

In-line sight glass(3-piece body design)

IM-HSG-02(3PD)

05/01

Note: This instruction sheet is applicable to the 3-piece In-line sight glass design only. This design was replaced by the 2-piece design in August 04. A separate maintenance sheet is available for the 2-piece design

Staitech

In-line sight glass

The In-line sight glass range are suitable for use in systems operating up to a maximum of 6 barg/ 150 deg.C. The sight glass should not be exposed to instantaneous temperatures exceeding 120 deg. C.

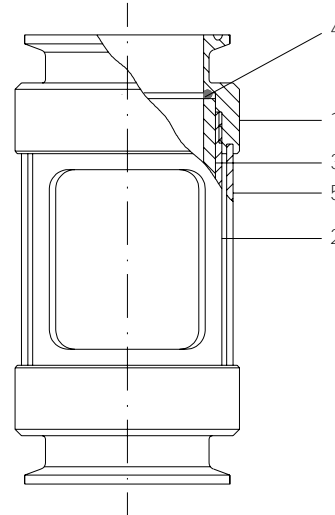
Installation

The sight glass may be installed in any orientation.

Maintenance

The In-line sight glass is easily disassembled for cleaning or maintenance. Replacement seals and glass are available for all sizes of In-line sight glass. Disassembly/assembly instructions are as follows:

1. Holding one end cap(1), unscrew the opposite end cap in an anti-clockwise direction. The tools outlined in 10 may be necessary. Once loosened the glass(3) may be removed. Remove knock shield(5) if fitted. Loosen and remove viewing tube(2)
2. Remove body O-ring seals(4) from end caps.
3. Ensure that all components are clean prior to re-assembly.
4. Fit new body O-ring seals(4) into end caps.
5. Apply small amount of silicone grease to end connection threads.
6. Screw viewing tube(2) into one end cap.
7. Slide glass(2) into partly assembled body.
8. Fit knock-shield(5) if applicable.
9. Screw on remaining end cap(1) until seal is pinched. Adjust viewing tube to centre window. Ensure seal is flush with internal bore, adjusting as necessary.
10. Apply tightening torque to compress seal in accordance with values given. Tightening can be achieved by adding a bolt to a Tri-Clamp blank cap and then fitting one on each end of the sight glass using a standard seal and clamp - fittings are available from Staitech.
11. Pressure test unit to a maximum of 9 barg with air under water, checking to ensure a bubble tight seal has been formed between the glass and end caps.



Parts list

1.	End cap
2.	Viewing tube
3.	Glass
4.	Body O-ring seal
5.	Knock shield(if fitted)

Available spares

Glass(3) & body O-ring seals(4)*

**specify EPDM or PTFE seal material when ordering*

Tightening torque(Nm)

Size	EPDM O-ring	PTFE O-ring
1/2"	1.5-2.5	3-4
3/4"		4-6
1"		9-11
1-1/2"		13-15
2"		20-25