

REBUILD INSTRUCTIONS



REASSEMBLE:

Use all the new seals, springs, balls and backup rings provided. Lightly lubricate seals with petroleum jelly.

1. Place o-ring and backup ring into groove on outside of the piston. All sizes.



2. Apply Loctite Quicktape#249 to the threads on shaft. Apply 1 – 2 wraps of tape! Liquid Loctite will not be sufficient as it could seep into unwanted areas of the connector. All sizes.



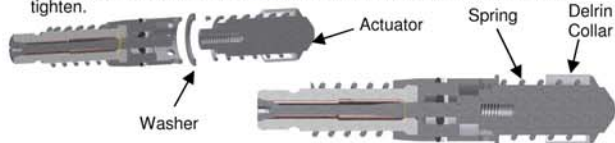
3. Align collets according to the timing line on the O.D. mid section of the collet set. Insert the collets in order into the piston as shown. Use the shaft to center the collets. You may need to work the shaft in and out while inserting the collets to allow them to fall into place. All sizes.



4. Install the small o-ring and back up ring over threaded end of the shaft. Lubricate o-ring with petroleum jelly. **The o-ring and backup ring should be fully inserted into the bore of the piston over the shaft. (Note: The front spring may be placed over the collets to help keep them in place.)**



5. For connectors without body adapters (**size 2**), thread shaft into actuator prior to installing into front body. Use Allen wrench and torque wrench to fully tighten.



6. Place large o-ring into groove on front body (**size 2**). Insert the assembly from step 5 into the front body leaving the ball holes exposed.



7. Coat ball holes with petroleum based jelly. Place balls into holes. Then push actuator forward so balls are slightly inside front body.



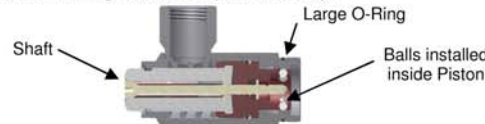
8. For connectors with Body Adaptors (sizes 1, 3 & 4), put the collet, piston, spring and shaft together as done in steps 1, 2, 3 & 4.



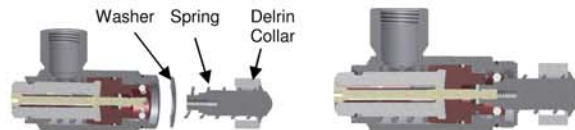
9. Slide the collet assembly into front body until spring hits shoulder inside front body. Apply two to three drops of liquid Loctite #242 to front body threads. Then place adaptor over piston and thread onto front body until tight to front body. (Loctite Quicktape#249 will not work on these threads). **Tighten adaptor to 15 ft/lbs.**



10. Install larger o-ring and coat the inside of the piston ball holes with petroleum jelly. Place all balls into ball holes from inside of the piston. The lube helps contain balls through the final steps of assembly.



11. Place the Delrin collar and spring onto the actuator. Place the washer (**no washer for size 1**) between the spring and adaptor. Using the correct Allen wrench, tighten the shaft and actuator assembly together. (See other side for final steps 12, 13 & 14. Which applies to all body sizes.)



RFNXXXX Rebuild Kit for FN Style Connectors Body Size 1-4

DESCRIPTION: Rebuild Procedure for FN, *FasMate* Series Connectors.

Special Note on Reassemble:

Step 5 & Step 11. When the shaft requires a 3/32" Hex Wrench, torque to 30 in/lbs. When the shaft requires a 7/64" Hex Wrench, torque to 46 in/lbs.

FN with Valve Control



FN with Lever Control



FN with Pneumatic Control



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REBUILD INSTRUCTIONS

DISASSEMBLY:

- 1) Actuate the connector and remove main seal and save.
- 2) Un-thread the back body from connector. (Lever style shown)
- 3) Using an adjustable wrench and Allen wrench remove the shaft from actuator. Some resistance will be felt because loctite is used on shaft threads.



- 4) Remove the collet/piston/shaft assembly from the front body in the direction shown.



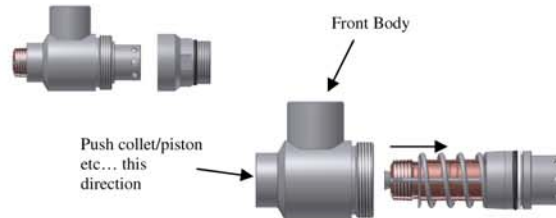
- 5) Remove and discard all seals, backup rings, springs and balls from assembly.
- 6) Push shaft out of piston and collets, this will help with removing o-ring and backup ring from inside piston. **All sizes.**
- 6) Clean all parts prior to re-assembly.

DISASSEMBLY OF FN'S WITH ADAPTORS:

1. Follow steps 1-3 in column to the left.
2. Remove body adaptor with adjustable wrench. Adaptor is installed with a locking/sealing compound, might feel some resistance.

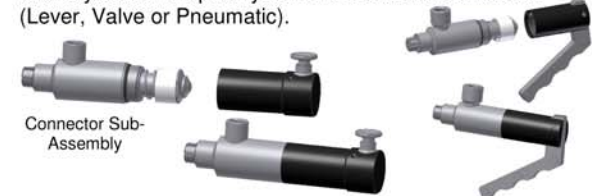


3. With adaptor removed the collet/piston/shaft assembly can be removed by pushed out of the front body as shown.



4. Remove and discard all seals, backup rings, springs and balls from assembly.
5. Clean all parts prior to re-assembly.

12. Now that connector sub-assembly is complete thread which ever style control option you have back onto connector. (Lever, Valve or Pneumatic).



13. Actuate your connector to expose main seal groove in collets and install the main seal over the collets.



14. Actuate connector several times to ensure proper function and movement of the collets.

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