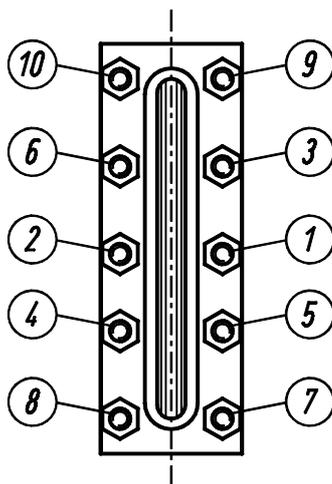


## INSTRUCTION MANUAL FOR WELDING SIGHT GLASSES SERIES RJB – TJB

1. If the sight glass is pre-assembled with glass and gaskets, remove the cover, the seals, the glass and the gaskets.
2. Use the sight glass as a reference and mark the tank wall at the top and bottom end of the milling by using a pencil.
3. Make two holes in the wall of the tank at the top and bottom end of the opening of the welding sight glass (make two holes for the single-section model, four holes for the two-section model and so on) using a 15 mm drill.
4. Before welding, it is recommended to insert a steel spacer between the sight glass and the cover and tighten the screws at 30 – 35 Nm.  
Do not use the gaskets at this stage. The cover screwed to the body makes it stiffer and thus minimizes any possible distortion of the gasket seat due to the weld heating.  
**FOR A GOOD TIGHTNESS AND EXCELLENT PERFORMANCE, THE GASKET SEAT SHALL REMAIN FLAT AFTER THE WELDING.**
5. Put the sight glass in place and weld properly all around the perimeter.
6. Let the assembly cool, and then remove the screws and the spacer.
7. If necessary, you may now obtain an opening in the tank wall next to the opening of the sight glass itself. This is a need that shows up in the case of transparency sight glasses.
8. Clean the seat of the gasket making sure that there is no welding waste.
9. Assemble glass, gaskets and cover as shown in the annexed drawing.
10. Tighten the screws with a torque of 30 Nm following a sequence as shown in figure 1.

Figure 1.

Tightening sequence



Coding: RJB.17.A.J.xx

Model: RJB (reflection version)

Size: 17 (sight 256mm)

Cover material: A (Carbon steel)

Body mat.: J (aisi 316)

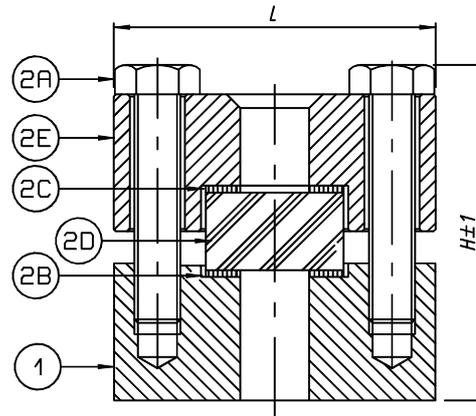
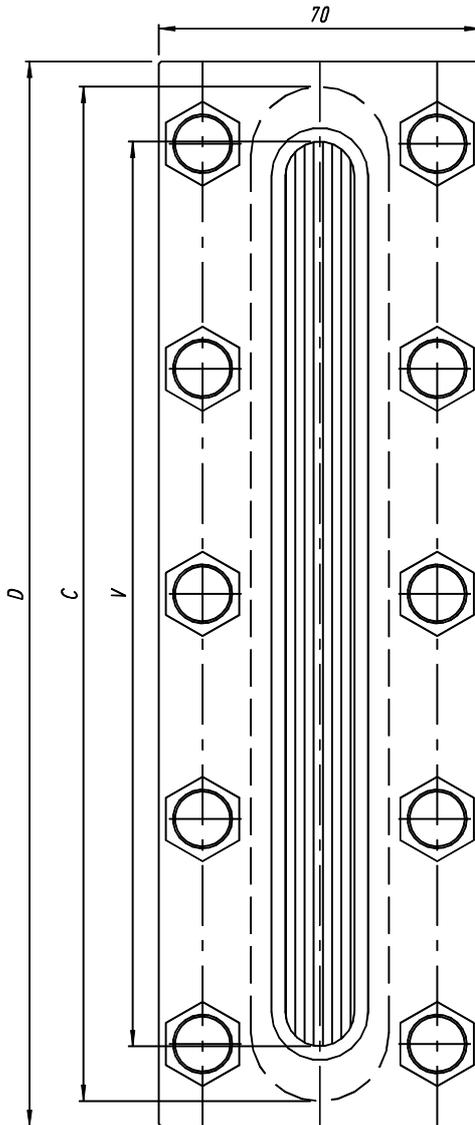
XX (Non-STD version)

## INSTRUCTION MANUAL FOR WELDING SIGHT GLASSES SERIES RJB – TJB

### DIMENSIONAL DRAWING

RJB version with reflective crystals

TJB version with transparent crystals



MIS 38	999	961	320	70	75
MIS 37	879	841	280	70	75
MIS 36	789	751	250	70	75
MIS 29	706	668	340	70	75
MIS 28	666	628	320	70	75
MIS 27	586	549	280	70	75
MIS 26	526	489	250	70	75
MIS 25	466	427	220	70	75
MIS 24	406	367	190	70	75
MIS 19	353	313	340	70	75
MIS 18	333	296	320	70	75
MIS 17	293	256	280	70	75
MIS 16	263	226	250	70	75
MIS 15	233	196	220	70	75
MIS 14	203	166	190	70	75
MIS 13	178	141	165	70	75
MIS 12	153	116	140	70	75
MIS 11	128	91	115	70	75
MODELLO MODEL	D	V	C	L	H

- 1 BODY
- 2A SCREW M10x50
- 2B GASKET
- 2C PROTECTION
- 2D CRYSTAL
- 2E PLATE