

T E C H N I C A L B U L L E T I N

#78 February 12, 1993

DIP TUBE, P/N 921021, REINSTALLATION PROCEDURE (THIS BULLETIN REPLACES TB #25)

This bulletin provides information to inform Distributors, Service Centers and Certified Technicians regarding the procedure required for the re-installation of press-fit dip tubes.

Dip tubes that have been installed using the procedure described in Tech Bulletin #25 may be left in place if they are secure in position upon valve inspection conducted during overhauls and hydrostatic testing. Those dip tubes which do not move when vigorously pulled by hand are secure.

Loose tubes or those that have fallen out should be re-installed in the following manner:

1. Using a copper bristle (bore) brush, clean valve interior and inserted end of dip tube so that both are free of solidified cement residue.
2. Using a press or smooth jawed vice, insert entire reduced end of the dip tube and gently squeeze until end is slightly out-of-round (approx. 0.015-0.020”).
3. Using a fine tooth file, make a light pass around the circumference of the insert end of the dip tube to create a bevel edge. Wipe clean of all filings.
4. Press the dip tube into the valve assembly using a press or smooth jawed vice.
5. Check the solidity of fit by pulling vigorously on the tube; it should not move.