

Product Information

News

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CYLINDER & VALVE ASSEMBLY PROCEDURE WITH TORQUE CHART

The following procedure documents the steps and torque values required for the assembly of MSA cylinder valves onto MSA cylinders.

- Using a high intensity light, inspect the inside of the cylinder for contaminants. Remove any loose particles. Be sure the cylinder interior is completely dry.
- Clean the o-ring sealing surface on the cylinder with a clean, dry, lint-free cloth. Ensure the cylinder surface is undamaged and free from contaminants, such as dirt or tape adhesive residue. Use a clean, lint-free cloth dampened with wood alcohol if required.
- Inspect the cylinder neck area. Do not use the cylinder if it has scratches, cuts, or grooves which may prevent an air tight seal.
- Apply a thin film of lubricant (Christo-Lube), P/N 604070, to the o-ring.
- Apply one drop of Christo-Lube 1/16" in diameter, in 2 places, 180 degrees apart in the o-ring groove of the valve.
- Place a plastic thread protector or thin piece of paper over the threads of the valve. Roll the o-ring over the thread protector and into the o-ring groove. Rotate the o-ring 1/2 to 3/4 turns and remove the thread protector. Apply a thin film of Christo-Lube to the o-ring seal surface inside the neck of the cylinder.
- Insert the cylinder valve into the cylinder neck slowly and carefully so that the sealing surface of the cylinder is not damaged by the tube or sharp edge of the valve threads.
- Tighten the valve into the cylinder according to the torque requirements for the cylinder and valve assembly.

Cylinder and Valve Assembly with Air P/N	Cylinder P/N	Valve P/N	O-ring P/N	Guard P/N	Type	Torque Spec - Valve Assembly to Cylinder
469619	469618	488894	68542	801131	Fiberglass, Hoop-Wound, 2216 psig, 45.5 cu ft, 30 min	70 - 75 ft lb
485565	485564	10002083	633549	470735	Fiberglass Wound Aluminum, 3000 psig, 7.75 cu ft, 5 min	30 - 35 ft lb
802191	802190	10002084	633550	470735	Aluminum, 3000 psig, 15 cu ft, 10 min	45 +/- 5 ft lb
807570	807580	488899	630926	801131	Carbon-Wrapped, 4500 psig, 66 cu ft, 45 min	70 - 75 ft lb
807586	807585	488894	68542	801131	Carbon-Wrapped, 2216 psig, 45 cu ft, 30 min	70 - 75 ft lb
807587	807583	488899	630926	801131	Carbon-Wrapped, 4500 psig, 45 cu ft, 30 min	70 - 75 ft lb
807588	807581	488899	630926	801131	Carbon-Wrapped, 4500 psig, 88 cu ft, 60 min	70 - 75 ft lb
809872	809871	488894	68542	801131	Aluminum, 2216 psig, 45 cu ft, 30 min	70 - 75 ft lb
816115	814632	494884	633550	801131	Carbon-Wrapped, 3000 psig, 60 cu ft, 30 min	70 - 75 ft lb
818159	818157	818158	68542	470735	Aluminum, 2216 psig, 8 cu ft, 5 min	45 +/- 5 ft lb
10008298	818157	10011634	68542	N/A	Aluminum, 2216 psig, 8 cu ft, 5 min	45 +/- 5 ft lb
10008299	802190	10011633	633550	N/A	Aluminum, 3000 psig, 15 cu ft, 10 min	45 +/- 5 ft lb
10035644	10039439	488899	630926	801131	Carbon-Wrapped, 4500 psig, 66 cu ft, 45 min, Low Profile	70 - 75 ft lb
10042420	10042390	10002083	633549	470735	Composite, 3000 psig, 8 cu ft, 5 min	30 - 35 ft lb
10042423	10042391	10002083	633549	470735	Composite, 3000 psig, 17 cu ft, 10 min	30 - 35 ft lb
10061364	818157	10061362	68542	N/A	Aluminum, 2216 psig, 8 cu ft, 5 min	45 +/- 5 ft lb
10061365	802190	10061363	633550	N/A	Aluminum, 3000 psig, 15 cu ft, 10 min	45 +/- 5 ft lb
10061366	10042390	10061361	633549	N/A	Composite, 3000 psig, 8 cu ft, 5 min	30 - 35 ft lb
10061367	10042391	10061361	633549	N/A	Composite, 3000 psig, 17 cu ft, 10 min	30 - 35 ft lb
10065044	10065043	10061363	633550	N/A	Composite, 3000 psig, 24 cu ft, 15 min	45 +/- 5 ft lb

For More Information, call 1-800-MSA-2222 or Visit Our Website at www.MSAnet.com



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