



CYLINDRICAL STEM THREAD VALVE/PRD/END PLUG

INSTALLATION INSTRUCTIONS

1. Remove the thread protection caps (when present); pay attention not to damage the seal seats.
2. Take the toroidal O-ring and the venting seal from the bag. Apply the toroidal sealing ring to the valve stem and position it correctly inside the sealing area and repeat the same operation for the venting seal. Pay attention not to damage the rings during positioning.
3. If necessary, spread an appropriate lubricant, compatible with CNG, on 3 or 4 threads furthest away from the sealing ring. Use a very small quantity of lubricant and wipe off any excess. The lower surface of the valve stem must be perfectly clean.
4. Threads on cylinder neck adjoining the sealing area must be free from debris, burrs, notches etc.
5. With the cylinder secured so as to prevent any rotation, assemble the valve to the cylinder by hand. Pay attention not to damage the sealing ring when it touches the cylinder seal seat.
6. Screw the valve by hand, as tight as possible, and then tighten it with the appropriate tooling.
7. The torque applied must comply with the values shown in the table below.
Use an appropriately gauged/calibrated torque wrench.
8. In order to verify the torque applied during assembly the torque must be measured while unscrewing the valve. The minimum torque needed to start unscrewing the valve must be within the specified limits. Use an appropriate gauged/calibrated torque wrench.
If hardening sealants are used, the torque must be measured before the sealant hardens.

Application	Stem Thread	Torque Force	
		Min. (ft. lbs.)	Max. (ft. lbs.)
Type 3 Aluminum-alloy cylinders	1" 1/8 - 12 UNF	70	95

The largest diameter Type 3 cylinders in the world!