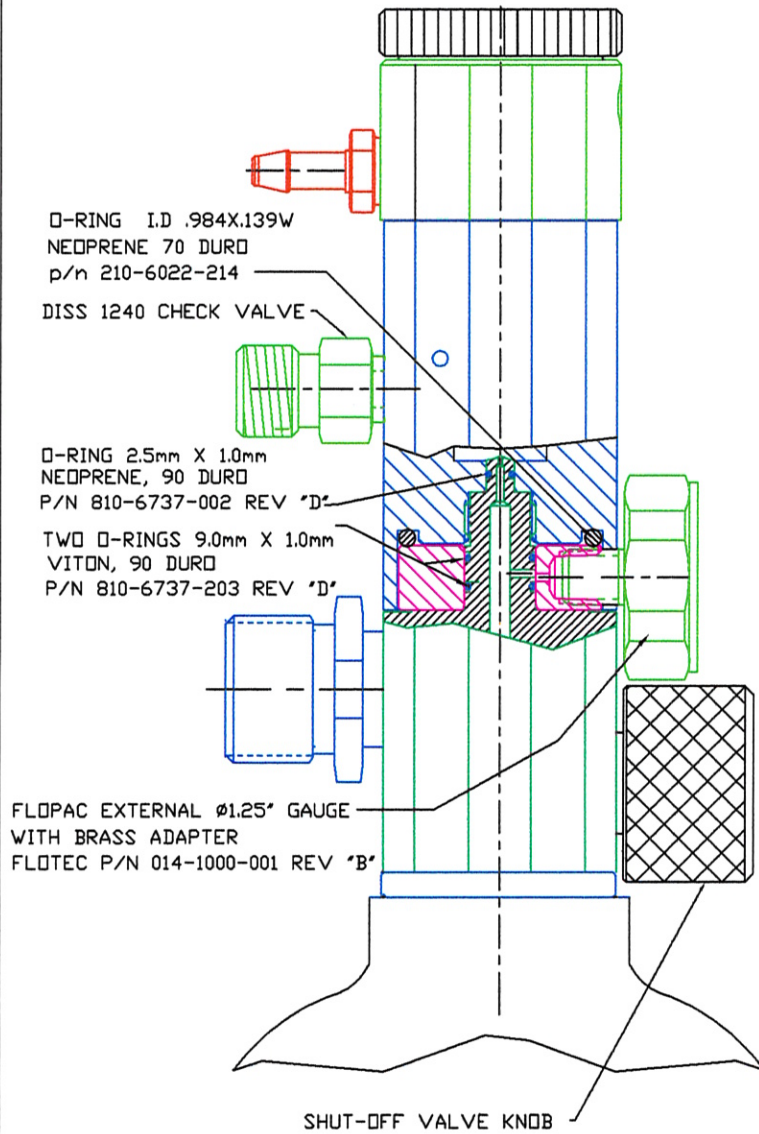


DATE	REV.	REVISION RECORD	ECN #	DR.	CHK.
5-25-07	A	RELEASE & ISSUE	E07-049	LEG	
8-8-07	B	ADD INSTRUCTIONS	E07-084A	JDA	

Instructions for External Gauge Conversion on Flopac

1. Secure Flopac and cylinder using vise or other clamping mechanism.
2. Ensure that Flopac Shutoff Valve Knob is in the OFF position.
3. Remove DISS-1240 Check-Valve Outlet (if equipped). Remove thread tape residue from female swivel body inlet port and check-valve, and re-tape check-valve.
4. Attach Flopac torque tool # 0150 onto 1/2" torque wrench and insert at downward angle over top of horizontal halo handle ring and against opposite Flopac side walls (flats) ensuring that contact is against swivel body only.
5. Untorque body in counter-clockwise motion. Remove tool and continue unthreading Flopac swivel body off of connector body.
6. Remove internal gauge assembly from connector body, preserving any timing shim which may be present.
7. Remove high pressure (2) and low pressure (1) O-rings and discard.
8. Check surfaces for cleanliness wiping any residue(s) from surface using Isopropyl alcohol and lint-free cloth.
9. Install new high pressure O-rings p/n 810-6737-203 (2) and low pressure O-ring p/n 810-6737-002 (1).
10. Reposition timing shim (if present)
11. Install external gauge assembly p/n 014-1000-001 onto connector body with external gauge face positioned directly above connector body shutoff valve. Ensure that external gauge face is oriented properly.
12. Using midget side cutter tool, snip narrow metal leading edges on bottom end side of swivel body internal gauge window along the apex of the two adjoining "flats".
13. Use metal file to remove any "burrs" which may be present.
14. Using compressed air, ensure removal of any /all metallic residue from entire swivel body, both internally and externally.
15. Install p/n 210-6022-214 O-ring into upper groove within internal gauge compartment.
16. Install swivel body onto connector body positioning internal gauge window over external gauge inlet threads.
17. Thread clockwise until hand-tight.
18. Attach torque tool # 0150 as described earlier and torque swivel body clockwise approximately 21-26 ft. lbs., until apex of flats are aligned properly.
19. Re-install DISS-1240 Check-Valve Outlet into Flopac swivel body and torque to 30 in.lbs.
20. If residual cylinder pressure is present, open shutoff valve and observe gauge function. Check for leakage using appropriate "Snoop" Detection Liquid.



FLOPAC CONVERSIONS KIT
FROM INGAUGE TO
EXTERNAL 1.25" DIA GAUGE

TOLERANCES:	.XX=±.01
∠s =±5° CHAMFERS, ETC.	.XXX=±.005
=±1' OTHERWISE	.XXXX=±.0005
	.005 A
	.005 A

CONFIDENTIAL
© 2007 FLOTEC, Inc.
INDIANAPOLIS, IN, USA
ALL RIGHTS RESERVED

FLOTEC

CAD # E	CAD FILE # 030-1000-001B	REF# FPX
NAME FLOPAC CONVERSIONS KIT		SHEET 1 OF 1
DRAWING NUMBER 030-1000-001		REV. B