



SONARtrac® Rework Instruction

**Subject: Procedure for Replacing
SST Cover Flange Gaskets**

RI00003

Rev. 01

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Purpose:


The purpose of this document is to establish a procedure for the replacement of the stainless steel cover flange gaskets. Read the entire procedure before replacement of the gaskets.

Materials for Replacing Gaskets:

<u>Part Number</u>	<u>Description</u>
S-20621-01	Kit, Spare, Hardware and Gasket Replacement, Stainless steel cover – ISS006
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Procedure

1. Verify the contents of the replacement kit are complete.
2. Remove cover from process pipe per RI0005 Procedure for Removal of Sensor Head (also found in Installation Manual).
3. Clean cover to remove surface dirt.

	CAUTION Upper cover contains electronic board. Do not put cover in dip tank or allow board to get wet.
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4. Move the cover assembly to a workshop area.
5. Remove the existing flange gasket and spacers from both sides of the lower cover flange.
 - a. Use a single edge razor blade knife or metal scraper to remove the gasket and RTV residue.
 - b. Use care to not cut or damage the boot gasket.
6. Apply a bead of RTV approx ¼" diameter along the entire length of the lower cover flange.
 - a. Spread the RTV so it evenly coats the flange surface.
 - b. Coat the edge of the boot seal with RTV.
7. Install the flange seal on the lower cover flange.
 - a. Align the bolt holes on the flange seal with the bolt holes in the cover flange and so that the edge of the flange seal is about 1/32" inboard of the cover flange outer edge.
8. Coat the outside of a compression set spacer with RTV and insert the spacer into the bolthole on the flange gasket. Repeat for all spacers. Verify alignment of the flange gasket with the boltholes in the flange.
9. Press the flange seal to the flange

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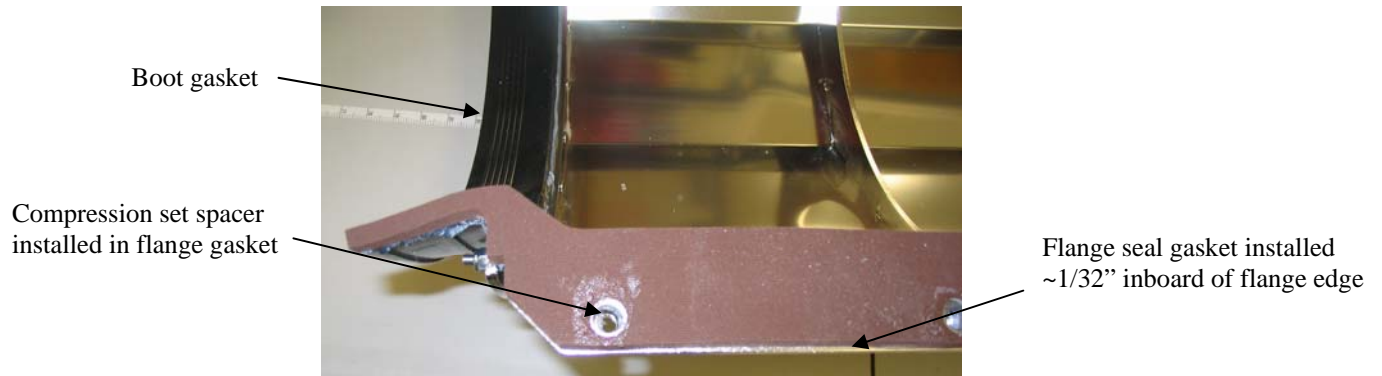


Figure 1 Lower Cover Flange Seal Gasket Installation

10. Repeat items #5 - 9 for the opposite flange gasket.
11. Let the reworked flanges to set for 15 minutes.
12. Carefully lift the cover and place it flange side down on a workbench and allow the RTV to cure for at least 2 hours.
13. Re-install the cover per the SONARtrac® installation manual.

MSDS Information:

The Material Safety Data Sheet for General Electric Silicone RTV #108 can be found at the following website:

<http://www.gesilicones.com/NASApp/gesilecomm/SQuickMsds?Pole=USA&SLORG=AM01&Product=RTV108>

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Document Change History

Date	Revision	Changed By	PCO #	Description of Change
03/17/05	01	B. Markoja	P04-0112	Initial Release