**Date** : March 28, 1995

**To** : District Offices

**Subject** : Steam Heads on High Temperature Generator

**Units Affected** : **All Steam Fired ParaFlow™ Absorption Units**

York has recently standardized on a new gasket material for all steam generator heads. Instead of pre-cut gaskets with a separate part number for each unit, we are now using 1/4 inch *Gore-Tex®* Joint Sealant, which comes in fifty foot rolls. We have found through field testing that the new gasket compound is much more reliable than the previous gasket material, however, special application and bolt torquing procedures must be adhered to in order to attain that reliability.

We are not advocating a change-out of existing gaskets if the gaskets are not leaking. If a unit under warranty begins to leak, it is mandatory to use the new gasket material. We will not pay to replace a second leaking gasket if the old style gasket is used.

**Replacement Procedure** (refer to Figure 1)

**Caution: Bleed off any residual pressure and completely close and tag steam supply and condensate valves prior to attempting to remove steam head. Use proper lifting devices to secure and remove steam head to avoid personal injury and damage.**

1. Completely remove all traces of the old gasket material from both the head and tube sheet. Clean all studs with a wire brush so that they are free of any residue and that the nuts can be run all the way on the stud by hand.

2. Remove the paper backing on the joint sealant and attach the joint sealant to the steam generator tube sheet near the 12 o'clock position just inside the bolt circle. Continue attaching the joint compound to the surface, working completely around until you are back at the starting point. Overlap the ends of the sealant by at least 1/2 inch.

3. Attach a strip of joint sealant across the pass baffle partition mating area, overlapping both of the ends across the joint sealant applied previously by 1/4 inch minimum.

4. Tap the overlapped areas down flush before attaching the head to the generator.

5. Apply a thin coat of high temperature anti-seize compound to the studs (*Fel-Pro® C5-A* —York p/n 013-01690-000).
6. Reattach the head to the generator, taking care not to disturb the placement of the gasket material. Slide the head gently up against the tube sheet and install all nuts finger tight.

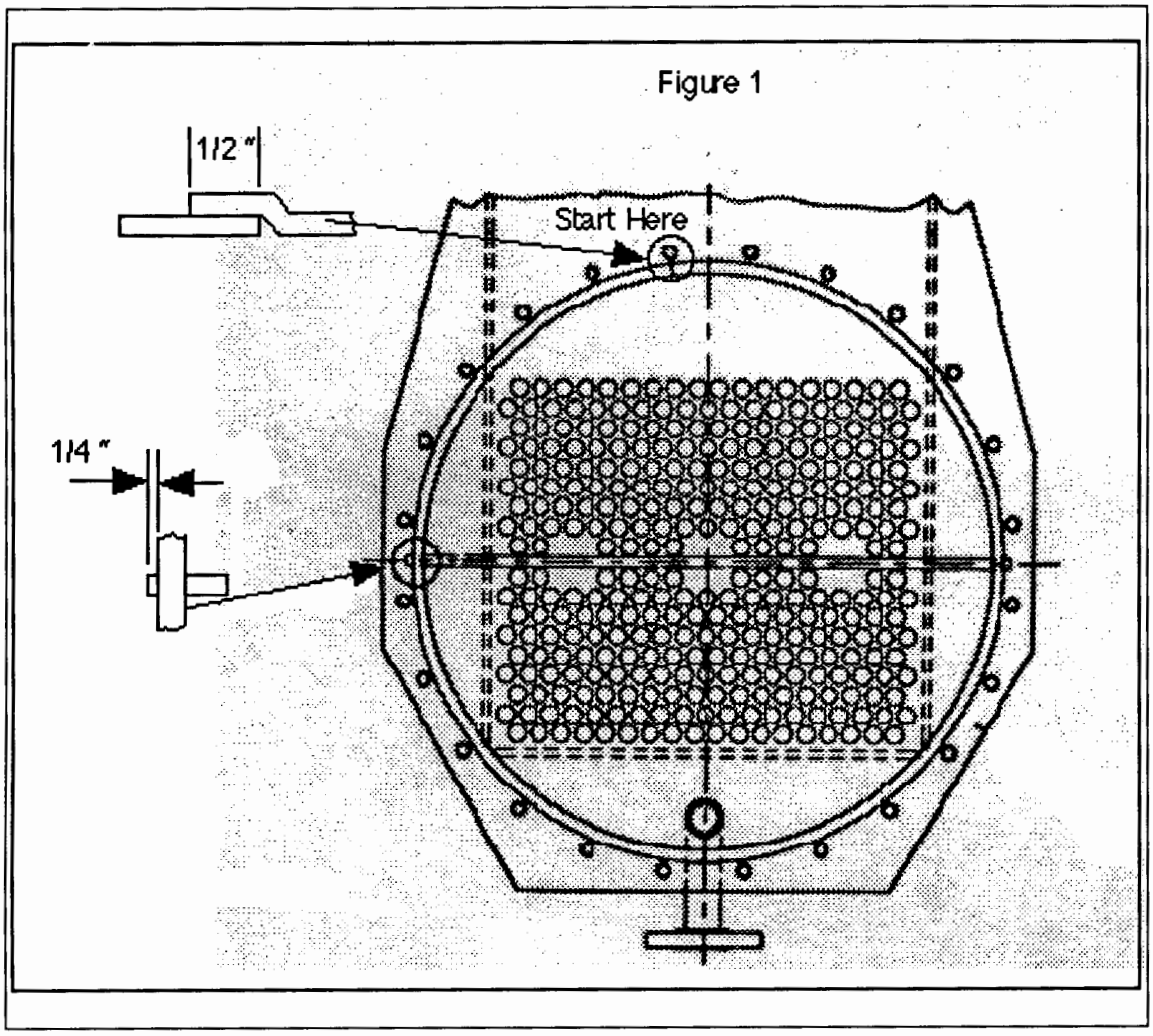
7. Using four (4) incremental steps, torque the nuts using a star (crisscross) pattern. In other words, first torque the nuts to 20 ft/lb, then 40 ft/lb, then 60 ft/lb and finally 80 ft/lb.

8. In a counter-clockwise direction (starting at the 12 o'clock position), recheck all studs/nuts and confirm they are at 80 ft/lbs.
9. After the unit has operated at design pressure and temperature, shut the unit down, reduce the pressure and re-torque all bolts to 80 ft/lb. The gasket should now be ready for normal use.

The type of Gore-Tex® Joint Sealant used in this application is one of many expanded PTFE compounds manufactured by W.L. Gore & Associates, Inc.. DO NOT SUBSTITUTE. For further information related to this product, call the Gore Engineering Group at (800) 654-4229.

The York part number for a 1/4 inch x 50 ft. roll of Gore-Tex®Joint Sealant is 028-12908-000. One roll of joint sealant should be sufficient to do several generators. The actual length required per generator will depend on the size of the unit.

Figure 1



P.O. Box 1592, York, Pennsylvania USA 17405-1592

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