

# LIQUID LEVEL GAUGE FOR WELDING ZGAU

## 706 O and 706 M

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## 1. Introduction

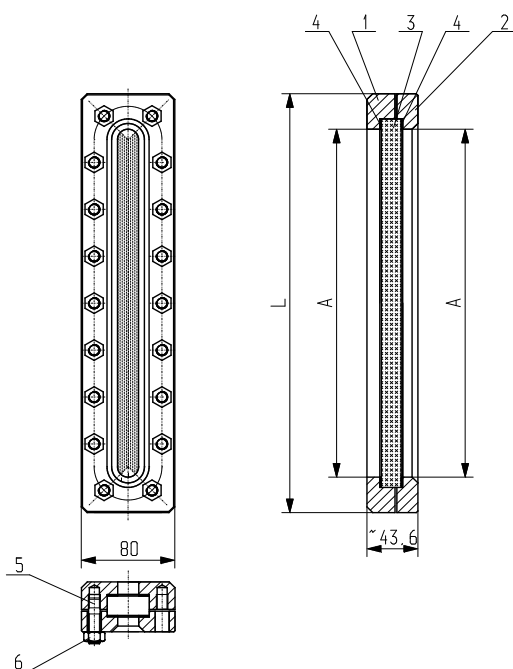
Liquid level gauge with reflexive glass 706O/706M (ex. 706/706 CrNi) is design to showing of liquid level in pressure tanks about working pressure to 20 bar. Body of liquid level gauge is welded to cylindrical wall of pressure tank.

Liquid level gauge 706 should to apply to devices, which design pressure  $p_o$  and temperature  $t_o$  do not exceed the sizes passed in table 1.

Table 1.

| $t_o$ | °C  | 100 | 150 | 200 | 250 |
|-------|-----|-----|-----|-----|-----|
| $p_o$ | bar | 20  | 18  | 16  | 14  |

## 2. Construction



Drawing 1

| Position No. | Name of detail  | Material |               |
|--------------|-----------------|----------|---------------|
|              |                 | 706O     | 706M          |
| 1.           | Body            | S275JR   | X6CrNiTi18-10 |
| 2.           | Cover plate     | S275JR   | X6CrNiTi18-10 |
| 3.           | Reflexive glass | KLINGER  | KLINGER       |
| 4.           | Glass gaskets   | KLINGER  | KLINGER       |

Different type of material after agreement with the manufacturer

Table 2. Dimension of liquid level gauge 706O and 706M

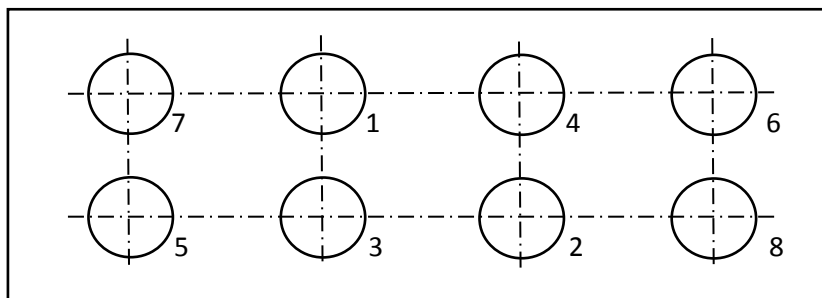
| Size | Length of liquid level gauge | Length of sight-glass | Dimensions of glass | Mass ca. |
|------|------------------------------|-----------------------|---------------------|----------|
|      | L                            | A                     |                     |          |
|      | mm                           |                       |                     |          |
| I    | 186                          | 115                   | 140x34x17           | 3,40     |
| II   | 211                          | 140                   | 165x34x17           | 3,90     |
| III  | 266                          | 195                   | 220x34x17           | 4,70     |
| IV   | 326                          | 255                   | 280x34x17           | 5,50     |
| V    | 366                          | 295                   | 320x34x17           | 6,30     |

Liquid level gauge consists of body [1] cover plate [2] and reflective glass [3] together with KLINGER set of gaskets [4] connected each other by screws [5] and nuts [6].

## 3. Installation

The factory liquid level gauge is twisted loosely in order to its disassembly before being welded to the shell of the pressure equipment.

Before welding, remove liquid level gauge, ie. unscrew the mounting nuts (6), then remove the cap of liquid level gauge (2) and remove the glass (3) with gaskets (4). After welding the body of liquid level gauge (1) to the shell of pressure equipment, assemble liquid level gauge in reverse order. In order to caulk the connection, tighten the nuts evenly and alternately according to the scheme set out in Drawing 2. After starting the unit, check for leaks. In case of a leak, tighten the screws in the following way:



Drawing. 2 Sequence of tightening of screws in liquid level gauge frame

#### 4. Glass changing

Crack of the glass in liquid level gauges covered by this user's manual or the occurrence of leaks which could not be eliminated by tightening the nuts of fixing screws - requires a cut-off factor (eg. by tank emptying or reducing the level of liquid out of liquid level gauge), which should be allowed by tank design and installation.

In order to replace the glass or gaskets, unscrew the mounting nuts, remove the cap of liquid level gauge [2], replace the glass [3] and gaskets [4]; then carry out the installation of liquid level gauge in reverse order, following the instructions in point. 3 of these instructions.

#### 5. Final Remarks

During service of liquid level gauges in exploitation, regulations of UDT as well as different regulations related to pressure devices has to be obeyed.

If during the inspections or repair some parts will prove for replacement, order of new part should include: number of position, name of the element, size and using material.

#### 6. Warranty

ZETKAMA grants quality warranty with assurance for proper operation of its products, providing that assembly of them is done according to the user's manual and they are operated according to technical conditions and parameters described in ZETKAMA's catalogue cards. Warranty period is 18 months starting from assembly date, however not longer than 24 months from the sales date.

Other warranty terms are to be agreed between the manufacturer of the valve and the purchaser. **The manufacturer reserves the right to introduce technical changes as the result of improving construction and manufacturing technology.** Failure to comply by the user with the regulations and indications included in this user's manual shall exempt the manufacturer from any liability and warranty.