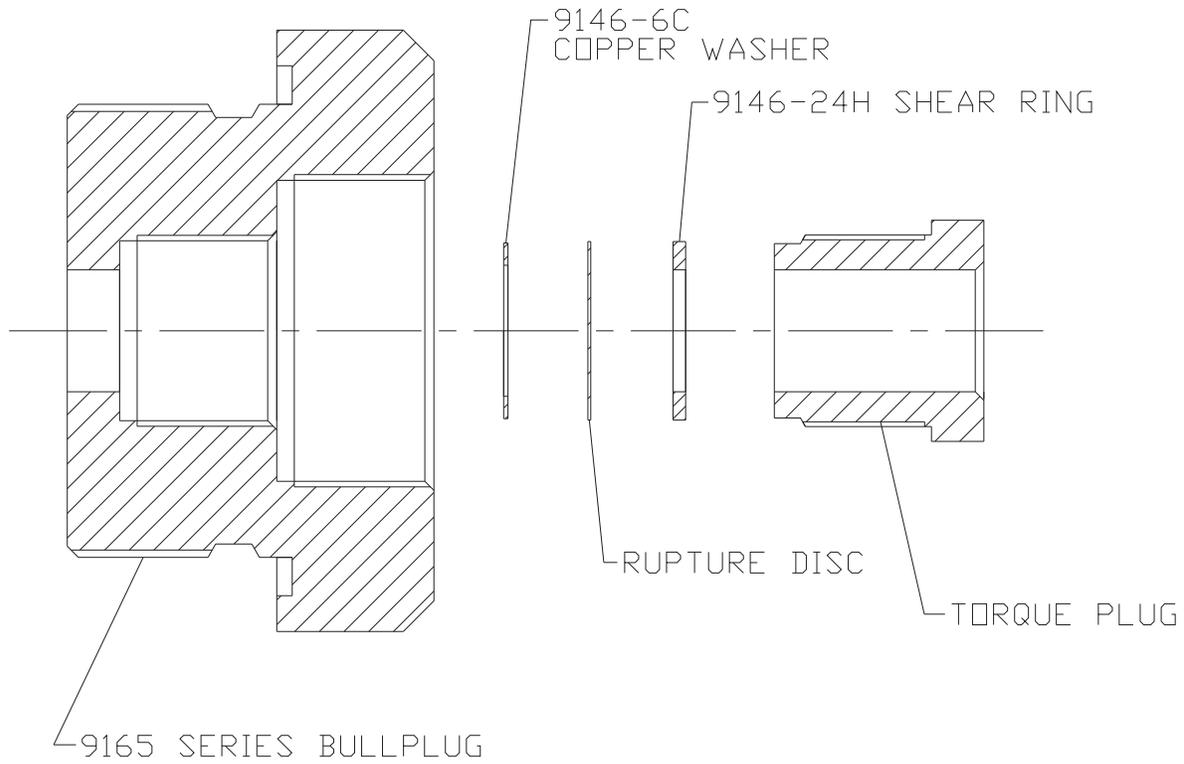


# ASSEMBLY PROCEDURE FOR 9165 SERIES RELIEF DEVICE



1. Lubricate 9146-6C copper washer using Halocarbon 25-10M grease or compatible grease.
2. Insert copper washer in 9165 series bullplug body.
3. Insert rupture disc letter code up in 9165 series bullplug body.
4. Lubricate 9146-24H shear ring using Halocarbon 25-10M grease or compatible grease.
5. Insert 9146-24H shear ring in 9165 body.
6. Screw torque plug in 9165 body.
7. Torque plug to 250 FT/LBS.

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# INSTALLATION PROCEDURE FOR 9165 SERIES RELIEF DEVICE

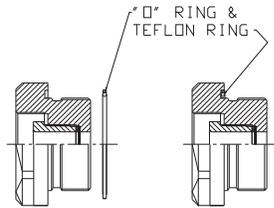


FIGURE 1

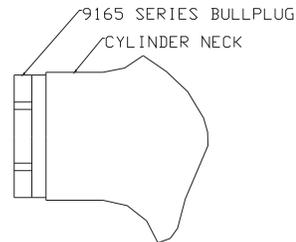


FIGURE 2

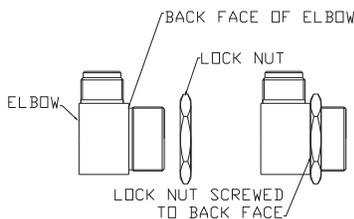


FIGURE 3

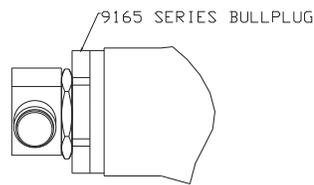


FIGURE 4

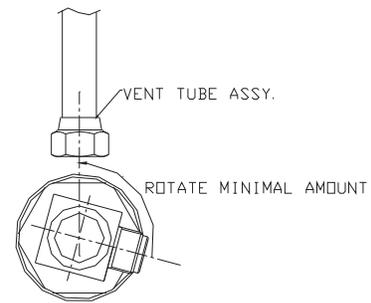


FIGURE 5

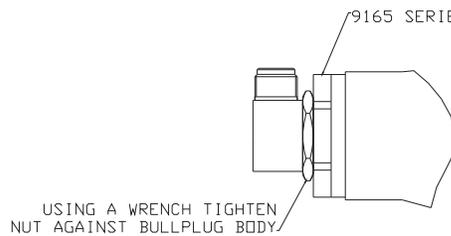


FIGURE 6

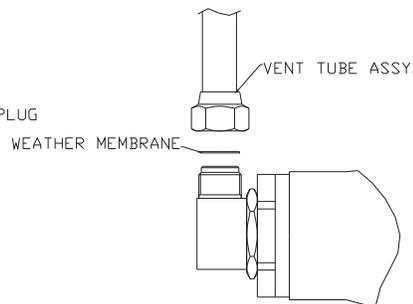


FIGURE 7

1. Lubricate "O" ring and Teflon back-up ring using Halocarbon 25-10M grease.
2. Install "O" ring and Teflon ring in groove of 9165 body. SEE FIGURE 1
3. Screw 9165 bullplug body in cylinder. SEE FIGURE 2
4. Torque 9165 bullplug body between 600 TO 1000 FT/LBS.
5. Screw lock nut on elbow to the back face of elbow. SEE FIGURE 3
6. Screw elbow to face of 9165 bullplug body. SEE FIGURE 4
7. Back off elbow the minimal amount for vent tube alignment. **DO NOT EXCEED 1 TURN.** SEE FIGURE 5
8. Screw lock nut to face of 9165 bullplug body and torque to 220 FT/LBS. SEE FIGURE 6
9. Install membrane and vent tube assembly. SEE FIGURE 7

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