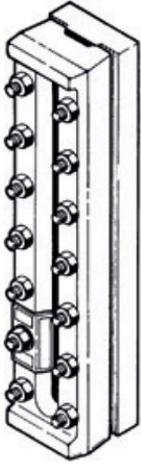


# Installation, Operation & Maintenance Instructions

Before installation these instructions must be read fully and understood

PB500.05

## PENBERTHY SERIES RM AND TM WELD PAD FLAT GLASS GAGES



### TABLE OF CONTENTS

Product warranty .....	1
1. About the manual .....	2
2. Introduction .....	2
2.1 System description .....	2
3. Available models .....	2-3
3.1 Design ratings .....	3
4. Inspection .....	4
4.1 Glass inspection .....	4
4.2 User's rating inspection .....	4
5. Installation .....	5-7
5.1 Preparation and disassembly prior to welding .....	4
5.2 Reassembly prior to welding with steel spacer .....	5
5.3 Welding .....	5
5.4 Disassembly-reassembly after welding .....	6
5.5 Nut torquing .....	6
5.6 Belleville washers (optional) .....	6
5.7 Differential thermal expansion .....	7
5.8 Mirror viewing .....	7
6. Operation .....	7
6.1 Hydrostatic test .....	7
7. Maintenance .....	7-8
7.1 Maintenance procedures .....	8
7.2 Troubleshooting .....	8
8. Removal - disassembly - reassembly .....	8-9
8.1 Disassembly .....	8
8.2 Inspection of glass seating surfaces .....	9
8.3 Reassembly .....	9

9. Disposal at end of useful life .....	9
10. Telephone assistance .....	9
11. Exploded parts diagrams .....	10

### Tables and figures

Table 1 Design ratings .....	3
Table 2 Bolt torque values .....	6
Figure 1 Nut loosening sequence .....	5
Figure 2 Nut tightening sequence .....	5
Figure 3 Tack weld pad .....	5
Figure 4 Bead weld pad .....	5
Figure 5 Belleville washer position .....	6
Figure 6 Exploded parts diagram (TMW) .....	10
Figure 7 Exploded parts diagram (RMW) .....	10

*This is Penberthy's sole warranty and in lieu of all other warranties, expressed or implied which are hereby excluded, including in particular all warranties of merchantability or fitness for a particular purpose.*

This document and the warranty contained herein may not be modified and no other warranty, expressed or implied, shall be made by or on behalf of Penberthy unless made in writing and signed by the company's general manager or director of engineering.

### PRODUCT WARRANTY

Penberthy products as designed and manufactured to be free of defects in the material and workmanship for a period of one year after the date of installation or eighteen months after the date of manufacture, whichever is earliest. Penberthy will, at its option, replace or repair any products which fail during the warranty period due to defective material or workmanship.

Prior to submitting any claim for warranty service, the owner must submit proof of purchase to Penberthy and obtain written authorization to return the product. Thereafter, the product shall be returned to Penberthy with freight prepaid.

This warranty shall not apply if the product has been disassembled, tampered with, repaired or otherwise altered outside of the Penberthy factory, or if it has been subject to misuse, neglect or accident.

The responsibility of Penberthy hereunder is limited to repairing or replacing the product at its expense. Penberthy shall not be liable for loss, damage or expenses related directly or indirectly to the installation or use of its products, or from any other cause or for consequential damages. It is expressly understood that Penberthy is not responsible for damage or injury caused to other products, buildings, personnel or property, by reason of the installation or use of its products.

# PENBERTHY®

# PENBERTHY SERIES RM AND TM WELD PAD FLAT GLASS GAGES

## INSTALLATION, OPERATION AND MAINTENANCE INSTRUCTIONS

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### 1 ABOUT THE MANUAL

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This manual has been prepared as an aid and guide for personnel involved in installation or maintenance. All instructions must be read and understood thoroughly before attempting any installation, operation or maintenance.

#### SAFETY INSTRUCTIONS

Penberthy does not have any control over the manner in which its gage is handled, installed or used and Penberthy cannot and does not warrant or guarantee that a gage is suitable or compatible for the user's specific application.

#### WARNING

*Contained fluids may be pressurized and can exit vessel connections unexpectedly due to apparatus or material failure. Safety glasses should be worn when installing a weld pad liquid level gage. Failure to follow instructions could result in serious physical injury or property damage.*

### 2 INTRODUCTION

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Penberthy weld pad liquid level gages are used to allow direct visualization of liquid level in vessels. By peering through the glass, it is possible to monitor color, clarity and level of a gas/liquid interface. Gages are available in varying lengths and configurations (flat pad or radius pad). Visual indication can be enhanced by using reflex glass. Weld pad liquid level gages are mounted directly to the tank or vessel to be measured.

#### 2.1 System description

Penberthy weld pad gages comprise six basic components. Each component may vary slightly, depending on the desired physical and mechanical properties for the gage. Use the exploded parts view in Section 11 as additional reference material.

**Chamber:** provides a pressure retaining metallic surface for weld attachment to the tank or vessel. Vessel chamber surface can be radiused to match tank or vessel curvature. Slot(s) are machined into the chamber to provide direct visualization of the process fluid.

**Gaskets:** seal the gap and prevent leakage between the chamber and the glass. Gaskets are available in a variety of materials for compatibility with the media in the gage.

**Glass:** allows for visual observation of the process fluid in the chamber.

**Cushion:** acts as a protective buffer between the glass and the cover. For proper sealing, cushions must be as hard or harder than the gasket material.

**Cover:** protects the glass assembly from external hits and provides a flat, rigid surface that is used to compress the gage assembly evenly.

**Bolting:** compresses the components between the covers and weld pad chamber.

**Shield:** (optional on transparent gages) used to prevent the process media from contacting the glass.

### 3 AVAILABLE MODELS

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Penberthy medium pressure weld pad (Series M) liquid level gages are designed for applications other than steam/water. Weld pad gages are frequently used in applications where: 1) the contained liquid is not appropriate for small diameter plumbing connections (e.g., highly viscous liquid or large solid particles) or 2) where the gage is installed in a severe vibration environment.

# PENBERTHY SERIES RM AND TM WELD PAD FLAT GLASS GAGES

## INSTALLATION, OPERATION AND MAINTENANCE INSTRUCTIONS

### 3.1 Design ratings at maximum and minimum operating temperatures

TABLE 1

Gasket material	Glass size	Model RMW reflex and model TMW transparent	
		Wetted parts material steel or stainless steel w/B7 bolting	
		-20°F (-29°C) to 100°F (38°C)	600°F (316°C)
Grafoil® (standard) or non-asbestos	1	2000 psig (13790 kPa)	1480 psig (10200 kPa)
	2	1850 psig (12760 kPa)	1375 psig (9480 kPa)
	3	1700 psig (11720 kPa)	1260 psig (8690 kPa)
	4	1550 psig (10690 kPa)	1145 psig (7890 kPa)
	5	1400 psig (9650 kPa)	1035 psig (7140 kPa)
	6	1250 psig (8620 kPa)	925 psig (6380 kPa)
	7	1100 psig (7580 kPa)	810 psig (5580 kPa)
	8	950 psig (6550 kPa)	700 psig (4830 kPa)
	9	800 psig (5520 kPa)	590 psig (4070 kPa)
Top-chem 2000®	1	2000 psig (13790 kPa)	100 psig (690 kPa) at 500°F (260°C)
	2	1850 psig (12760 kPa)	
	3	1700 psig (11720 kPa)	
	4	1550 psig (10690 kPa)	
	5	1400 psig (9650 kPa)	
	6	1250 psig (8620 kPa)	
	7	1100 psig (7580 kPa)	
	8	950 psig (6550 kPa)	
	9	800 psig (5520 kPa)	
25% glass filled PTFE	1-9	650 psig (4480 kPa) at -20°F (-29°C) to 100°F (38°C) 150 psig (1030 kPa) at 500°F (260°C)	
Buna N (NBR)	1-9	300 psig (2070 kPa) at -20°F (-29°C) to 100°F (38°C) 225 psig (1550 kPa) at 250°F (121°C)	
Viton® (FKM)	1-9	300 psig (2070 kPa) at -20°F (-29°C) to 100°F (38°C) 180 psig (1240 kPa) at 400°F (204°C)	
Teflon® (PTFE)	1-9	300 psig (2070 kPa) at -20°F (-29°C) to 100°F (38°C) 150 psig (1030 kPa) at 500°F (260°C)	
PCTFE/(Kel-F®) shields 0.063" (1.6 mm) thick	1-9	300 psig (2070 kPa) at -20°F (-29°C) to 100°F (38°C) 180 psig (1240 kPa) at 400°F (204°C)	

**Note:** lower temperatures are possible with metallic material variation, [e.g., 316/316L stainless construction, Grafoil® gaskets/cushions useable to -325°F (-198°C)].

The pressure and temperature ratings may deviate from Table 1 if the gasketing materials of construction and/or bolting are other than those specified. Higher and/or lower temperature ratings are available with different materials of construction.

To determine the maximum allowable working pressure for a specific temperature within the design limits stated in the table, the user should refer to relevant technical data sheets or, when provided, the specifically stated design limits on a product proposal.

**Note:** under no circumstances should shields be used in reflex style gages. Installation of shields in reflex style gages will keep the liquid from coming in contact with the refractive prisms, thereby prohibiting visualization of the liquid level in the gage.

#### DANGER

*NEVER exceed these design ratings or application data. Exceeding design ratings or application data may result in mechanical failure of gage components resulting in death, serious personal injury and property damage.*

#### NOTE

Grafoil® is a registered trademark of Graftech.

Top Chem 2000® is a registered trademark of Klinger.

PCTFE (Formerly known as Kel-F®, a registered trademark of 3M) is manufactured by Daikin.

Viton® and Teflon® are registered trademarks of E.I. du Pont de Nemours and Company.



# PENBERTHY SERIES RM AND TM WELD PAD FLAT GLASS GAGES

## INSTALLATION, OPERATION AND MAINTENANCE INSTRUCTIONS

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### 4 INSPECTION

On receipt of a weld pad liquid level gage, check all components carefully for damage incurred in shipping. If damage is evident or suspected, do not attempt installation. Notify the carrier immediately and request a damage inspection. Penberthy standard 1 section MW weld pad gage consists of: (1) chamber, (1) gasket, (1) borosilicate flat glass, (1) rubber band, (1) cushion, (1) cover, (1) washer, (1) nameplate and (6-14) bolting sets, depending on the size.

#### 4.1 Glass inspection

The self stick caution tape was applied at the factory to protect the glass during shipping, handling and installation. Do not remove the tape from the glass until all installation procedures have been completed, except during receiving inspection to inspect glass momentarily for shipping damage. Glass that is not protected will be vulnerable to dust, grit, tools and any other objects which may scratch, chip or break the glass.

#### WARNING

*DO NOT use glass that is chipped or even slightly scratched. Glass surface defects weaken the glass, which may result in glass breakage and fluid loss under pressure resulting in serious personal injury or property damage.*

4.2 User's rating inspection The user should confirm that:

1. The Series MW weld pad liquid level gage model and assembly number stamped on the nameplate conform to the description on the user's purchase order.
2. The operating conditions described in the purchase order agree with the actual operating conditions at the installation site.
3. The actual operating conditions at the installation site are within the application data shown on the relevant technical data sheet or product proposal referred to previously.
4. The materials of construction of the gage are compatible with the surrounding atmosphere in the specific application.

#### SAFETY INSTRUCTIONS

*If the size, model or performance data of the liquid level gage as received does not conform with any of the criteria above, do not proceed with installation. Contact an authorized Penberthy distributor for assistance. The incorrect gage can result in unacceptable performance and potential damage to the gage.*

### 5 INSTALLATION

Installation should only be undertaken by qualified, experienced personnel who are familiar with equipment of this type. They should have read and understood all of the instructions in this manual. The user should refer to the relevant technical data sheet or product proposal to obtain dimensional information for the specific size and model of weld pad liquid level gage. The number of different types of weld pad liquid level gage installations is too great to detail adequately in an installation manual. Therefore, it is the user's responsibility to assure that knowledgeable installation personnel plan and carry out the installation in a safe manner following local, national and international welding codes. The following procedures are some of the installation guidelines that should be employed:

#### 5.1 Preparation and disassembly prior to welding

Secure a workbench longer than the liquid level gage, and sufficiently wide to lay out parts as they are removed. If the weld pad chamber is radiused, additional blocks may be required to prevent the weld pad from rolling during disassembly.

The Penberthy factory assembles weld pad gage nuts finger tight: 1) to prevent compression 'set' of gaskets and cushions and 2) to contain assembly components and avoid loss of separate pieces during shipment. Cushions, glass, shields (if any) and gaskets can be re-installed after welding in this instance only because the gage has not been torqued at assembly.

#### WARNING

*Extreme care must be taken to avoid damage to cushions, glass, shields (if any) and gaskets. If any of these items are damaged in any way, it could result in glass breakage with sudden release of contained fluid causing serious physical injury or property damage.*

**PENBERTHY®**

# PENBERTHY SERIES RM AND TM WELD PAD FLAT GLASS GAGES

## INSTALLATION, OPERATION AND MAINTENANCE INSTRUCTIONS

1. Lay gage on bench so nut side is up.
2. Hold gage firmly; and loosen nuts starting at both ends of each section and then proceed from both ends to the center of each section as shown in Figure 1.
3. Nut loosening sequence
  - Remove nuts, washer, belleville washers (if any) and nameplate.
  - Tap covers with rubber hammer as needed to loosen and remove.
  - Remove cushions, glass, shields (if any), and gaskets.

**Note:** if size of gage is smaller than shown, follow spiraling sequence from the ends until all bolting is loosened.

### 5.2 Reassembly prior to welding with steel spacer

All Series MW weld pad liquid level gages should be provided with a steel spacer. Steel spacers are designed to prevent warpage of the liquid chamber when welding.

1. Place steel spacer on liquid chamber in place of glass.
2. Install covers in place.
3. Using a torque wrench, tighten nuts in 5 ft·lb (7 Nm) increments, following the sequence in Figure 2 until a torque value of 25 to 30 ft·lb (34 to 41 Nm) is reached.

### CAUTION

*Extreme care must be taken to avoid gouging or scarring glass seating surfaces on the liquid chamber and cover. Fluid leak paths can develop under gaskets resulting in sudden release of contained fluid causing physical injury or property damage.*

### 5.3 Welding

DO NOT weld liquid chamber to tank or vessel with cushions, glass, shields (if any) and gaskets in place. The thermal heat from the weld operation can destroy the integrity of weld pad components. It is the user's responsibility to assure that knowledgeable installation personnel plan and carry out the installation in a safe manner following local, national and international welding codes (e.g., ASME Pressure Vessel Code, Section IX.)

1. Tank or vessel must be relieved of all pressure or vacuum, allowed to reach ambient temperature and must be drained or purged of all fluids prior to welding.
2. A slot or holes must be cut in the tank or vessel at the location that the user wants the liquid level gage to read. The slot must be equal in size or slightly larger than the vision slot in the liquid chamber. Minimally two holes must be cut with diameters equal in size to the width of the vision slot. Holes at the top and bottom of the vision slot allow liquid to enter the weld pad chamber.
3. Locate liquid chamber assembly over opening(s) in tank or vessel making sure that the opening in the tank or vessel and the slot in the liquid chamber are aligned and centered.
4. Hold liquid chamber assembly in place and tack weld four places as shown in Figure 3.
5. Complete welding of liquid chamber to vessel by making short passes approximately 1½" (38 mm) long and alternating from side to side and end to end until the entire circumference of the liquid chamber is welded in place as shown in Figure 4.

FIGURE 1  
Nut loosening sequence

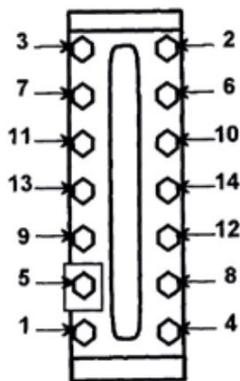


FIGURE 2  
Nut tightening sequence

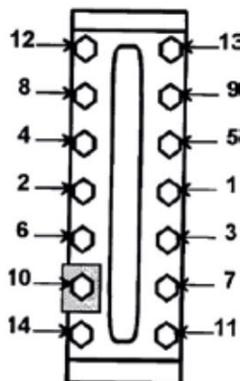


FIGURE 3  
Tack weld pad

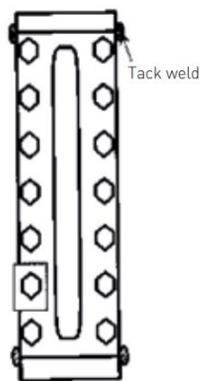
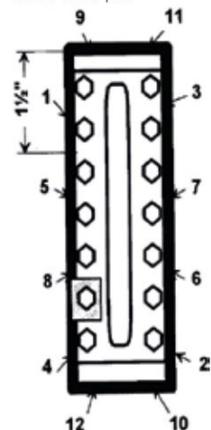


FIGURE 4  
Bead weld pad



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# PENBERTHY SERIES RM AND TM WELD PAD FLAT GLASS GAGES

## INSTALLATION, OPERATION AND MAINTENANCE INSTRUCTIONS

### 5.4 Disassembly-reassembly after welding

#### Disassembly:

1. Make sure that gage has cooled to ambient temperature before disassembling gage.
2. Remove nuts, cover and steel spacer.

#### Reassembly:

1. Check flatness of each glass seating surface of liquid chamber and under cover for distortion by using a known flat piece of the same size glass and a thickness gage. Surface must be flat within 0.002 inch (0.05 mm) over the glass seating area.
2. If any one glass seating surface flatness is found to be beyond a tolerance of 0.002 inch (0.05 mm), it must be restored with a stone. Gasket seating surface must have a final surface finish of 63 to 250 AARH.
3. If the glass seating surface cannot be restored to within the 0.002 inch (0.05 mm) tolerance, the entire gage must be removed, disposed of and replaced

### WARNING

*Flatness of glass seating surfaces outside 0.002 inch (0.05 mm) tolerance specified may result in abnormal stresses on the glass which may cause glass break. If surface finish is not in the 63 to 250 AARH range, gasket may extrude under pressure with resulting sudden release of pressure, leakage of contained fluid, serious personal injury or property damage.*

4. If glass seating surfaces are found to be within 0.002 inch (0.05 mm) tolerance described above, proceed to assemble gage.
5. Install one cushion inside each cover.
6. Install rubber band around each piece of glass, then place glass centered inside each cover.
7. Install shields, if used, and gasket being careful to keep components aligned inside.
8. Install each cover in place being careful to maintain components alignment inside.
9. Install nameplate, washer, Belleville washers (2 per nut if used) and nuts. Using a torque wrench, tighten nuts in 5 ft·lb (7 Nm) increments, following the sequence in Figure 2 until the torque values in Table 2 are achieved.

**TABLE 2 - BOLT TORQUE VALUES**

Gage models and gasket material	ft-lb (Nm)
RMW, TMW w/Grafoil® (standard)	25 to 30 [34 to 41]
RMW, TMW w/non-asbestos (optional)	30 to 35 [41 to 48]
Top-Chem 2000®	25 to 30 [34 to 41]
PTFE and PCTFE (Kel-F®)	20 to 25 [27 to 34]
25% glass filled PTFE	19 to 22 [26 to 30]
All models with FKM or elastomeric (optional)	10 to 15 [14 to 20]
TMW with PCTFE (Kel-F®) shields (optional) 0.063" [1.6 mm]	20 to 25 [27 to 34]

### 5.5 Nut torquing

Tightening of nuts to values specified in Table 2 after welding procedures and assembly is complete is necessary to insure pressure retaining capabilities of the liquid level gage to specific design ratings. The user must refer to the liquid level gage model and assembly number and to the purchase order or tag to determine materials of construction.

Using a torque wrench, tighten nuts in 5 ft·lb (7 Nm) increments following the 'Z' pattern sequence in Figure 2, until the torque values shown in Table 2 for the specific liquid level gage are reached. For multiple section gages, torque the center section(s) and work progressively toward the ends of the gage. If bolting, gasketing or glass on any section of a multi-section gage is disturbed, all sections must be checked for integrity and retorqued as necessary.

### WARNING

Failure to comply with the proper torquing sequence or force value can lead to leakage, gasket blow-out or glass breakage resulting in gage failure, serious personal injury or property damage.

**Note:** depending on gage size there may be less bolting than shown in Figure 2. Start at the center and follow the 'Z' pattern outward to the limit of bolting on a specific gage.

### 5.6 Belleville washers (optional)

Belleville washers are used to reduce the need to retorqued nuts. This is especially important for gages subject to pressure and/or thermal cycling. The conical washers allow for material expansion and contraction while maintaining axial bolt loading and, therefore, compression on the gasket. Model RMW and TMW gages require 2 washers per nut. Washers should be assembled with the cupped side facing the gage cover. Refer to Figure 5 for proper washer assembly. Using a torque wrench, tighten nuts in 5 ft·lb (7 Nm) increments following the 'Z' pattern sequence in Figure 2 until the torque values shown in Table 2 are reached.

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# PENBERTHY SERIES RM AND TM WELD PAD FLAT GLASS GAGES

## INSTALLATION, OPERATION AND MAINTENANCE INSTRUCTIONS

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### 5.7 Differential thermal expansion

High mechanical loads may be imposed on a gage by expanding and contracting vessels or tanks due to hot or cold service. Such mechanical loads on the gage must be minimized by designing the gage system with the minimum allowable chamber length. Failure to allow for expansion or contraction can result in leaks or glass breakage.

### 5.8 Mirror viewing

For added safety, a system of indirect viewing by means of mirrors should be installed to protect personnel from the hazards of possible gage failure.

## 6 OPERATION

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Before initializing liquid level gage operation, check that all installation procedures have been completed. Use only qualified, experienced personnel who are familiar with liquid level gage equipment and thoroughly understand the implications of the tables and all the instructions. Check to determine that all connections are pressure tight. Assure that nuts have been retorqued to their proper values as specified in Table 2. Remove self stick caution tape from the glass and inspect to be sure that glass is clean and free of any damage such as cracks, scratches, pits and chips.

### 6.1 Hydrostatic test

#### WARNING

*Liquid level gage installations should be brought into service slowly to avoid excessive shock or stress on the glass. Rapid pressurization or sudden changes in temperature may cause glass breakage. To avoid excessive thermal shock or mechanical stress on glass, the vessel/ tank/gage temperature and pressure should be allowed to equalize slowly. Failure to follow the recommended operating procedures can result in death, severe personal injury and/or property damage.*

Take all precautions necessary to handle the possibility of leakage during the test. Hydrostatically pressure test all installations to at least 100 psig (690 kPa) but less than the design pressure and correct any leakage before proceeding.

## 7 MAINTENANCE

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#### WARNING

*Use only qualified, experienced personnel who are familiar with liquid level gage equipment and thoroughly understand the implications of the tables and all the instructions. DO NOT proceed with any maintenance unless the liquid level gage has been relieved of all pressure or vacuum, has been allowed to reach ambient temperature and has been drained or purged of all fluids. Failure to follow instructions can cause serious personal injury and property damage.*

The rate at which components degrade is dependent upon a variety of conditions. Pressure, temperature and process media all influence the rate at which gage components deteriorate. Higher temperatures can accelerate the deterioration of gaskets, cushions, glass and metals. Acids and similar chemicals can break down the integrity of almost any material. Concentration of chemicals can accelerate the corrosion rate. Penberthy cannot create a blanket maintenance schedule for every application. The end user is the most familiar with the process media and conditions and must be responsible for creating a maintenance schedule. The user must create maintenance schedules, safety manuals and inspection details for each liquid level gage. Realistic maintenance schedules can only be determined with full knowledge of the services and application situations involved. These will be based upon the user's own operating experience with their specific application. If bolting, gasketing or glass on any section of a multi-section gage is disturbed, all sections must be checked for integrity and retorqued or repaired as necessary.

On all installations the following items should be evaluated regularly by the user for purposes of maintenance:

1. Glass, for cleanliness and signs of damage or wear.
2. Shields, if used, for signs of clouding, wear or deterioration.
3. Gage, for signs of leakage around gaskets.
4. Gage, for signs of internal or external corrosion.

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# PENBERTHY SERIES RM AND TM WELD PAD FLAT GLASS GAGES

## INSTALLATION, OPERATION AND MAINTENANCE INSTRUCTIONS

### 7.1 Maintenance procedures

**Glass** should be given regular and careful attention. Keep glass clean using a commercial glass cleaner and a soft cloth. Inspect the surface of the glass for any clouding, etching or scratching or physical damage such as bruises, checks or corrosion. Glass that is damaged is weakened and may break under pressure. Shining a light at approximately a 45° angle will aid in detecting some of these conditions. Typical damaged areas will glisten more brightly than the surrounding glass because the light is reflected.

Detection of any damage, problem areas or surface wear is sufficient evidence to take the liquid level gage out of service. DO NOT proceed with operation of the liquid level gage until the glass has been replaced with a glass replacement kit following the disassembly - reassembly instructions in Section 8.

**Shields** showing any signs of clouding, wear or deterioration are an indication that the gage glass has been exposed, or could soon be exposed to the contained fluid. Take liquid level gage out of service immediately. DO NOT proceed with operation of the liquid level gage until shields and glass have been replaced by following the disassembly-reassembly instructions in Section 8.

**Gasket leaks** must be repaired immediately. DO NOT proceed with operation of a liquid level gage until gaskets have been replaced by following Section 8 disassembly-reassembly instructions.

**Corrosion** may occur if the user has selected an improper material for the liquid level gage application. It is the responsibility of the user to choose a material of construction compatible with both the contained fluid and the surrounding environment. If internal or external corrosion is present, an investigation must be performed immediately by the user. It may be necessary to contact an authorized Penberthy distributor to better determine the origin of the corrosion.

### 7.2 Troubleshooting

Problem:	Glass becomes etched prematurely or clouded in service.
Cause:	Fluid being handled is not compatible with the glass or shields.
Solution:	Replace the glass and install shields which will not be affected by contained fluid.
Problem:	Glass breaks continually in service despite careful attention to maintenance procedures.
Cause:	Thermal shock, hydraulic shock, mechanical loads, exceeding design ratings or a combination of these.

Solution: Check entire system to determine possible sources of loads. Check application to determine actual operating conditions and contact an authorized Penberthy distributor on how to proceed.

## 8 REMOVAL - DISASSEMBLY - REASSEMBLY

### WARNING

*Use only qualified, experienced personnel who are familiar with liquid level gage equipment and thoroughly understand the implications of the tables and all the instructions. DO NOT proceed with any maintenance unless the liquid level gage has been relieved of all pressure or vacuum, has been allowed to reach ambient temperature and has been drained or purged of all fluids. Failure to follow instructions can cause serious personal injury and property damage.*

### 8.1 Disassembly

Secure a workbench longer than the liquid level gage, and sufficiently wide to lay out parts as they are removed.

1. Loosen nuts starting at both ends of each section and then proceed from both ends to the center of each section as shown in Figure 1.
2. Remove nuts, washer, Belleville washers (if any) and nameplate.
3. Tap covers with rubber hammer as needed to loosen and remove.
4. Remove cushions, glass, shields (if any) and gaskets.
5. Tap liquid chamber or remaining covers as necessary with rubber hammer to break loose and remove remaining components.
6. Remove, destroy and dispose of all glass, cushions, gaskets and shields. Under no circumstances should these components be re-used or installed on a gage.

**Note:** if size of gage is smaller than shown, follow spiraling sequence from the ends until all bolting is loosened.

### WARNING

*Once used, cushions, gaskets and shields are deformed permanently by compression and, if re-used, may cause leaks and high stress points resulting in glass breakage. Glass may contain hidden damage and internal stresses caused by previous usage. If re-used, the glass may break under pressure causing severe personal injury or property damage.*

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# PENBERTHY SERIES RM AND TM WELD PAD FLAT GLASS GAGES

## INSTALLATION, OPERATION AND MAINTENANCE INSTRUCTIONS

### 8.2 Inspection of glass seating surfaces

Clean the glass seating surfaces on the liquid chamber and cover with a soft metal scraper (preferably brass) to remove all burrs, rust and remnants of the previous gaskets and cushions. Exercise extreme care to avoid gouging or scarring gasket and cushion seating surfaces. Use a known flat piece of metal the same approximate length as the glass or a new piece of glass and a thickness gage to check flatness of each glass seating surface on liquid chamber and under cover. Surface must be flat within 0.002 inch (0.05 mm). If any one surface is found to be beyond a tolerance of 0.002 inch (0.05 mm), the entire gage must be cut out from the tank or vessel, disposed of and replaced. Gasket seating surface must have a final surface finish of 63 to 250 AARH.

### WARNING

*Flatness of glass seating surfaces outside 0.002 inch (0.05 mm) tolerance specified is an indication of the gage having been overstressed through repeated exposure to mechanical, thermal or hydraulic shock during its previous service. Operation of a liquid level gage which has been overstressed will result in abnormal stresses on the glass which may cause glass to break. If surface finish is not in the 63 to 250 AARH range, the gasket may extrude under pressure with resulting sudden release of pressure, leakage of contained fluid, serious personal injury or property damage.*

Glass seating surfaces should NOT be machined to achieve seating tolerance. The chamber and cover are designed for a critical thickness to achieve the pressure/temperature ratings. Machining glass seating surfaces may result in non-compliance to the necessary critical thickness due to material removal.

### 8.3 Reassembly

If all glass seating surfaces are found to be within the 0.002 inch (0.05 mm) tolerance and gasket seating surface has a finish of 63 to 250 AARH described in the previous section, proceed to obtain new glass, gaskets, cushions and shields (if used) and proceed to reassemble as follows (refer to exploded parts view in Section 11 if needed):

1. Clean threads on studs and nuts to remove all paint, rust and scale. Apply a light coat of oil to the threads.
2. Install one cushion inside each cover.
3. Install rubber band around each piece of glass, then place glass centered inside each cover.
4. Install shields, if used, and gasket on glass being careful to keep components centered.
5. Install covers in place being careful to maintain components alignment inside.
6. Install nameplate, washer, Belleville washers (2 per nut if used) and nuts. Using a torque wrench, tighten nuts in 5 ft-lb (7 Nm) increments, following the sequence in Figure 2 until the torque values in Table 2 are achieved.

Refer to Section 5 for installation and Section 6 for operation of the liquid level gage when returning to service.

### 9 DISPOSAL AT END OF USEFUL LIFE

Penberthy gages are used in a variety of fluid applications. By following the appropriate federal and industry regulations, the user must determine the extent of preparation and treatment the gage must incur before its disposal. A Material Safety Data Sheet (MSDS) may be required before disposal services accept certain components.

Metal, glass and polymers should be recycled whenever possible. Refer to order and applicable technical data sheets for materials of construction.

### 10 TELEPHONE ASSISTANCE

If you are having difficulty with your liquid level gage, contact your local Penberthy distributor. You may also contact the factory direct at (956) 430-2500 and ask for an applications engineer. So that we may assist you more effectively, please have as much of the following information available as possible when you call:

- Model #
- Name of the company from whom you purchased your liquid level gage
- Invoice # and date · Process conditions (pressure, flow rates, tank shape, etc.)
- A brief description of the problem
- Trouble shooting procedures that failed

If attempts to solve your problem fail, you may request to return your gagecock to the factory for intensive testing. You must obtain a Return Authorization (R.A.) number from Penberthy before returning anything. Failure to do so will result in the unit being returned to you without being tested, freight collect. To obtain an R.A. number, the following information (in addition to that above) is needed:

- Reason for return
- Person to contact at your company
- 'Ship-to' address

There is a minimum charge for evaluation of non-warranty units. You will be contacted before any repairs are initiated should the cost exceed the minimum charge. If you return a unit under warranty, but it is not defective, the minimum charge will apply.

**PENBERTHY®**

# PENBERTHY SERIES RM AND TM WELD PAD FLAT GLASS GAGES

## INSTALLATION, OPERATION AND MAINTENANCE INSTRUCTIONS

### 11 EXPLODED PARTS DIAGRAMS

FIGURE 6  
Transparent

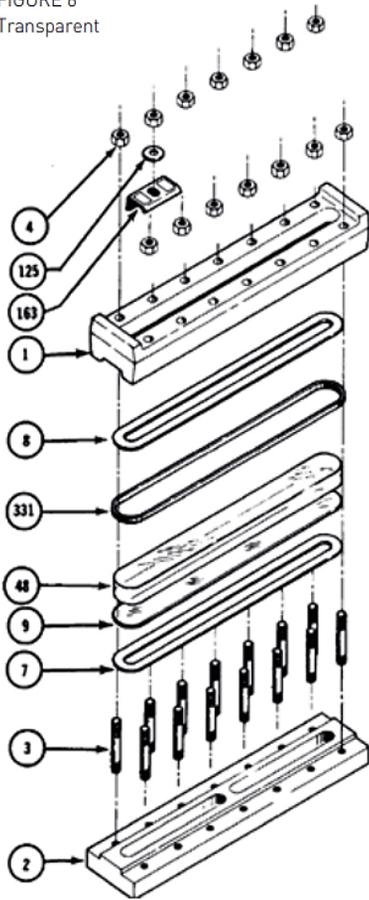
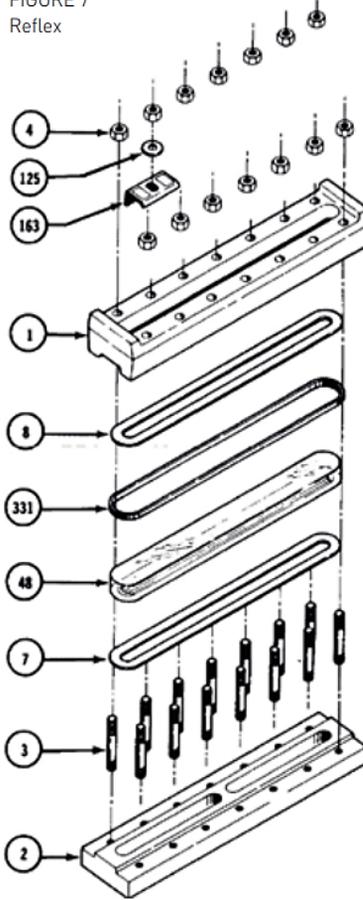


FIGURE 7  
Reflex



### PARTS LIST

Item	Description
1	Cover
2	Chamber
4	Nut
48	Glass
7	Gasket
8	Cushion
9	Shield
3	Stud
125	Washer
163	Nameplate
331	Band

### RECOMMENDED SPARE PARTS

Item	Description	Qty.
3	Stud	2 per sect.
4	Nut	2 per sect.
48	Glass	1
7	Gasket	1
8	Cushion	1
9	Shield (if used)	1

### NOTE

Size 9 shown - actual gage may be shorter and require fewer bolting components.

# PENBERTHY®

# PENBERTHY SERIES RM AND TM WELD PAD FLAT GLASS GAGES

## INSTALLATION, OPERATION AND MAINTENANCE INSTRUCTIONS

### DECLARATION OF CONFORMITY

*In conformance with ISO/IEC Guide 22 - 96 LGI.DC r C*

Manufacturer's name: Penberthy  
Manufacturer's address: 16633 Foltz Pkwy,  
Strongsville, OH 44149

#### Product:

Type of equipment: Pressure vessel - liquid level gage glass  
Equipment class: Industrial lighting - hazardous area  
Model designations: RL, TL, RM, RMR, TM, TMR, RH, RHR, TH, THR, RMW, TMW, RLC, TLC

The product described above is in conformity with:

92/59/EEC	General product safety	1992
87/404/EEC	Simple pressure vessel	1987
89/392/EEC	Machinery	1989
EN 10213-1:4	Technical delivery conditions for steel castings	1996
ISO 7-1	Pipe threads where pressure-tight joints are made	1996
BS 10	Flanges and bolting for pipes, gagecocks and fittings	1962
BS 21	Pipe threads for tubes and fittings where pressure tight	1985
BS 759	Gagecocks, gages and other safety fittings for application	1984
BS 970 Part 1	Wrought steels for mechanical and allied engineering	1996
BS 970 Part 3	Wrought steel for mechanical and allied engineering	1991
BS 1501 Part 3	Steels for pressure purposes	1990
BS 1502	Steels for fired and unfired pressure vessels	1982
BS 1506	Carbon, low alloy and stainless steel bars and billets	1990
BS 1560	Circular flanges for pipes, gagecocks and fittings	1989
BS 1640 Part 1	Steel butt-welding pipe fittings	1962
BS 1640 Part 2	Steel butt-welding pipe fittings	1962
BS 1965	Butt-welding pipe fittings	1963
BS 3076	Nickel and nickel alloys: bar	1989
BS 3463	Observation and gage glasses for pressure vessels	1975
BS 3602 Part 1	Steel pipes and tubes for pressure purposes	1987
BS 3605	Austenitic stainless steel pipes and tubes	1991
BS 3643	ISO metric screw threads	1981
BS 3799	Steel pipe fittings, screwed and socket-welding	1974
BS 4504	Circular flanges for pipes, gagecocks and fittings	1989
ASME B&PV Code Section VIII	Rules for construction of pressure vessels	1995
ANSI/ASME B1.1	Unified screw inch threads un and unr thread form	1982
ANSI/ASME B1.20.1	Pipe threads, general purpose (inch)	1983
ANSI/ASME B16.5	Pipe flanges and flanged fittings	1988
ANSI/ASME B18.2.1	Square and hex nuts and screw inch series	1981
ANSI/ASME B18.2.2	Square and hex nuts	1972
ANSI/ASME B31.3	Process piping	1996

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