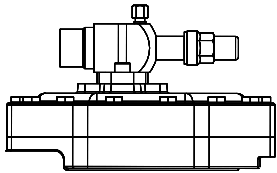


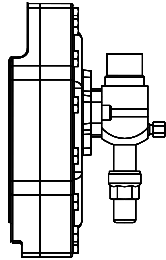
Rotolock Valve - Installation Guideline

Installation should be done in two ways:



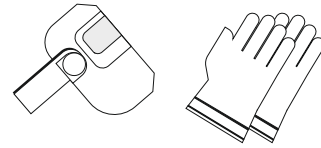
1

1. Horizontal



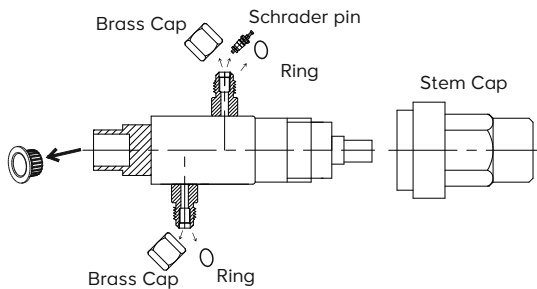
2. Vertical

Installation should be done normal, clean and safe atmospheric conditions. Use face protection for eyes and heat resistance gloves. Wear protective coveralls made of breathable materials.



2

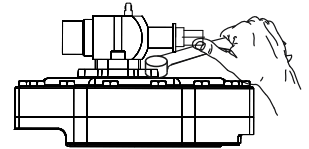
Remove all Schrader valve cap, Schrader valve pin, brass cap with O ring and stem cap:



3

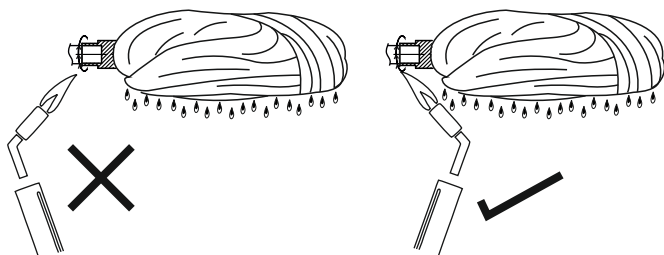
Use the appropriate torque for Rotolock Connection according to the following table:

Tightening Torque of Rotolock Joints (ORFS)		
Nominal diameter	Outer diameter (mm)	Tightening torque N.m (kgf.cm)
3/4" -16	19.05	40-50 (400-500)
1" -14	25.4	70-80 (700-800)
1" -1/4-12	31.75	120-135 (1200-1350)
1" -3/4-12	44.45	135-160 (1350-1600)
2" -1/4-12	57.15	165-190 (1650-1900)



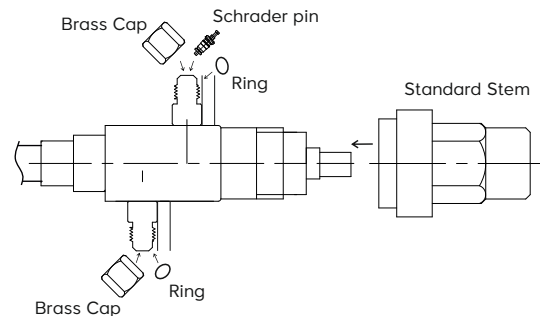
4

Wrap a wet cloth over rotolock valve. It must cover the existing brazed tubes on the body and spindle. Position the flame in the opposite direction of the valve body. Avoid direct contact between the torch flame and the tube. Heat the tube evenly by moving the torch around, rather than concentrating on one point.



5

Do not forget to attach the brass caps and inner parts of Schrader Valve back to their places. Check the Schrader Valve and connections for leaks.



6