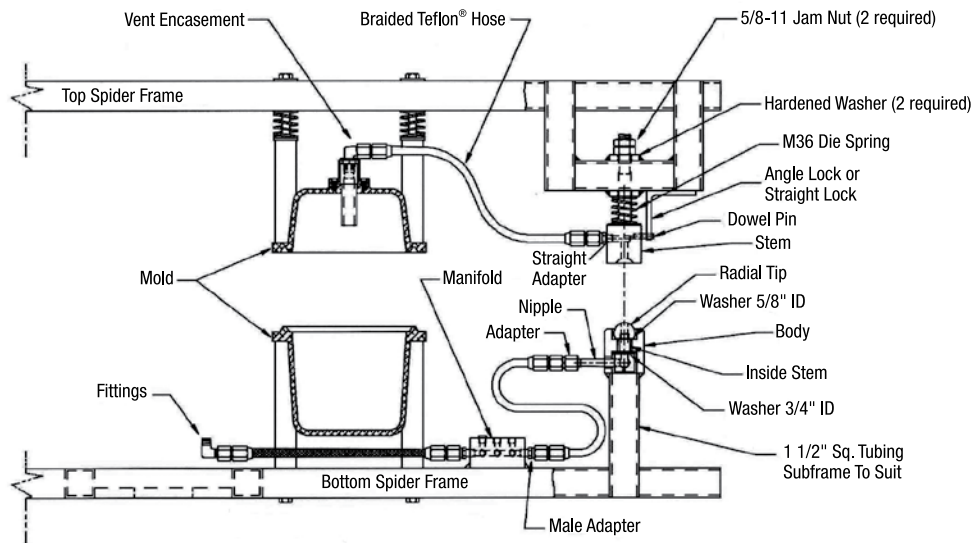


GAS TRANSFER ASSEMBLY

ASSEMBLY DRAWING



Installation Instructions

- Step 1 Gather all the components as shown in the above assembly drawing.
- Step 2 Install the dowel pin (DP-0001) into the hole drilled into the stem (GT-2200). It should be a tight fit, making it necessary to drive or press it in place.
- Step 3 Lubricate both washers (WA-0002 and WA-0003) with high-temperature grease.
- Step 4 Place washer (WA-0003) onto inside stem (GT-2550).
- Step 5 Put inside stem (GT-2550) with washer (WA-0003) through the center of body (GT-2320) as shown in the above drawing.
- Step 6 Install second washer (WA-0002) over the threaded section of the inside stem (GT-2550) that is protruding through the center of the body (GT-2320).
- Step 7 Screw the radial tip (GT-2440) onto the threaded section of the inside stem. To insure that no air leaks develop, use thread sealer or pipe tape on the threads. Tighten radial tip (GT-2440) using a pin or spanner wrench in the hole drilled into the radius to ensure a good seal, yet still allow the inside stem to float freely from side to side in the body (GT-2320).
- Step 8 Insert the pipe nipple (NP-0010) through the body and into the inside stem, using thread sealer or pipe tape.
- Step 9 Cut and weld a suitable framework that will allow the stem (GT-2200) to be mounted in the desired position. Drill 21/32" through the frame to accept the stem (GT-2200). Position hardened washers (HW-1000) over the drilled hole and weld in place. The stem assembly mounts to the top spider.
- Step 10 Cut tubing (determine length by holding body in position and measuring to point on spider that you wish to connect to) and weld body assembly into position on bottom spider. Be sure to maintain good alignment with the framework welded onto the top spider for the stem (GT-2200).
- Step 11 Install spring (DS-1036) onto stem ((GT-2200), then insert stem through the frame. Add the jam nuts (JN-5811) and adjust the stem to engage 1/8" before the mold completely closes.
- Step 12 Weld the straight lock (GT-2840) in place, keep room for stem travel.
- Step 13 Add plumbing to connect air source and devices.