

FIELD TRIMMING OF Clark-Reliance® END STEM GAGE NIPPLES



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Procedure for Trimming a Water Gage Nipple (End Stem Connections)

A gage nipple for a Clark-Reliance water gage glass may be trimmed to the correct length in the field. A standard length gage nipple will be furnished if the water gage valve centers are not known or not furnished with the purchase order. The standard length nipple that is normally furnished is part number PG4-060 - 6" (152 mm) long. The length calculation for the nipple part number does not include the 3/8" (9.5 mm) of the NPT end that engages into the gage body. For example, part number PG4-060 actually measures 6.375" (161.9 mm). The nipple is made out of 3/4" O.D. 304 Stainless Steel Tubing.

The procedure for trimming the nipple to correct length is as follows:

1. Place the nipple in a vise and secure in place, being very careful not to damage the surface. Any scratches or gouges on the surface of the nipple can possibly cause a leak path for steam or water.
2. Measuring from the threaded end of the gage nipple measure the required length (the distance from the end of the gage body to the tip of the gage nipple) and add **3/8"** (9.5 mm) to the length for thread engagement into the gage body.
3. Using a hacksaw, cut the gage nipple to the required length, keeping the cut end as square as possible.
4. Remove any burrs from the end of the gage nipple and file clean.
5. Apply high temperature pipe dope (sealant), such as Deacon 770-L (or equal) to the threads, assemble to the gage (**using caution not to damage the surface of the gage nipple**), and tighten, making sure that the extension from the gage body is at the correct length. A stud extractor is the suggested tool for the procedure.

When measuring the gage, the correct length (from end of the top nipple to the end of the bottom nipple), using Clark-Reliance Bronze valves, should be the water gage valve centers less 2 3/4" (70 mm). With Clark-Reliance Steel valves the correct length should be the water gage valve centers less 3 1/4" (83 mm).

There are minimum gage nipple lengths for the top and bottom nipples, depending on the model of gage and type of water gage valves being used. The minimum nipple lengths are as follows:

All gages using Clark-Reliance Bronze valves -	Upper Nipple 1 3/4" (44 mm) min. Lower Nipple 1 3/8" (35 mm) min.
Clark-Reliance Steel valves with Prismatic Series 'C' and 'S' gages -	Upper Nipple 3 1/8" (79 mm) min. Lower Nipple 2 1/4" (57 mm) min.
Clark-Reliance Steel valves with FG400 Series Flat Glass gages -	Upper Nipple 3 1/8" (79 mm) min. Lower Nipple 2 1/4" (57 mm) min.
Clark-Reliance Steel valves with FG900 Series Flat Glass gages -	Upper Nipple 3 1/8" (79 mm) min. Lower Nipple 2 1/4" (57 mm) min.
Clark-Reliance Steel valves with FG1500 Series Flat Glass gages -	Upper Nipple 3 3/8" (86 mm) min. Lower Nipple 2 1/2" (63 mm) min.

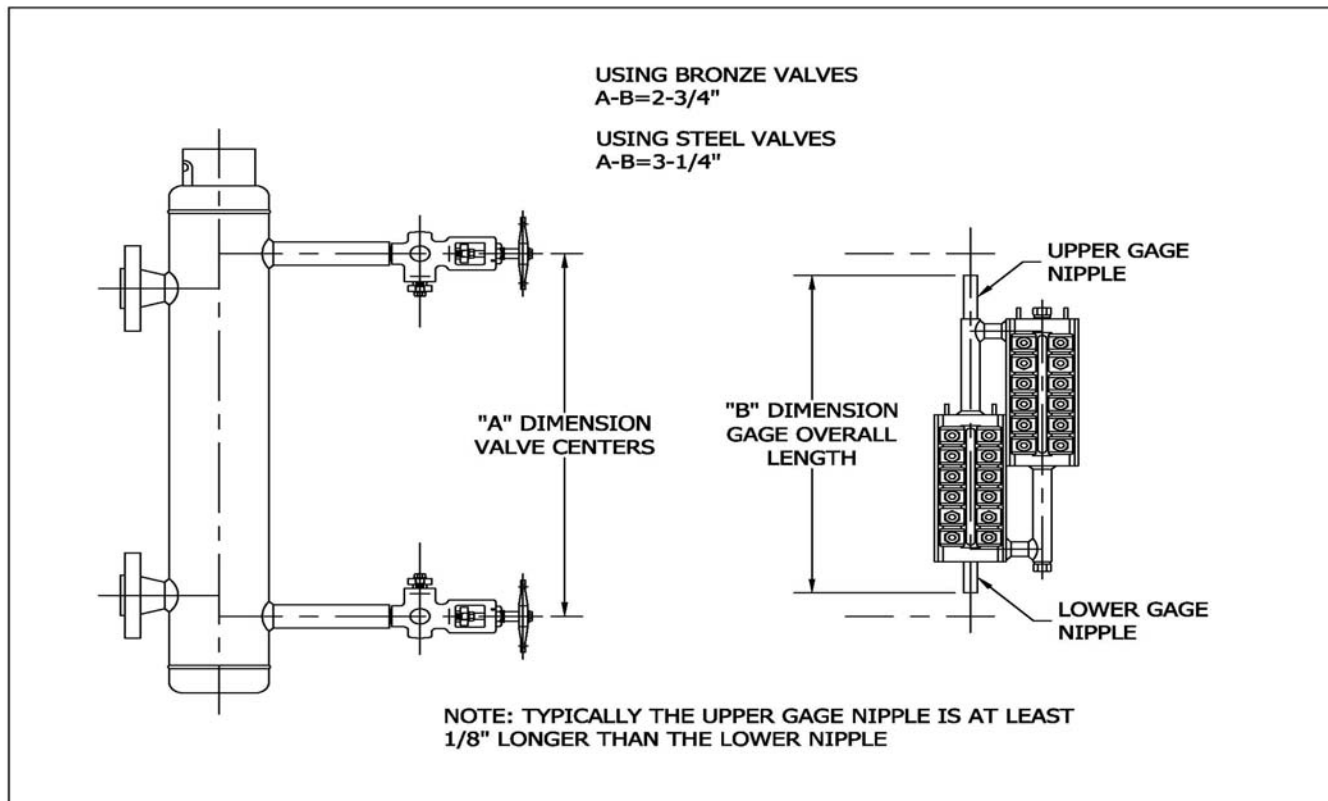
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Clark-Reliance Steel valves with P4000 Series Simpliport gages -

Upper Nipple 3 1/8" (79 mm) min.

Lower Nipple 2 3/4" (70 mm) min.



REPLACEMENT PARTS WARNING

THE USE OF NON-ORIGINAL EQUIPMENT MANUFACTURER PARTS (SUCH AS GLASS, GASKETS, PROBES, MODULES, ETC.) WILL VOID THE AGENCY APPROVAL (FM, UL, CAS, CRN, ABS, ETC.) PRESSURE/TEMPERATURE RATING, AND WARRANTY OF THE EQUIPMENT. CLARK-RELIANCE REQUIRES THE USE OF OEM PARTS FOR ALL REPAIRS IN ON THIS PRODUCT IN ORDER TO MAINTAIN PLANT AND PERSONNEL SAFETY, AND RELIABLE OPERATION.

Consult the factory or your local Clark-Reliance Representative with any questions. Please have the model numbers and/or reference drawing numbers available when calling. You can also contact us at our website www.relianceboilertrim.com or RelianceAppEng@clark-reliance.com.

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