

Installation Method of *Nor-Ray-Vac* Tube Couplers.



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General information.

The Nor-Ray-Vac Tube Coupler is a screw tightening, self aligning - positive located tubular coupler. Manufactured in a non-corrosive stainless steel it is available in both 100mm (4") and 150mm (6").

Two high tensile stainless steel set pins tighten to clamp the coupler onto the tube whilst a rivet pro-

vides a centralised permanent stop to give the joint equidistance.

The information contained in this technical bulletin is designed to aid a qualified or competent service technician in the instruction it is intended for.

Tools required.

The following tool(s) and equipment will be required to complete this task:



6 6mm Allen key or power tool with suitable 6mm attachment

Step by step instructions.

! CAUTION – SHARP EDGES!

- 1** Before assembly, carefully loosen the two screws. Position the coupler onto the first tube ensuring that the bars are positioned uppermost.



- 2** Slide the coupler over the tube ensuring that the rivet stop has butted up to the tube end.



- 3** Using a 6mm allen key, tighten the relevant pin. DO NOT OVERTIGHTEN AT THIS STAGE.



- 4** Slide the second tube into the coupler ensuring that the rivet stop has butted up to the tube end.



- 5** Using the 6mm allen key, tighten the second pin. DO NOT OVERTIGHTEN AT THIS STAGE.



- 6** Moving between the two set pins, tighten both ensuring that equal pressure is applied to each set pin in turn.



- 7** If step 6 has been correctly, the coupler should have aligned itself parallel to the two tubes and a slight indentation can be observed. Using the 6mm allen key, finally tighten each screw by a further quarter turn. If a power tool is used, use a torque limit setting of 6.6 lbf/ft (0.91kgf/m) must be achieved.



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