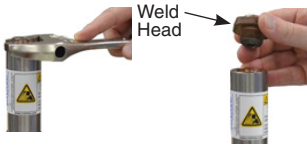


LVDT

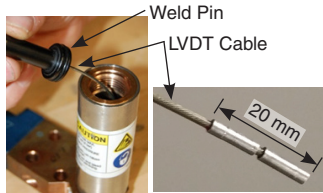
- 1** Remove the air and water services from the system.



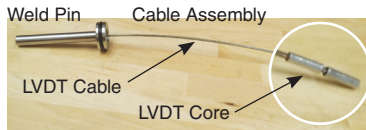
- 2** Unthread and remove the Weld Head.



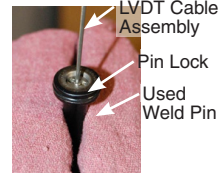
- 3** Gently remove the used Weld Pin from the Weld Body, altogether with the whole LVDT Cable Assembly that is attached at the bottom of the weld pin. Slightly twisting the weld pin while pulling it may help the cable find its way out.



- 4** Inspect the Cable Assembly and ensure that the LVDT Cable has no kinks or bends, and the LVDT Core is intact and in correct position.

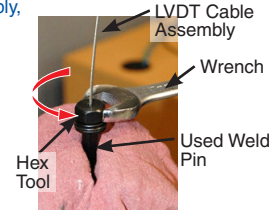


- 5** If the LVDT Cable Assembly and Pin Lock are in good shape, they can be disassembled from the used Weld Pin and reused with a new Weld Pin. Install the used Weld Pin upside down in a vise and continue with step 6 below.

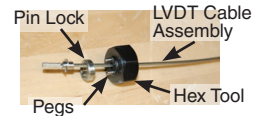


**Otherwise,** if the Weld Pin and LVDT Cable Assembly are being replaced as a whole assembly, go to **step 12**.

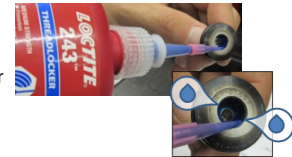
- 6** Slide the Hex Tool over the LVDT Cable and fit its pegs into the holes of the Pin Lock. Using a wrench, rotate the Hex Tool altogether with the Pin Lock to unthread the Pin Lock from the bottom of the old Weld Pin.



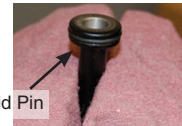
- 7** Set the LVDT Cable Assembly and Pin Lock aside for future use. The Hex Tool can stay on the LVDT Cable Assembly for now. Discard the used Weld Pin. The cable can only be re-used if it is not damaged and in good condition.



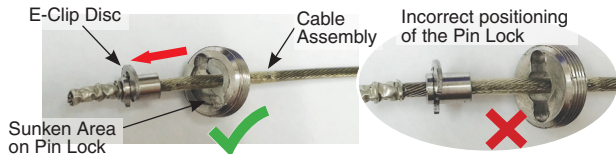
- 8** Check that the Use By date on Loctite 243 has not passed. Thoroughly shake the bottle of Loctite 243 Threadlocker (blue color). Apply one drop of Loctite onto the outer side of the thread of the new weld pin. Then, rotate the weld pin 180° and apply one more drop diametrically opposed.



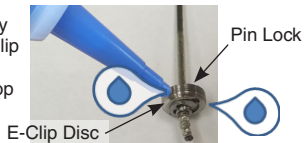
- 9** Place the new Weld Pin upside down into the vise. A soft jaw vise is recommended.



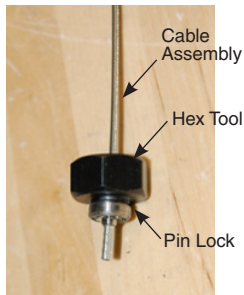
**10** Slide the Pin Lock (sunken side first) onto the Cable Assembly. Ensure that the E-Clip Disc fits properly into the sunken area of the Pin Lock.



**11** Orient the Cable Assembly downward so that the E-Clip Disc stays seated into the sunken area of the Pin Lock. Apply one drop of Loctite 243 Threadlocker (blue color) onto the threads of the Pin Lock. Then, rotate the weld pin 180° and apply one more drop diametrically opposed.



**12** Fit the pegs of the Hex Tool into the holes of the Pin Lock.  
**Note:** To keep all the components in place, keep the cable under tension by gently pulling its other end with your other hand.  
**Very Important:** After the procedure, check that the Pin Lock and the LVDT Cable are tight and do not move or rotate relative to the Weld Pin. The Pin Lock must sit flush or below the base of the Weld Pin. The cable should have no play.



**13** Using a wrench to turn the Hex Tool, thread the Pin Lock (with the Cable Assembly) onto the base of the Weld Pin, being careful not to cross the threads. Wipe off any excess Loctite.  
**Note:** Do not over tighten! Maximum 30 in./lbs (3.4 Nm).

**VERY Important:** After the procedure, check that the Pin Lock and the LVDT Cable are tight and do not move or rotate relative to the Weld Pin. The Pin Lock must sit flush or below the base of the Weld Pin. The cable should have no play.

**14** Use a marker to place a mark across the Pin Lock and base of the Weld Pin. The mark will provide an indication of the Pin Lock loosening during use.

**15** Apply a small amount of grease to the O-ring on the new Weld Pin. Magnalube-G grease is recommended. Then, remove the Weld Pin from the vise.

**16** Gently insert and fully slide the LVDT Cable Assembly through the hole in the bottom center of the Weld Body, until the Weld Pin will properly sit inside the Weld Body. During this process, slightly twisting the cable or using needle nose pliers may help to gently guide the LVDT Cable Assembly through the hole.

**17** Ensure that the Weld Pin moves freely up and down inside the Weld Body (with no constraint from the LVDT Cable Assembly). Then, thread on the Electrode Head and tighten to the corresponding torque (according to the weld body series):  
 15 ft/lbs. – for Series 2 weld bodies  
 30 ft/lbs. – for Series 3 weld bodies  
 100 ft/lbs. – for Series 4 weld bodies

