



*Installation, Operation, and  
Maintenance Manual*

***Welker<sup>®</sup> Constant Pressure Cylinders with  
Tracker Tube  
Models  
CP-80***

The information in this manual has been carefully checked for accuracy and is intended to be used as a guide for the installation, operation, and maintenance of the Welker equipment described above. Correct operating and/or installation techniques, however, are the responsibility of the end user. Welker reserves the right to make changes to this and all products in order to improve performance and reliability.

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# TABLE OF CONTENTS

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## 1. SPECIFICATIONS 2

1.1	INTRODUCTION	3
1.2	DESCRIPTION OF PRODUCT	4
1.3	IMPORTANT INFORMATION	5
1.4	SPECIFICATIONS	5
1.5	PRODUCT DIAGRAM	6

## 2. INSTALLATION & OPERATIONS 7

2.1	IMPORTANT INFORMATION	7
2.2	PRE-CHARGING THE CYLINDER	8
2.3	INSTALLATION	9
2.4	SPOT SAMPLING	10
2.5	CONTINUOUS SAMPLING	11

## 3. MAINTENANCE 12

3.1	GENERAL	12
3.2	DISASSEMBLY	14
3.3	MAINTENANCE	14
3.4	REASSEMBLY	15
3.5	CYLINDER CLEANING	16

## SAFTEY WARNING 17

## 4. TROUBLE SHOOTING GUIDE 19

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# SPECIFICATIONS

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## 1. SPECIFICATIONS

### 1.1 INTRODUCTION

We appreciate your business and your choice of Welker products. The installation, operation, and maintenance liability for this product becomes that of the purchaser at the time of receipt. Reading the applicable *Installation, Operation, and Maintenance (IOM) Manual* prior to installation and operation of this equipment is required for a full understanding of its application and performance prior to use. If you have any questions, please call 1-800-776-7267 in the USA or 1-281-491-2331.

The following procedures have been written for use with standard Welker parts and equipment. Assemblies that have been modified may have additional requirements and specifications that are not listed in this manual.

#### Notes, Cautions, and Warnings



**Notes** emphasize information or set it off from the surrounding text.



**Caution** messages appear before procedures that, if not observed, could result in damage to equipment.



**Warnings** are alerts to a specific procedure or practice that, if not followed correctly, could cause personal injury.

# SPECIFICATIONS

## 1.2 DESCRIPTION OF PRODUCT



The Constant Pressure Sample Cylinder is designed for use in systems where it is necessary to extract and isolate accurate product samples by maintaining a steady pressure from the pipeline to the cylinder. The cylinders are equipped with a magnetic indicator and a graduated scale set to specify the capacity of the device. During continuous sampling, when the magnetic indicator reaches the 80% mark, all sampling should be stopped. A pneumatic supply pre-charges the cylinder with pressure to

correspond with pipeline pressure. Pre-charging allows the sample to be transferred to the cylinder without taking a pressure drop. An internal piston in the cylinder helps to purge out air and contaminants prior to taking the sample by displacement.



Figure 1

During the purge process, the piston is pushed to the end of the cylinder, also preventing any other possible contaminants from entering. Burst discs and gauges are also included on each end cap of the device. In the event that the cylinder is overpressurized, these discs will rupture, relieving excess pressure from the cylinder. CP-80 model cylinders have valves built into the pre-charge and product end cap ports. They are also included with product purge valves.

### Adjustable relief valve (optional)

The adjustable relief valve functions as a safety device for the unit. During continuous sampling and transportation of the cylinder, the relief valve assures that the device maintains a constant pressure and does not exceed maximum allowable pressure. The valve will relieve any pressure that exceeds the set pressure.

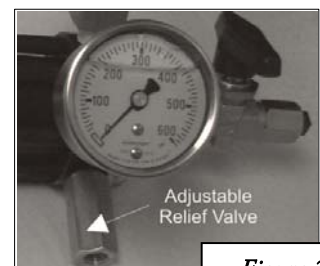


Figure 2

# SPECIFICATIONS

## 1.3 IMPORTANT INFORMATION



Please read the following information in its entirety before using the Welker equipment described above. Failure to adhere to the recommendations could result in injury.

- Never fill a cylinder completely full of hydrocarbon liquid or refrigerated gas. Always allow for at least 20% expansion.
- **Never transport this cylinder when pressurized.** It is not designed for transport. For D.O.T. approved cylinders, please contact the Welker sales department.
- Protect the cylinder at all times and handle with care. It is a precision instrument and may contain a flammable or hazardous product as well as a valuable representation of your company's product.
- When analysis is complete, the cylinder should be emptied safely and in a safe area by opening the product inlet valve, allowing the pre-charge pressure to push the piston to the product end cap, emptying the cylinder.
- Welker recommends cleaning and leak testing of the cylinders after each use.
- Because of the design of the cylinder and the incorporated seals, the process of emptying the cylinder will simultaneously wipe the walls of the device clean. The end cap will also be purged clean with the next use.

## 1.4 SPECIFICATIONS



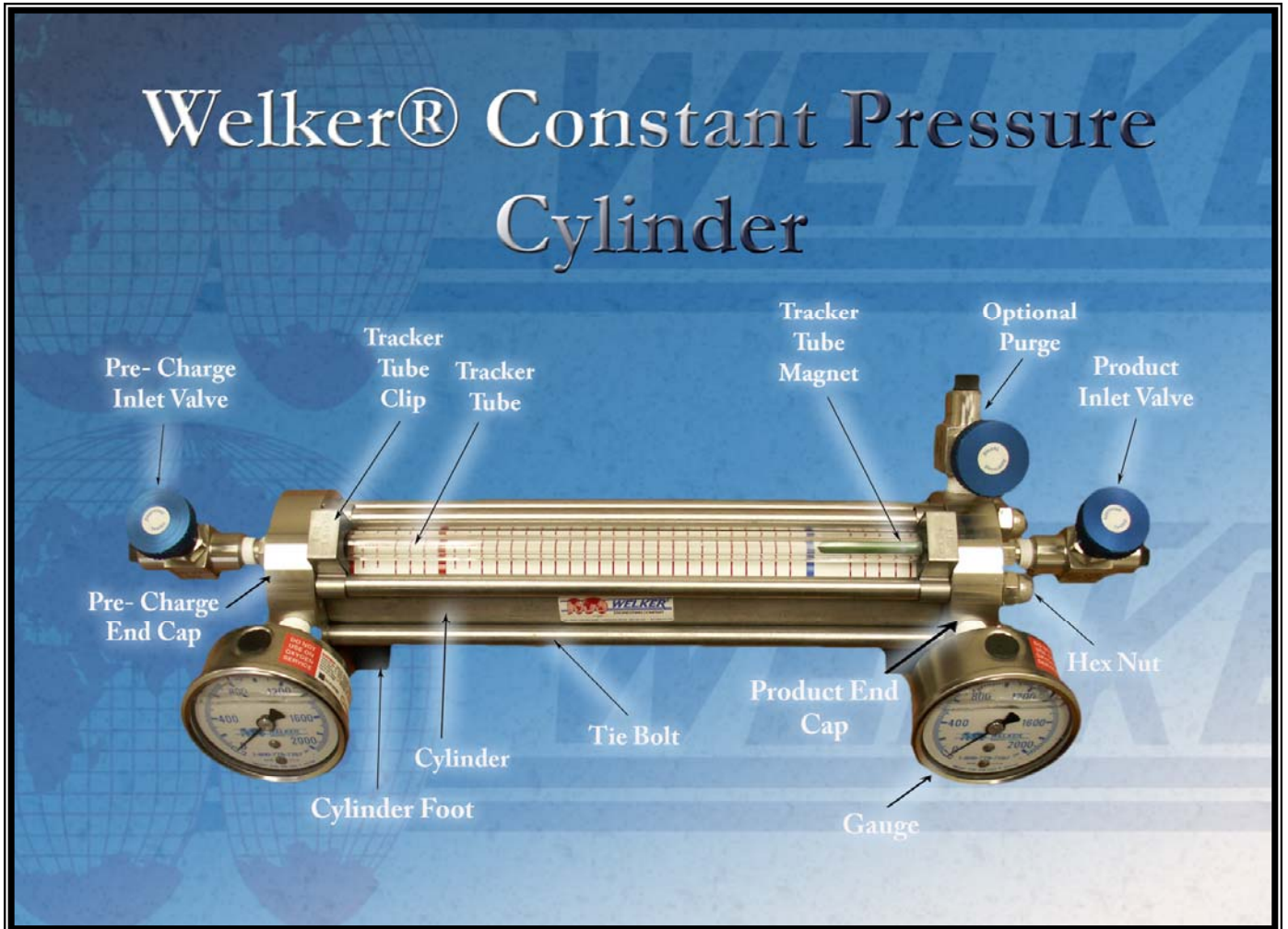
The specifications listed in this section are generalized for this equipment. Welker can modify the equipment according to your company's needs. However, please note that **\*the specifications may vary depending on the customization of your product.**

**Table 1**

Specifications CP-80	
<b>Products Sampled:</b>	Light liquid hydrocarbons, refined products, liquid petroleum gas, natural gas liquids, light crude and condensate
<b>Materials of Construction:</b>	316 stainless steel, aluminum, Viton, and PTFE; others available.
<b>Maximum Allowable Operating Pressure*:</b>	5,000 PSI
<b>Ports/Connections:</b>	1/4" NPT; others available
<b>Temperature Range*:</b>	-20°F to 100°F (-28.9°C to 37.8°C)
<b>Area Classification*:</b>	Can be used in hazardous areas. Note: This cylinder does not carry the D.O.T. exemption. For D.O.T. approved cylinders, please contact the sales department at Welker.

# SPECIFICATIONS

## 1.5 PRODUCT DIAGRAM



*Refer to above diagram throughout manual*

Cylinder may vary slightly

# INSTALLATION & OPERATIONS

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## 2. INSTALLATION & OPERATIONS

### 2.1 IMPORTANT INFORMATION

- After unpacking the unit, check it for compliance and for any damages that may have occurred during shipment.
- Claims for damages caused during shipping must be initiated by the receiver and directed to the shipping carrier. Welker is not responsible for any damages caused from mishandling by the shipping company.
- When sealing fittings with PTFE tape, refer to the proper sealing instructions for the tape used.
- There are two ends to the cylinder, separated internally by a floating piston. One end is marked **PRODUCT INLET**; this end can easily be identified by the blue vertical line on the tracker tube. The other end of the cylinder is marked **PRE-CHARGE END**, and it is marked on the tracker tube with a red vertical line at both 80% full and 100% full.
- A sample probe should be located in the least turbulent area available of the flowing stream; i.e., not in a header or blow-down stack and away from obstructions, elbows or partially closed valves. The sample probe should be installed reaching approximately into the center one-third of the pipeline.
- The sample cylinder should be located as close to the sample point as is possible.

#### Recommended Tools

It would be advisable to have the following tools available for installation of the unit. However, tools used will vary depending on cylinder model.



- Flexible hose or tubing
- 6" adjustable wrench
- Tubing cutters
- Small diameter stainless steel tubing

# INSTALLATION & OPERATIONS

## 2.2 PRE-CHARGING THE CYLINDER



The pre-charge gas being used must be compatible with the seals in the cylinder. The relief valves and gauges must also be adequate for the pressures used when pre-charging.

### 1. Connecting the cylinder pre-charge valve to the pipeline (pressurized gas pipeline only):

- Use small diameter stainless steel tubing to connect from an available pipeline valve to the pre-charge inlet valve. (See Figure 3).
- Make sure all valves are closed on the sample cylinder (CP-80).
- Open the pipeline isolation valve.
- Slowly open the pre-charge inlet valve.
- Slowly open the product inlet valve (see Figure 4), to relieve any pressure buildup. The piston will begin to move.



Figure - 3  
Pre-Charge End Cap



Always open valves slowly to avoid slamming the piston from one end to the other.

- The pre-charge gauge should begin to read pressure and will eventually reach pipeline pressure.
  - Once the piston has reached the end of the cylinder, close all valves and check for leaks.
  - Disconnect the tubing from the cylinder and from the pipeline isolation valve.
- ### 2. Connecting the pre-charge valve to the return port on a sampler probe (for continuous sampling of pressurized gas pipeline only):

- Install a valve into the return port of the sampler probe.
- Make sure all valves are closed on the sample cylinder (CP-80).
- Use small diameter stainless steel tubing to connect from the cylinder's pre-charge inlet valve (see Figure 3), to the valve on the return port of the probe (not shown).
- Open the valve on the return port of the sampler probe.
- Slowly open the pre-charge inlet valve on the sample cylinder (see Figure 3).

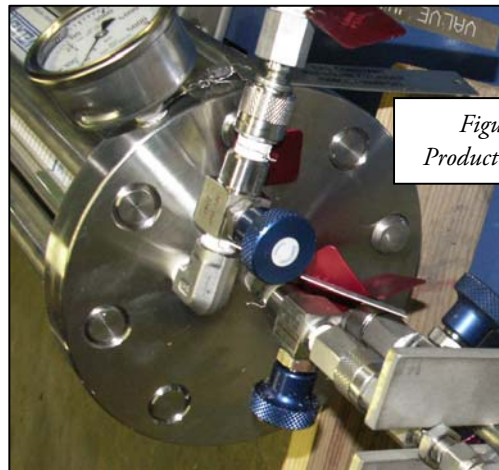


Figure - 4  
Product End Cap



# INSTALLATION & OPERATIONS

## 2.2 PRE-CHARGING THE CYLINDER (CONTINUED)

- Slowly open the product inlet valve on the sample cylinder (see Figure 4) to relieve any pressure buildup.
- The pre-charge gauge should begin to read pressure and will eventually read the pipeline pressure.
- Leave the pre-charge valve on the sample cylinder open during the sampling procedure.
- Leave the return port valve on the probe open during the sampling procedure.
- Check for leaks.

### 3. Using an auxiliary pre-charge gas:



When using an auxiliary gas, the pre-charge side of the cylinder should be pressurized with a regulated gas supply (i.e., nitrogen or helium) and set 50-100 psi above pipeline operating pressure, not to exceed the maximum allowable pressure of the device.

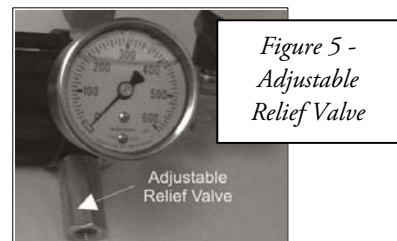
- Make sure all valves on the sample cylinder are closed.
- Use small diameter stainless steel tubing to connect the pre-charge valve to the regulated auxiliary gas supply. (See Figure 3).
- Open the valve on the gas supply.
- Slowly open the pre-charge inlet valve on the sample cylinder (CP-80).
- Slowly open the product inlet valve on the sample cylinder (see Figure 4) to relieve any pressure buildup. The piston will begin to move.
- The pre-charge gauge should begin to read pressure and will eventually read the designated pressure.
- Once the piston has reached the end of the cylinder, and obtained between 50-100psi, close all valves and check for leaks.
- Disconnect the tubing from the cylinder and from the pipeline isolation valve.

## 2.3 INSTALLATION



If steps 2.2 Section 1 or 2.2 Section 3 are used to pre-charge, or if the cylinder is being used for continuous sampling and the pre-charge is not connected to the pipeline, it will be necessary to install an adjustable, resetting relief valve in order to relieve pre-charge pressure while continuous sampling.

1. If your cylinder is equipped with an adjustable relief valve (see Figure 5), use an auxiliary gas supply to set the valve at least 50-100 psi above pipeline pressure, not to exceed the maximum allowable working pressure indicated in Table 1 on page 5 (refer to IO&M for relief valve).



2. If your cylinder is not equipped with a product purge valve (see Figure 4), create a purge valve by tubing a T-fitting and valve inline between the sample point and the cylinder in order to provide a way to purge the system.

# INSTALLATION & OPERATIONS

## 2.3 INSTALLATION (CONTINUED)



Purging the system of excess air is important to ensure the system is not contaminated from the previous sample.

3. Close the product inlet valve.
4. Connect the product inlet valve to the sample point (i.e., probe or sampler).
5. Proceed to Section 2.4 for instructions on how to spot sample the product, or Section 2.5 for instructions on how to continuously sample the product.

## 2.4 SPOT SAMPLING

1. Open the product purge valve on the sample cylinder (see Figure 4) to purge the system of any contaminants. Close the purge valve.
2. After pre-charging the cylinder above pipeline pressure (see Section 2.2), connect the product inlet valve of the cylinder to the sampler outlet port (see Figure 6).
3. Slowly open the sampler outlet valve.
4. Slowly open the product inlet valve on the product end cap of the sample cylinder (see Figure 4). The piston will not yet move because pre-charge pressure is above pipeline pressure.
5. With the sampler valve and product valve fully open, slowly open the pre-charge valve to relieve pre-charge pressure. This will allow the sampled product to enter the cylinder and push against the piston. Thus, no pressure loss is encountered.

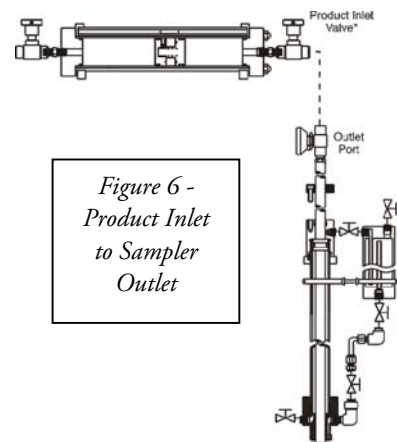


Figure 6 -  
Product Inlet  
to Sampler  
Outlet



Relieving the pre-charge too quickly can result in a pressure drop and an inaccurate sample. A bleed plug can be installed on the pre-charge valve to regulate the relieving rate. The bleed plug will allow only a small amount of pressure to exit; ensuring that pre-charge pressure is relieved steadily.

6. When the desired amount of sample is extracted, close all valves on the cylinder.
7. Close the probe outlet valve.
8. Carefully disconnect the cylinder from the probe, allowing the trapped product between the probe and cylinder valves to vent.
9. Plug or cap all valves on the cylinder.
10. Make a note of pressure, locations, etc., on the information tag according to company policy.
11. Check all fittings for leaks.
12. The cylinder is now ready for product removal.

# INSTALLATION & OPERATIONS

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## 2.5 CONTINUOUS SAMPLING

1. Pre-charge the sample cylinder (see Section 2.2) and connect the product inlet end (see Figure 4) of the cylinder to the sampler outlet port.
2. Open the product purge valve on the sample cylinder to purge the system of any contaminants. Close the purge valve. Welker recommends plugging the purge valve when not in use.
3. Open the sampler outlet valve.
4. Slowly open the product valve on the product end cap of the sample cylinder. The piston will not yet move because pre-charge pressure is above pipeline pressure.



The automatic sampler will push product against the piston, causing the pre-charge pressure to relieve from the adjustable relief and/or to be pushed into the pipeline.

5. Turn the sampler off when the cylinder is at 80% capacity. This allows a 20% margin for possible expansion due to temperature changes.
6. When the desired amount of sample is extracted, close all valves on the cylinder.
7. Close the sampler outlet valve.
8. Carefully disconnect the cylinder from the sampler, allowing the trapped product between the sampler outlet valve and the product inlet valve to vent.
9. Plug or cap all valves on the cylinder.
10. Record pressure, locations, etc., on the information tag according to company policy. Check all fittings for leaks.
11. The cylinder is now ready for product removal.


# SPECIFICATIONS

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## 3. MAINTENANCE

### 3.1 GENERAL

Prior to maintenance or disassembly of the unit, it is advisable to have a repair kit handy for the system in case of unexpected wear or faulty seals.


 We recommend that the unit have annual maintenance under normal operating conditions. In the case of severe service, dirty conditions, excessive cycling usage, or other unique applications that may subject the equipment to unpredictable circumstances, a more frequent maintenance schedule may be appropriate.


#### Recommended Tools

It would be advisable to have the following tools available for installation of the unit. However, tools used will vary depending on cylinder model and connectors used.



- Small hex key set
- 6" adjustable wrench
- 10" adjustable wrench
- 10" channel lock pliers
- Fine-grit sandpaper
- Flat blade screwdriver
- Torque wrench
- O-Ring kit

 New seals supplied in spare parts kits are not lubricated. They should be lightly coated with lubrication grease (silicone grease or other) before they are installed into the equipment. This helps in the installation of the seals while reducing the risk of damage when positioning them on the parts. After the seals are installed, some additional lubrication can be applied to shafts or cylinder inner diameters to allow smooth transition of parts. While lubrication should be thorough, only a minimal amount should be applied. Wipe excess lubrication from the seals, as it may have an adverse effect on sampling.

 In the case of constant pressure cylinders, the lubrication grease should be applied sufficiently but lightly (Krytox® is preferred). When using lubrication other than Krytox, wipe excess lubrication from the seals as it may have an adverse effect on some analytical instrument results.



Do not dig into the metal surfaces of the parts when removing O-rings from the O-ring grooves. Scratching the sealing surface can result in a leak. If necessary, dig into the O-ring, and replace it during reassembly. If the sealing surface becomes damaged, use a

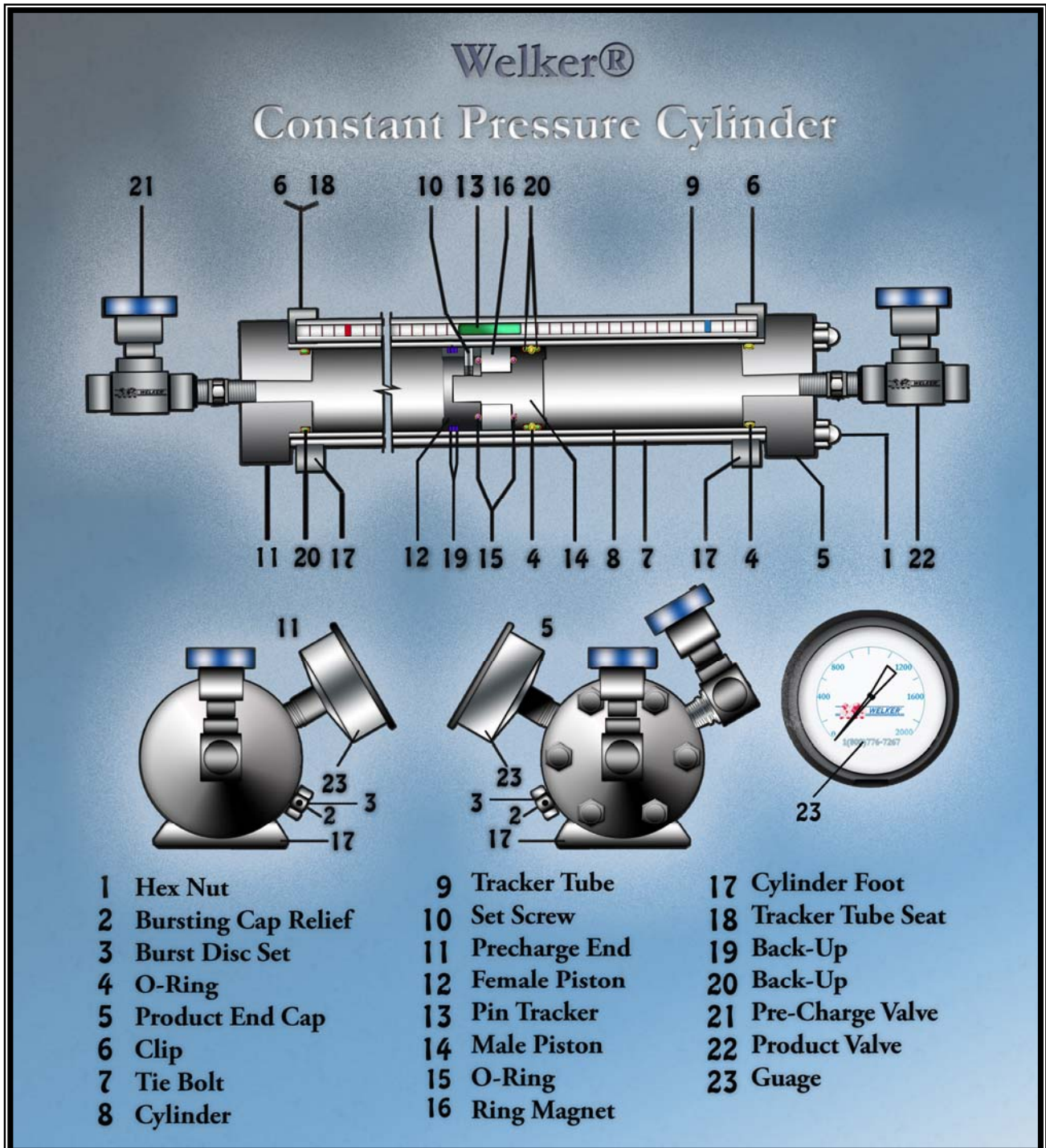
# SPECIFICATIONS

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600-grit wet sand paper strip to smooth the surface, and then clean it. Check the ball bearing for any signs of wear or damage. Replace if necessary.

# SPECIFICATIONS

## 3.2 MAINTENANCE PARTS DIAGRAM



Cylinder may vary slightly

# MAINTENANCE

## 3.3 DISASSEMBLY (*Refer to diagram on page 13*)

1. Make sure the unit is depressurized prior to maintenance.
2. Remove the cylinder stands (Part 17).
3. Remove the six nuts (Part 1) and the six tie bolts (Part 7).
4. Remove the tracker tube clips (Part 6) and tracker tube seats (Part 18).
5. Remove both the product end cap (Part 5) and the pre-charge end cap (Part 11).
6. Remove the tracker tube (Part 9).

**N** NOTE

Burst discs should be replaced after 6-10 cylinder fillings or at least once a year. While the discs do help to maintain the product, they are designed as a safety device to prevent overpressurization of the cylinder.

7. When necessary, replace the burst discs (Part 2)
  - Insert the clear seal.
  - Insert the rupture disc after the clear seal. The dome should face out.
  - Torque the bursting relief caps to the proper specification (see Table 2).

Table 2

TORQUE SPECIFICATIONS FOR CYLINDER RUPTURE DISC CAPS			
Pressure Range (psi)	Torque Requirements		
	0-300	50 in-lbs	5.6 Nm
301-5000	20 ft-lbs	27 Nm	
5001-6000	24 ft-lbs	32 Nm	
6001-7000	29 ft-lbs	39 Nm	
7001-10,000	38 ft-lbs	52 Nm	

8. If there is an adjustable relief valve on either end cap, remove it and replace all seals within the part (*refer to IO&M for adjustable relief valve*).

**!** CAUTION

Do not dig into the metal surfaces of the parts when removing O-rings from the o-ring grooves. Scratching the sealing surface can result in a leak. If necessary, dig into the o-ring, and replace it during reassembly. If the sealing surface becomes damaged, use a 600-grit wet sand paper strip to smooth the surface, and then clean it. Check the ball bearing for any signs of wear or damage. Replace if necessary.

**N** NOTE

New seals supplied in spare parts kits are not lubricated. All seals should be lightly coated with Krytox<sup>®</sup> lubrication grease before they are installed into the equipment. Other lubrication greases can be used, although they risk contaminating the sample. After the seals are installed, additional lubrication can be applied to the shaft or cylinder inner diameters to allow a smooth transition of the parts. While lubrication should be thorough, only a minimal amount should be applied. Wipe excess lubrication from the seals, as it may have an adverse effect on sampling.

9. Push the piston out of the cylinder (Part 8).
10. Loosen the set screw (Part 10) in the piston assembly. Disconnect the male piston (Part 14) from the ring magnet (Part 16) and female piston (Part 12).

# MAINTENANCE

## 3.4 MAINTENANCE INSTRUCTIONS

1. Remove and replace the backups (Part 19 and Part 20) on the male and female piston.
2. Replace the O-rings (Part 4 and 15) in the male and female piston.
3. Remove and replace the seals (Part 4) in each end cap.
4. Wipe down the inside of cylinder and dry carefully (*also see Section 3.5*).
5. Closely examine the honed surface of the cylinder. Scratches and pits will cause the seals to leak.



The following are causes to return the device to the manufacturer:

- Scratches or pitting that allow migration of gas from one side to the other.
- Any damage to the outside cylinder shell that may compromise the cylinder wall thickness.

## 3.5 REASSEMBLY INSTRUCTIONS

1. Reassemble the piston as below. Reinsert the piston back into the cylinder (Part 8) carefully. Again, be careful not to scratch the cylinder or damage the seals. Make sure that the direction of piston insertion is correct. The female end (Part 12) of piston goes toward the pre-charge end cap (Part 11).
2. Reattach the pre-charge (Part 11) and product end caps (Part 5) onto the cylinder.
3. Reattach the tie bolts (Part 7) and tighten the nuts (Part 1) to the correct torque using a cross bolting sequence

Torque Specifications for Tie Bolts		
Diameter of Tie Bolt	Foot Pounds	KG/M
$\frac{3}{8}$ " (CP-2, etc.)	5-6	.69-.82
$\frac{1}{2}$ " (CP-7, CP-24, etc.)	15-20	2.07-2.76
$\frac{5}{8}$ " (CP-5, etc.)	23-30	3.45-4.14
$\frac{7}{8}$ " or 1" (CP-11, LS-7, CP-80etc.)	55-65	7.60-8.98

4. Reattach the tracker tube (Part 9), clips (Part 6), and seats (Part 18).
5. Pressure up cylinder at one end with an inert gas supply and test for leaks. Repeat the process from the opposite end. Pressurize slowly to avoid the slamming the piston from one end to the other.



Welker recommends using helium to test for leaks.



# MAINTENANCE

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## 3.5 CYLINDER CLEANING

Regular cleaning of the cylinder is essential for the proper functioning of the device. Solvent cleaning is normally done during scheduled maintenance; however, some companies require this before each cylinder is put into service. Any debris or residue that is not removed from the cylinder will contaminate the results of the next sample extracted from the cylinder. Welker recommends cleaning and leak testing of the cylinder after each use.

### Cleaning a constant pressure sample cylinder can be done one of three ways:

#### 1. Purging with helium

- Fill and empty the cylinder with helium repeatedly.
- Take a sample of the helium to test for trace amounts of hydrocarbons.

#### **N** NOTE

If hydrocarbons are present in the analysis, the system has not been adequately cleaned, and further purging will be necessary. If hydrocarbons or contaminants remain present, a solvent cleaning may be required (*see step 3.5.3*). After cleaning with solvent, purge with helium to remove the solvent and analyze the helium to verify the solvent and hydrocarbons have been removed.

- If no hydrocarbons are found, cleaning is complete.
- Repeat step 7 of Section 3.4.

#### 2. Purging with new product

- Purge the cylinder using the product to be sampled. This can be accomplished each time the cylinder is put into service.
- Repeat step 7 of Section 3.4.

#### **N** NOTE

This method is acceptable only if the cylinder will be used in one location.

#### 3. Cleaning with solvent

- Fill and empty the cylinder repeatedly with solvent.
- Use an inert gas to dry and purge the cylinder.
- Use method 3.5.1 to verify the system is free of contaminants.
- Repeat step 7 of Section 3.4

# SAFETY WARNING

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## SAFETY ISSUE WARNING FOR LIQUID SAMPLE CYLINDERS

After drawing the sample into the cylinder, the inlet and pre-charge valves should be closed. The sample line is then disconnected from the cylinder and the cylinder is completely isolated from the process. Paperwork is processed and the cylinder is prepared for transport. Prior to transporting the cylinder, it is a common and recommended practice to plug or cap the valves on the cylinder. These valves may terminate with a female NPT or a male NPT. The female valves are typically plugged, while the male valves are typically capped.

In the case of liquid sampling and due to the potential extremes of thermal expansion of many LPG products, caution should be taken to ensure that any residual liquid is drained, blown, or absorbed from the accessible exterior dead volume of the valve body (downstream of the seat) prior to plugging or capping the valve.

It is common to see temperature differentials of as much as 100° F (38° C) or more. Liquid samples that are drawn at -40 to -50° F (-40 to -46° C) can be transported in shipping cases that may see ambient temperatures as high as 100° F to 160° F (38° to 71° C), and at times may exceed 160° F (71° C).

Operators should be familiar with the basic and general physical properties of the product that they are sampling so that they can adequately estimate the expansion potential of the sampled product within the cylinder and therefore have them allow ample outage for expansion to occur. In a majority of cases, 80% fill and 20% pre-charge is acceptable, but certain products may require a larger inert gas pre-charge ratio – i.e., 70%-30% or 60%-40%.



Burst discs are installed on these cylinders to protect them from structural failure. The operator must be aware that flammable product will be released in the event of overpressurization of the working pressure of the cylinder and therefore it is important to allow for ample expansion within the cylinder prior to attainment of the rupture disc activation

If you have any questions, please contact Welker.

# TROUBLESHOOTING

## 4. TROUBLESHOOTING GUIDE

The following is a troubleshooting table of issues most commonly associated with the Welker® Constant Pressure Cylinder models. If you are having a problem that is not listed, or if the solution provided does not repair the problem, please call Welker for service options.

PROBLEM	POSSIBLE CAUSE	SOLUTION
Gauge indicates a loss of pressure.	<ul style="list-style-type: none"> <li>• There is a leak from one of the fittings.</li> <li>• There is a leak from the burst discs.</li> <li>• The cylinder experienced a temperature drop.</li> <li>• There is a defective valve.</li> </ul>	<ul style="list-style-type: none"> <li>• Check all fittings for leaks with leak detector. Replace thread sealant.</li> <li>• Make sure the burst discs are torqued properly. If the problem persists, the discs may need replacement. <i>See Table 2.</i></li> <li>• Restore the temperature to pipeline temperature.</li> <li>• Repair or restore the defective valve.</li> </ul>
Pressure is leaking across the piston.	Seals in the piston are leaking.	Disassemble and clean the unit. Inspect cylinder for scratches. Replace seals in the piston and reassemble.  <i>See Sections 3.2-3.4.</i>
The pre-charge or product end cap is leaking.	<ul style="list-style-type: none"> <li>• The burst disc is leaking.</li> <li>• There is a loose fitting.</li> <li>• The seat on purge valve is leaking.</li> </ul>	<ul style="list-style-type: none"> <li>• Replace the burst disc. <i>See step 3.2 Section 13.</i></li> <li>• Tighten the fittings.</li> <li>• Replace the seat.</li> </ul>



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