



CAMERON H2 CHOKE BEAN & SEAT MAKE-UP

In an H2 choke if the bean or seat is not made up correctly then the gasket may not hold pressure. This can cause leakage past the gasket that if undetected can quickly ruin the choke body. The purpose of this bulletin is to describe the correct method of make-up which will minimize the chance of seat-to-body seal failure.

MAKE-UP PROCEDURE:

1. Ensure that the sealing surfaces on both sides of the gasket and on the bean or seat shoulder are clean and free of scratches, gouges or any other defect which could cause the gasket to leak. To the extent possible, ensure that the bean/seat sealing surface in the choke body is clean and free from defects.
2. Lubricate both sides of the gasket, the bean/seat shoulder seal surface and the bean/seat threads with a generous amount of extreme pressure, anti-galling grease. This will serve to maximize the load applied to the gasket by reducing friction loss during make-up.
3. Using the appropriate Cameron bean/seat wrench (see table below), screw the bean/seat into the body and tighten with at least 500 lb-ft of torque for 2" nominal chokes rated at 10,000 psi WP or lower. For the 3" and 4" nominal chokes use 1,000 lb-ft. Use 1,500 lb-ft of torque when installing a bean/seat in the 2" nominal 15,000 psi WP choke.
4. It is recognized that torque wrenches of adequate capacity will not generally be available in the field. It is therefore permissible to use other methods which will produce the approximate torque requirements. It is important to realize that the H2 beans and seats and the mating surfaces in the body can withstand significantly higher torque values than those specified without damage.

Cameron publication, "H2 Choke Operation & Maintenance Manual" should be consulted for complete information on the proper usage of the H2 choke. A copy of the manual may be obtained from your Cameron service representative.

Bean & Seat Wrenches

Choke Nominal Size	Choke Wrench Part Number
2"	626964-01
3"	626963-01
4"	019892