

6-K ACCUMULATOR REPAIR

Port Sealing Head and Seal Ring Replacement

1. Loosen the jam nut with the unit at operating pressure.
2. Shut down and relieve all high-pressure water in the system.
3. Remove the jam nut.
4. Loosen the retaining nut and unscrew $\frac{1}{4}$ ". Install the jam nut and tighten, which will pull the port-sealing head out $\frac{1}{4}$ ". Repeat step #4, two more times. At this point you should be able to remove the parts by hand.
5. Clean all of the parts, including the accumulator threads. Clean and polish the bore of the accumulator in a cylindrical motion one inch deep with 600-grit paper. Polish the taper on the port-sealing head.
6. Use High-Purity Goop on both the male and female threads.
7. Put a new wedge ring on the port-sealing head and place it in the bore of the accumulator.
8. Install the retaining nut and tighten it with the spanner wrench. Tap the spanner wrench with a rubber mallet until all of the slack is out of the threads.
9. Install and tighten the jam nuts.
10. Start the unit and pressurize it to 55,000 PSI. Then tighten the jam nuts again.
11. Repeat step #10, every four hours of operation, until the jam nuts have been checked 12 times.
12. After each completion of step #10, return the pump to its normal operating pressure.