





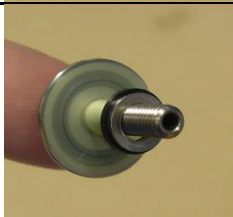





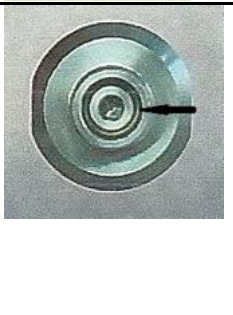





Installation of traditional VITROVEX vacuum ports

1.		<p>Inspect drill hole and vacuum port (vp) with o-ring(s) carefully for any damages, it is recommended to lubricate the o-ring(s) slightly before use.</p> <p>Do NOT install a vp, if spot face or edges around the drill hole show any sign of scratches or chipping.</p>
2.1		<p><u>For P/N 790260:</u></p> <p>Lubricate O-Ring $\varnothing 10,82 \times 1,78$ slightly and put it into the groove.</p>
2.2.1		<p><u>For P/N 790262L:</u></p> <p>Lubricate O-Ring $\varnothing 8 \times 1,5$ slightly and put it into the groove.</p>
2.2.2		<p>Lubricate O-Ring $\varnothing 14 \times 1,5$ slightly and put it into the groove.</p>
2.		<p>Carefully place the vp into the drill hole so that the o-ring is seated on top of the spot face and while holding it in place, follow the two steps below:</p>
3.		<p>a) Pull the plastic disc over the threaded shaft...</p>
4.		<p>b) ...followed by the stainless steel washer and push both gently towards the glass.</p>



5.		<p>Place M5 stainless steel nut onto the threaded shaft and lightly tighten it. When the whole assembly is nearly fixed, center the vp and finally tighten it using a force of 1Nm.</p>
6.		<p>Counter with second M5 stainless steel nut.</p>
7.1		<p><u>For P/N 790260:</u></p> <p>Place o-ring size 3x1 over the shaft of the Allen screw and insert the Allen screw into the appropriate opening on top of the vp.</p> <p>Please do NOT lubricate this o-ring.</p>
7.2.1		<p><u>For P/N 790262L:</u></p> <p>Fit o-ring size 6x1,5 into the lower groove of the Allen screw</p>
7.2.2		<p>Place o-ring size 4x1 over the shaft of the Allen screw and insert the Allen screw into the appropriate opening on top of the vp.</p> <p>Please do NOT lubricate this o-ring.</p>
8.		<p>Tighten the Allen screw with a force of 0.2 Nm.</p> <p>Alternatively you can tighten the Allen screw with the following procedure: Insert the screw with o-ring until you just feel the screw starts to touch the o-ring. Then turn the screw another 270 to 300 degree to tighten it. The variation (30°) depends on your sensibility to recognize the point when the screw starts to touch the ring. If only two fingers are used to hold the screw driver while softly screwing the Allen screw in, it should be quite easy to determine the point where the resistance starts.</p>
9.1		<p><u>For P/N 790262L:</u></p> <p>Install the o-ring size 10x1 at the outside of the vp into the groove provided for that purpose.</p>