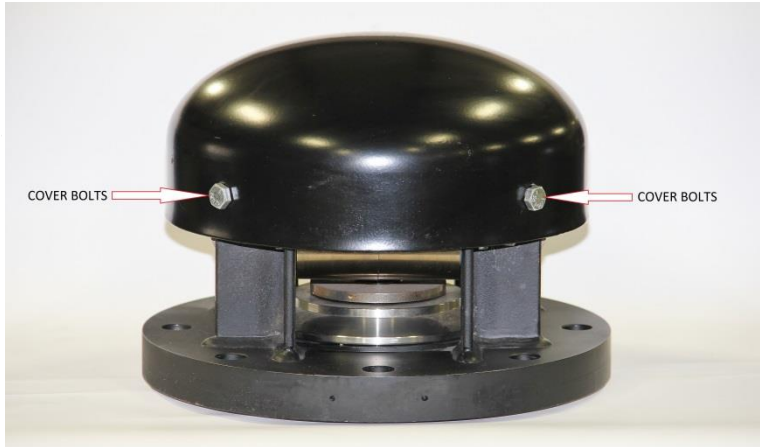




Service Bulletin #101

Loose or Missing Dome Cover Bolts



We have received field service reports of dome cover bolts loosening or missing and potentially causing the loss of the dome cover during transportation. The loss of a dome cover does not impair the operation of the pressure relief valve in any way. However, the dome cover bolts should be tight to secure the dome cover. The following options are available to secure loose or missing bolts:

Application of Loctite 242 and Installation of split lock washer to secure bolts

1. Inspect valve for loose or missing dome cover bolts
2. If a bolt is loose, remove all 4 bolts and lift off dome cover:
 - a. Clean off any material from threads and bolt holes with solvent-based cleaning solution
 - b. Install a zinc-plated split lock washer on all four bolts
 - i. For valves with 10 ½" diameter dome cover use a 3/8" zinc-plated split lock washer
 - ii. or valves with 6 ½" diameter dome cover use a 5/16" zinc plated split lock washer
 - c. Apply Loctite 242 to bolt threads according to manufacturer's recommendation
 - d. Put dome cover in place
 - e. Install all four dome cover bolts
 - f. Torque each bolt to 100 inch-lbs. (8 foot-lbs.)
3. If a bolt or washer is missing, replace with:
 - a. 3/8"-16 x 1" long zinc-plated bolt for valves with 10 ½" diameter dome cover along with a 3/8" zinc-plated split lock washer
 - b. 5/16"-18 x ¾" long zinc plated bolt for valves with 6 ½" diameter dome cover along with a 5/16" zinc plated split lock washer

Note: Kelso will supply these bolts and washers at no charge. Please call 1-630-495-1151 or email sales@kelsotech.com for assistance.