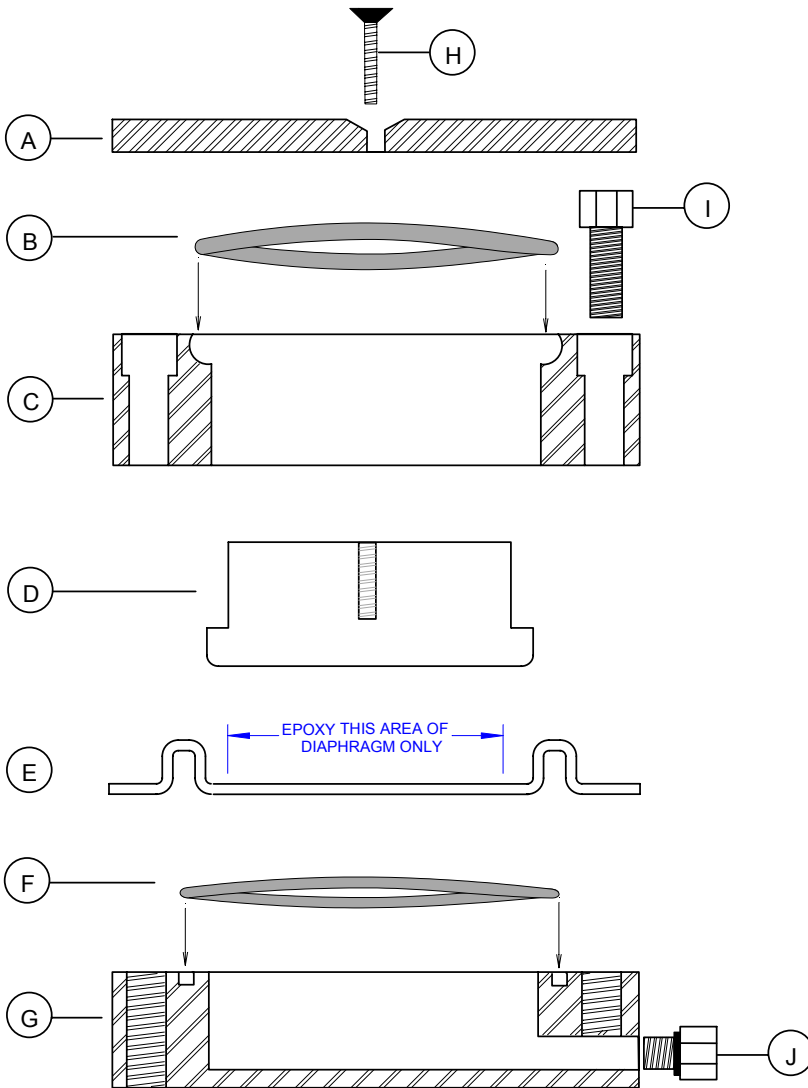


DIAPHRAGM REPLACEMENT INSTRUCTIONS FOR STANDARD 12.56 LOAD CELL



12.56 DIAPHRAGM KIT CONSISTS OF:

High Pressure Diaphragm (Qty 1) (Item E)
 Bumper O-Ring (Qty 1) (Item B)
 Flat Head Screw (Qty 1) (Item H)
 2-Part Epoxy with Template (1 Packet)
 Filler Plug w/O-Ring (Qty 1) (Item J)
 Thin O-Ring (Qty 1) (Item F)
 Allen Internal Hex Head Bolts (Qty 8) (Item I)
 Diaphragm Replacement Instructions
 Filling Instruction Sheet
 Troubleshooting Tips

TOOLS REQUIRED:

1/4" Allen Key and 3/16" Allen Key
 Torque Wrench
 Sand Paper
 Oil (consult factory for compatibility)

1. Remove Flat Head Screw (H) from Top Plate (A) with 3/16" allen key. Remove eight (8) Allen Internal Hex Head Bolts (I) from Top Ring (C) with 1/4" allen key. Remove Top Ring.
2. Remove Piston (D) and old Diaphragm (E). Separate and discard diaphragm. Sand piston face to remove epoxy. Apply new 2-part epoxy to Piston face, leaving outer 3/8" edge free of epoxy. This helps keep epoxy away from diaphragm convolute. **DO NOT APPLY EPOXY TO CONVOLUTE of Diaphragm.** Very little epoxy is need to sufficiently bond Piston to Diaphragm. Seat Piston on Diaphragm. Spin Piston to evenly distribute epoxy. Momentarily separate Piston from Diaphragm to verify thorough epoxy coverage. Re-seat (centered) and allow to dry overnight before proceeding.
3. Put Rubber Bumper (B) in place. With holes aligned in both Ring (C) and Diaphragm (E), ease Ring down over Piston glued to Diaphragm. Rubber Bumper should be flush with outer surface of Ring.
4. Lightly stretch thin O-Ring (F) until it seats freely in groove in Bottom Plate (G). Place the Piston/Diaphragm assembly on Bottom Plate so that holes align. Set Ring (C) on top and align holes.
5. Replace Bolts (I) loosely in Ring (C). Using torque wrench, tighten 2 opposing bolts to only 14 foot pounds pressure. Tighten remaining bolts in same manner.
6. Replace Top Plate(A) and tighten allen bolt "snug" only.



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STANDARD 12.56 LOAD CELL Diaphragm Replacement Instructions

Drawn by: SLP/MN
 Date: 03/02/81
 Revised: 04/22/02
 Scale: NONE

Drawing Number

29551