



Assembly Procedure for 20LF4 Line Filter

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1.0 REFERENCES

- 1.1 B-1288 - Assembly Drawing for 20LF4

2.0 PURPOSE

- 2.1 To establish an assembly procedure for all 20LF4 filters.

3.0 SCOPE

- 3.1 This procedure shall be used for all standard 20LF4 filters unless otherwise stipulated on the register/order face or in the work instructions for a specific order.

4.0 PROCEDURE

- 4.1 All filter components shall be accumulated in the Assembly Department from either stores or directly from manufacturing.
- 4.2 The filter assembler shall, as a minimum, check all components for the following:
 - (A) Cleanliness
 - (B) Identification - (Ref: applicable assembly drawing)

NOTE: All non-conformities are to be reported to the Quality Control Department.

- 4.3 The filter assembler shall assemble all filters in accordance with the latest applicable assembly drawing.
- 4.4 The filter assembler shall lubricate all filter components requiring lubrication, with "Moly-Lit" as follows:
 - 4.4.1 Gland, P/N A-1288-01, shall be lubricated on the first three (3) external threads.
 - 4.4.2 Cone plug, P/N A-1724-01, shall be lightly lubricated on the gland and cone plug seating point.
 - 4.4.3 Body, P/N A-1527-01, shall be lubricated on the first two (2) internal threads on each end.



- 4.5 Insert the lower rated micron rated disc into the downstream opening of the body P/N A-1527-01, and press into place.
- 4.6 Insert cone plug P/N A-1724-01 into the downstream opening of the body P/N A-1527-01, and push the cone plug slightly against the filter disc.
- 4.7 Screw the gland P/N A-1288-01, into the downstream opening side of the body P/N A-1527-01, and rotate until finger tight.
- 4.8 Tighten the gland P/N A-1288-01, and torque to 50 to 55 ft. lbs.
- 4.9 Insert the spacer P/N A-2660-01, into the upstream opening of the body P/N A-1527-01 and align as shown on filter assembly drawing.
- 4.10 Insert the higher rated micron rated disc into the upstream opening of the body P/N A-1527-01 and press into place.
- 4.11 Insert cone plug P/N A-1724-01 into the upstream opening of the body P/N A-1527-01, and push the cone plug slightly against the filter disc.
- 4.12 Screw the gland P/N A-1288-01, into the upstream opening side of the body P/N A-1527-01, and rotate until finger tight.
- 4.13 Tighten the gland P/N A-1288-01 to 50 to 55 ft. lbs.
- 4.14 Assembled filter is now ready for installation into piping system.

Caution: Install filter with flow arrow in the correct position



RECORD OF REVISIONS

REV NO	DESCRIPTION OF CHANGE	DATE	BY	APPR
0	Original document	12/18/96	RAC	RAC