



File in ABS, SM Manual(s).

SERVICE BULLETIN

Supersedes: 155.17-NM1 (SB3)(1092) 1094 Form 155.17-NM1 (SB3)

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Date : September 20, 1994
To : District Offices
Subject : REVISED Threaded Joint Sealant Procedures
(This document supercedes 155.17 NM1(SB3) dated 1092)
Units Affected : **All Paraflow Absorption Units**

Recent changes in the Loctite Primer "N" formulation (removal of degreasing solvent) requires a change in our procedure for threaded joint sealants on all ParaFlow units. Please refer to the York Loctite Standard that was recently sent out to the field for more information on Loctite Products.

Absorption Units operating in a deep vacuum are severely affected by air leaks. Accelerated corrosion, copper plating and performance problems are several of the reasons we do everything we can to prevent air ingress. For that reason, threaded pipe joints require special care on absorption equipment.

On the USA manufactured units, we have elected to use threaded 2 inch removable sight glasses instead of the welded type used on the Hitachi-built units. We believe that the advantages of the threaded sight glasses far outweigh the leak potential. Since several of the sight glasses see temperatures in excess of 300°F, it is extremely important to use a sealant capable of withstanding these high temperatures. To prevent confusion, we have adopted one sealant and one application procedure for all threaded joints. **NO SUBSTITUTIONS ARE PERMITTED.**

Action Required:

- (1) Brush threaded joints with wire brush to clean any previous sealant or corrosion off.
- (2) Check threads (both male and female) for damage that may promote leakage.
- (3) Clean all threads with Loctite Cleaner 7070.
- (4) Spray Locquic Primer Type "N" (Loctite N7649) on both female and male threads and allow to dry.
- (4) Apply Loctite 567 to threads on male fitting being careful to avoid the lead thread of the fitting so that no Loctite is exposed to the inside of the system. Work the thread sealant

7 into the threads so that the entire area between threads is filled with sealant.

(4) Tighten fittings using standard piping practice. Ensure thread engagement is correct. (1/3 by hand, 1/3 by wrench, and approximately 1/3 exposed) Too much thread engagement is a sign of incorrect tapers and may be a potential leaker. Be sure to use a **SIX point socket** when tightening sightglasses.

(5) Leak check using no more than 12 psig. of N₂ or Argon and soap solution. (don't forget to remove or equalize the rupture disk - it will rupture at 7 psig)

Loctite Primer Type "N7649" in 6 oz. aerosol can

:York p/n 013-01753-000

Loctite 567 in 250 ml tube

:York p/n 013-02280-000

Loctite Cleaner 7070

:York p/n 013-02899-000

