

FLOTEC

Work Instruction (WI-PRO-112) InGage Assembly (010-6222-001)

ASSEMBLY PROCEDURE

- 1.0 **EQUIPMENT REQUIRED:** InGage body, plastic decal ring with long decal, edge deburring tool, 0.437 in. pin gauge, 0.439 in. pin gauge, adhesive (such as Loctite), and a rubber band.
- 2.0 **PREPERATION:**

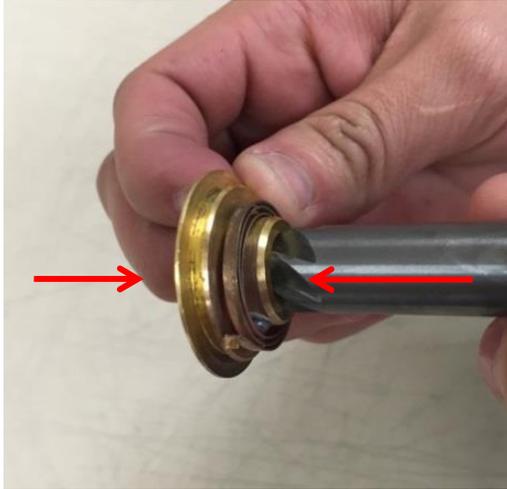


Figure 1

Remove the sharp edges from the center hole on both sides using the edge deburring tool

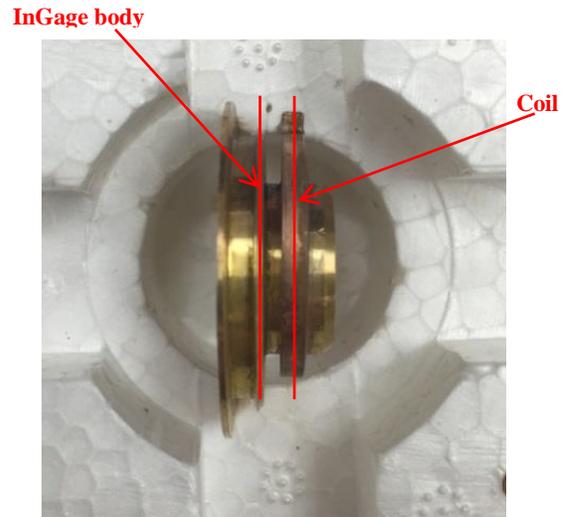


Figure 2

Coil is parallel with the InGage body

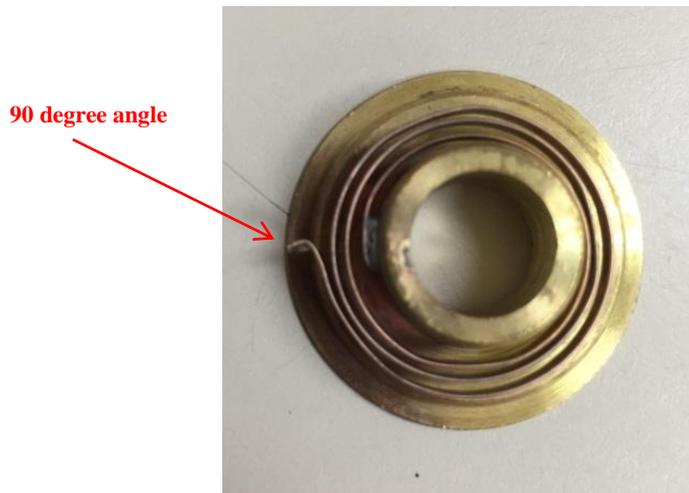


Figure 3

90 degree angle and inside the outer diameter

- 2.1 Remove the burs off both sides of the center hole of the InGage body using the edge deburring tool. (Figure 1)
- 2.2 Check that the center hole is greater than 0.437 and less than 0.439 using the pin gauges.
- 2.3 Verify the coil is straight and parallel with the InGage body. (Figure 2)
- 2.4 Verify that the hook at the end of the coil is at a 90 degree angle and is inside the outer diameter of the InGage body. (Figure 3)
- 2.5 Visually verify that the pressure inlet on the InGage body is not clogged.

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3.0 PROCEDURE

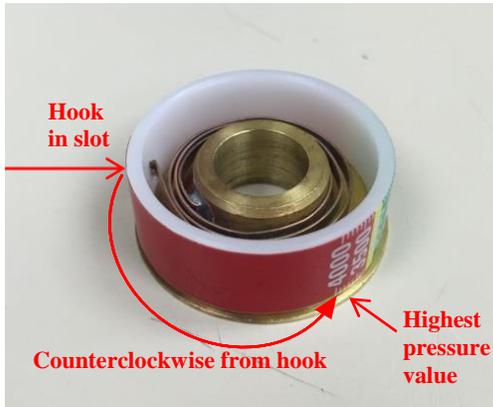


Figure 4

Hook facing left. The largest pressure (PSI) is the first value moving counterclockwise

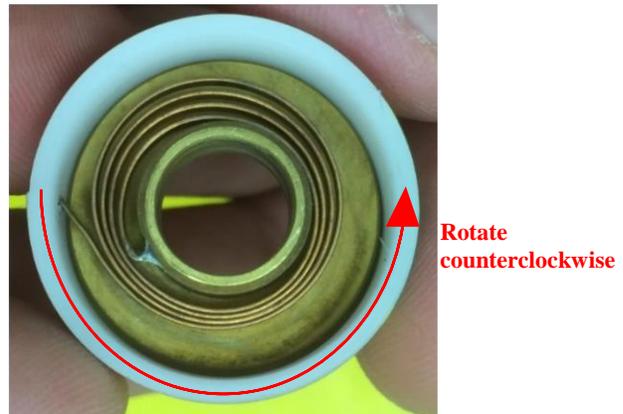


Figure 5

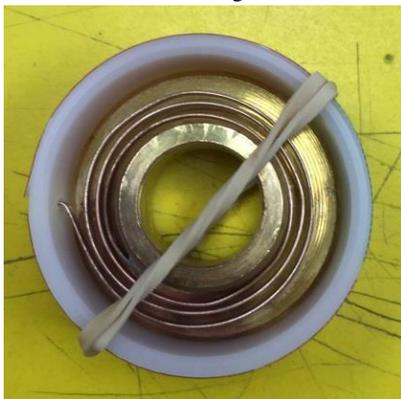


Figure 6

Rubber banded assembly

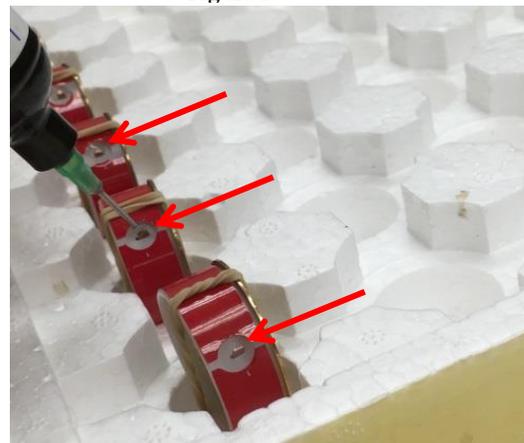


Figure 7

Location where the adhesive is applied

- 3.1 Place the plastic ring with the pressure decal over the InGage body and guide the hook into its slot. (Figure 4)
- 3.2 Verify that the plastic ring is installed such that the highest pressure value on the label is the first value counterclockwise from the hook while the assembly is aligned as in figure 4.
- 3.3 Turn the plastic ring in the counterclockwise direction and release to verify that the InGage is working properly. (Figure 5)
- 3.4 Center the plastic decal ring and verify that it is aligned with the largest diameter of the InGage body. Rubber band the plastic ring and InGage body together to keep them aligned. (See Figure 6)
- 3.5 Set the assemblies upright and add a small drop of adhesive to each plastic ring above the hook allowing the hook to be encapsulated. (Figure 7)
- 3.6 Allow the adhesive to cure in a manner appropriate to the adhesive used. Loctite requires a minimum of 3 hours to cure.

Released By _____

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