FLOWSERVE

Installation Instructions

SPEx Sanitary Fitting

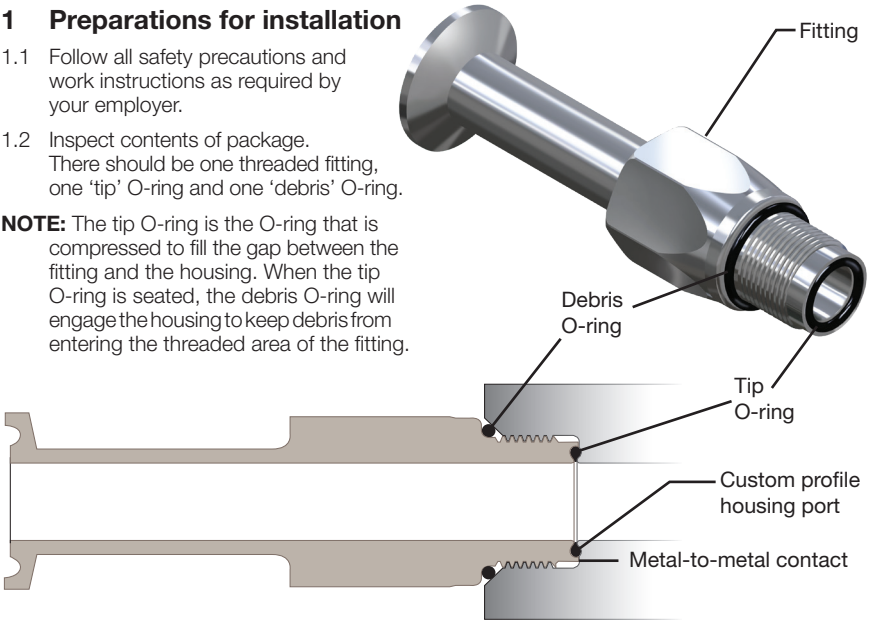
One- and two-piece

1 Preparations for installation

1.1 Follow all safety precautions and work instructions as required by your employer.

1.2 Inspect contents of package. There should be one threaded fitting, one 'tip' O-ring and one 'debris' O-ring.

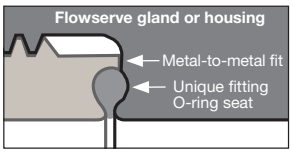
NOTE: The tip O-ring is the O-ring that is compressed to fill the gap between the fitting and the housing. When the tip O-ring is seated, the debris O-ring will engage the housing to keep debris from entering the threaded area of the fitting.



2 One-piece fitting installation

2.1 Ensure that both O-rings are in proper position for installation. Lubricate only if your company allows lubrication AND if the O-ring material will not be damaged by the lubricant. **NOTE:** Do NOT use petroleum-based lubricants on ethylene propylene polymers such as EPDM or EPR.

2.2 Inspect the port. The port in the housing is a custom profile to maximize the effectiveness of the tip O-ring with controlled compression. The port must be clean, smooth and properly profiled.



2.3 Carefully and smoothly turn the fitting threads into the housing threads.

2.4 Lightly finger-tighten the fitting.

2.5 Using a wrench, lightly tighten the fitting to approximately 1/3 to 2/3 flats, or approximately 40 inch-pounds (4.5 Newton-Meters) of torque. **Do not over-tighten.**

3 Two-piece fitting installation

3.1 Ensure that the two visible O-rings are in the proper positions for installation. Lubricate only if your company allows lubrication AND if the O-ring material will not be damaged by the lubricant. NOTE: Do not use petroleum-based lubricants on ethylene propylene polymers such as EPDM or EPR.

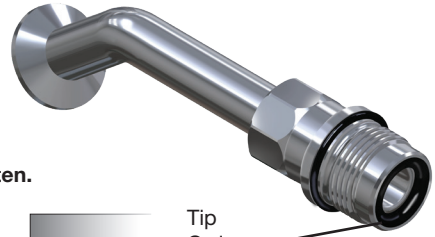
3.2 If the tubing is intentionally bent to end up in a specific position, then the tubing must be held in that position while the nut is tightened. This is only possible with the two-piece fitting.

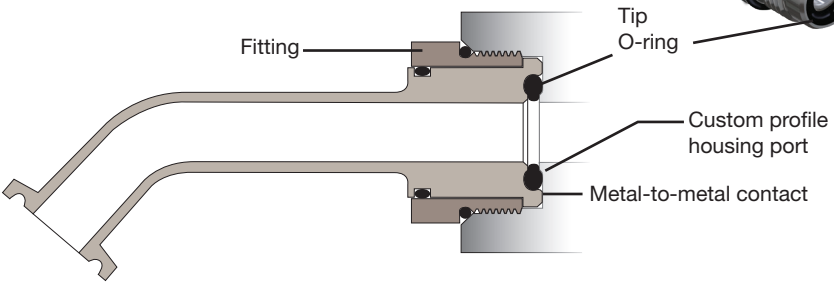
3.3 Inspect the port. The port in the housing is a custom profile to maximize the effectiveness of the tip O-ring with controlled compression. The port must be smooth, clean and properly profiled.

3.4 Carefully start the threads on the fitting into the port. Notice that the tube and ferrule will try to rotate with the nut. Maintain the correct position of the bent tube. If the tube is not bent, disregard this instruction.
Finger-tighten firmly.

3.5 Lightly tighten the fitting with a wrench until it starts to offer resistance because the tip O-ring is at the bottom of the port.

3.6 While holding the bent fitting in position, tighten nut to no more than 10 ft-lbs (13.5 Newton-Meters). **Do not over-tighten.**





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