



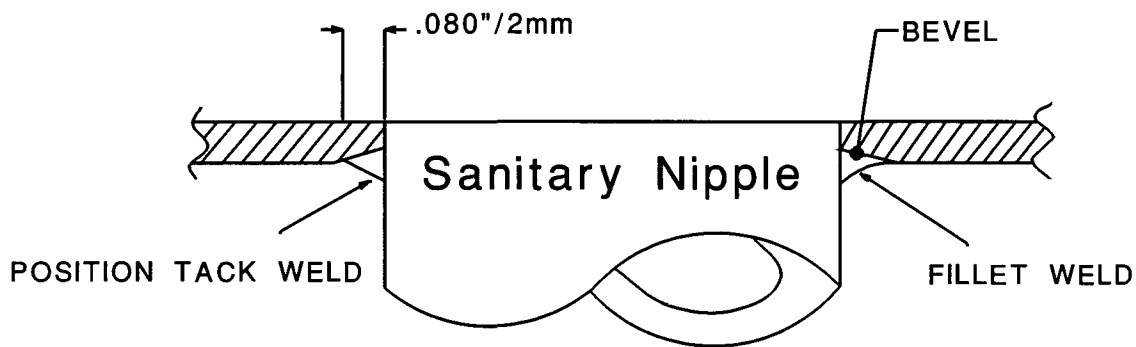
# SPECIAL INSTRUCTIONS

## FOR SANITARY NIPPLE PT/LT/VT/EL

### IMPORTANT

*INSTALLATION AND WELDING OF THESE NIPPLES SHOULD BE DONE BY SKILLED MACHINIST/WELDERS USING HELIARC (INERT GAS WELDING PROCESS). CARELESS INSTALLATION WILL RESULT IN A DISTORTED SEAL LIP, AND JAMMED THREADS.*

*REGULAR INSTRUCTIONS FOR TRANSMITTER INSTALLATION SHOULD BE FOLLOWED, PAYING SPECIAL ATTENTION TO THE FOLLOWING POINTS.*



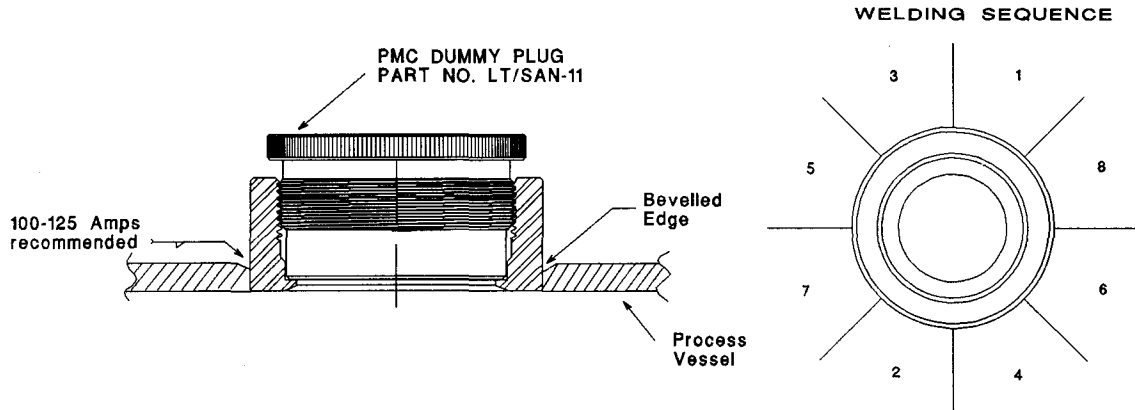
### INSTRUCTIONS FOR INSTALLATION

1. Cut the hole for PT/LT/VT/EL Sanitary Nipple to produce a tight fit. *OVERSIZE HOLES WILL RESULT IN DISTORTION.*
2. Bevel the edge of the outside face of the hole as shown on the sketch above.
3. Remove transmitter and teflon gasket from nipple, then tack nipple in place at 6 points.
4. Weld nipple in place using 0.032\"/>
5. Clean up and polish face to meet process requirements.
6. Install teflon gasket, transmitter, and hand tighten lock ring. Tighten the lock ring an additional 1/8 turn with adjustable wide mouth pliers to compress the teflon gasket, in order to assure a leak-free seal. Do not over-tighten. Position transmitter and adapter fittings before tightening, but do not restrain transmitter from turning during final tightening. (This could move diaphragm retainer ring and affect calibration.)
7. Where several nipples are to be installed, we recommend the purchase of a stainless steel Mandrel, Part Number: LT-07SAN-MDL. A clearing tap kit is available from stock for nipples damaged by welding, Part Number: LT-07SAN-CTK.

## WELDING INSTRUCTIONS

Locate the transmitter and nipple on the side or top of the pipeline runs, next to flanged connections, so that inside welds can be ground and polished. Avoid locations where pulp, food or slurries can settle out and block the diaphragm face.

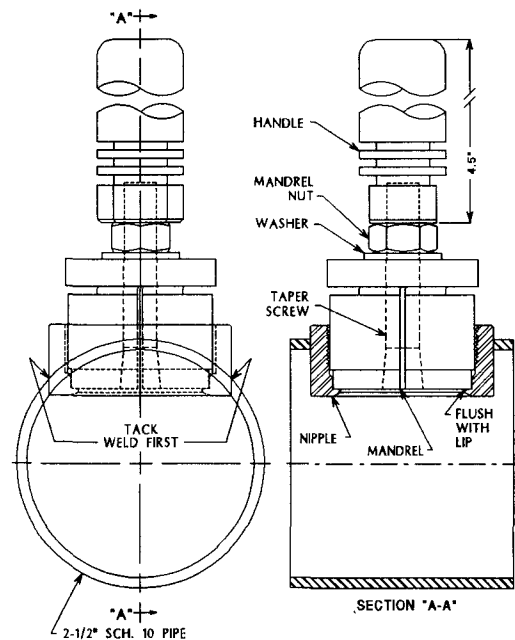
1. Cut the hole for sanitary nipple to produce a tight fit. **OVERSIZE HOLES WILL RESULT IN DISTORTION.**
2. Bevel the edge of the outside face of the hole as shown on the sketch.
3. Remove transmitter and teflon gasket from nipple, then tack nipple in place at 6 points.



4. Insert dummy plug (Part No. LT-11-SAN) to minimize distortion. Weld nipple in place using 0.032"/316 S/S rod as filler in the beveled area adjoining the nipple. Adjust amperage for 0.080"/2mm penetration. With filler rod this should produce 0.080"/2mm continuous weld depth.

### ALTERNATE NIPPLE INSTALLATION INSTRUCTIONS USING EXPANDING WELDING MANDREL (Part No. LT-07SAN-MDL)

1. Bore a 2.120" ID hole in top or side of pipe or tank.
2. Mount mandrel in nipple. Make sure that mandrel contacts lip on nipple.
3. Expand mandrel by tightening mandrel nut. Thread handle onto exposed taper screw.
4. Place nipple into bored hole so that nipple bottom is flush with pipe I.D. On small diameter pipes the nipple protrudes into the flow line.
5. Tack weld the nipple at 6 points. Proceed to weld all around.
6. Loosen handle and mandrel nut.
7. Free mandrel by tapping taper screw loose. Using a welding clamp, grip the outboard part of the mandrel and work free.



**CAUTION:** Do not pull taper screw.

**IMPORTANT:** Installation and welding of these nipples should be done by skilled machinist/welders using heliarc (inert gas welding process). Careless installation will result in a distorted seal lip and damaged threads.