of the system test pressure prior to test.
Automatic model — prior to test, dampener must be equipped with a constant source of compressed air with pressure equal to or greater than system test pressure.
Inlet Stabilizer model — maximum pressure test 30 psi (2.0 bar), charge to 20 psi (1.3 bar) for system pressure test.

FIGURE 1

Bolt Tightening Pattern



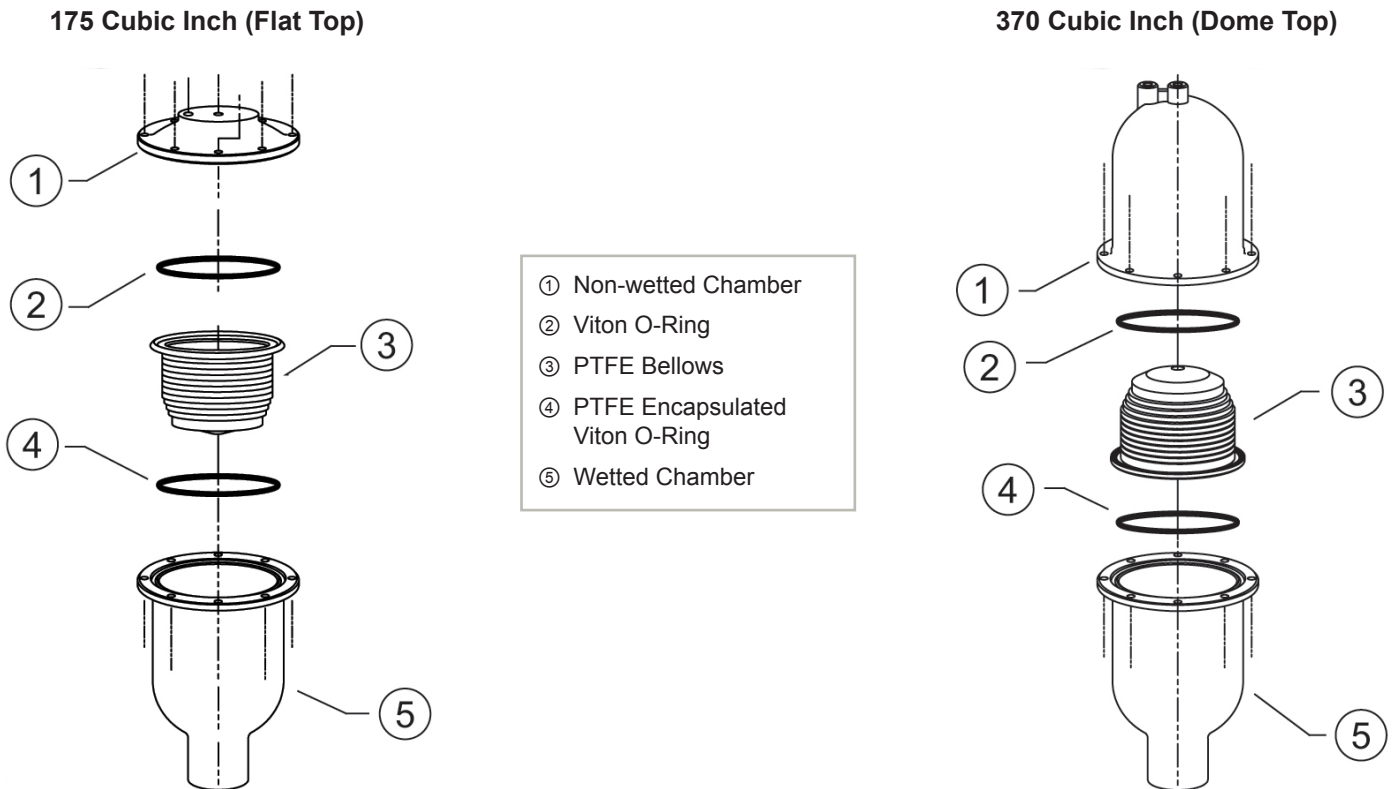
1. Disassemble dampener by removing fasteners securing wetted and non-wetted chambers. Remove and discard old bellows and O-rings. Make sure all components are clean and free of corrosion. Order replacement parts as needed.
2. Prior to installation, test fit the new PTFE encapsulated O-ring ④ in the O-ring groove on the PTFE bellows ③. If the O-ring diameter is too small to fit easily into the groove, the O-ring will need to be stretched slightly. Using your hands, gradually stretch the O-ring at multiple points around the periphery until it is a good fit in the bellows O-ring groove. **Note:** Soaking the O-ring in hot water (180°F/82°C) will make it easier to stretch.
3. Place the new PTFE encapsulated O-ring ④ into the sealing groove of the wetted chamber ⑤ centering as much as possible.
4. Place the PTFE bellows ③ into the groove ensuring the O-ring seats in the O-ring groove on the bellows. A short, back and forth, circular twist of the bellows onto the O-ring will help seat it into the bellows O-ring groove.

175 cu in (Flat Top): PTFE bellows must be pointed **down** into the wetted chamber ⑤ with open end facing **up**.

370 cu in (Dome Top): PTFE bellows must be pointed **up** into the non-wetted chamber ① with open end facing **down**.

5. Place the Viton O-ring ② into the O-ring groove on the non-wetted side of the bellows sealing bead. The O-ring may require a slight stretching to fit into the sealing bead groove.
6. For models with ring band fasteners, reinstall ring bands on wetted and non-wetted chambers with bolt holes aligned.
7. Reassemble dampener by placing the non-wetted chamber ① onto the bellows assembly aligning the bolt holes. A short circular twist of the chamber will help to seat the O-ring. Secure dampener assembly with new bolts, nuts and washers. The gap between the non-wetted and wetted chambers must remain even all around the unit.
8. Tighten bolts in a criss-cross pattern as shown in FIGURE 1, and torque to specifications on dampener tag. **DO NOT reuse old nuts and bolts. New nuts and bolts must be of equal grade/strength value.**
9. Due to the nature of PTFE, dampeners should set for 24 hours as the PTFE will *cold flow*. After 24 hours, tighten bolts again to torque specifications on dampener tag.
10. To reinstall dampener, refer to the appropriate Installation and Operation Manual for complete instructions.

FIGURE 2



M53E11_032