

**INSTALLATION INSTRUCTION FOR**  
**TYPE 105 & 205 SADDLE SEAL**

When installing a Type 105 or Type 205 Ashcroft saddle type diaphragm seal into a process line, care must be taken to adhere to good welding practices.

The instrument/seal assembly must never be welded in line as a complete seal. The seal fill fluid diaphragm could become overheated and the diaphragm distorted. The proper installation procedure is as follows:

- 1) Remove the 8 cap screws connecting the top housing to the bottom housing and set aside the instrument/top housing diaphragm ring, sleeve and cap screw for later reassembly.
- 2) A heat sink, such as a wet cloth or towel, should be placed on top of the bottom housing prior to welding it in line. This will prevent any heat distortion of the top surface of the bottom housing.
- 3) After the welded in bottom housing has cooled to room temperature, reinstall the instrument/seal top housing and torque the cap screws holding the diaphragm ring to the housing to 10 ±3 foot pounds.