

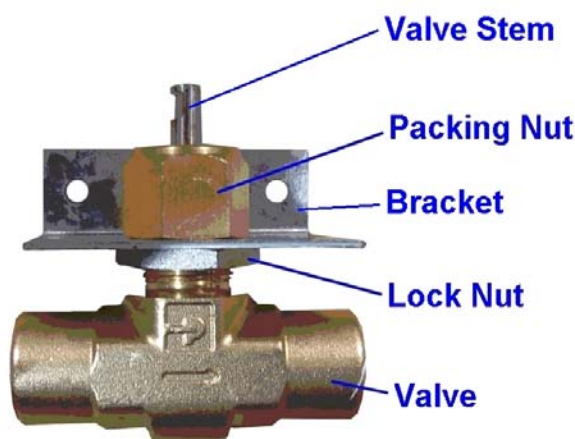


<b>Subject:</b>	Needle Valve Mounting - NitroPro
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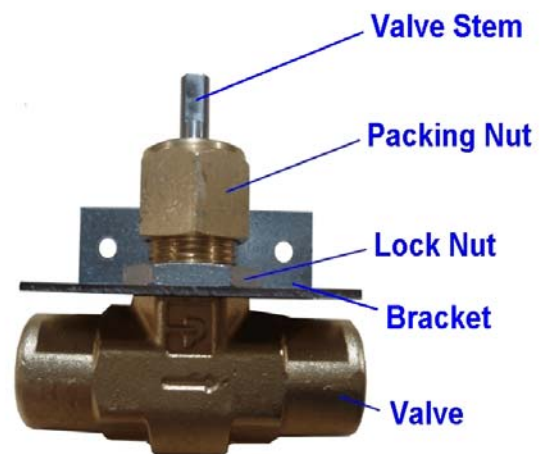
Model Numbers Affected:	All NTF machines with catalog numbers beginning with 455
Manufacture Dates:	All machines manufactured before July 27, 2007
Serial Numbers Affected:	All with middle 6 digits dated before 270707 (DDMMYY)
Tools Required:	Torque wrench capable of measuring 90 In-Lb of torque recommended
Parts Required:	None
Supplemental Document:	562-80002-00 TECH BULLETIN ADJUSTING NEEDLE VALVE
Action Required:	Recommend anyone servicing an NTF machine which is experiencing a problem with the adjustment of this valve should change the mounting.

The method of mounting the Needle Valve to the bracket has been modified to eliminate the possibility of changing the Valve Stem snugness while tightening the Lock Nut.

**Figure 1** shows the previous configuration. Movement of the Lock Nut or Valve could cause the Packing Nut to also change position which would affect the snugness of the Valve Stem.



**Figure 1**



**Figure 2**

**Figure 2** shows the improved method for mounting the Valve to the bracket. Tightening of the Lock Nut does not affect the Packing Nut. It is recommended that the Packing Nut be tightened to a torque of 90 In-Lb. This will ensure the proper snugness of the Valve Stem.

Note: If a torque wrench is not available, tighten the Packing Nut finger tight and then tighten further with an end wrench another ¼ to ½ turns. The Valve Stem should be snug enough that one can not turn it by hand.

The Needle Valve needs to be adjusted to obtain the proper Nitrogen purity. See 562-80002-00 for adjustment instructions