

HSG02 sight glass

The HSG02 sight glass range is suitable for use in systems operating up to a maximum of 10 barg. For units with EPDM seals, the maximum operating temperature is 135°C. Units fitted with Viton, Silicone or FEP-Silicone seals have a maximum operating temperature of 200°C.

Installation

Units may be installed in any orientation and with the flow in either direction.

Maintenance

The HSG02 sight glass is easily disassembled for cleaning or maintenance. Replacement seals and glass are available for all sizes.

Disassembly/assembly instructions are as follows:

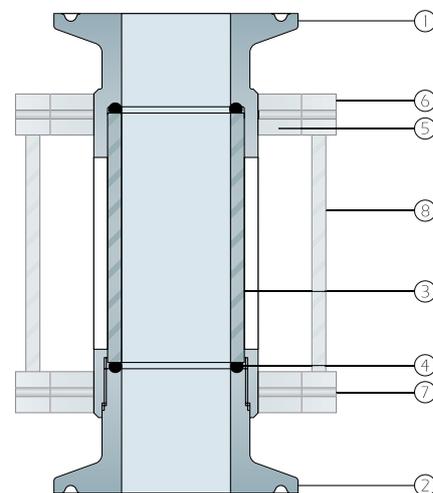
1. Holding the body (1), unscrew the end fitting (2) in an anti-clockwise direction. Tightening/loosening can be achieved by adding a bolt to a solid cap and then fitting one cap on each end of the sight glass using standard seals and clamps - such fittings are available from Staitech. Once loosened, the end fitting (2), glass (3) and seals (4) can be removed.
2. Ensure that all components are clean prior to re-assembly. Inspect seals and glass before re-assembly, replacing if required.
3. Locate seal (4) in groove of body (1).
4. Slide glass (3) into body (1).
5. Apply coating of anti-seize compound to end fitting thread (consult Staitech for suitable compound specification if required).
6. Locate seal (4) in groove of end fitting (2).
7. Screw end fitting into body, ensuring that the seals are correctly located in the seal grooves and that the glass is central before tightening.
8. Apply tightening torque to compress seals in accordance with values given.
9. Pressure test units to a maximum of 15 barg with air or nitrogen under water, checking to ensure a bubble tight seal has been formed between the glass, body and end fitting.

Knock shield assembly

Where protection of the glass against accidental damage is required a Polycarbonate knock shield is available.

1. Place one of the support rings (6) over one end of the sight glass with the lens lip facing inwards.
2. Fit the inner rings inside (1) the outer ring screwing the grub screws (3) through the inner ring clearance holes. Position the ring cluster at the end of the body as illustrated.
3. Fit the Polycarbonate lens (4) over the opposite end of the sight glass.

4. Fit the second ring cluster. Adjust the position of the ring cluster to allow the lens some free movement. Tighten the grub



Part	Material
1 Body	316L stainless steel
2 End fitting	316L stainless steel
3 Glass	Borosilicate
4 Seal	EPDM, Viton, Silicone or FEP-Silicone
5 Inner ring	316L stainless steel
6 Outer ring	316L stainless steel
7 Grub screw	Stainless steel
8 Lens	Polycarbonate

Available spares

Glass (3), seals (4) and lens (8)

Tightening torques

Size	Nm
1/2"	10-12
3/4"	13-15
1"	20-23
1-1/2"	25-28
2"	35-40

Note: This instruction sheet is applicable to the 2-piece HSG02 design with physical stop only. Consult Staitech for information regarding the superseded 2-piece and 3-piece designs.