



# Production Control Units, Inc.

2280 West Dorothy Lane, Dayton, Ohio 45439-1892

Phone (937) 299-5594 FAX: (937) 299-4843

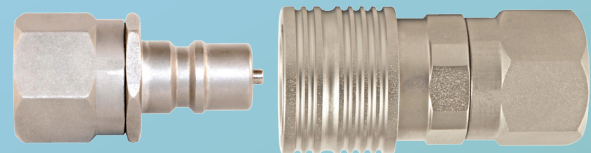
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## SERVICE BULLETIN

### for

## Series 250 Two-Way Shutoff Valved Nipples and Couplers

## Models 64 and 65



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# Production Control Units, Inc.-Coupler Products

2280 West Dorothy Lane, Dayton, Ohio 45439-1892 USA - Phone (937) 299-5594 - FAX: (937) 299-4843  
PCU Web Site: [www.pcuinc.com](http://www.pcuinc.com) - E-mail: [couplers@pcuinc.com](mailto:couplers@pcuinc.com)

## Coupler Application Data Inquiry

Company \_\_\_\_\_ Phone # \_\_\_\_\_

Contact \_\_\_\_\_ Fax # \_\_\_\_\_

Address \_\_\_\_\_ E-mail \_\_\_\_\_

City \_\_\_\_\_ State \_\_\_\_\_ Country \_\_\_\_\_ Zip \_\_\_\_\_

Type & brand name for current coupler \_\_\_\_\_

Customer product manufactured \_\_\_\_\_

### Type of coupler required

Size and type of tube or port to be sealed \_\_\_\_\_

☐ Straight ☐ Swaged ☐ Expanded ☐ Other \_\_\_\_\_

Length of tube or port available for coupler \_\_\_\_\_

Quantity required \_\_\_\_\_

Delivery due date \_\_\_\_\_

### How will the coupler be used?

Refrigerant processing

What type of refrigerant? (HFC-134a, HP62, R-22, etc.) \_\_\_\_\_

Oil processing

What type of oil (Mineral, Polyol Ester, PAG, etc.) \_\_\_\_\_ (Attach MSDS)

Leak Burst testing

Maximum pressure & type of test media? (Air, Helium, etc.) \_\_\_\_\_

Vacuum

What level of vacuum needs to be achieved? \_\_\_\_\_

What Oil be present during vacuum pump down? \_\_\_\_\_

If "yes", what type of oil? \_\_\_\_\_

### Additional process information

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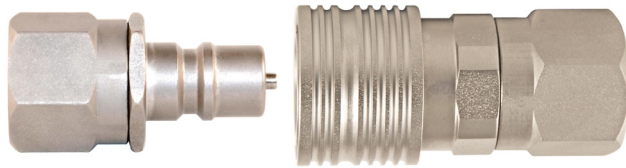
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Along with your request for quote, please provide (1) copy of print showing area to be sealed, and (3) quality sample parts.

NOTE: The Data Inquiry form is available in pdf format on our web site at

[www.PCUInc.com](http://www.PCUInc.com)



## GENERAL DESCRIPTION

Models 64 and 65 Series 250 is the same flow and internal components as Models 61 and 62 however it is NOT interchangeable. Use these models when there are two fluids or more which should not be mixed. Models 64 and 65 are nickel plated for color difference from Models 61 and 62 which are black in color.

These tough, compact, lightweight PCU couplers utilize heat-treated parts for interchangeability and long life oxide and nickel finishes resist corrosion. They provide a large, unrestricted flow rate for a variety of production uses while minimizing process material loss during coupling/uncoupling.

An eight (8) ball detent lock provides instant positive coupling. Simply pull back the grooved locking ring on the coupler, slide the coupler over the Nipple and push together until the lock ring snaps to it's "lock position".

Because of the unique design of the Series 250 Couplers and Nipple assemblies, they are able to be built using inexpensive O-ring seals which provide positive leak-tight shutoff. They will hold pressure from vacuum to 1000 psig.

## COUPLER FEATURES & SPECIFICATIONS

**SAFE:** Positive ball-lock action prevents blow-off or premature loss of sealed connection.

**STRONG:** Holds pressures from 25 microns up to 1000 psig, minimum proof pressure 4000 psig.

**MANY APPLICATIONS:** Seal compounds can be easily changed for many uses with oils, refrigerants, water, air, and vacuum.

The standard Series 250 Coupler and Nipple assembly can be built with a variety of seal compounds to satisfy your application. Neoprene compound is generally used for R-22, R410, R404a and compressed air. Buna-N is generally used for HFC-134a with lubricants.

## MAINTENANCE INSTRUCTIONS

Coupler life is dependent upon a regular scheduled maintenance program. The application and its risk potential should determine frequency. PCU cannot determine a maintenance schedule due to the many factors involved: temperature, proper size selection, fluid compatibility, pressure, mechanical loads, user responsibility. User must establish a maintenance program based on previous service life. There are several factors that must be included when setting up a maintenance program: visual inspection for cracked, defective parts and excessively worn components; dirt or particle buildup in seal and clamping areas; thorough cleaning and proper lubrication; replace worn out and defective seals.

## SERIES 250 TWO-WAY SHUTOFF VALVED COUPLERS AND NIPPLES

The basic Series 250 Two-Way Shutoff Valved coupler, less end cap adapter, consists of thirteen parts and the basic Series 250 Two-way Shutoff Valved Nipple, less end cap adapter, consists of eight parts, both of which must be assembled in correct order to assure proper functioning of the unit. Although all units are tested in our plant at 1000 psig air and less than 50 microns vacuum, Production Control Units, Inc. cannot be responsible for any malfunction of the Series 250 Coupler or Nipple due to faulty servicing of the unit in the field by people other than PCU field engineers.

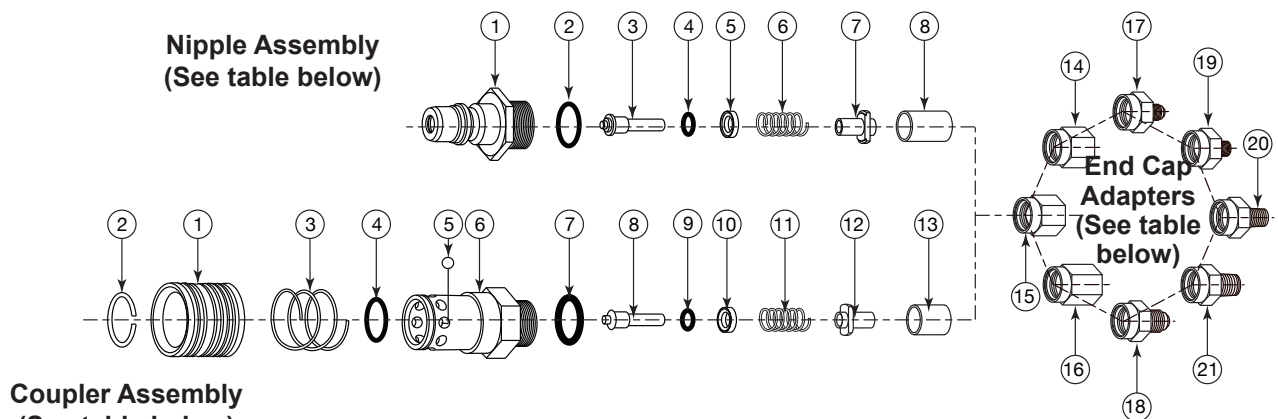
NEOPRENE SEALS

NIPPLE  
ASSEMBLY

64N111	64N211	64N311	64N131	64N231	64N331	64N221	64N321
1/8" FPT ADAPTER	1/4" FPT ADAPTER	3/8" FPT ADAPTER	1/8" MPT ADAPTER	1/4" MPT ADAPTER	3/8" MPT ADAPTER	1/4" SAE FL ADAPTER	3/8" SAE FL ADAPTER

COUPLER  
ASSEMBLY

65N111	65N211	65N311	65N131	65N231	65N331	65N221	65N321
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End Cap Adapters			
14.	61N876 - 1/8" FPT	18.	61N821 - 3/8" SAE FL
15.	61N830 - 1/4" FPT	19.	61N868 - 1/8" MPT
16.	61N869 - 3/8" FPT	20.	61N845 - 1/4" MPT
17.	61N829 - 1/4" SAE FL	21.	61N870 - 3/8" MPT

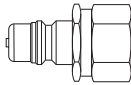
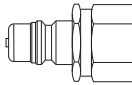
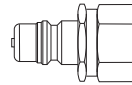
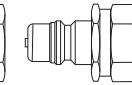
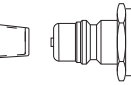
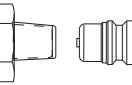
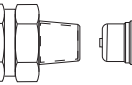
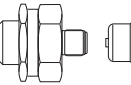
REPLACEMENT PARTS LIST

Nipple Assembly NEOPRENE SEALS		
1.	Nipple Body	102640-001
2.	End Cap O-Ring	61822
3.	Nipple Valve Stem	61N844
4.	Valve O-Ring	61843
5.	O-Ring Retainer	61840
6.	Nipple Valve Spring	61804
7.	Perch	61825
8.	Nipple Spacer	61824

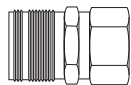
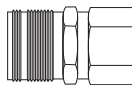
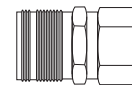
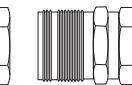
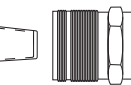
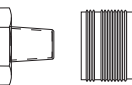
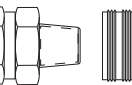
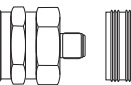
Coupler Assembly NEOPRENE SEALS		
1.	Coupler Sleeve	61N831
2.	Retaining Ring	61832
3.	Coupler Sleeve Spring	61801
4.	O-Ring	102417-1
5.	Ball (8) Req'd	61833
6.	Coupler Body	102416-004
7.	End Cap O-Ring	61822
8.	Coupler Valve Stem	61N863
9.	Valve O-Ring	61843
10.	O-Ring Retainer	61840
11.	Coupler Valve Spring	61802
12.	Perch	61825
13.	Coupler Spacer	61837

**BUNA-N (NITRILE) SEALS**

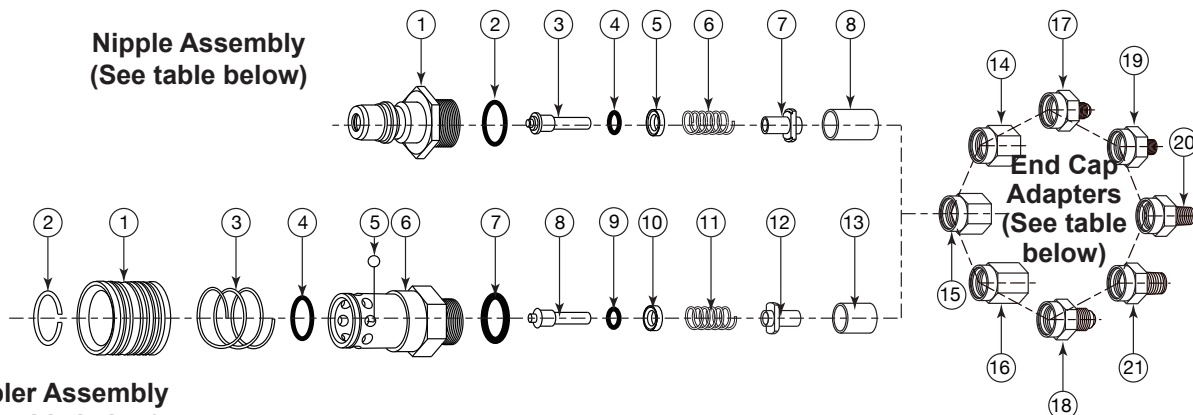
NIPPLE  
ASSEMBLY

64N112	64N212	64N312	64N132	64N232	64N332	64N222	64N322
							
1/8" FPT ADAPTER	1/4" FPT ADAPTER	3/8" FPT ADAPTER	1/8" MPT ADAPTER	1/4" MPT ADAPTER	3/8" MPT ADAPTER	1/4" SAE FL ADAPTER	3/8" SAE FL ADAPTER

COUPLER  
ASSEMBLY

65N112	65N212	65N312	65N132	65N232	65N332	65N222	65N322
							

**Nipple Assembly**  
(See table below)



**Coupler Assembly**  
(See table below)

**End Cap Adapters**

14. 61N876 - 1/8" FPT	18. 61N821 - 3/8" SAE FL
15. 61N830 - 1/4" FPT	19. 61N868 - 1/8" MPT
16. 61N869 - 3/8" FPT	20. 61N845 - 1/4" MPT
17. 61N829 - 1/4" SAE FL	21. 61N870 - 3/8" MPT

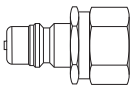
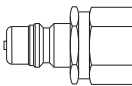
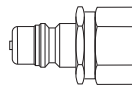
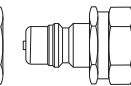
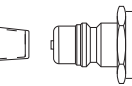
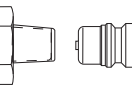
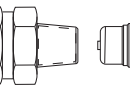
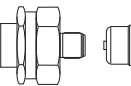
**REPLACEMENT PARTS LIST**

Nipple Assembly BUNA-N (NITRILE) SEALS		
1.	Nipple Body	102640-001
2.	End Cap O-Ring	61846
3.	Nipple Valve Stem	61N844
4.	Valve O-Ring	61847
5.	O-Ring Retainer	61840
6.	Nipple Valve Spring	61804
7.	Perch	61825
8.	Nipple Spacer	61824

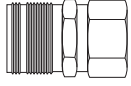
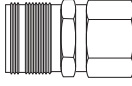
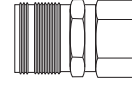
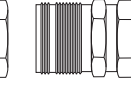
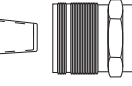
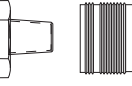
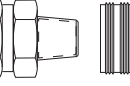
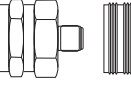
Coupler Assembly BUNA-N (NITRILE) SEALS		
1.	Coupler Sleeve	61N831
2.	Retaining Ring	61832
3.	Coupler Sleeve Spring	61801
4.	O-Ring	102417-2
5.	Ball (8) Req'd	61833
6.	Coupler Body	102416-004
7.	End Cap O-Ring	61846
8.	Coupler Valve Stem	61N863
9.	Valve O-Ring	61847
10.	O-Ring Retainer	61840
11.	Coupler Valve Spring	61802
12.	Perch	61825
13.	Coupler Spacer	61837

FLUOROCARBON SEALS

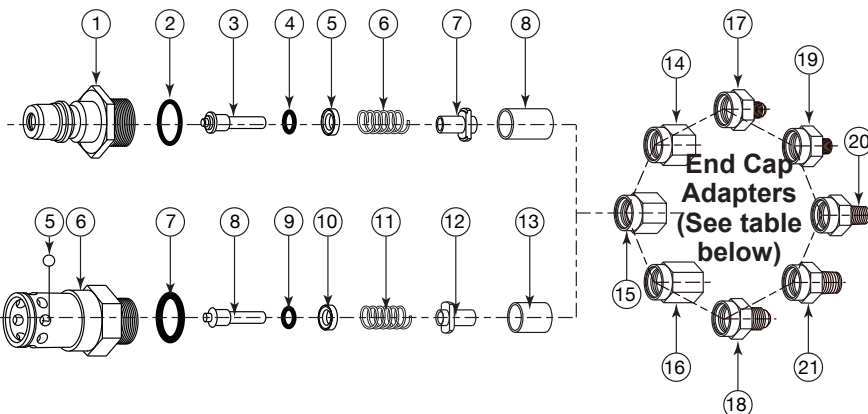
NIPPLE  
ASSEMBLY

64N113	64N213	64N313	64N133	64N233	64N333	64N223	64N323
							
1/8" FPT ADAPTER	1/4" FPT ADAPTER	3/8" FPT ADAPTER	1/8" MPT ADAPTER	1/4" MPT ADAPTER	3/8" MPT ADAPTER	1/4" SAE FL ADAPTER	3/8" SAE FL ADAPTER

COUPLER  
ASSEMBLY

65N113	65N213	65N313	65N133	65N233	65N333	65N223	65N323
							

Nipple Assembly  
(See table below)



Coupler Assembly  
(See table below)

End Cap Adapters

14. 61N876 - 1/8" FPT	18. 61N821 - 3/8" SAE FL
15. 61N830 - 1/4" FPT	19. 61N868 - 1/8" MPT
16. 61N869 - 3/8" FPT	20. 61N845 - 1/4" MPT
17. 61N829 - 1/4" SAE FL	21. 61N870 - 3/8" MPT

REPLACEMENT PARTS LIST

Nipple Assembly FLUOROCARBON SEALS		
1.	Nipple Body	102640-001
2.	End Cap O-Ring	61852
3.	Nipple Valve Stem	61N844
4.	Valve O-Ring	61853
5.	O-Ring Retainer	61840
6.	Nipple Valve Spring	61804
7.	Perch	61825
8.	Nipple Spacer	61824

Coupler Assembly FLUOROCARBON SEALS		
1.	Coupler Sleeve	61N831
2.	Retaining Ring	61832
3.	Coupler Sleeve Spring	61801
4.	O-Ring	102417-3
5.	Ball (8) Req'd	61833
6.	Coupler Body	102416-004
7.	End Cap O-Ring	61852
8.	Coupler Valve Stem	61N863
9.	Valve O-Ring	61853
10.	O-Ring Retainer	61840
11.	Coupler Valve Spring	61802
12.	Perch	61825
13.	Coupler Spacer	61837



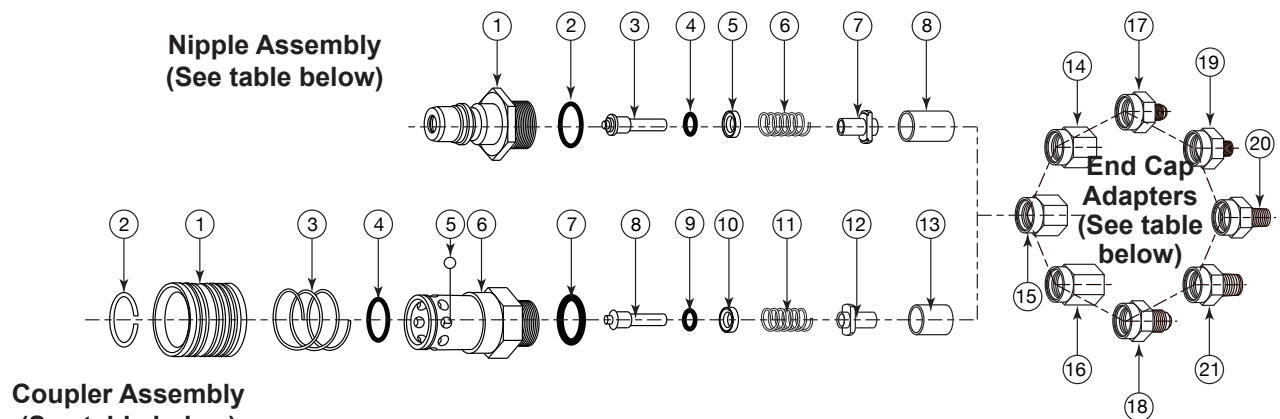
**R410a (NEOPRENE) SEALS**

NIPPLE  
ASSEMBLY

64N115	64N215	64N315	64N135	64N235	64N335	64N225	64N325
1/8" FPT ADAPTER	1/4" FPT ADAPTER	3/8" FPT ADAPTER	1/8" MPT ADAPTER	1/4" MPT ADAPTER	3/8" MPT ADAPTER	1/4" SAE FL ADAPTER	3/8" SAE FL ADAPTER

COUPLER  
ASSEMBLY

65N115	65N215	65N315	65N135	65N235	65N335	65N225	65N325
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End Cap Adapters			
14.	61N876 - 1/8" FPT	18.	61N821 - 3/8" SAE FL
15.	61N830 - 1/4" FPT	19.	61N868 - 1/8" MPT
16.	61N869 - 3/8" FPT	20.	61N845 - 1/4" MPT
17.	61N829 - 1/4" SAE FL	21.	61N870 - 3/8" MPT

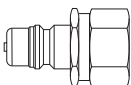
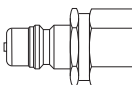
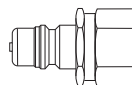
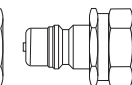
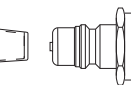
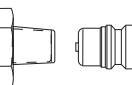
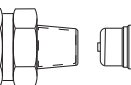
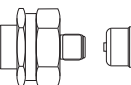
**REPLACEMENT PARTS LIST**

Nipple Assembly NEOPRENE SEALS		
1.	Nipple Body	102640-001
2.	End Cap O-Ring	61822
3.	Nipple Valve Stem	61N844
4.	Valve O-Ring	OR010-C1278
5.	O-Ring Retainer	61840
6.	Nipple Valve Spring	61804
7.	Perch	61825
8.	Nipple Spacer	61824

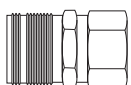
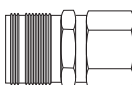
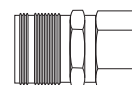
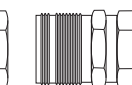
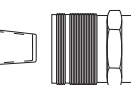
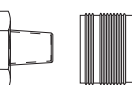
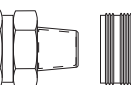
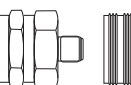
Coupler Assembly NEOPRENE SEALS		
1.	Coupler Sleeve	61N831
2.	Retaining Ring	61832
3.	Coupler Sleeve Spring	61801
4.	O-Ring	OR113-C1278
5.	Ball (8) Req'd	61833
6.	Coupler Body	102416-004
7.	End Cap O-Ring	61822
8.	Coupler Valve Stem	61N863
9.	Valve O-Ring	OR010-C1278
10.	O-Ring Retainer	61840
11.	Coupler Valve Spring	61802
12.	Perch	61825
13.	Coupler Spacer	61837

EPDM SEALS

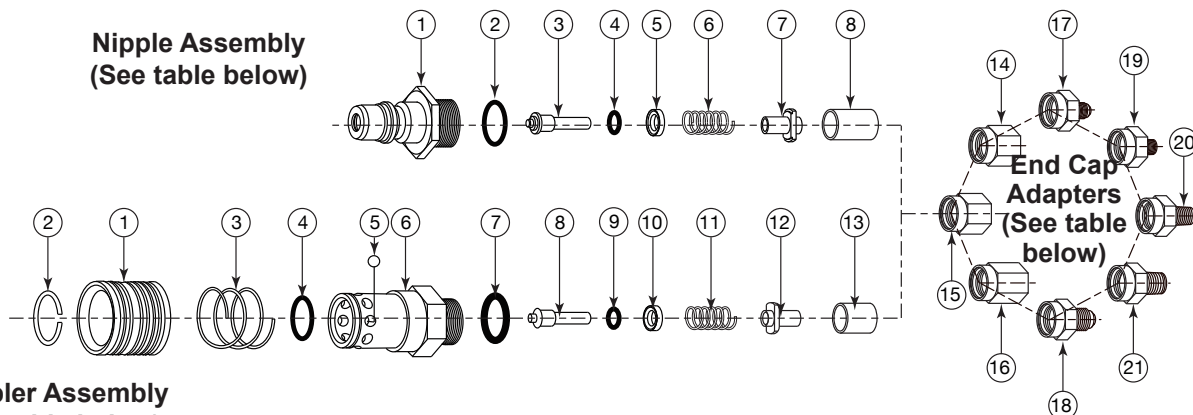
NIPPLE  
ASSEMBLY

64N116	64N216	64N316	64N136	64N236	64N336	64N226	64N326
							
1/8" FPT ADAPTER	1/4" FPT ADAPTER	3/8" FPT ADAPTER	1/8" MPT ADAPTER	1/4" MPT ADAPTER	3/8" MPT ADAPTER	1/4" SAE FL ADAPTER	3/8" SAE FL ADAPTER

COUPLER  
ASSEMBLY

65N116	65N216	65N316	65N136	65N236	65N336	65N226	65N326
							

Nipple Assembly  
(See table below)



Coupler Assembly  
(See table below)

End Cap Adapters

14. 61N876 - 1/8" FPT	18. 61N821 - 3/8" SAE FL
15. 61N830 - 1/4" FPT	19. 61N868 - 1/8" MPT
16. 61N869 - 3/8" FPT	20. 61N845 - 1/4" MPT
17. 61N829 - 1/4" SAE FL	21. 61N870 - 3/8" MPT

REPLACEMENT PARTS LIST

Nipple Assembly EPDM SEALS		
1.	Nipple Body	102640-001
2.	End Cap O-Ring	61871
3.	Nipple Valve Stem	61N844
4.	Valve O-Ring	61873
5.	O-Ring Retainer	61840
6.	Nipple Valve Spring	61804
7.	Perch	61825
8.	Nipple Spacer	61824

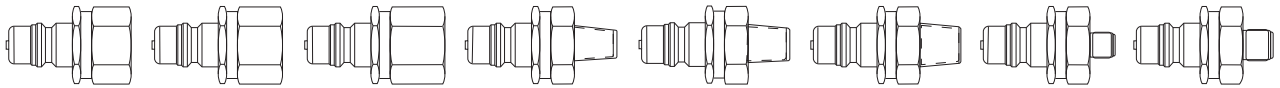
Coupler Assembly EPDM SEALS		
1.	Coupler Sleeve	61N831
2.	Retaining Ring	61832
3.	Coupler Sleeve Spring	61801
4.	O-Ring	102417-6
5.	Ball (8) Req'd	61833
6.	Coupler Body	102416-004
7.	End Cap O-Ring	61871
8.	Coupler Valve Stem	61N863
9.	Valve O-Ring	61873
10.	O-Ring Retainer	61840
11.	Coupler Valve Spring	61802
12.	Perch	61825
13.	Coupler Spacer	61837



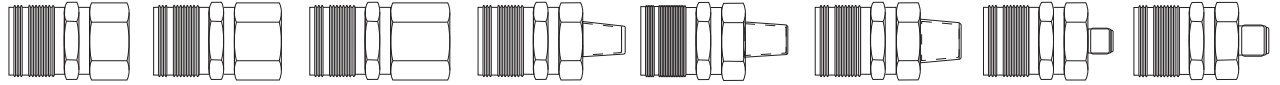
**HFC-134a REFRIGERANT SEALS**

NIPPLE  
ASSEMBLY

64N117	64N217	64N317	64N137	64N237	64N337	64N227	64N327
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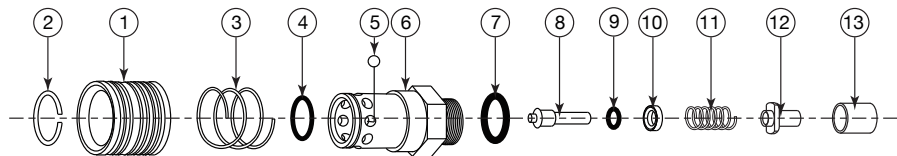
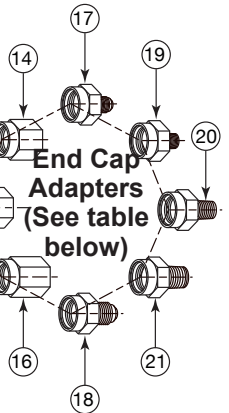
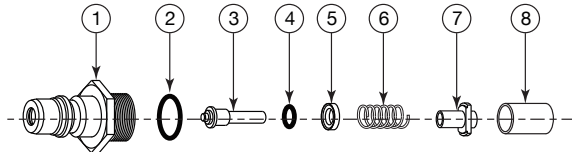
1/8" FPT ADAPTER	1/4" FPT ADAPTER	3/8" FPT ADAPTER	1/8" MPT ADAPTER	1/4" MPT ADAPTER	3/8" MPT ADAPTER	1/4" SAE FL ADAPTER	3/8" SAE FL ADAPTER
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COUPLER  
ASSEMBLY

65N117	65N217	65N317	65N137	65N237	65N337	65N227	65N327
--------	--------	--------	--------	--------	--------	--------	--------

**Nipple Assembly**  
(See table below)



**Coupler Assembly**  
(See table below)

**End Cap Adapters**

14. 61N876 - 1/8" FPT	18. 61N821 - 3/8" SAE FL
15. 61N830 - 1/4" FPT	19. 61N868 - 1/8" MPT
16. 61N869 - 3/8" FPT	20. 61N845 - 1/4" MPT
17. 61N829 - 1/4" SAE FL	21. 61N870 - 3/8" MPT

**REPLACEMENT PARTS LIST**

Nipple Assembly HFC-134a REFRIGERANT SEALS		
1.	Nipple Body	102640-001
2.	End Cap O-Ring	61879
3.	Nipple Valve Stem	61N844
4.	Valve O-Ring	61880
5.	O-Ring Retainer	61840
6.	Nipple Valve Spring	61804
7.	Perch	61825
8.	Nipple Spacer	61824

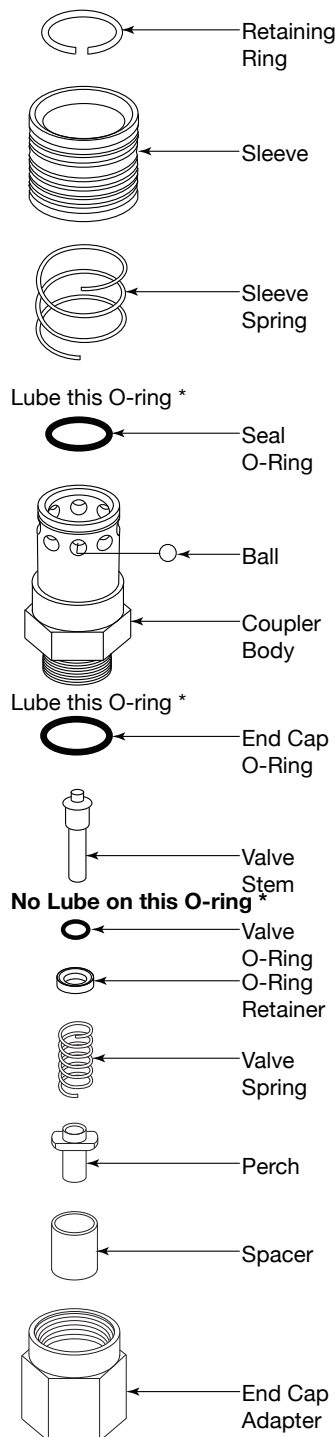
Coupler Assembly HFC-134a REFRIGERANT SEALS		
1.	Coupler Sleeve	61N831
2.	Retaining Ring	61832
3.	Coupler Sleeve Spring	61801
4.	O-Ring	102417-2
5.	Ball (8) Req'd	61833
6.	Coupler Body	102416-004
7.	End Cap O-Ring	61879
8.	Coupler Valve Stem	61N863
9.	Valve O-Ring	61880
10.	O-Ring Retainer	61840
11.	Coupler Valve Spring	61802
12.	Perch	61825
13.	Coupler Spacer	61837



## SERIES 250 COUPLER ASSEMBLY

### DISASSEMBLY - COUPLER

Holding the coupler assembly in one hand, pull the sleeve back with thumb and forefinger of same hand to expose the end of the coupler body. Using retaining ring pliers (PCU Part # A-21599) or a pointed tool, pry the retaining ring from the groove on the coupler body. Set aside. Insert Ball Assembly Tool (PCU Part # A-21587) to hold balls in place while removing coupler sleeve and sleeve spring. If you don't have a Ball Assembly Tool, carefully remove coupler sleeve and spring over a shop rag or towel to keep balls from rolling away. Remove balls and set aside. Place coupler body in a vise clamping on the hex. Use a 1" open-end wrench (or equivalent) on end cap adapter. Loosen until the end cap adapter can be removed by hand. Remove the coupler assembly from the vise. Holding the coupler body with its related parts threaded end up, remove the spacer and set aside. Tilt the coupler body down and slide out the valve assembly. (Note: Tap valve assembly loose if stuck.) Check and remove perch, spring, O-ring retainer, and valve O-ring from valve stem. Discard all O-rings. With a pointed tool, pry seal O-ring from inside coupler body, being careful not to scratch O-ring groove.



\* Use PCU O-ring lubricant 490-00134

### REASSEMBLY - COUPLER

Lubricate O-ring with PCU Lubricant #490-00134 before inserting seal O-ring in groove inside coupler body. Press firmly against inner diameter to ensure proper placement of seal. After parts have all been inspected, pick up valve stem and slide new valve O-ring over stem and upon shouldered portion of the valve stem. **(Do not lube this O-ring.)** Next, position the O-ring retainer behind the O-ring, making certain the cupped portion of the O-ring retainer is next to the O-ring. Slide the valve spring over the valve stem until it comes in contact with the flat side of the O-ring retainer. Slide the perch onto the valve stem, short end first, pushing it under the spring. Pick up the coupler body, holding it threaded end down, and slide the valve assembly up into the coupler body, valve stem first. Tilt the coupler body until the threaded end is pointing up, allowing the valve assembly to drop into place. Ensure that the valve assembly remained intact, then insert spacer into the coupler body until it comes in contact with the shoulders of the perch. Pick up the end cap adapter and screw the adapter to the coupler assembly. Set torque wrench, using approximately 35 to 40 foot lbs. torque. Turn assembly over. Using the Ball Assembly Tool (PCU Part # A-21587), insert the balls (8) into the holes in the coupler body. If the Ball Assembly Tool is not available, use O-ring grease or petroleum jelly in ball holes to hold balls in place. Slide sleeve spring over end of coupler body; place sleeve over spring, large diameter first. Push retaining ring into groove in coupler body using fingers or you may use the small diameter of the Ball Assembly Tool and push down on the retaining ring until the retaining ring snaps into the groove on the coupler body. Remove assembly tool, if used; this completes assembly.

#### 250 Coupler Service Tool Kit #460-00250

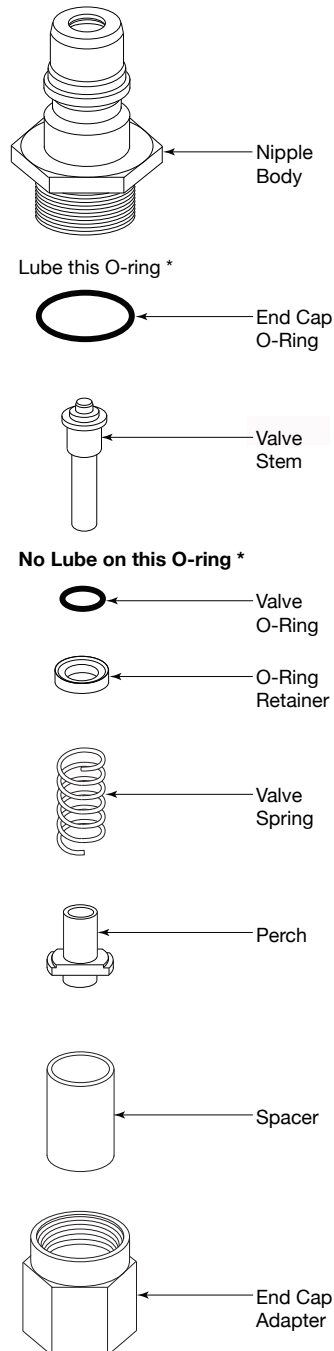
625-00810	O-Ring Insertion Tool
21587	Magnetized Ball Assembly Tool
21599	Retaining Ring Pliers



## SERIES 250 NIPPLE ASSEMBLY

### DISASSEMBLY - NIPPLE

To disassemble the nipple assembly, place nipple body in a vise, clamping on the 1" hex. Use a 1" open-end wrench (or equivalent) on end cap adapter. Loosen until the end cap adapter can be removed by hand. Set end cap adapter aside. Remove nipple assembly from vise. Holding the nipple body with its related parts threaded end up, remove the spacer and set aside. Tilt nipple body down and slide out valve assembly (NOTE: Tap valve assembly loose if stock.) Check and remove perch, spring, O-ring retainer, and valve O-ring from valve stem. Discard O-rings.



\* Use PCU O-ring lubricant 490-00134

### REASSEMBLY - NIPPLE

After parts have been inspected, pick up valve stem in one hand and slide valve O-ring (No Lubrication) over stem and upon shouldered portion of the valve stem. Next, position the O-ring retainer behind the O-ring, making certain that the cupped portion of the O-ring retainer is next to the O-ring. Slide the valve spring over the valve stem until it comes in contact with the O-ring retainer. Slide the perch onto the valve stem, with its long end over the stem. Pick up the nipple body, holding it with the threaded end down, and slide the valve assembly up into the nipple body, valve stem first. As the valve assembly is slid into the nipple body, tilt the nipple body until the threaded end is pointing up to allow the valve assembly to drop into place. Holding the nipple body in that position, pick up spacer and slide it down into the nipple body until it comes in contact with the shoulders of the perch. Lubricate end cap O-ring with PCU Lubricant #490-00134 and slide over nipple body threads until it drops into groove. Screw the end cap adapter to the nipple body. Set torque wrench, using approximately 35 to 40 foot lbs. torque. Reassembly of the Series 250 Nipple is now complete.



**WE SPECIALIZE IN CUSTOM COUPLERS & TOOLING TO SUIT YOUR APPLICATION.**



Series 25



Series 86



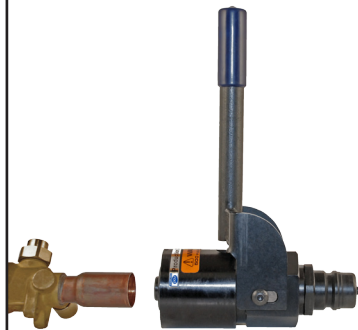
Series 87



Series 91



Series 93



Series 98



Series 100 & 101



Series 109



Series 250



Series 410



Series 500



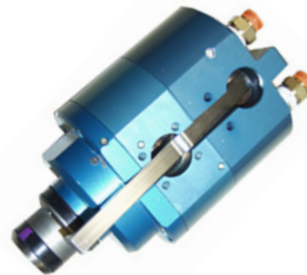
Series 250 Evac & Charge



Series 13000



Series 104



Series 106



Series 106 Adapter

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