

SB/FS/12

OCTOBER 1968

## INSTRUCTIONS FOR FITTING UNIONS ON PETROL

### INJECTION FUEL PIPES

In order to fit petrol injection fuel pipe unions, it will be necessary to make a suitable pipe clamp.

Figure 1. illustrates a simple clamp made from Tufnol block (approximately 2" x 1" x 1"). A  $\frac{1}{4}$ " diameter hole is drilled through the centre of the block, which is then cut along its centre line.

Cut the piping to the required length and clamp it, as shown in figure 2. Allow approximately  $\frac{1}{8}$ " clearance above the clamp, in addition to the length of pipe required to fit the connection. If a straight connection is being fitted, place the union nut over the pipe before it is clamped.

Locate the connection in the pipe, and gently tap it into its final position, using a soft headed hammer.

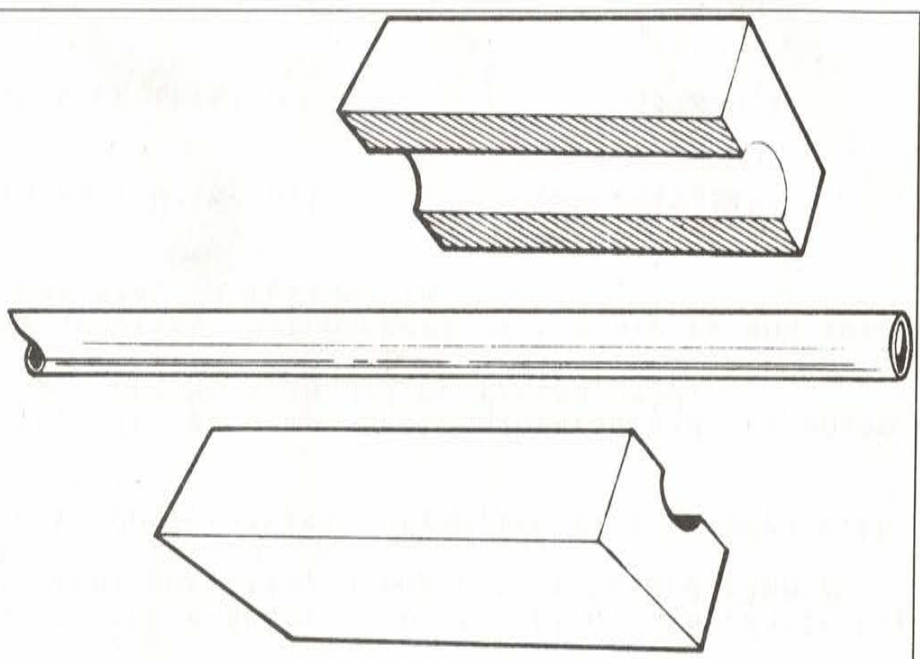
Remove dust particles from interior of pipe with compressed air.

Note: The pipe must not be heated and the union assembly should be fitted cold.

The ordering part numbers of the piping and respective connections are, as follows :-

Piping (50' spool)	54733455
Elbow Connection	54730924
Banjo	54731886
Straight Connection	54733399

FIGURE 1.



Place nut on  
pipe before  
clamping.

FIGURE 2.

