Manway Nozzle Gasket Installation

Parker's Sure Torque manway nozzle gasket design makes it easy to install in the field. The recommended installation and securement procedure is as follows:

Installation

Prior to installation, check to see that the mating surfaces are clean and free of defects and corrosion (reference M-1003, AAR specification, appendix D) that could affect a tight joint. Install the gasket appropriate to the commodity to be transported (see charts, page 3) so that the four installation tabs (see figure 1) are in position on the outside diameter of the manway nozzle. Close the lid slowly and position the bolts and nuts finger tight.

Figure 1: *Alignment tabs (4) located on outside of manway nozzle.*

Securement

The Parker Manway nozzle gasket design incorporates a stainless steel compression limiter that acts a positive dead stop when tightening the nuts onto the Manway assembly. The sure torque design protects the integrity of the seal and allows the bolts to be torqued to an appropriate yield depending on the bolt type used in accordance with ASTM and the manufacture's recommendations. NORMALLY 60% OF BOLT YIELD IS RECOMMENDED.

Note: CLEANING & lubricating bolt threads will reduce torque loss due to friction. Utilizing thoroughly hardened steel washers (e.g, ASTM F-436) should be used for even load distribution during gasket installation. DO NOT PUT LUBRICANT ON THE GASKET.

Tighten the nuts with properly calibrated torque or impact wrenches in a sequential order (figure 2) as recommended by the AAR, taking a minimum of three passes to achieve the required torque.

First Pass	10 to 20 ft-lbs
Second Pass	50% of target torque*
Third Pass	100% of target torque*

**Based on bolt manufactures specifications.*

The stainless steel compression limiter will maintain the required torque until the manway needs to be opened.

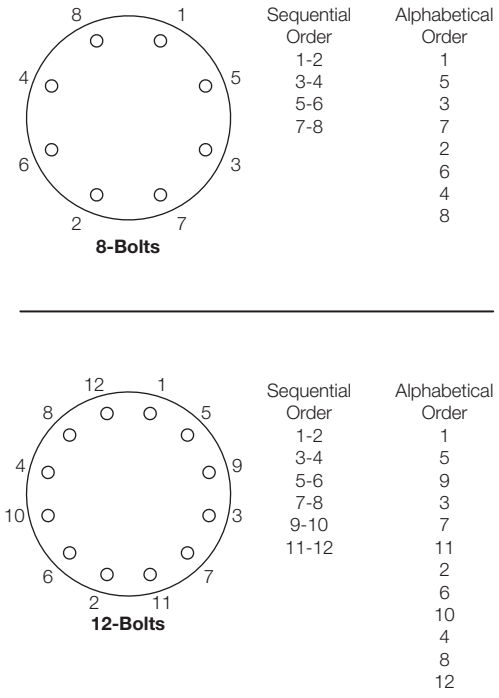
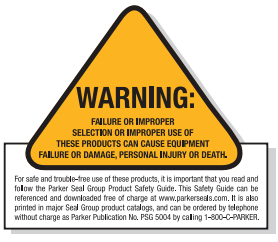


Figure 2: *Bolt securement sequence reference Appendix D of Specifications M-1002 of the AAR.*



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