

1. Align waveguide flanges to be joined to ensure they will mate in a flush, parallel and uniform manner.
2. Clean the mating waveguide and their flange faces to make them free of dust, metal chips, grease or other contamination.
3. Remove the Megaseal from its packaging making certain that it is kept clean.
4. Megaseal Gasket may be coated with a Silicone Grease lubricant such as Dow Corning DC-4 or equivalent.
5. Place Megaseal between flanges and insert flange bolts. Use two or more bolts to help align the flanges and gasket. Do not twist or laterally slide the gasket as this may damage the seal.
6. Install hardware hand tight making sure to keep flange faces even & parallel.
7. Once all hardware is in place, use the tightening sequence shown on the outline drawing below to slowly and uniformly increase the torque on the flange bolts.
8. Tighten each bolt one half turn at a time following that sequence until the desired torque for the mounting hardware is reached. 15.0 ft-lbs (20.5 N-m).

