

RADIATORI 2000 PLUS ASSEMBLY GUIDE



Before Assembly

ASSEMBLY PREPARATION

Place all parts on a flat surface.

Ensure all machined faces and internal threads are clean.

PARTS REQUIRED

There are two joints to be made for each pair of sections. Each requires one connection nipple and one gasket. A nipple key and tommy bar are required to rotate and tighten the connections.

CONNECTIONS

Each section has right-handed connections at one end and left-handed ones at the other. Nipples have one end left handed and one right handed. Determine the orientation of connections before assembly.



Assembly

ATTACHING THE NIPPLES TO THE FIRST SECTION

Screw a pair of nipples into one end of the radiator.

Only screw in by one turn, do not screw in fully.

Place a gasket approximately at the mid-point of each nipple.

Do not use any jointing paste or tape (PTFE or similar) to the gasket, nipple threads or radiator.



ALIGNING THE SECTIONS

Carefully slide the second section next to the first so that the nipples align with the connections correctly.



CONNECTING THE SECTIONS

Mark how far to insert the nipple key by placing it over the top of the radiator so that the end aligns with the nipples to be turned. Slide the key in from the open end of the waterway until it engages into the nipple that needs tightening. Keep the key as parallel to the floor as possible for easier insertion; forcing the key will jam it in the waterway. Once the key is inserted enough, check the end of the key has fully engaged in the internal lugs inside the nipple.



One turn at a time, rotate the nipple using the nipple key. This will pull the two sections together. After one turn, repeat with the other nipple. Continue to alternate between the nipples, one turn at a time, until the two sections are pulled together. It is important to keep the sections parallel to one another.



When the sections are connected, tighten the joints so the gaskets are firmly compressed. A tightening torque of 100 lbf-ft must be applied.

Do not test with air.