

**SCOPE**

This procedure describes the method of replacing seals on the 71-3 series coupling, and the 2" 71-1 coupling.

**1.0 GENERAL**

- 1.1** Before commencing with disassembly of the coupling one should study the enclosed assembly drawings and exploded view figures.
- 1.2** All processes described shall be conducted in a clean environment with all staging areas for disassembly, assembly, test benches and equipment maintained to a high level of cleanliness ensuring minimal contamination to the couplings.
- 1.3** Spare part kits for this refurbishment may only be purchased from Snap-tite. The following are the spare part kit numbers.

| <b><i>Spare part kit</i></b> | <b><i>used on</i></b>        |
|------------------------------|------------------------------|
| 71-3C4-SPK                   | 71-3C4, S71-3C4, SH71-3C4    |
| 71-3N4-SPK                   | 71-3N4, S71-3N4, SH71-3N4    |
| 71-3C6-SPK                   | 71-3C6, S71-3C6, SH71-3C6    |
| 71-3N6-SPK                   | 71-3N6, S71-3N6, SH71-3N6    |
| 71-3C8-SPK                   | 71-3C8, S71-3C8, SH71-3C8    |
| 71-3N8-SPK                   | 71-3N8, S71-3N8, SH71-3N8    |
| 71-3C12-SPK                  | 71-3C12, S71-3C12, SH71-3C12 |
| 71-3N12-SPK                  | 71-3N12, S71-3N12, SH71-3N12 |
| 71-3C16-SPK                  | 71-3C16, S71-3C16, SH71-3C16 |
| 71-3N16-SPK                  | 71-3N16, S71-3N16, SH71-3N16 |
| 71-2C16-SPK                  | 71-2C16, S71-2C16, SH71-2C16 |
| 71-1C32-SPK                  | 71-1C32, S71-1C32, SH71-1C32 |
| 71-1N32-SPK                  | 71-1N32, S71-1N32, SH71-1N32 |

Standard seal material used in the above kits is Nitrile i.e 71-3C4-SPK.

For Viton add the suffice V, i.e. 71-3C4-SPKV

For EPDM add the suffice E, i.e. 71-3C4-SPKE

- 1.4** To disassemble and reassemble the coupler the following Snap-tite ball lock fixture is required. Note all stainless 71-1C32 couplers require a dog lock fixture.

| <b><i>Snap-tite fixture number</i></b> | <b><i>used on</i></b>     |
|----------------------------------------|---------------------------|
| 40237-11-13-04                         | 71-3C4, S71-3C4, SH71-3C4 |
| 40237-11-13-06                         | 71-3C6, S71-3C6, SH71-3C6 |
| 40237-11-13-08                         | 71-3C8, S71-3C8, SH71-3C8 |
| 40237-11-13-12                         | 71-3C12, S71-3C12         |
| 40237-11-13-16                         | 71-3C16, S71-3C16         |
| 40237-11-13-22                         | SH71-3C12                 |
| 40237-11-13-26                         | SH71-3C16                 |
| 40237-11-13-32                         | 71-1C32                   |
| 40237-11-13-33                         | S71-1C32, SH71-1C32       |
| 40237-11-13-36                         | 71-2C16, S71-2C16         |
| 40237-11-13-37                         | SH71-2C16                 |