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Checke			Rev Ltr.	
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Approve			Page 1 of 3	

SPECIFICATION

Description	BAYONET ASSEMBLY PROCEDURE (PHPK TBA SERIES BAYONET)
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Revisions

Ltr	Description	Rel. Date	Initial and Date					
			Ch'gd	Ch'kd	Engr.	App'd.	App'd.	
A	Updated headers and address	1/26/09	DJS					

SPECIFICATION

Description

**BAYONET ASSEMBLY PROCEDURE
(PHPK TBA SERIES BAYONET)**

1.0 Remove the protective wrapping from the male and female bayonets.

CAUTION: Do not cut protective wrapping. Damage may occur to machined and plated surfaces.

2.0 Clean the O.D. of the male and the I.D. of the female with an approved solvent applied with a clean, lint-free rag. Allow to dry.

CAUTION: Assembly contains equipment plated with nickel. Cleaning with acids or other caustic solutions will remove plating and void warranty.

**Questions Contact: PHPK Technologies
 2111 Builders Place
 Columbus, Ohio 43204
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3.0 Inspect the male tube for damage.

4.0 Clean the O-ring using procedures as outlined in Step 2.

5.0 Inspect the O-ring for scratches, cracks, or flat spots. O-ring material is Viton (Fluorocarbon Rubber) unless otherwise specified by customer. (Replace the O-ring if any such imperfections are found.)

6.0 Apply a very thin coat of vacuum grease to the O-ring (Dow Corning High Vacuum Grease #970, or equal) and install in the O-ring groove on the bayonet.

CAUTION: In oxygen service, use only lox compatible grease.

7.0 Align the male and female bayonet and gently slide them together, making sure that the O-ring stays in the O-ring groove.

CAUTION: Pipes must be aligned or bayonets will not engage and damage can occur.

The bayonet will easily slide together if properly aligned. If any resistance occurs, **do not force the bayonets together**. Re-check the piping alignment, adjust pipe hangers as necessary, and proceed with the engagement of the bayonets.

8.0 Hand tighten the nut (provided with the male) to the female portion of the bayonet. Bayonet flanges should be parallel when nut is tightened. Tighten to slightly compress O-ring. If necessary use a strap wrench to snug nut (Do not over tighten).

CAUTION: Always relieve any system pressure prior to loosening or removing the retaining nut. Over-torquing should not be used to stop joint leakage. If a leak is found, check for incorrect assembly, or damage to flanges or seal.

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9.0 Important Advisory/Disclaimer

The above information, of course, only provides general guidelines. Actual details of the installation procedure may vary depending upon the condition and applications. Please ensure that the part(s) are installed by a qualified maintenance engineer experienced in the installation of similar parts. Improper installation of this part can be dangerous. PHPK Technologies is not responsible for improper installation of the parts.

THE ABOVE INFORMATION DOES NOT CREATE ANY EXPRESS WARRANTY, IMPLIED WARRANTY OF MERCHANTABILITY OR IMPLIED WARRANTY OF FITNESS FOR A PARTICULAR PURPOSE, ALL SUCH WARRANTIES ARE HEREBY EXPRESSLY EXCLUDED AND DISCLAIMED. SEE THE CONTRACT OF SALE FOR RELEVANT INFORMATION IN THIS REGARD.

Please advise if additional information or clarification is needed.

