

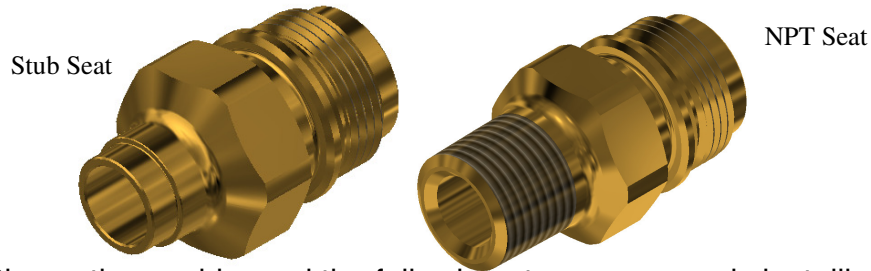
INSTALLATION INSTRUCTIONS



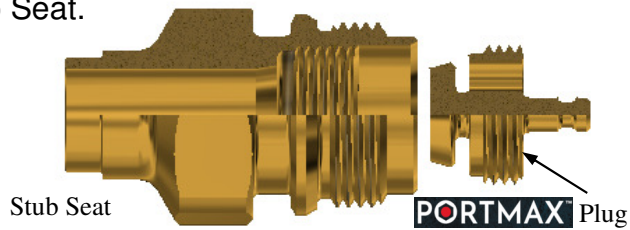
PORTMAX Access Valve

Saddle Mount and NPT Seat

Description: Installation instructions between Plug and Seat.

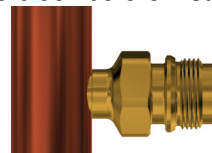


Please thoroughly read the following steps on properly installing Plug to Seat.



INSTALLATION PROCEDURE FOR ALL SEATS AND PLUGS:

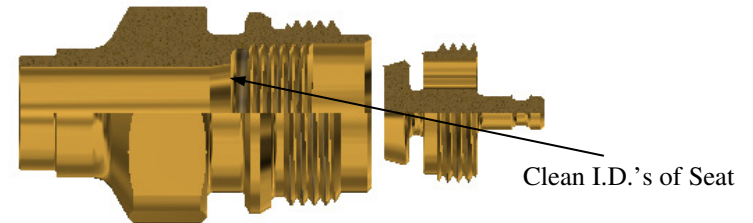
1. **PORTMAX** Plugs should remain in protective packaging until assembly is required to ensure cleanliness and eliminate damage. Just prior to assembly remove the **PORTMAX** Plug from packaging tray.
2. Braze SEAT ONLY into tube or valve block before installing/threading Plug into Seat.



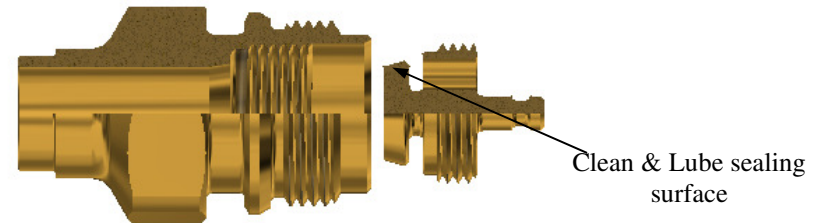
Example: Tube brazed to Seat

Steps 3 - 4 apply to all style seats.

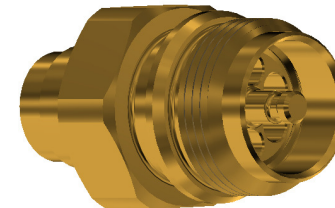
3. Make sure there is no contamination in the I.D. of the Seat, especially the sealing area.



4. Make sure the plug is free of contamination and foreign particulates. Lightly lubricate with compatible refrigerant oil.



5. Thread Plug into Seat and torque with the CMFT70 Charge tool, clockwise to 12-14 ft-lb's.



PORTMAX™