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Since 1975

End Cap installation guidelines:

The first step in any installation or disassembly process is to consult the machines maintenance guide to insure that safety measures are taken and that the correct procedure is followed as applied to the individual machine requirements. This document contains generally accepted industry guidelines and may vary between machine makes. Please check your machine manual to insure that proper installation is followed.

It is important to uniformly tighten mating surfaces that are responsible for sealing such as those found on the barrel face to end cap and associated components. The surfaces must be square and mate evenly to facilitate an effective seal. When installing thread on end caps, nozzles and when torque wrenches are not available, caution must be taken to prevent over tightening and to insure a proper seal. Differences in the thermal expansion rates in steels used for barrels, end caps and nozzles, makes it necessary to re-torque the end cap bolts and nozzles once the machine reaches operating temperature. Improper tightening results in damage to components, coining of the mating surfaces, changes in the barrel internal diameter, cracks, leakage and premature fatigue failure.

- Check for interference between the end cap and non-return valve. Make sure mating surfaces are square and that pilot diameters and counter bores properly align and mate. Interference can occur as a result of design flaw, alignment, incorrect components or improper forward screw position.
- Preheat the barrel to operating temperature.
- Lubricate male bolt threads with nickel based anti-seize.
- Position the end cap in place on the barrel face and install and hand tighten all bolts.
- Follow the machine manual or industry standard recommended in torque pattern and torque requirement. Application should be in 20% increments of required torque, loading all bolts before proceeding to the next sequence.
- Install heater bands on the end cap and allow the assembled barrel and end cap to come up to operating temperature then repeat the final torque sequence at operating temperature.

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