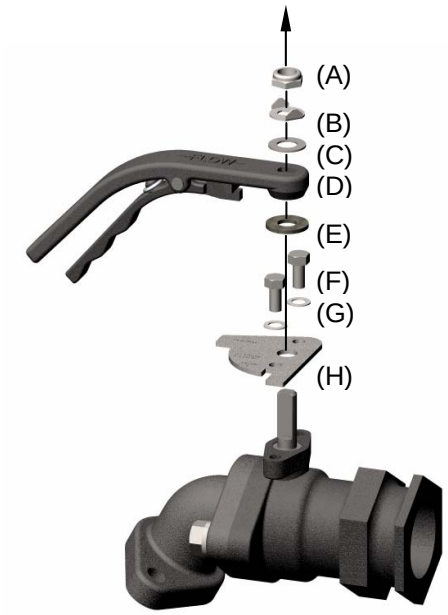
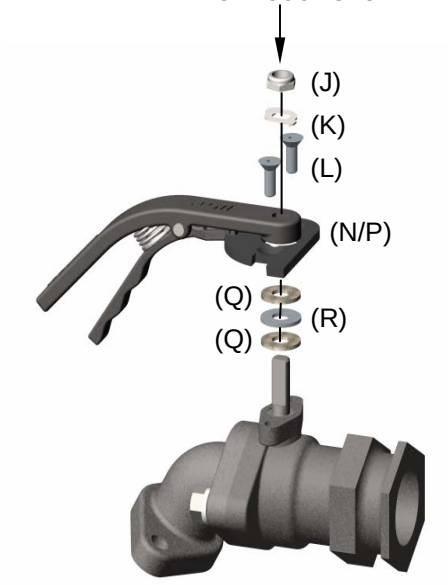
ANGLE COCK
UPGRADE INSTRUCTIONS

PURPOSE To upgrade any style Cock manufactured before Nov. 2000 to include the Angle Cock Handle Assembly Torque Kit, P/N 33890-1 (Left Hand), P/N 33890-2 (Right Hand). This upgrade should be considered when the Cock does not meet the inspection criteria of Maintenance Advisory MA-65 and ELLCON-NATIONAL Form 107.

WARNING All field maintenance operations should be performed in a workmanlike fashion to eliminate the possibility of damaging O-Rings, Seats, etc. The Cock should never be subjected to excessive striking forces. If the Cock is damaged the air should be exhausted from the train line to prevent the possibility of injury.



E-N MODEL 7270-RH
ANGLE COCK SHOWN



E-N MODEL 7270-RH
ANGLE COCK SHOWN

INSTRUCTIONS

A. REMOVAL

1. If present, bend Retainer (B) tabs away from Lock Nut (A) so that the Nut flats are exposed using a drift pin and ball peen hammer.
2. Using a ¾" wrench or socket, remove Lock Nut (A).
3. If present, remove Retainer (B).
4. If present, remove Belleville Spring (C).
5. Lightly pry between the underside of Handle and top of stainless steel Stop Plate (H) to remove Handle Assembly (D).
6. If present, remove Friction Disc (E).
7. Remove 5/16" Hex Screws (F) and Lock Washers (G).
8. Remove stainless steel Stop Plate (H).
9. Discard all of these parts.

B. ASSEMBLY

1. Install a Friction Disc, Poly Spring, and Friction Disc (Q,R,Q) and seat them directly on Cock Body.
2. Install the Locking Lever Tang of the Handle Assembly into the open position Lock Notch of the Stop Plate.
3. Seat handle assembly on stop plate (N,P), install handle assembly with stop plate over stem and seat on angle cock body.
4. It is recommended that Loctite Thread Locker 242 or equal be applied to threads and install two 5/16"-18 Socket Flat Head Screws (L) in threaded holes and tighten to 10 foot pounds torque.
5. Place a new Retainer (K) over Stem and seat it directly against Handle.
6. Install a new ½" Lock Nut (J) on Stem and tighten to 20 foot-lbs. torque.
7. Operate Handle Assembly (closed and open) twice to seat Friction Disc.
8. Repeat tightening of Lock Nut to 20 foot-lbs. torque. This should result in 75-100 inch-lbs operating torque.
9. Operate Handle Assembly and check that Locking Tang on Locking Lever latches into Lock Notch in both open and closed positions.
10. Bend two tabs on Retainer (K) up and fully against flats of ½" Lock Nut using a drift pin and ball peen hammer.

FORM 108
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