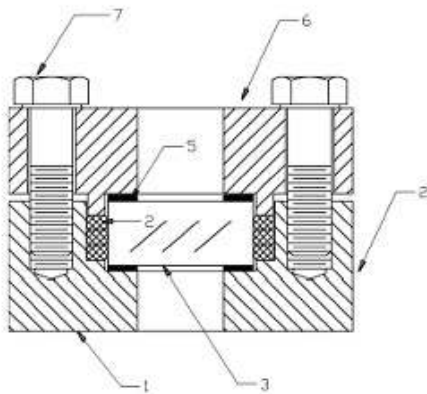
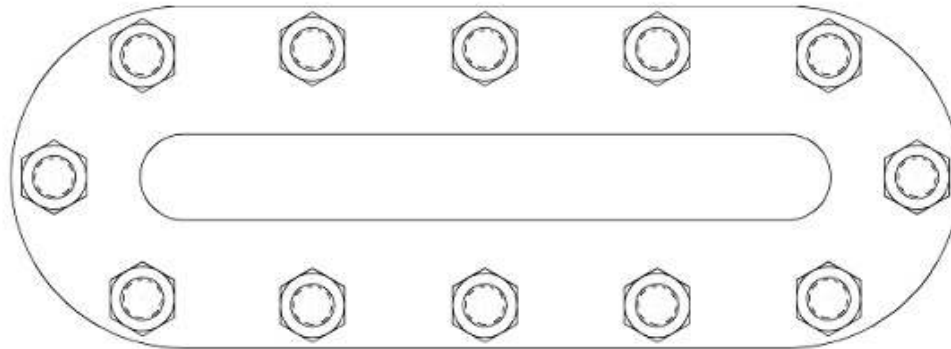


Oblong Sight Glass Documentation



Assembly Instructions



NOTE: MICA SHIELD
IS NOT SHOWN

This unit was assembled at the factory and the hex head bolts were purposely not tightened. Before installation, the unit should be disassembled by removing the hex head bolts, retainer cap, O-ring cord or packing, lens and cushion gaskets. Before welding, replace only the retainer cap to the unit body and tighten the hex head bolts (approx. 80 ft-lbs). The retainer cap will help to prevent the base from warping during the welding process. Use the appropriate welding procedures to prevent distortion of the unit body. After the unit body has cooled, the unit may be completely reassembled by following the instructions below:

Installing parts: follow (A) through (K). If leakage occurs, begin step (K) again.

- A. The interior of the unit body (2) must be clean.
- B. Place the bottom cushion gasket (1) into the unit body (2) and place Mica Shield on gasket.
- C. Carefully place the lens (3) on the bottom cushion gasket (1).
- D. Insert all but one piece of the lens packing (4) between the lens (3) and the interior wall of the unit body (2), be sure to stagger each piece.
- E. Place the top cushion gasket (5) on top of the lens (2).
- F. Place the retainer cap (6) into position and install the hex head bolts (7).
- G. Starting in the center of the unit and working outward toward the ends, evenly tighten the hex head bolts until the cap (6) makes contact with the body (2).
- H. Remove the hex head bolts (7), the cap (6), and the top cushion gasket (5).

- I. Insert the final piece of lens packing (4).
- J. Replace the hex head bolts (7), the cap (6), and the top cushion gasket (5).
- K. Starting in the center of the unit and working outward toward the ends, torque the hex head bolts to 10 ft-lb, then start over and torque to 20 ft-lb, then finally 30 ft-lb.

IF THERE ARE ANY QUESTIONS CALL 1-800-624-9043