

PT-07-SAN Nipple Installation Instructions

1. Bore a 1- $\frac{1}{2}$ " ID hole in top or side of pipe.
2. Mount MANDREL in NIPPLE. Make sure that MANDREL contacts lip on NIPPLE.
3. Expand MANDREL by tightening MANDREL NUT. Thread HANDLE onto exposed TAPER SCREW.
4. Place NIPPLE into bored hole so that NIPPLE is flush with pipe I.D. On small diameter pipes the NIPPLE protrudes into the flow line.
5. Tack weld the nipple at three points.
6. Proceed to weld nipple all around.
7. Remove MANDREL by loosening MANDREL NUT and tapping TAPER SCREW free. Using a welding clamp, grip the outboard part of the MANDREL and work free.

CAUTION: Do not pull TAPER SCREW.

PAPER MACHINE COMPONENTS

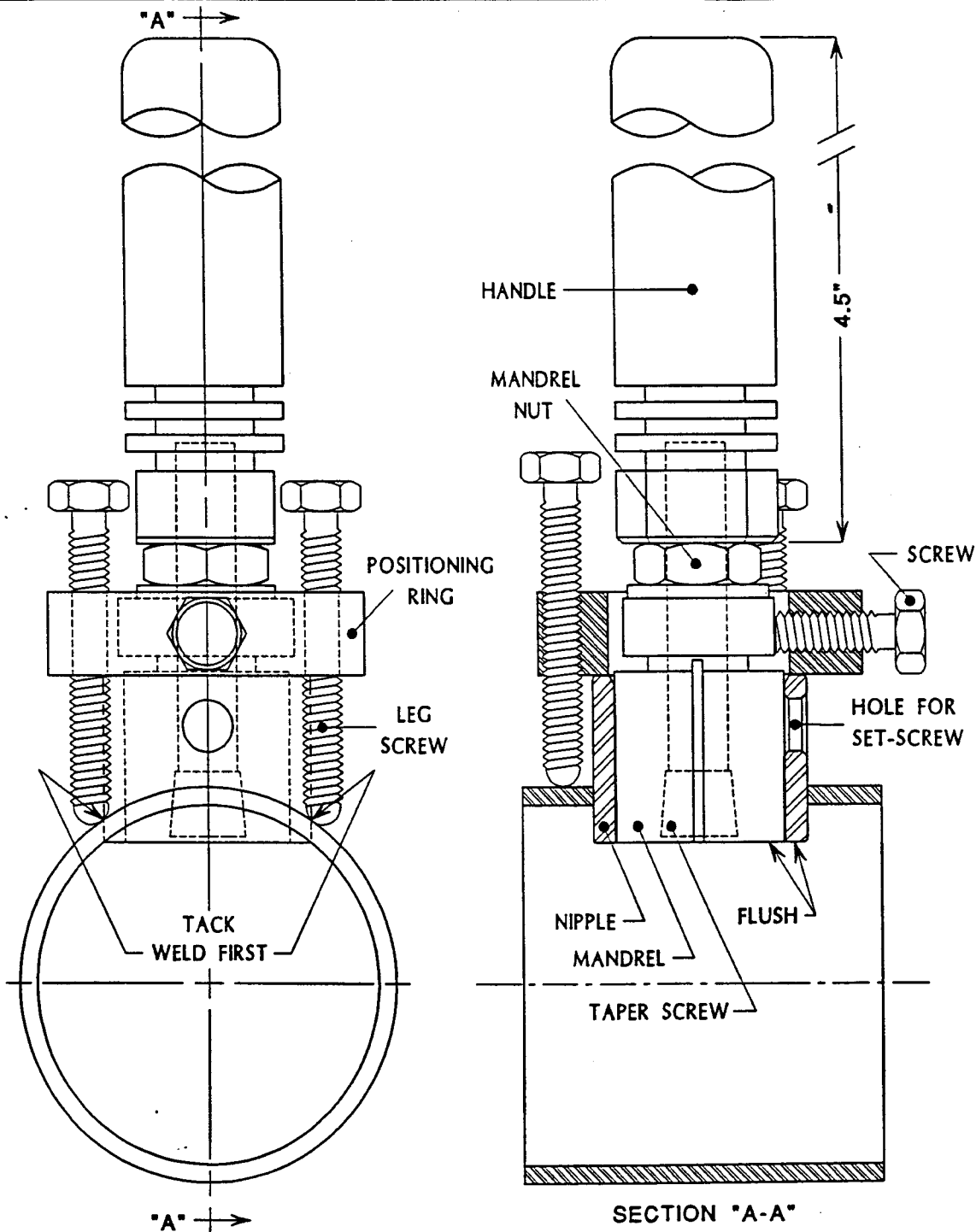
DANBURY, CONNECTICUT U.S.A.

PART NAME PT-07-SAN NIPPLE WELDING MANDREL ASSEMBLY

MATERIAL	DATE	SCALE
#303 STAINLESS STEEL	Jan. 21, 1993	FULL

QUANTITY	DRAWN BY	ORIG. DWG.	ASSY. DWG.
	L.W.		

BREAK ALL SHARP EDGES AND CORNERS	DWG. NO.
FRACT. DIMS. +/- 1/64" . DECIMAL DIMS. +/- .005" ANGLES +/- 1/4 . UNLESS OTHERWISE SPECIFIED	1930-A



PT-07 Nipple Installation Instructions

1. Bore a $1\frac{5}{16}$ " ID hole in top or side of pipe.
2. Mount MANDREL in NIPPLE, making sure that NIPPLE and MANDREL bottoms are flush.
3. Expand MANDREL by tightening MANDREL NUT. Thread HANDLE onto exposed TAPER SCREW.
4. Mount POSITIONING RING onto MANDREL and tighten SCREW.
5. Adjust three LEG SCREWS to position nipple on pipe wall. On small diameter pipes the nipple protrudes into the flow line.
6. Tack weld the nipple at three points then remove POSITIONING RING.
7. Proceed to weld nipple at sides as noted then complete weld all around.
8. Remove MANDREL by loosening MANDREL NUT and tapping TAPER SCREW free. Using a welding clamp, grip the outboard part MANDREL and work free.

CAUTION: Do not pull TAPER SCREW.

PAPER MACHINE COMPONENTS

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DWG. NO.

FRACT. DIMS. +/- 1/64", DECIMAL DIMS. +/- .005"
 ANGLES +/- 1/4' UNLESS OTHERWISE SPECIFIED

1925-A