



Orientation of these parts is critical

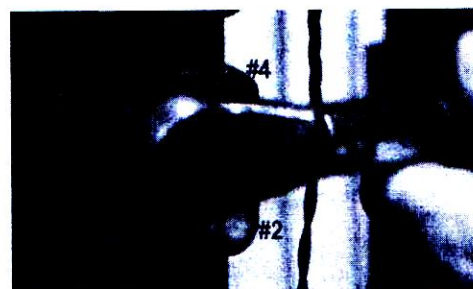
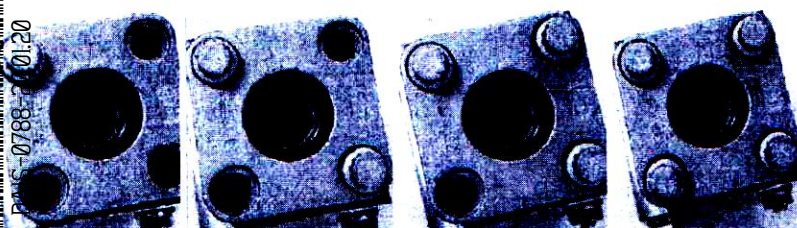
11. Install the new repair kit assembly (items 1 to 4) into the glass retaining spring. Handle the glass by the edges and do not contact the sealing gasket or mica surfaces. Ensure that it is properly centered and fully seated against the cushion gasket.



12. Lubricate the threads and head of the cover bolts with a high temperature Anti-Seize pure nickel compound.

13. Insert the cover assembly into the body groove with the cover vent slot oriented toward the wide side of the gauge body.

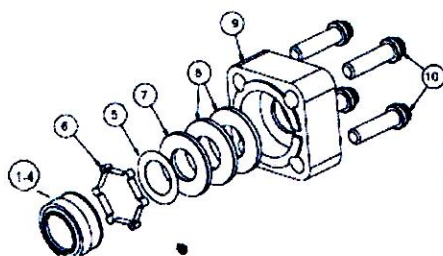
14. Install the cover bolts one at a time in a cross pattern, tighten each by hand a little at a time until snug. **Do not use a power driver to torque the bolts.** A torque wrench must be used. Tighten Bolt # 1 one turn, then cross to # 2, then # 3 Cross to # 4 tightening one turn at a time until all bolts are torque uniformly to 30 to 35 ft-lbs (41 to 48 Nm). When torque is complete the cover should be metal to metal against the gauge body.



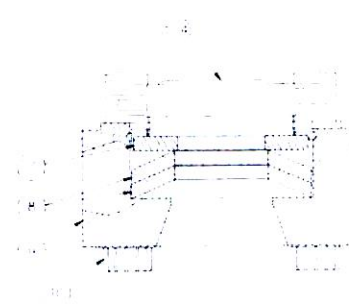
15. Re-install the illuminator and level display.

16. Apply "Serviced" sticker to maintenance tag and record date.

17. If the boiler is at pressure, the gauge must be heated very slowly to prevent damage to the mica. Check that the drain valves are fully open. Crack open the upper gauge isolation valve. Wait 15 minutes. Slowly shut the drain valves, one turn every 5 minutes. When the drain valve is fully shut, fully open the upper and lower gauge isolation valves.



PORT ASSEMBLY			
ITEM	QTY	DESCRIPTION	P/N
1	1	GASKET RETAINER	9320-0109 Port Rebuild Kit
2	1	SEALING GASKET	
3	2	MICA	
4	1	GLASS	
5	1	CUSHION GASKET	1080-0018
6	1	GLASS RETAINING SPRING	
7	1	FLAT WASHER	1020-0400
8	2	BELLEVILLE WASHER	1020-0002
9	1	PORT COVER	9940-0200
10	4	COVER BOLT	1000-0030



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