

KIT ITEM

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

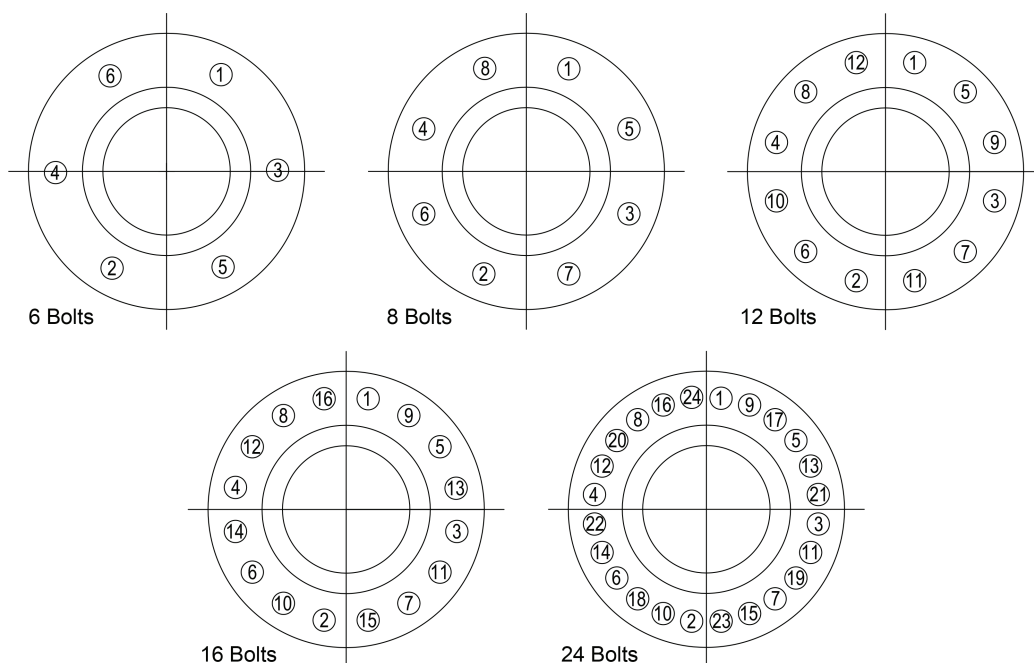
_____ FT LBS _____ IN LBS _____ Nm

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.

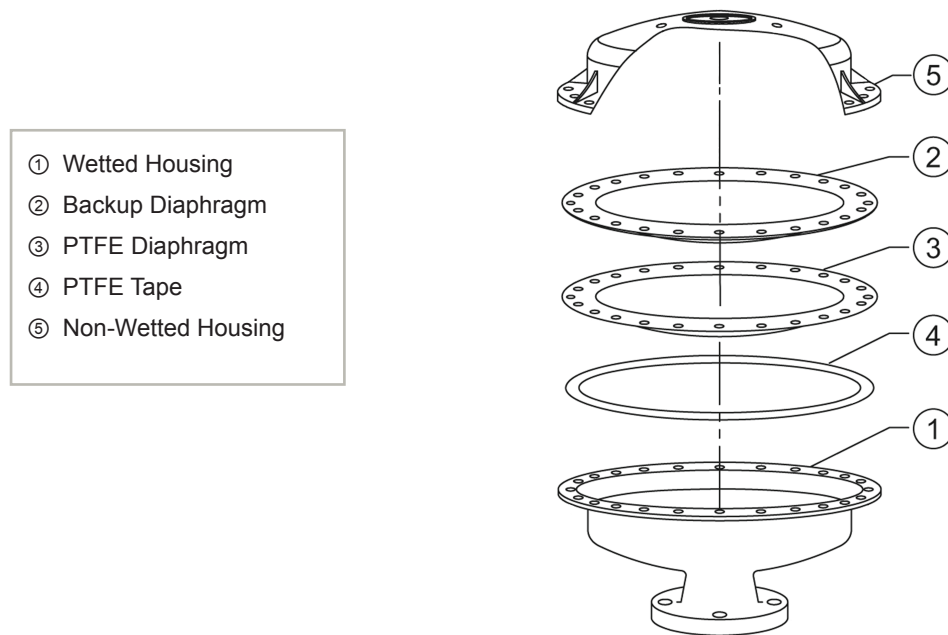
FIGURE 1

Bolt Tightening Pattern



1. Disassemble dampener by removing all nuts and bolts securing wetted and non-wetted housings. Remove and discard old diaphragms ②③. Remove old PTFE tape ④ from wetted housing ① and discard. Make sure all components are clean and free of corrosion. Order replacement parts as needed.
 2. Install new PTFE tape ④ on the wetted housing ① as close as possible to bolt holes. Overlap tape ends by 1/2" (12mm).
 3. Place the non-wetted housing ⑤ on a flat surface with the open side (inside) facing up.
 4. Place the backup diaphragm ② onto the non-wetted housing ⑤ with the dome side up.
 5. Place the PTFE diaphragm ③ on top of the backup diaphragm ② with the dome side up.
- ❗ **DO NOT reuse old nuts and bolts. New nuts and bolts must be of equal grade/strength value.**
6. Insert the first bolt and washer through the non-wetted housing ⑤ and both diaphragms. Insert the second bolt and washer on the opposite side of the non-wetted housing. Continue installing remaining bolts and washers in a crisscross pattern.
 7. Reassemble dampener by placing the non-wetted housing ⑤ with all bolts installed onto the wetted housing ①, inserting the bolts on the non-wetted housing through the bolt holes on the wetted housing. Bolts must be inserted one at a time for a proper fit.
 8. Once all bolts are fitted through both housings, install the nuts and tighten bolts in a criss-cross pattern as shown in FIGURE 1, and torque to specifications on dampener tag. The gap between the non-wetted and wetted housings must remain even all around the unit.
 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.

FIGURE 2



M54E11_030