

SPECIFIC RETUBE INSTRUCTIONS
7 TO 25 H.P. PARKER INDUSTRIAL HORIZONTAL DRUM STEAM BOILER

CAREFULLY REVIEW THE **GENERAL RETUBE INSTRUCTION BULLETIN GRI 101-5** BEFORE STARTING TO REPAIR. ALSO REFER TO **SPECIFIC RETUBE INSTRUCTION AND BAFFLE PLACEMENT DRAWING**. READ THROUGH THESE INSTRUCTIONS THOROUGHLY.

1. Turn off gas and electricity and blow boiler down to zero pressure.
2. Cabinet must be removed for retubing. The cabinet is a two section model and can be removed as follows:
 - A. Disconnect the following:
 - (1) Water Column and Switch Connections.
 - (2) Blowdown and Water Feed Lines.
 - (3) Steam Line.
 - (4) Safety Valve.
 - (5) Electrical.
 - (6) Vent Stack.
 - (7) Water Feed Line and Boiler Feed System/Condensate Tank if Kompact Model.
 - B. Remove Cabinet:
 - (1) Take sheet metal screws out of top cover and lift off.
 - (2) Take off the top insulation sheet and top inner liner.
 - (3) Remove the bolts attaching the frame to the bottom of the Kompact cabinet.
 - (4) Pull the cabinet apart in the center and lift off.
3. Be careful not to damage burners. All T64T9S burners should be removed and cleaned. Orfices should be cleaned with #42 drill bit on Natural Gas or #55 for Propane.
4. Boiler Tube Set consists of two tube sections each attached with two union connections.
5. Remove all of the tube baffles and braces. Disconnect the two unions to remove the tubes. Remove one section of tubes at a time.
6. Remove burner stringer assembly/disconnect steam drum downcomer unions and remove drum.
7. Thoroughly test and clean the steam drum as outlined in General Retube Instruction Bulletin GRI 101-5 steps #11-14.
8. When retubing the boiler, the downcomer nipples, mud leg, water feed inlet, gas baffles, and all other internal piping should be completely replaced. This is furnished with the complete tube set. The steam drum **MUST** be thoroughly cleaned per General Retube Instruction Bulletin GRI 101-5 steps #11-12.
9. Carefully review Drwg. RT-103 and install lower tube section with unions furthest from the level control.
10. Install upper tube section. Unions are nearest the level control.
11. Boiler equipped with baffles and tube braces must be installed exactly as originally furnished. Baffles incorrectly installed may be hazardous. For correct placement, see Drawing RT-103.
12. The new tubes should be securely fastened and all fittings properly connected.
13. Boiler should be hydrostatically tested before re-installing the cabinet. In re-assembling the boiler, carefully review Basic Instruction II of General Retube Instruction Bulletin GRI 101-5. **VERY IMPORTANT**.

NOTE: All pipe fittings should be properly lubricated with a teflon tape or steam rated pipe dope to assure a satisfactory installation.