

TECH NOTE

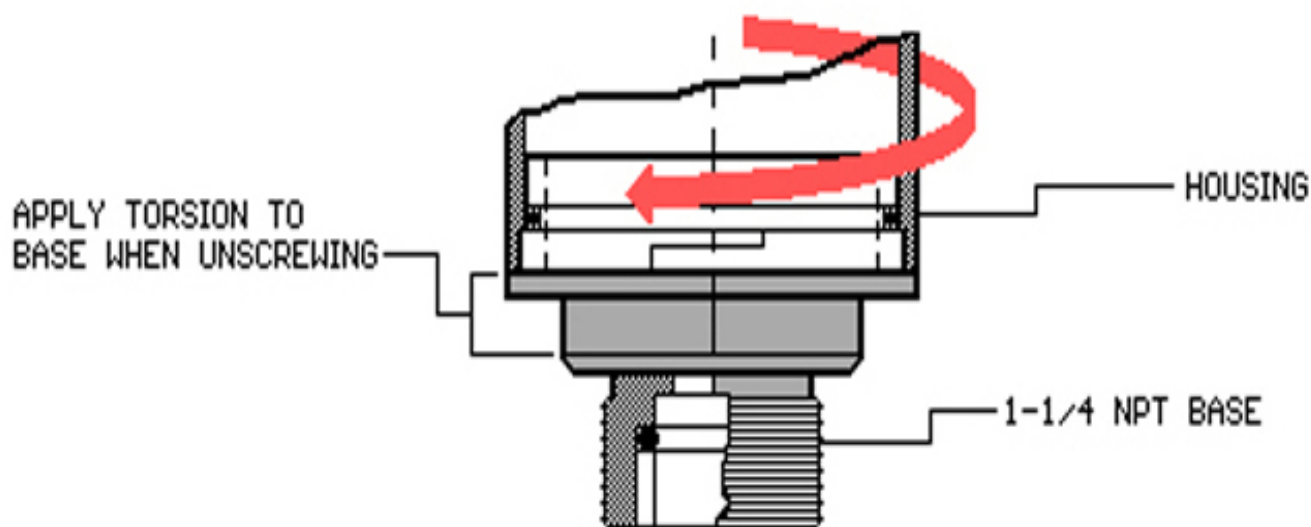
TN-112 – 1-1/4 Relay Hsg Cam Lock Attachment

The attachment mechanism of the 20-725, 20-725-HS, and 10-701-XX relay and control head housings has some tricky aspects. The base is attached to the relay housing by a rotating cam lock mechanism. The interface between the two parts is sealed by an O-ring. It is a precision, close-fitting assembly.

The O-ring adds considerable friction and makes the assembly process difficult. A light coat of silicone lubricant applied to the O-ring and the mating surfaces reduces this friction to a tolerable level.

The cam lock/O-ring seal feature allows access to whatever is inside the housing. When access is not desired, parts can be sealed and glued together with ABS cement.

If the assembly is not glued together, it is important to apply torsion to the base and not the housing should it be necessary to unscrew the assembly from the tank or piping. If torsion is applied to the housing, the cam lock may disassemble. The cam lock is not affected when screwing the assembly in.



Cam lock assembly showing correct torsion application direction. Apply torque to the 1-1/4 NPT base (bottom) when unscrewing from tank or piping. Never apply torque to the housing — the cam lock will disassemble.

Critical Assembly Note

Always apply unscrewing torque to the base, not the housing. Use silicone lubricant on the O-ring before assembly. For permanent sealed installations, bond with ABS cement after confirming correct orientation.