

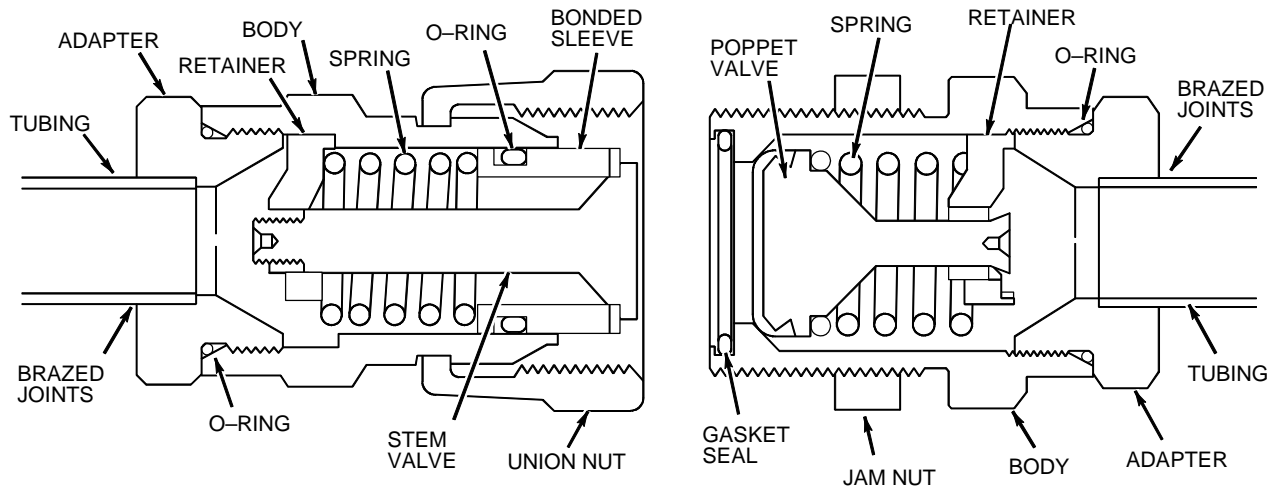
APPENDIX G - AEROQUIP COUPLINGS

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G-1 AEROQUIP COUPLING COMPONENTS

The components of an Aeroquip coupling are identified in Illustration G-1.



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AEROQUIP COUPLING COMPONENTS
 ILLUSTRATION G-1

G-2 CONNECTING AEROQUIP COUPLINGS

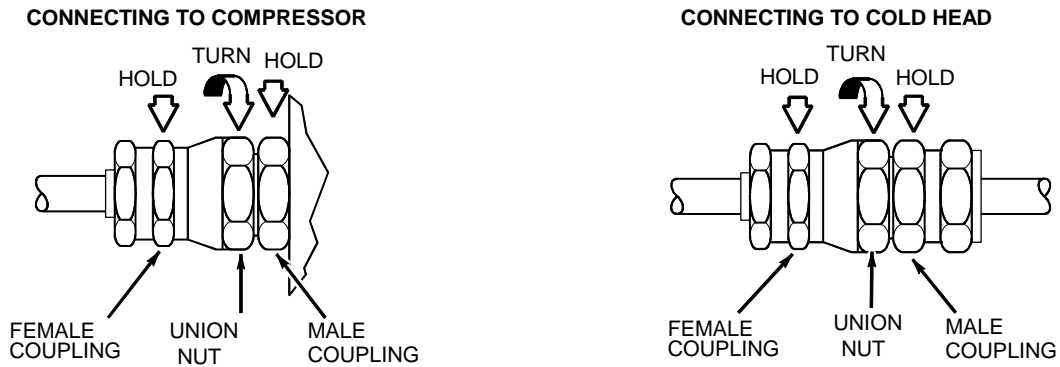


Avoid torsional forces on tubing. Place wrenches as specified in procedure.

1. The system gas connections are shipped with caps and plugs to keep fittings clean and free from damage. Remove caps and plugs and thread them together.
2. Wipe faces of couplings with a lint-free cloth to ensure they are clean and free of chips and dust.
3. Check that gasket seal is in place on inside male coupling. Verify seal is clean and not damaged. See Illustration G-1.
4. By hand, screw union nut of female coupling onto male coupling.

G-2 CONNECTING AEROQUIP COUPLINGS (continued)

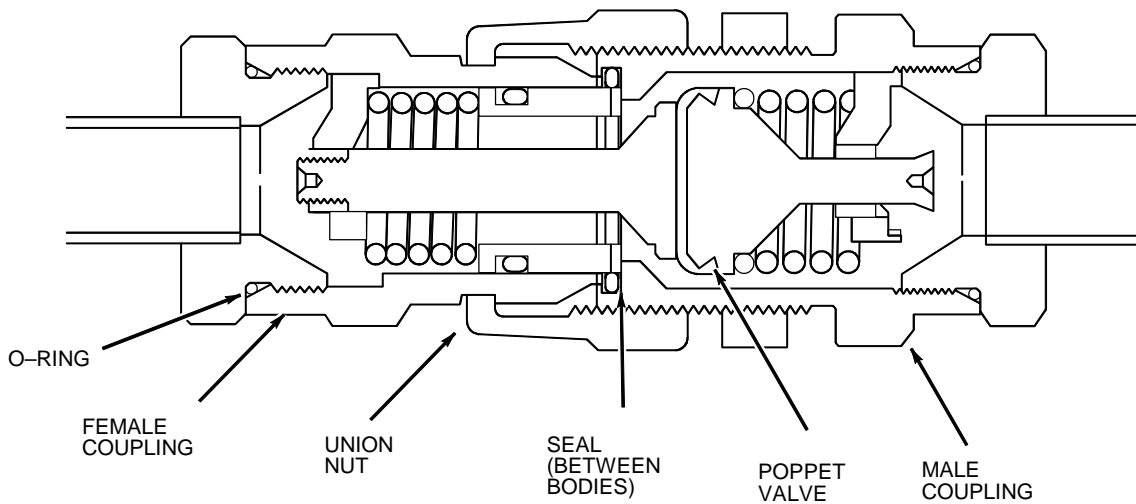
- Use two wrenches to hold stationary part of both couplings. Turn union nut with a third wrench. Illustration G-2 shows where to place wrenches when making a connection to compressor or cold-head.



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CONNECTING
 ILLUSTRATION G-2

- As poppet valve begins to open, a slight venting of gas may occur. See Illustration G-3. Continue to tighten connection until female coupling is firmly seated against face seal on male coupling. Required torques are:
 - 35 ft-lbs (47.5 N-m) (1/2 inch couplings)
 - 45 ft-lbs (61.0 N-m) (3/4 inch couplings).



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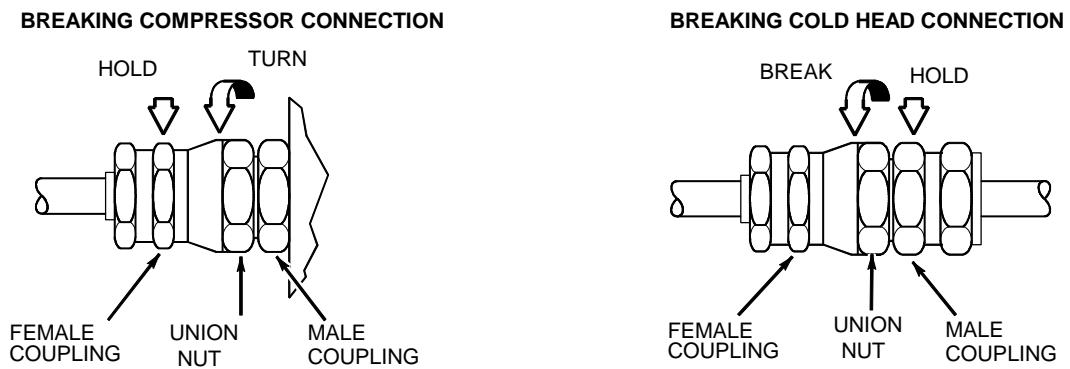
AEROQUIP COMPONENTS
 ILLUSTRATION G-3

G-3 DISCONNECTING AEROQUIP COUPLINGS



Avoid torsional forces on tubing. Place wrenches as specified in procedure.

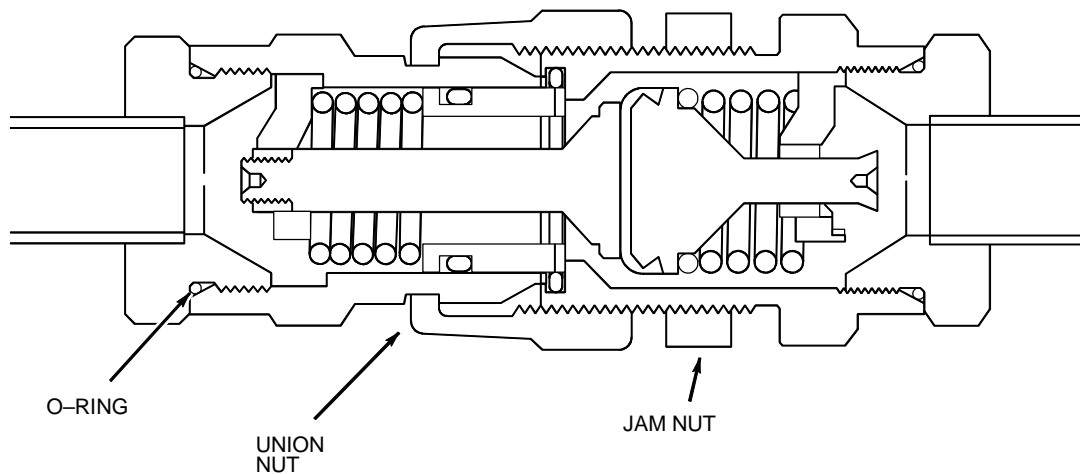
1. Hold male coupling with one wrench while turning union nut of female coupling about 1/8 turn with a second wrench. This will break connection without loosening male coupling from its adapter. See Illustration G-4 for correct placement of wrenches.



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BREAKING CONNECTION
 ILLUSTRATION G-4

2. Check that union nut is free to rotate to avoid a torsional force on tubing.
3. Check that jam nut is secure so male coupling does **not** rotate when loosening union nut. See Illustration G-5.



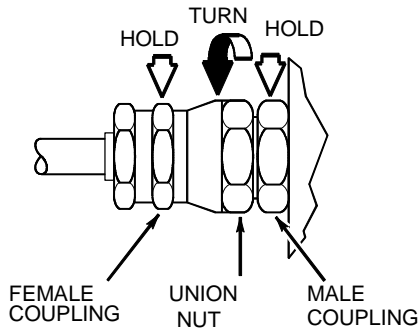
JAM NUT ON MALE COUPLING
 ILLUSTRATION G-5

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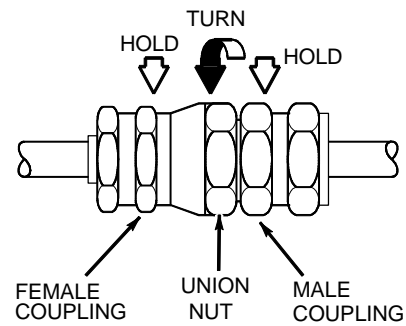
G-3 DISCONNECTING AEROQUIP COUPLINGS (continued)

- Place third wrench on stationary part of female coupling and continue to unscrew union nut. Be sure male coupling does **not** rotate. See Illustration H-6 for correct placement of wrenches.

DISCONNECTING FROM COMPRESSOR



DISCONNECTING FROM COLD HEAD



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DISCONNECTING
 ILLUSTRATION G-6



Avoid leaky connection. Verify face seal is present in male coupling.

- When coupling is disconnected, check that face seal is inside male coupling. During disconnections, face seal may blow into female coupling. Failure to remove face seal from female coupling will cause connection to leak.
- While coupling is disconnected, install dust caps and plugs on coupling halves.

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