



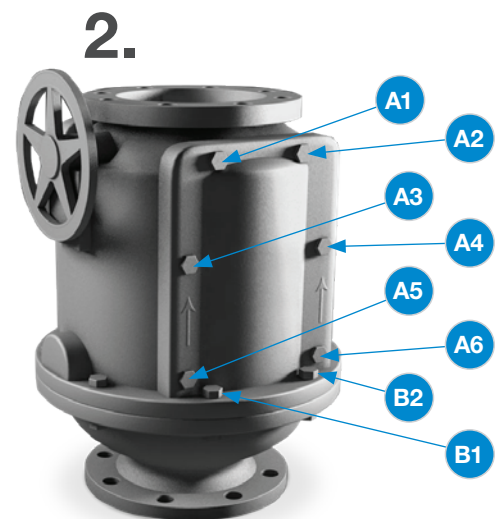
Multiport Relief Valve Final Assembly Procedure

COCHRANE® by Newterra multiport relief valves final assembly and door bolt tightening procedure. After testing has been completed, the additional steps are required in preparation for final shipment.

1. Install Gasket Sealant - Permatex #81160, red RTV high temperature gasket make

- Make sure that all surfaces are clean and dry before application.
- Apply continuous 1/16" to 1/4" bead to valve body door gasket surface, surrounding all bolt holes.
- Apply continuous 1/16" to 1/4" bead to door gasket surface, surrounding all bolt holes.
- Apply 1/4" bead to corner area between valve body door gasket surface and lower body gasket surface.
- Place gasket on door and assemble to valve body while RTV is still wet.
- Install and hand tighten door bolts until RTV material begins to squeeze out around door.
- Let dry one hour then tighten door bolts as indicated in the instructions.

2. Door Bolting Tightening Sequence - tighten door bolts first – **A** in below figure. Tighten in sequence **A1 – A6**. Then tighten flange bolts – **B** in below figure in same 1-2 sequence.




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