

COMPANY OPERATING PROCEDURE.

0330210 Precision Valve Assembly.

VM3/COP/50.06

Date: 9-May-03.

Revision date: 7-Apr-11.

Issue: 1.

Important: Use only Fomblin grease during assembly of Tom Thumbs. Do not use or allow organic greases to enter the Tom Thumb. Ensure all parts are clean before assembly.

Equipment required. Small flat blade screwdriver.

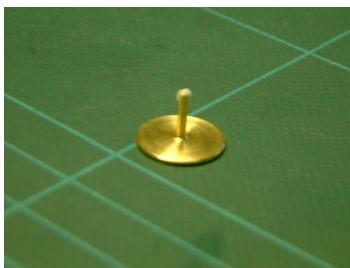
Parts list.		
Qty.	Description.	Part No.
1	Precision valve body	0330224
1	Precision valve adjustable screw	0330228
1	Precision valve seat	0330227
1	Valve seating	0330225
1	Precision valve spring	0330222
1	Fomblin grease	0330220

Assembly.

1. Screw in the precision valve adjustable screw until flush with the valve body.



2. Lightly grease the spindle to the precision valve seat.



3. Place the valve spring over the adjustable screw in the precision valve body. Insert valve seat spindle through the spring and into the precision valve adjustable screw.



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4. Screw on the valve seating on the precision valve body. Apply a small amount of Oxygen-compatible threadlock to the thread, and tighten



5. Ensure the unit is clean prior to assembly with the Tom Thumb.