

ASSEMBLY PROCEDURE FOR ADJUSTABLE LENGTH CONNECTOR

Rev	ECN No.	Date	Reviewed By	Approved By	Status
A	5020542	14-JUL-2008	Douglas, Don	Soltau, James	RELEASED

Summary:

This procedure is to be used for the assembly of Adjustable Length Connectors for use on single and double plug cement heads.

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1.0 SCOPE

This procedure is to be used for the assembly of Adjustable Length Connectors for use on single and double plug cement heads.

2.0 PROCEDURE

- 2.1 Thoroughly grease O-rings, backup rings, slip tubes (Fig 1) and slip rings (Fig 2) with lithium moly disulfide, Chiksan #7, or equal.
- 2.2 Install small O-ring (uniform #227) into the inside diameter of the slip ring. Install remaining O-rings (uniform #334) and back-up rings (uniform #334) onto the outside diameter of the slip tube and the slip ring.

*IMPORTANT: On the slip ring, the back-up rings should be flat against the groove wall with the O-rings towards the shortest land area (Fig 3).
- 2.3 Thoroughly grease the ACME threads on the right hand nut, left hand nut and collar (Fig. 4) with lithium moly disulfide, Chiksan #7, or equal. Thread right hand and left hand nuts into the collar. Allow approximately .50" of the nuts to extend beyond the collar on both sides.
- 2.4 Assemble the slip tube through the left hand threaded nut first and continue through the right hand threaded nut. Slide slip ring onto the slip tube, making sure that the end of the slip ring with the I.D. O-ring is inserted first, until the snap ring groove is visible on the slip tube.
- 2.5 Place the snap ring on the slip tube.
- 2.6 Adjust the nuts so that the ACME threads on the nuts are flush with each end of the collar. This can be done using a spanner wrench (Ref: FMC P/N 3259080).

- 2.7 Insert the snap ring/slip ring end of the collar assembly into the deep slip tube recess of the T-valve assembly. Screw the nut onto the T-valve assembly and tighten with spanner wrench.

*IMPORTANT: This end of the Plug valve has two recessed steps. Do not insert Connector assembly into other end. This will result in leakage (Fig 4 & 5). In Fig 5, Section A shows that the slip tube will not adjust and bottoms out in the plug valve. Section B also shows that the slip tube will not adjust due to being bottomed out in the plug valve. See Fig 4 for the correct installation.

- 2.8 Screw collar assembly toward the T-valve until the assembly stops against the valve. Lightly tap the slip tube into the cavity of the T-valve. Place the other end of the collar assembly onto the second T-valve assembly. The slip tube should be toward the small transducer end of the valve. Screw the nut onto the T-valve and tighten with a spanner wrench.
- 2.9 Rotate the T-valve until the adjustable collar is flush with the ACME threads of the nuts. This adjustment is necessary to align the centerline to centerline dimensions of the assembly.
- 2.10 After the adjustments are made per step 2.9, the centerline to centerline dimensions are adjusted by rotating the collar with a spanner wrench.

To assemble a manifold for a double plug cement head, repeat the above procedure.

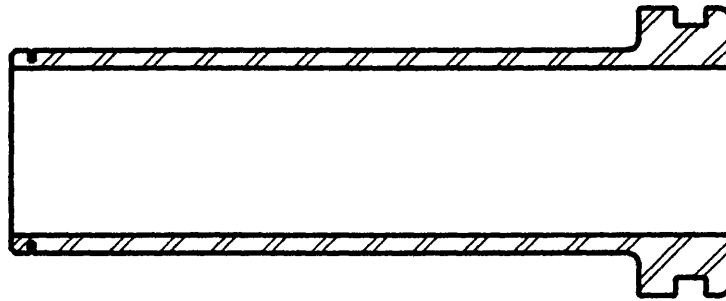


FIG 1
SLIP TUBE

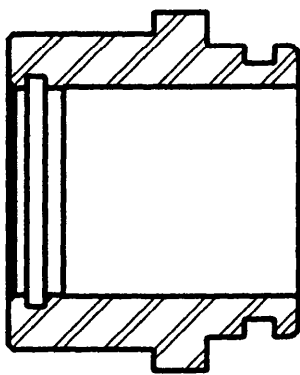


FIG 2
SLIP RING

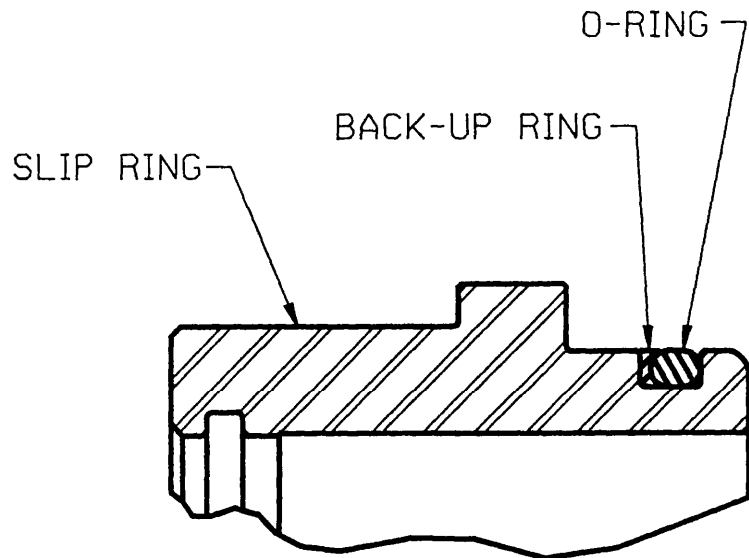


FIG 3

