



ASSEMBLY INSTRUCTIONS FOR O-RING SEAL REACTORS

- 1.0 The "OC" and "TOC" series reactors employ a simple yet highly reliable sealing design. This is a self-sealing type of closure and does not require any torque to effect a proper seal. Assembly and disassembly can be accomplished by hand even on the larger size reactors.
- 2.0 Proper assembly is as follows:
 - 2.1 Place the O-ring into the groove in the cover. A process-compatible grease sealant is usually desirable to enhance sealing.
 - 2.2 Insert the cover into the body until it fully contacts the end of the body.
 - 2.3 Lubricate the body threads with an appropriate thread lubricant.
 - 2.4 Rotate the main nut clockwise onto the reactor until it contacts the cover. Excessive force is not required for sealing.
- 3.0 NOTE:
 - 3.1 It is extremely important that an ample supply of thread lubricant be kept on the body and main nut threads.
 - 3.2 The use of a bar inserted into the main nut might prove helpful during assembly or disassembly of the closure. However, excessive force on the bar should never be used.
- 4.0 Caution: In order to guard against thread galling:

The weight of the cap may be significant and must be offset (neutralized) prior to assembly or disassembly.

Thread lubricant must be applied to the body threads prior to each reassembly.

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