



Assembly Procedure for 60LF4, 60LF6 and 60LF9 Line Filters

TABLE OF CONTENTS

<u>Section</u>	<u>Title</u>	<u>Page Number</u>
1.0	References	2
2.0	Purpose	2
3.0	Scope	2
4.0	Procedure	2
5.0	Record of Revision	3



1.0 REFERENCE:

- 1.1 B-1218 - Assembly Drawing for 60LF4
- 1.2 B-1275 - Assembly Drawing for 60LF6
- 1.3 B-1430 - Assembly Drawing for 60LF9

2.0 PURPOSE

- 2.1 To establish an assembly procedure for all 60LF4, 60LF6 and 60LF9 Line Filters.

3.0 SCOPE

- 3.1 This procedure shall be used for all 60LF4, 60LF6 and 60LF9 Line Filters.

4.0 PROCEDURE

4.1 Disassembly:

- 4.1.1 De-pressurize and remove the complete filter assembly from the system and fixture in a vise equipped with "soft jaws".
- 4.1.2 Loosen and remove the gland nuts (items 2) securing the covers (item 3) in the body (item 1).
- 4.1.3 Remove the covers, filter discs (items 4 and 5) and spacer (item 6) from the body.
- 4.1.4 Inspect the filter body, gland nuts and covers for wear or damage.

4.2 Reassembly:

- 4.2.1 Replacement filter elements are obtained from the factory.
- 4.2.2 Lightly lubricate the external gland nut threads and the angled face of the covers with anti-seize.



4.2 Reassembly (continued):

- 4.2.3 Re-install the downstream cover and gland nut and tighten to the following specifications.
 - 4.2.3.1 60LF4 and 60LF6 – 55 to 60 lb-ft.
 - 4.2.3.2 60LF9 – 80 to 85 lb-ft.
- 4.2.4 Insert the finest (lowest micron rated) disc into upstream body bore. Using a plastic dowel, tap the disc into place to contact the downstream cover. Add the spacer and second coarsest (highest micron rated) disc. Use the plastic dowel to tap the second element into place. The elements should be tight in the bore.
- 4.2.5 Re-install the upstream cover and gland nut and tighten to the para. 4.2.3 specifications. The refurbished filter assembly is ready for pressure testing.

Caution: Install the filter in line according to the etched flow arrow.

RECORD OF REVISION

REV NO	DESCRIPTION OF CHANGE	DATE	BY	APPR
0	Original document	3/26/04	DTG	DTG