Risbridger
Quality Engineering Solutions

INSTRUCTION SHEET

RIS-FLANGE2-SO-SUCTION-MK2 INSTRUCTIONS

The RIS-FLANGE2-SO-SUCTION-MK2 with an added lever operated shut-off feature allows line testing without any disassembly in the containment chamber. This assembly comes with a suction tube deflector and rivets to attach to a suction tube.

N.B: It is important that the lever is locked in the 'open' position for normal suction operation using the cable tie supplied.

INSTALLATION

1. Measure from the tank bottom surface to the tank lid top surface, at the suction entry point. This distance is the correct overall length for the drop tube and compensates for the intake, bottom clearance and flange stand off height.
2. Cut (non flared end) suction tube to this O.A. length using a pipe cutter for a clean square cut.
3. Use the 2IN suction tube drill jig at the cut end to drill 3 x equi-spaced 3.2mm rivet holes in the tube. Remove all burrs and clean the external wall of the tube.
4. Place the RIS-FLANGE2-SUCTION body in a soft jaw vice clamping the sides (not the side entry port).
5. Remove the base flange core using a RIS-FLANGE2-WRENCH or the clevis lock pin supplied together with a standard wrench.
6. From the 4463-A5 suction assembly kit, position the internal and external 'O' rings on the removed flange core. Smear the large section internal 'O' ring with petroleum jelly to assist fitting over the drop tube.
7. Slide the flange core over the suction tube with care to avoid damage to the internal 'O' ring. The threaded end of the core must face the flared end of the suction tube.
8. Place the flat rubber washer from the 4463-A5 kit inside the base recess of the suction body against the flat internal face.
9. Slide the clamp ring over the drop tube flange core assembly. Thread into the suction body so that the drop tube flared end is clamped against the flat rubber washer.
10. Tighten using a RIS-FLANGE2-WRENCH. Tighten until the flange core is flush with the bottom face of the suction body. This will slightly compress the flat rubber washer.
11. Rivet the intake deflector from 4467-A5 kit onto the bottom of the suction tube. Use a hand rivet gun and the rivets supplied.
12. Check that the tank lid surface, body, flange faces and gaskets are clean.
13. Locate the suction assembly in position on the flange port and hand tighten the base flange screws (M8 x 20) into the tank-lid so that the flange is still free to swivel.

14. Align the body as required and make the side port connection to the vent pipe work. Hand tighten the (M8 x 25) screws into the body.

15. Torque all screws to 20 N/m (15 ft/lbs) with a torque wrench and 13mm socket.

16. Test the suction pipe work for vapour tightness.

17. **After testing** wrap the cable tie through the 'flip over lever' cross hole and around the side entry pipe work and lock in the normal 'open' position.