

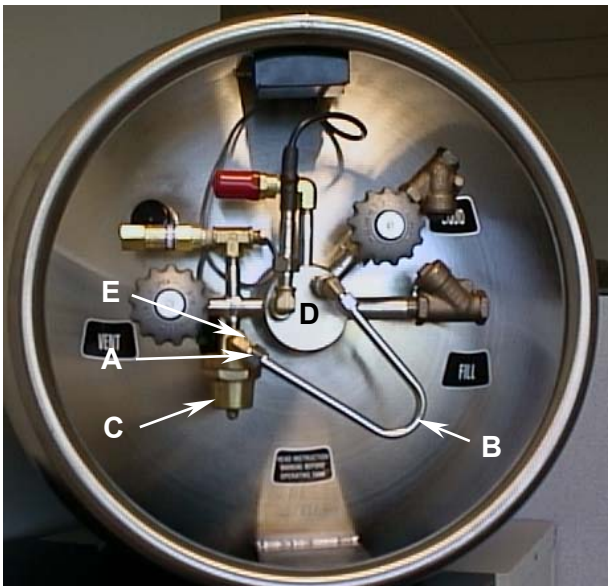


**ECONOMIZER REPLACEMENT
PROCEDURE**

Caution:

Follow all LNG safety guidelines and procedures when working with LNG systems and components.

1. Completely drain vehicle tank(s) of liquid in accordance with station procedures.
2. Completely vent tank(s) in accordance with station vehicle tank venting procedures.
3. Once all fuel (liquid and vapor) has been removed from vehicle tanks, close hand valves and disconnect de-fueling hoses to prevent moisture from entering tanks.
4. Position vehicle in a non-enclosed well ventilated area.
5. Shut down all vehicle electrical systems.
6. Carefully loosen fitting (A) on stainless steel u-tube (B). Use an open-end wrench to loosen fitting. Allow some threads to remain engaged.



7. Loosen stainless steel u-tube (B) by moving and wiggling it enough to break it loose from fitting swage. If excessive amounts of vapor are found, go back to Step 2.
8. Remove stainless steel u-tube (B) from economizer (C) and tank knuckle (D).
9. Remove brass 90-degree elbow (E) from economizer (C). Be careful not to damage the threads with the wrench.
10. Remove economizer (C) from tank knuckle (D).
11. Verify the set point of the economizer regulator being installed (Refer to procedure VT-0003). It is recommended that threads be marked to clearly show any adjustment away from the set point. Economizer set point is determined by engine type.
12. Clean threads of all old sealant, dirt, and debris that could potentially inhibit a good seal. It may be necessary to chase threads with an appropriate die. Wipe threads clean of any oil or grease.
13. Apply suggested thread sealant (NexGen Fueling Part numbers 11061546 (Loctite Primer #7649) and AAA1066 (Loctite Hydraulic Sealant #569).
14. Install and tighten new economizer (C) into place on knuckle (D). Ensure threaded hole of economizer faces proper direction.
15. Sparingly apply sealant onto pipe-threaded end of 90-degree brass elbow (E). Ensure sealant is not dripping into lines and fittings.
16. Thread brass elbow (E) into economizer (C) and tighten into place so u-tube (B) lines up properly with the fitting on knuckle (D).

This procedure is for use by trained mechanics experienced with using Liquefied Natural Gas systems and vacuum technology. Review all pertinent safety documents before starting this procedure.



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17. Install u-tube (B). Tighten compression fitting nuts on with fingers only until threads are started on both ends of u-tube. Tighten into place snugly with two wrenches (do not over tighten). Do not apply any sealant to compression fittings.
18. Allow sealant to dry.

Note:

Sealant treated with primer must be allowed to cure and dry for a minimum of 4 hours before being exposed to pressure and cryogenic temperatures. If primer is not used, the cure time is then increased to a minimum of 24 hours.

19. Pressure test system and check for leaks.
20. Repair as necessary.

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