

# How to assemble API

## Assembly Instruction API



## Objectives of this Presentation. Knowledge to learn.

1. Objectives | 2. General | 3. General Illustration | 4. Preparation for valve assembly | 5. Assembly Instruction Type 526

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The aim of this presentation is to give an **overview** about the **assembly of API safety valves type 526**.



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# General. API Safety Valves.

1. Objectives | 2. General | 3. General Illustration | 4. Preparation for valve assembly | 5. Assembly Instruction Type 526

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**LESER API Safety Valves** offer ultimate protection against overpressures in all applications for steam, gases and liquids. They can be used e.g. in refineries, in the chemical industry and in onshore and offshore plants.

## Advantages:

- Single trim for steam, gas and liquid
- Valves sizes 1" – 8", Orifice D – T
- Great variety of aseptic connections and options to fit any application



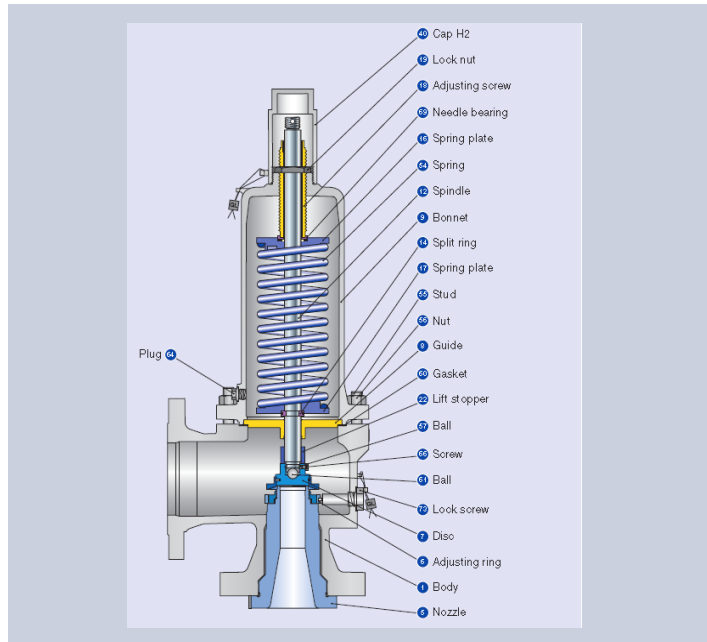
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# General Illustration.

1. Objectives | 2. General | 3. **General Illustration** | 4. Preparation for valve assembly | 5. Assembly Instruction Type 526

## Cross-sectional view API 526



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## Preparation for Valve Assembly. Emboss the punch numbers (if requested).

1. [Objectives](#) | 2. [General](#) | 3. [General Illustration](#) | 4. [Preparation for valve assembly](#) | 5. [Assembly Instruction Type 526](#)

- Emboss the code into the edge of the outlet flange (position of the code as per the work plan)
- Tools: Hammer, punch numbers



# Assembly of Type 526. Assembly of the nozzle and blow down ring.

1. Objectives | 2. General | 3. General Illustration | 4. Preparation for valve assembly | 5. Assembly Instruction Type 526

## Step 1-1

- Grease sealing surface.
- Tools: brush, grease (Molykote-Paste)



## Step 1-2

- Screw nozzle into the body



# Assembly of Type 526. 1. Assembly of the nozzle and blow down ring.

1. [Objectives](#) | 2. [General](#) | 3. [General Illustration](#) | 4. [Preparation for valve assembly](#) | 5. [Assembly Instruction Type 526](#)

## Step 1-3

- Tighten nozzle with C-spanner (put a small protective slab between the nozzle and C-spanner).
- Tools: C-spanner with a nose



## Step 1-4

- Screw the blow down ring completely down to the nozzle



## Assembly of Type 526. 2. Screw the studs into the body.

1. [Objectives](#) | 2. [General](#) | 3. [General Illustration](#) | 4. [Preparation for valve assembly](#) | 5. [Assembly Instruction Type 526](#)

### Step 2-1

- Screw in the studs with an impact wrench.
- Tip: Place the guide on the opening of the body so that no studs can fall on the seat.
- Tools: impact wrench



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# Assembly of Type 526. 3. Installation of the locking screw and screw plug.

1. Objectives | 2. General | 3. General Illustration | 4. Preparation for valve assembly | 5. Assembly Instruction Type 526

## Step 3-1

- Grease the locking screw and screw plug.
- Tools: brush, halocarbon (OI-56 S / 60H)

## Step 3-2

- Grease a spacer ring for each of the screws and put on as a seal.



# Assembly of Type 526. 3. Installation of the locking screw and screw plug.

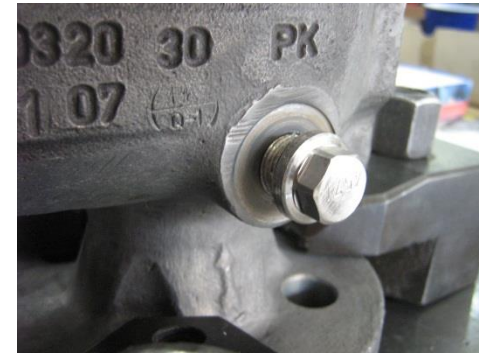
1. Objectives | 2. General | 3. General Illustration | 4. Preparation for valve assembly | 5. Assembly Instruction Type 526

## Step 3-3

- Screw the locking screw into the back section of the body and tighten.
- Tools: open-end spanner

## Step 3-4

- Grease a spacer ring for each of the screws and put on as a seal.



# Assembly of Type 526. 4. Assembly of disc assembly – 4.1 Metal seat.

1. Objectives | 2. General | 3. General Illustration | 4. Preparation for valve assembly | 5. Assembly Instruction Type 526

## Step 4.1-1

- Put disc body and lifting aid together and clamp in place.
- Tools: bench vice

## Step 4.1-2

- Insert retaining ring and tighten with C-spanner.
- Tools: C-spanner with a nose



# Assembly of Type 526. 4. Assembly of disc assembly group – 4.2 O-ring-seal.

1. Objectives | 2. General | 3. General Illustration | 4. Preparation for valve assembly | 5. Assembly Instruction Type 526

## Step 4.2-1

- Individual parts of the disc assembly with O-ring seal



## Step 4.2-2

- Wet O-ring with water and avoid any twisting when introducing it.



# Assembly of Type 526. 4. Assembly of disc assembly group – 4.2 O-ring-seal.

1. Objectives | 2. General | 3. General Illustration | 4. Preparation for valve assembly | 5. Assembly Instruction Type 526

## Step 4.2-3

- Insert retainer

## Step 4.2-4

- Screw nut onto neck and tighten.  
(Set torque as per LGS 3325)
- Tools: torque wrench with socket attachment, bench vice



# Assembly of Type 526. 4. Assembly of disc assembly group – 4.2 O-ring-seal.

1. Objectives | 2. General | 3. General Illustration | 4. Preparation for valve assembly | 5. Assembly Instruction Type 526

## Step 4.2-5

- Secure the nut by hitting it with a centre punch.
- Tools: centre punch, hammer

## Step 4.2-6

- Emboss the marking for the O-ring material according to WI 3308-08.
- Tools: punch numbers, hammer



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# Assembly of Type 526. 4. Assembly of disc assembly group – 4.3 Sealing plate.

1. Objectives | 2. General | 3. General Illustration | 4. Preparation for valve assembly | 5. Assembly Instruction Type 526

## Step 4.3-1

- Individual parts of the disc assembly with sealing plate



## Step 4.3-2

- Put the sealing plate in the disc.



# Assembly of Type 526. 4. Assembly of disc assembly group – 4.3 Sealing plate.

1. Objectives | 2. General | 3. General Illustration | 4. Preparation for valve assembly | 5. Assembly Instruction Type 526

## Step 4.3-3

- Put the retainer on the sealing plate.

## Step 4.3-4

- Screw nuts onto studs and tighten (torque as per LGS 3325).
- Secure the nut by hitting it with a centre punch.
- Emboss the marking for the sealing plate material according to WI 3308-08.
- Tools: torque wrench with socket attachment, centre punch, hammer, punch numbers





# Assembly of Type 526. 5. Assembly of spindle/disc assembly group.

1. Objectives | 2. General | 3. General Illustration | 4. Preparation for valve assembly | 5. Assembly Instruction Type 526

## 5.1 Assembly of spindle/disc assembly group (without bellows).

### Step 5.1-1

- Insert the ball into the disc.

### Step 5.1-2

- Push on spindle and insert small balls into the screw opening of the disc.
- Tools: possibly tweezers.



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# Assembly of Type 526. 5. Assembly of spindle/disc assembly group 5.1.

1. Objectives | 2. General | 3. General Illustration | 4. Preparation for valve assembly | 5. Assembly Instruction Type 526

## 5.1 Assembly of spindle/disc assembly group (without bellows).

### Step 5.1-3

- Screw in and tighten the clamping screw.
- Tools: ring spanner

### Step 5.1-4

- Put on lift stopper, if requested.



# Assembly of Type 526. 5. Assembly of spindle/disc assembly group 5.1.

1. Objectives | 2. General | 3. General Illustration | 4. Preparation for valve assembly | 5. Assembly Instruction Type 526

## 5.1 Assembly of spindle/disc assembly group (without bellows).

### Step 5.1-5

- Push on guide, put split rings in the recess of the spindle and secure with a retaining clip.



### Step 5.1-6

- Push the lower spring plate, the spring and the upper spring plate onto the spindle.



# Assembly of Type 526. 5. Assembly of spindle/disc assembly group 5.2.

1. Objectives | 2. General | 3. General Illustration | 4. Preparation for valve assembly | 5. Assembly Instruction Type 526

## 5.2 Assembly of spindle/disc assembly group (with stainless steel bellows).

### Step 5.2-1

- Stainless steel bellows and guide

### Step 5.2-2

- Grease the sealing surface and thread of the bellows
- Tools: brush, grease (Molykote-paste).



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# Assembly of Type 526. 5. Assembly of spindle/disc assembly group 5.2.

1. Objectives | 2. General | 3. General Illustration | 4. Preparation for valve assembly | 5. Assembly Instruction Type 526

## 5.2 Assembly of spindle/disc assembly group (with stainless steel bellows).

### Step 5.2-3

- Screw the guide onto the bellows.

In some cases, larger bellows have an inside thread and are screwed on the corresponding outside thread of the guide



# Assembly of Type 526. 5. Assembly of spindle/disc assembly group 5.2.

1. Objectives | 2. General | 3. General Illustration | 4. Preparation for valve assembly | 5. Assembly Instruction Type 526

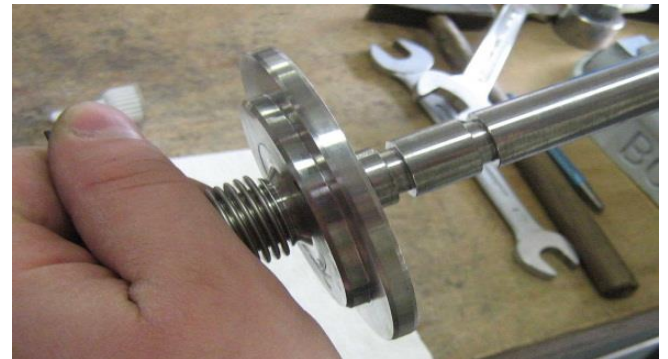
## 5.2 Assembly of spindle/disc assembly group (with stainless steel bellows).

### Step 5.2-4

- Sparingly apply one drop of glue to the thread of the spindle
- Tools: glue DELO ML 5449

### Step 5.2-5

- Quickly screw the spindle together with the bellows hand tight.



# Assembly of Type 526. 5. Assembly of spindle/disc assembly group 5.2.

1. Objectives | 2. General | 3. General Illustration | 4. Preparation for valve assembly | 5. Assembly Instruction Type 526

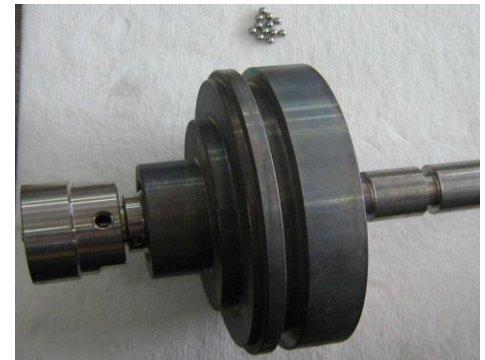
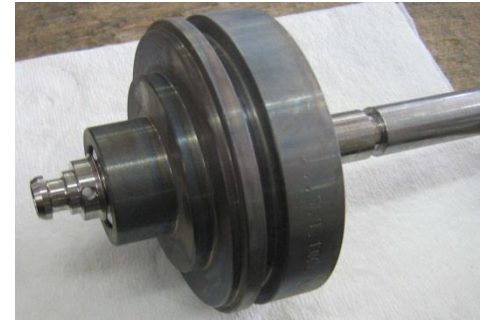
## 5.2 Assembly of spindle/disc assembly group (with stainless steel bellows).

### Step 5.2-6

- Put the cooling zone onto the spindle.

### Step 5.2-7

- Put the disc on the spindle.
- Put the balls into the opening of the disc, or alternatively secure the disc with a pin (depending on the disc version).



# Assembly of Type 526. 5. Assembly of spindle/disc assembly group 5.2.

1. Objectives | 2. General | 3. General Illustration | 4. Preparation for valve assembly | 5. Assembly Instruction Type 526

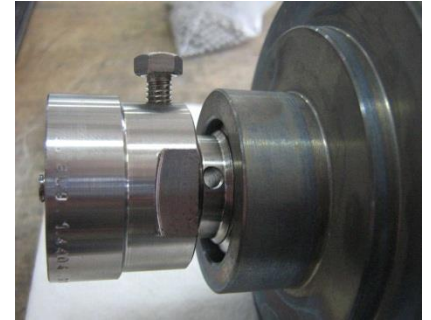
## 5.2 Assembly of spindle/disc assembly group (with stainless steel bellows).

### Step 5.2-8

- Screw the clamping screw into the disc hole.
- Tools: ring spanner

### Step 5.2-9

- Put split rings into the recess and secure with a retaining clip.





# Assembly of Type 526. 5. Assembly of spindle/disc assembly group 5.3.

1. Objectives | 2. General | 3. General Illustration | 4. Preparation for valve assembly | 5. Assembly Instruction Type 526

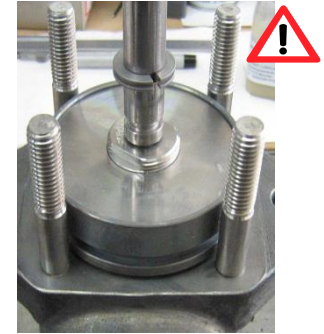
## 5.3 Inserting the spindle/disc assembly group (with stainless steel bellows).

### Step 5.3-1

- Insert the spindle/disc/cooling zone into the body.
- In the process, push the guide down and lift the spindle somewhat so that the disc does not touch down.
- Carefully put the disc with the spindle down on the seat.

### Step 5.3-2

- Put the bottom spring plate, the spring and the top spring plate on one after the other.



# Assembly of Type 526. 5. Assembly of spindle/disc assembly group 5.3.

1. Objectives | 2. General | 3. General Illustration | 4. Preparation for valve assembly | 5. Assembly Instruction Type 526

## 5.3 Inserting the spindle/disc assembly group (with stainless steel bellows).

### Step 5.3-3

- Grease the axial needle bearing on the top spring plate.
- Tools: brush, halocarbon (OI-56 S / 60H)

### Step 5.3-4

- Put the bearing washer on the axial needle bearing and grease.
- Tools: brush, halocarbon (OI-56 S / 60H)



# Assembly of Type 526. 6. Assembly of the bonnet.

1. Objectives | 2. General | 3. General Illustration | 4. Preparation for valve assembly | 5. Assembly Instruction Type 526

## Step 6.1

- Put the bonnet on the studs, screw nuts onto the studs and tighten (Set torque as per LGS 3323).
- Tools: torque wrench



# Assembly of Type 526. 7. Determination and installation of the lift stopper 7.1.

1. Objectives | 2. General | 3. General Illustration | 4. Preparation for valve assembly | 5. Assembly Instruction Type 526

## 7.1 Lift stopper with ring/sleeve.

### Step 7.1-1

- Take the extent to which the lift has to be limited from the work order. Insert the spindle/disc assembly without the spring and spring plate. Put on the bonnet and tighten the nuts. Make the adjusting screw and spindle flush.



# Assembly of Type 526. 7. Determination and installation of the lift stopper 7.1.

1. Objectives | 2. General | 3. General Illustration | 4. Preparation for valve assembly | 5. Assembly Instruction Type 526

## 7.1 Lift stopper with ring/sleeve.

### Step 7.1-2

- Clamp the body on the outlet in the vice.  
Lift the disc with a screwdriver through the inlet as far as it will go.
- Tools: screwdriver, bench vice

### Step 7.1-3

- Measure the spindle overlap in an opened state.  
Deduct the requested lift from this measurement and have a lift stopper made.
- Tools: sliding vernier, calliper



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# Assembly of Type 526. 7. Determination and installation of the lift stopper 7.2.

1. Objectives | 2. General | 3. General Illustration | 4. Preparation for valve assembly | 5. Assembly Instruction Type 526

## 7.2 Procedure for large valves without bellows (as of approx. DN 80/3").

### Step 7.2-1

- Carefully put the disc on the nozzle and put the sealing ring in the body.
- Take the extent to which the lift has to be limited from the job order.

### Step 7.2-2

- Put the guide on the body.



# Assembly of Type 526. 7. Determination and installation of the lift stopper 7.2.

1. Objectives | 2. General | 3. General Illustration | 4. Preparation for valve assembly | 5. Assembly Instruction Type 526

7.2 Procedure for large valves without bellows  
(as of approx. DN 80/3").

## Step 7.2-3

- Use the depth gauge to measure the path from the top edge of the guide to the top edge of the disc.
- Deduct the measurement of the guide as well as the desired lift from the order and have the lift stopper made.



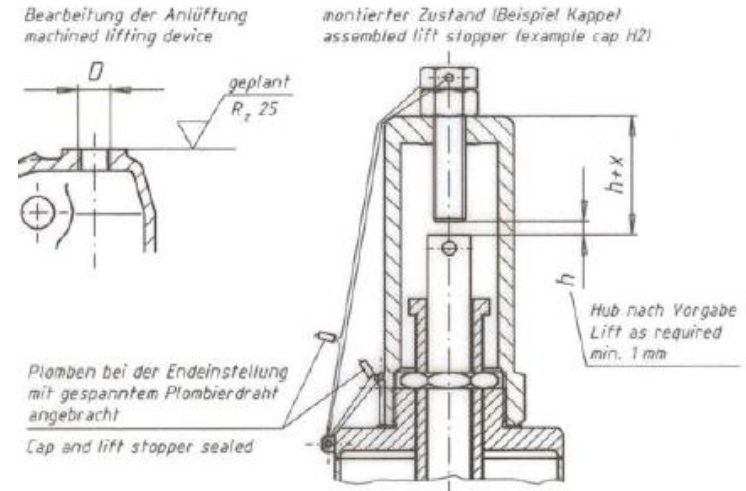
# Assembly of Type 526. 7. Determination and installation of the lift stopper 7.3.

1. Objectives | 2. General | 3. General Illustration | 4. Preparation for valve assembly | 5. Assembly Instruction Type 526

## 7.3 Lift stopper with set screw (taken from LGS 3324).

### Description

- Take the extent to which the lift has to be limited from the job order.
- Use a completely assembled valve to measure the distance from the top edge of the cap/lever to the end of the spindle.
- Deduct the measurement of the guide as well as the desired lift from the order and have the lift stopper made.
- Seal the screws with PTFE tape, screw them in and tighten. (Set torque as per LGS 3323).





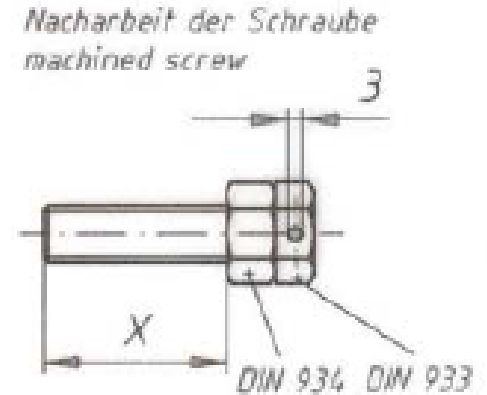
# Assembly of Type 526. 7. Determination and installation of the lift stopper 7.3.

1. Objectives | 2. General | 3. General Illustration | 4. Preparation for valve assembly | 5. Assembly Instruction Type 526

## 7.3 Lift stopper with set screw (taken from LGS 3324).

### Aids / Tools

- PTFE tape
- Sliding vernier calliper



# Assembly of Type 526. 8. Assembly of the adjusting screw.

1. Objectives | 2. General | 3. General Illustration | 4. Preparation for valve assembly | 5. Assembly Instruction Type 526

## Step 8-1

- Individual parts of the adjusting screw



## Step 8-2

- Put the bushing in the adjusting screw.



## Assembly of Type 526. 8. Assembly of the adjusting screw.

1. Objectives | 2. General | 3. General Illustration | 4. Preparation for valve assembly | 5. Assembly Instruction Type 526

### Step 8-3

- Screw the lock nut on approximately three-quarters of the way down the adjusting screw.



### Step 8-4

- Grease adjusting screw.
- Tools: brush, grease (Molykote paste)



# Assembly of Type 526. 8. Assembly of the adjusting screw.

1. Objectives | 2. General | 3. General Illustration | 4. Preparation for valve assembly | 5. Assembly Instruction Type 526

## Step 8-5

- Screw the adjusting screw into the bonnet until resistance from the spring is felt.



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# Assembly of Type 526. 9. Adjusting the set pressure.

1. Objectives | 2. General | 3. General Illustration | 4. Preparation for valve assembly | 5. Assembly Instruction Type 526

## Step 9-1

- Secure the spindle from turning with a pin punch.
- Tools: pin punch, open-end spanner

## Step 9-2

- Slowly pressurize the valve on the test bench to find out whether the valve opens at the set pressure.
- The set pressure of the valve has been reached when you can hear air escaping.
- If the valve opens outside the stipulated set pressure tolerance, then the adjusting screw must be adjusted again.



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# Assembly of Type 526. 9. Adjusting the set pressure.

1. Objectives | 2. General | 3. General Illustration | 4. Preparation for valve assembly | 5. Assembly Instruction Type 526

## Step 9-2

- Turning in a clockwise direction causes the valve to open at higher pressure.  
Turning in a counter-clockwise direction causes the valve to open at lower pressure.
- Release the pressure when readjusting the adjusting screw.  
Readjust the adjusting screw and then pressurize the valve again.

## Step 9-3

- If the pressure setting has been completed, secure the adjusting screw with a lock nut.
- Afterwards, check the set pressure once again.
- Tools: open-end spanner



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# Assembly of Type 526. 10. Testing the seat tightness P12.

1. Objectives | 2. General | 3. General Illustration | 4. Preparation for valve assembly | 5. Assembly Instruction Type 526

This test is performed for every valve after setting the pressure.

The exact execution of the test is described in WI 0007.00

## 11. Assembly of cap / lever – 11.1 Assembly of cap H2

### Step 11.1-1

- Grease the thread and sealing face of the cap.
- Tools: brush, halocarbon (OI-56 S / 60H)

### Step 11.1-2

- Screw on the cap and tighten with a spanner (set torque as per LGS 3323)
- Tools: open-end spanner



# Assembly of Type 526. 11. Assembly of the cap / lever – 11.2 Lever H3.

1. Objectives | 2. General | 3. General Illustration | 4. Preparation for valve assembly | 5. Assembly Instruction Type 526

## Step 11.2-1

- Put the spindle cap onto the spindle and secure with a pin and retaining clip.



## Step 11.2-2

- Put clamping screw into H3 cap at designated place.
- Tools: ring spanner





# Assembly of Type 526. 11. Assembly of the cap / lever – 11.2 Lever H3.

1. Objectives | 2. General | 3. General Illustration | 4. Preparation for valve assembly | 5. Assembly Instruction Type 526

## Step 11.2-3

- Put the small plastic balls in the hole of the adjusting screw.

## Step 11.2-4

- Grease the thread of the lever cap and screw it onto the bonnet (lever must be opposite from outlet).
- Tools: brush, halocarbon (OI-56 S / 60H)



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# Assembly of Type 526. 11. Assembly of the cap / lever – 11.2 Lever H3.

1. Objectives | 2. General | 3. General Illustration | 4. Preparation for valve assembly | 5. Assembly Instruction Type 526

## Step 11.2-5

- Insert the lifting lever into the lever cap.

## Step 11.2-6

- Use a pin and retaining washer to secure the lifting lever.

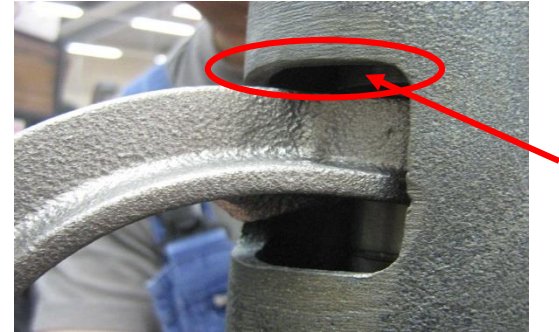


# Assembly of Type 526. 11. Assembly of the cap / lever – 11.2 Lever H3.

1. Objectives | 2. General | 3. General Illustration | 4. Preparation for valve assembly | 5. Assembly Instruction Type 526

## Step 11.2-7

- Make sure that the lever has enough play to vent!



## Step 11.2-8

- Tighten the clamping screw on the lever.
- Tools: ring spanner



# Assembly of Type 526. 11. Assembly of the cap / lever – 11.3 Lever H4.

1. Objectives | 2. General | 3. General Illustration | 4. Preparation for valve assembly | 5. Assembly Instruction Type 526

## Step 11.3-1

- Put the spindle cap onto the spindle and secure with a pin and retaining clip.



## Step 11.3-2

- Align the lever cap with sealing rings so that the lever arm is parallel to the outlet.



# Assembly of Type 526. 11. Assembly of the cap / lever – 11.3 Lever H4.

1. Objectives | 2. General | 3. General Illustration | 4. Preparation for valve assembly | 5. Assembly Instruction Type 526

## Step 11.3-3

- Grease the lever and sealing rings. Put them on and tighten with an open-end spanner (torque as per LGS 3323).
- Tools: open-end spanner, torque wrench



# Assembly of Type 526. 12. Assembly of the lift indicator.

1. Objectives | 2. General | 3. General Illustration | 4. Preparation for valve assembly | 5. Assembly Instruction Type 526

## Step 12-1

- Individual parts of the lift indicator.



## Step 12-2

- Put the lever cap into position as described in 11.3-2 and secure .
- Tools: open-end spanner



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# Assembly of Type 526. 12. Assembly of the lift indicator.

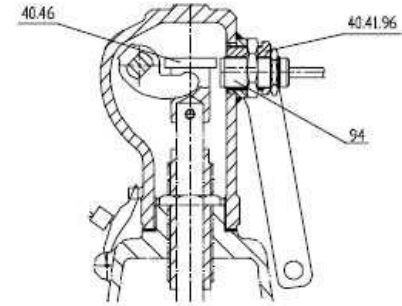
1. Objectives | 2. General | 3. General Illustration | 4. Preparation for valve assembly | 5. Assembly Instruction Type 526

## Step 12-3

- Put the eccentric hole of the holder into such a position that the collar of the spindle cap would seal on top with the edge of the lift indicator (see illustration).

## Step 12-4

- Secure the position with a lock nut.



# Assembly of Type 526. 12. Assembly of the lift indicator.

1. Objectives | 2. General | 3. General Illustration | 4. Preparation for valve assembly | 5. Assembly Instruction Type 526

## Step 12-5

- Screw the lift indicator into the collar of the spindle cap as far as it will go. Then unscrew it one complete turn.
- Secure the position of the lift indicator by tightening the first nut hand tight.
- Then lock with a second nut.





# Assembly of Type 526. 13. Assembly of the test gag (possible for H2 and H4).

1. Objectives | 2. General | 3. General Illustration | 4. Preparation for valve assembly | 5. Assembly Instruction Type 526

## Step 13-1

- Grease the sealing surface of the short screw.
- Tools: brush, halocarbon (OI-56 S/60H)



## Step 13-2

- Put on the sealing ring and grease it as well.
- Tools: brush, halocarbon (OI-56 S/60H)



# Assembly of Type 526. 13. Assembly of the test gag (possible for H2 and H4).

1. [Objectives](#) | 2. [General](#) | 3. [General Illustration](#) | 4. [Preparation for valve assembly](#) | 5. [Assembly Instruction Type 526](#)

## Step 13-3

- Screw the test gag into the cap or lever cap and tighten (torque as per LGS 3323).



# Assembly of Type 526. 14.1 Assembly of the O-ring damper H2.

1. Objectives | 2. General | 3. General Illustration | 4. Preparation for valve assembly | 5. Assembly Instruction Type 526

## Step 14.1-1

- Individual parts of the O-ring damper H2.



## Step 14.1-2

- Put the support sleeve onto the adjusting screw.



# Assembly of Type 526. 14.1 Assembly of the O-ring damper H2.

1. Objectives | 2. General | 3. General Illustration | 4. Preparation for valve assembly | 5. Assembly Instruction Type 526

## Step 14.1-3

- Put O-ring onto the spindle over the support sleeve. The O-ring must not sit on the cross hole or a thread, if one is present.

## Step 14.1-4

- Put the counter ring onto the O-ring or support sleeve.



# Assembly of Type 526. 14.1 Assembly of the O-ring damper H2.

1. Objectives | 2. General | 3. General Illustration | 4. Preparation for valve assembly | 5. Assembly Instruction Type 526

## Step 14.1-5

- Put retaining spring onto the counter ring.



## Step 14.1-6

- Grease the cap on the thread. Screw it onto the bonnet and tighten (torque as per LGS 3323).
- Tools: open-end spanner



# Assembly of Type 526. 14.2 Assembly of the O-ring damper H4.

1. Objectives | 2. General | 3. General Illustration | 4. Preparation for valve assembly | 5. Assembly Instruction Type 526

## Step 14.2-1

- Individual parts of the O-ring damper H4



## Step 14.2-2

- Fasten the O-ring damper on the spindle with a steel pin and retaining clip.



# Assembly of Type 526. 14.2 Assembly of the O-ring damper H4.

1. Objectives | 2. General | 3. General Illustration | 4. Preparation for valve assembly | 5. Assembly Instruction Type 526

## Step 14.2-3

- Individual parts of the O-ring damper H4.



## Step 14.2-4

- Put the first O-ring, counter ring, second O-ring, support sleeve, spring, and cap onto the lever one after the other.



# Assembly of Type 526. 14.2 Assembly of the O-ring damper H4.

1. [Objectives](#) | 2. [General](#) | 3. [General Illustration](#) | 4. [Preparation for valve assembly](#) | 5. [Assembly Instruction Type 526](#)

## Step 14.2-5

- Grease thread and sealing lip of the cap, screw on and tighten the cap (torque as per LWN LGS 3323).
- Tools: halocarbon (OI-56 S / 60H), open-end spanner





# Assembly of Type 526.

1. Objectives | 2. General | 3. General Illustration | 4. Preparation for valve assembly | 5. Assembly Instruction Type 526

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## 15. Adjusting the set pressure

- Pressurise the valve. Check whether the valve opens at the set pressure. The set pressure of the valve has been reached when the pressure display remains constant when the line pressure increases.
- The valve must open within the tolerance range 3 times in succession.
- Document the set pressure.

## 16. Testing the seal tightness of the back seal P21 (seal tightness to the outside)

- This test is performed for every gas-tight valve after its assembly.

# Assembly of Type 526. 17. Sealing the valve.

1. Objectives | 2. General | 3. General Illustration | 4. Preparation for valve assembly | 5. Assembly Instruction Type 526

## Step 17-1

- Seal the valve
- Closely connect the sealing hole or lug from the cap/lever and bonnet in a clockwise direction, and connect the locking screw and sealing lug with sealing wire and seal the ends of the wire with a lead seal.
- Tools: sealing pliers, wire twisting pliers, sealing block, wire



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**How to assemble API**  
Thank you for your attention.

