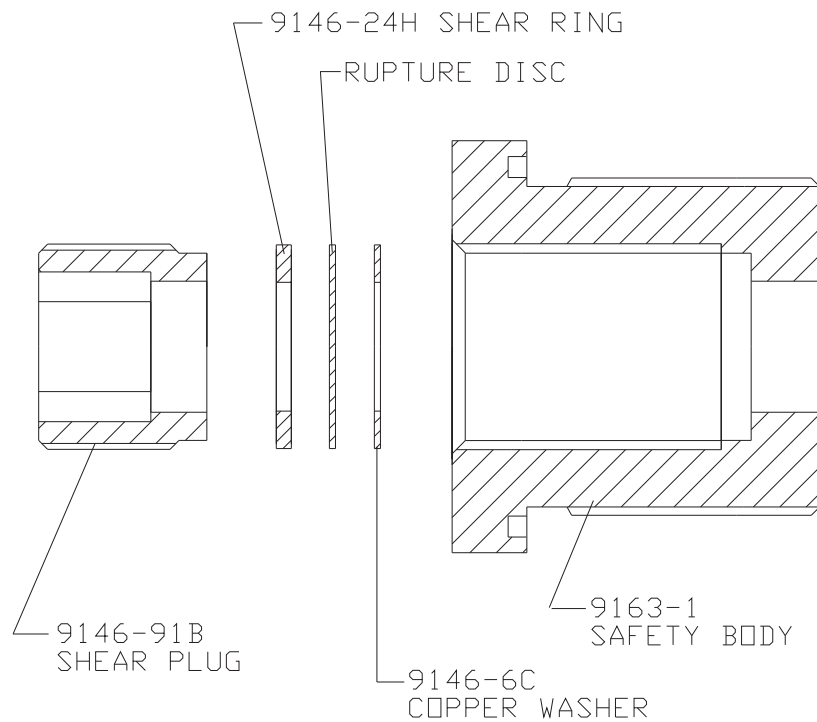


ASSEMBLY PROCEDURE FOR 9163 SERIES RELIEF DEVICE



1. Lubricate 9146-6C copper washer using Halocarbon 25-10M grease or compatible grease.
2. Insert copper washer in 9163-1 body.
3. Insert rupture disc letter code up in 9163-1 body.
4. Lubricate 9146-24H shear ring using Halocarbon 25-10M grease or compatible grease.
5. Insert 9146-24H shear ring in 9163-1 body.
6. Screw 9146-91B shear plug in 9163-1 body.
7. Torque shear plug to 250 FT/LBS.

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INSTALLATION PROCEDURE FOR 9163 SERIES RELIEF DEVICE

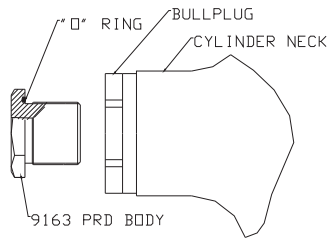


FIGURE 1

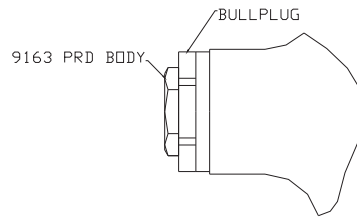


FIGURE 2

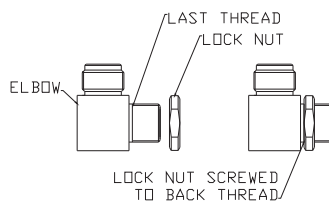


FIGURE 3

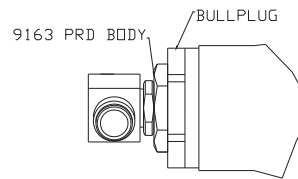


FIGURE 4

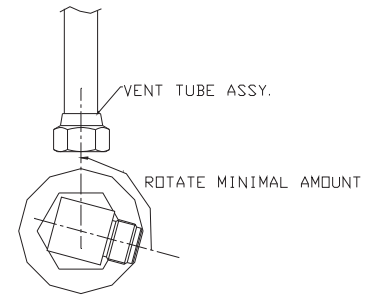


FIGURE 5

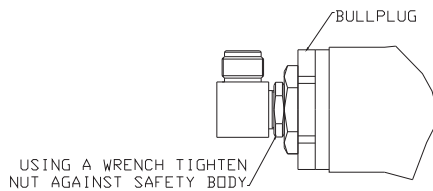


FIGURE 6

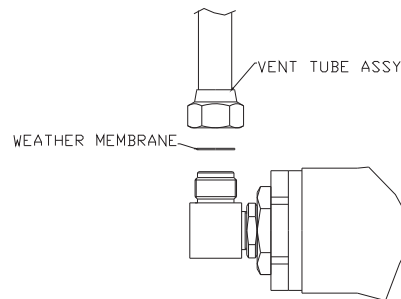


FIGURE 7

1. Lubricate 9146-96 "O" ring using Halocarbon 25-10M grease or compatible grease.
2. Install "O" ring in groove of 9163 body. SEE FIGURE 1
3. Screw 9163 body in bullplug. SEE FIGURE 2
4. Torque 9163 body to 250 FT/LBS.
5. Screw 9146-92 lock nut on elbow to last thread. SEE FIGURE 3
6. Screw elbow to face of 9163 body. SEE FIGURE 4
7. Back off elbow the minimal amount for vent tube alignment. **DO NOT EXCEED 1 TURN.** SEE FIGURE 5
8. Screw lock nut to face of 9163 body and torque to 100 FT/LBS. SEE FIGURE 6
9. Install membrane and vent tube assembly. SEE FIGURE 7

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