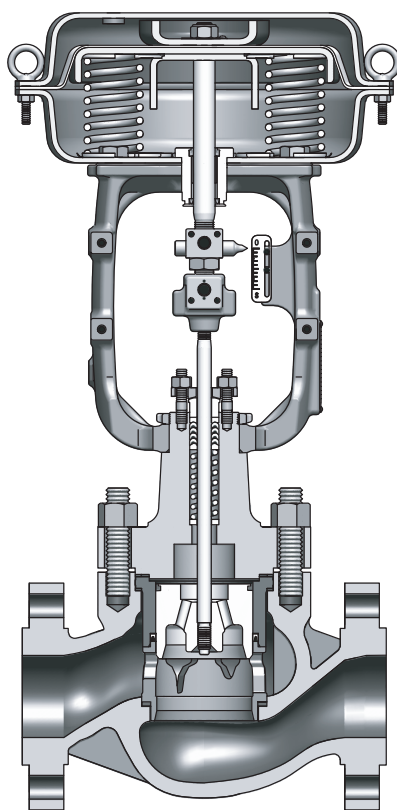


Control Valves

Model ACP___/ACN___

User's Manual



Azbil Control Instruments (Dalian) Co., Ltd.

NOTICE

While the information in this manual is presented in good faith and believed to be accurate, Azbil Corporation disclaims any implied warranty of merchantability or fitness for a particular purpose and makes no express warranty except as may be stated in its written agreement with and for its customer.

In no event shall Azbil Corporation be liable to anyone for any indirect, special or consequential damages. This information and specifications in this document are subject to change without notice.

Safety

1. Nomenclature of parts

For control valve terminologies and words in this guide, please read the following explanations before using the device.

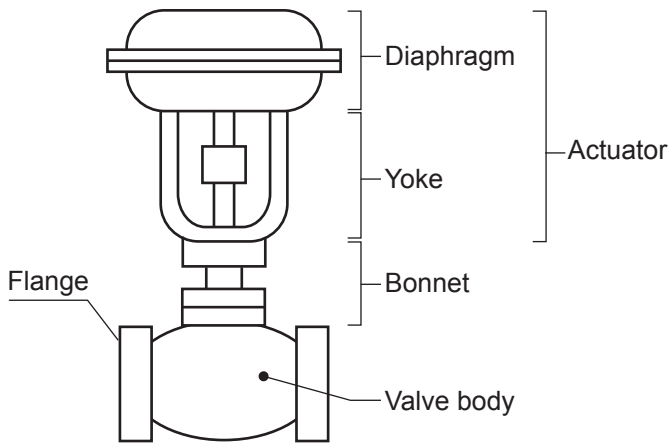


Fig. S-1. Nomenclature of globe valve

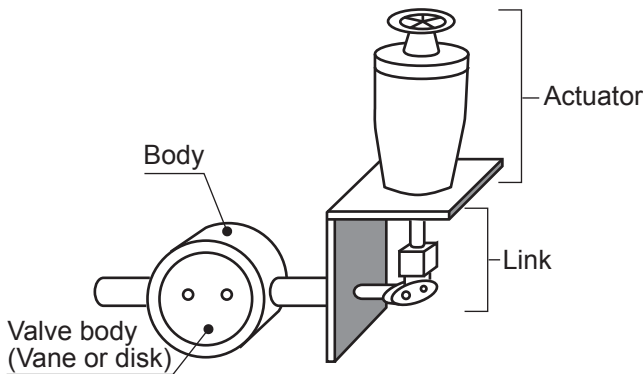




Fig. S-2. Nomenclature of butterfly valve

2. Safety precautions

Please read this guide before using the valve to ensure proper handling.

| | | |
|-----------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------|--|
| |  WARNING | |
| Denotes a potentially hazardous situation which, if not avoided, could result in death or serious injury. | | |

| | | |
|-------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------|--|
| |  CAUTION | |
| Failure to observe these precautions may produce dangerous conditions that could result in operator injury or in physical damage to the device. | | |

3. Verification of Valve specifications and precautions on storage

3-1. Unpacking

Control valve is a precision equipment. Handle it with care to avoid damaging it.

When unpacking, check for the following items in the crate:

- Main valve body, actuator and accessories as ordered,
- Additional equipment as ordered. Installation Options

3-2. Verification of specifications

Please check and see if that the process flow fluid conditions, and valve Tag No. agree with the purchasing specifications. The nameplate of each product are found as shown below.
(Other products also have identical nameplates attached to the identical positions.)

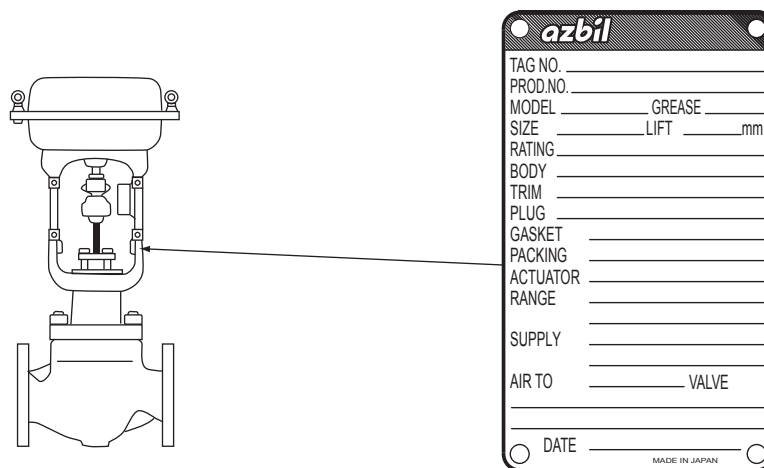


Fig. S-3. Position of nameplate on CV3000 Series


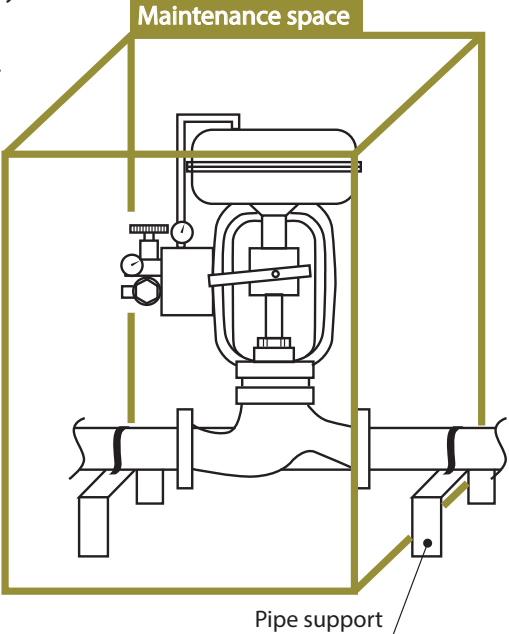
**CAUTION on storage**


When storing the control valve, pay attention to the following precautions of caution:

- A Control valve that has been packed in a cardboard box should be stored indoors at normal temperature and humidity.
- A Control valve that has been packed in a wooden crate should be stored indoors at normal temperature and humidity as a rule. In the event of outdoor storage, open the crate, verify specifications and cover with polyethylene protecting sheet.
- When storing a used valve, follow the procedures as described below:
 - (1) Flush out the process fluid from inside the valve body and dry,
 - (2) When there is a possibility of the valve body rusting, preservation treatment should be given,
 - (3) To prevent water from getting in the instrument, cover pneumatic tubing connection and electric connector with watertight cap or tape. Also, protect connector threads,
 - (4) Place flange cap on the end of pipe connecting surface (flange face, butt welding connections) to avoid possible damage.

4. Installation

4-1. Installation environments

|  CAUTION | |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------|
| <ul style="list-style-type: none">• Ensure sufficient space for easy and safe operation and maintenance of control valve.• Avoid installing valve in a location where vibration or external stress may impair proper valve functions. If necessary, make appropriate provisions against these.• Consider providing a support for the valve so that the process piping is not burdened with the excessive weight of valve, or provide supports on the upstream and downstream pipe runs.• Provide a cover or protective fence around valve installation when a valve is installed facing a path or if physical contact with valve is expected.• Do not install a valve where it may be submerged water, or snow or where freezing may take place.• Provide a wall for protection against heat radiation.• Provide measures to protect valve against salt spray or corrosive atmospheres.• To stop operation of the Flowmeter:<ul style="list-style-type: none">- Switch the control equipment connected to the flowmeter to manual control.- Turn off power to the Converter. |  |

|  CAUTION | |
|---------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|
| <ul style="list-style-type: none">• In order to guard against accident while handling the valve, always wear safety gloves, goggles and safety shoes. | |

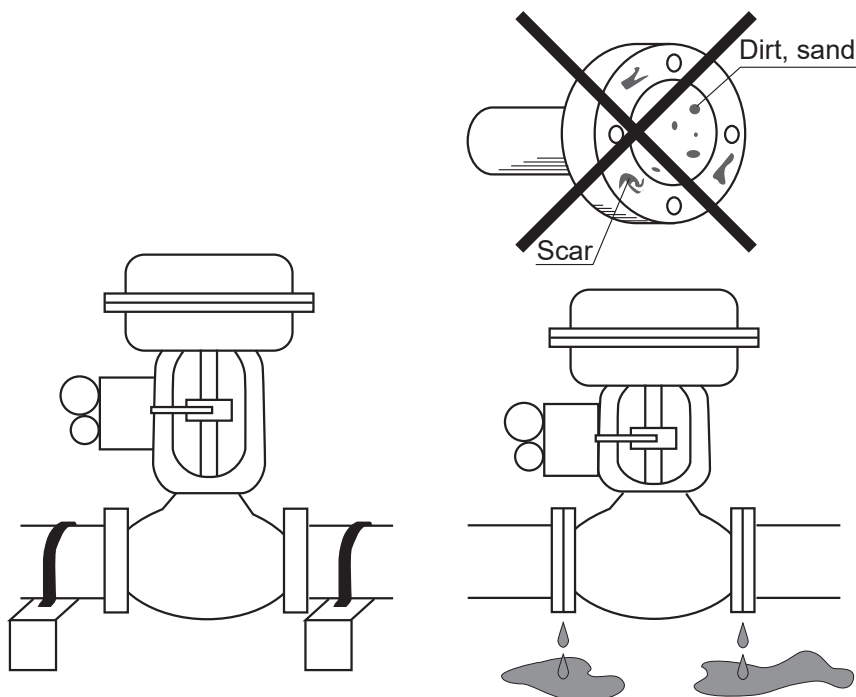
Prior to installation work, follow the items of caution as described below:

CAUTION

- Check and confirm that there is no external damage to the valve (body, actuator, accessories).
- Check and confirm that there is no damage on pipe connecting flanges or butt welding connections,
- Ensure that temperature of welded part of pipe has been reduced before proceeding,
- Make sure that the flanges on pipe have been chamfered.
- Remove dust, sand, welding spatter or any other foreign matter from pipe and clean out pipe. Any foreign matter will damage the valve seat and reduces shutoff characteristics.
- Ensure that upstream and downstream pipe supports are sufficiently strong. Otherwise, the valve's weight may cause leakage from flange connections.

WARNING

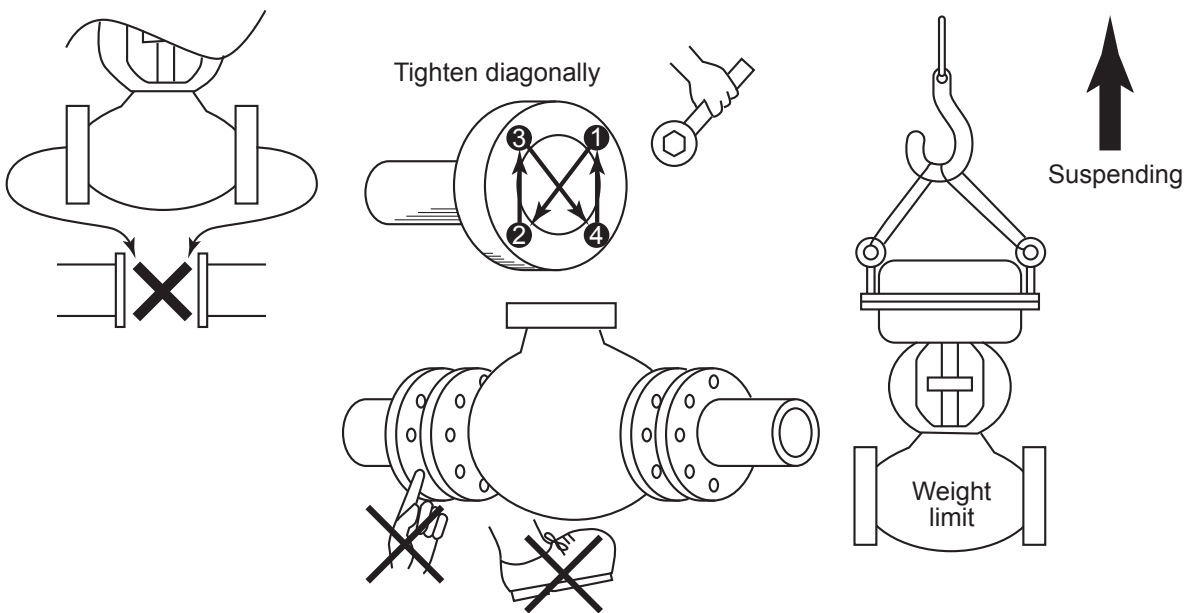
- Operation of valve over and beyond the rated pressure or connection other than recommended of specified connection may cause damage or leakage which may result in serious injury.



4-2. Installation work

CAUTION

- Ensure that centers of upstream and downstream pipes are aligned when pipe installation has been completed. Any mis-alignment of pipe will distort the valve and will cause leakage from the connections. (Gasket)
- Make sure that the face to face dimension of pipe flanges is equal to face to face dimension of valve body plus gasket thickness.
- Use proper gaskets for pipe flanges. Otherwise, process fluid may leak. Always use new gaskets for pipe flanges that will meet process fluid specifications, temperature and pressure conditions. Otherwise process fluid leakage may occur.
- When flushing pipes, keep valve in the fully open position and do not stroke valve. Welding spatter or foreign matters may damage valve.



WARNING

When installing a valve on a pipe, keep hands and feet away from valve body's bottom or between flanges to avoid physical injury.

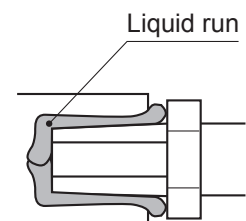
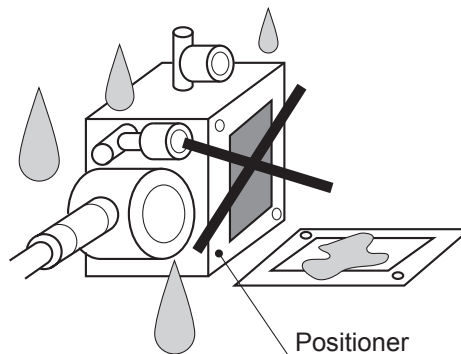
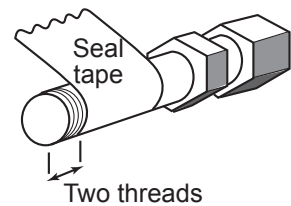
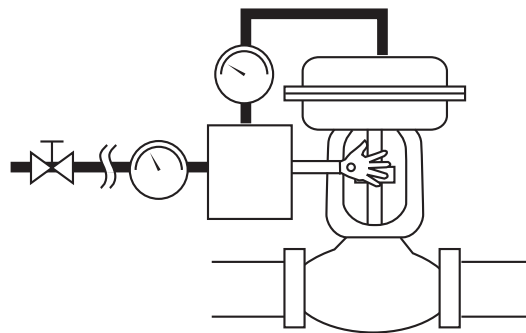
When reinstalling the valve after inspection, maintenance or modification, flush out process fluid remaining in the pipe or replace it with safer liquid.

4-3. Pneumatic piping and electric work



CAUTION

- Pneumatic tubing should be sized so as not to cause dropping of air pressure when control valve is in operation, Pneumatic tubing should have an allowance in bend (use specialized tool) and bands should bind parallel tubing.
- Only qualified persons should do electric work in accordance to electrical facility engineering standards.
- Cable connections should be made to conform to the facility's conditions. A suitable adaptor or packing should be selected to suit the outer dimension of the completed installation.
- When using seal tape on pneumatic tubing, do not apply the tape on the first two threads from the tip of connector. This may block air passage and cause malfunction of valve.
- When using liquid packing (seize lock) on pneumatic tubing, care should be exercised so as not to leak the liquid into tubing. It may block the air passage, resulting in valve malfunction.
- Avoid electrical work in rainy weather or time of high humidity. Any intrusion of water into connector or terminal will cause rusting and electric leakage.
- Covers of accessories such as the positioner are provided with seal packing (gasket). Exercise care so as not to misplace or lose them while electric work is in progress.
- Exercise care so as not to lose fixing screws of accessories such as the positioner. When tightening screws, ensure that packing is in place and tighten screws with an even torque.
- Cable threads and conduit seal should be tightened so as to ensure that water does not get in.



5. Caution disassembly, reassembly

5-1. Disassembly

! CAUTION

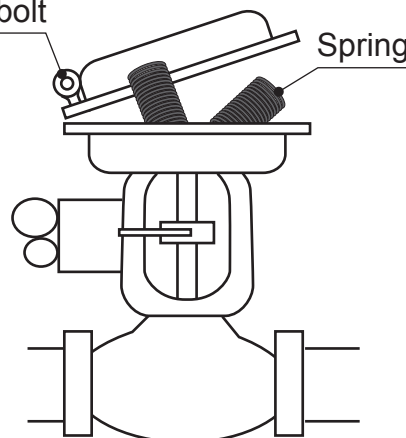
- When disassembling a spring-incorporated positioner, follow the prescribed procedure in removing bolts and nuts. Otherwise, the spring may pop out, resulting in physical injury.
- When the eye-bolts of actuator are used to lift valve from pipe, ensure that the weight limitation as described in manual is adhered to. Otherwise, there is the danger of dropping the valve,
- When removing trim (inner valve) from the body, ensure that the proper type of specialized tool is used. Refer to the instruction manual for proper tools. Otherwise, the trim may be damaged.

! WARNING

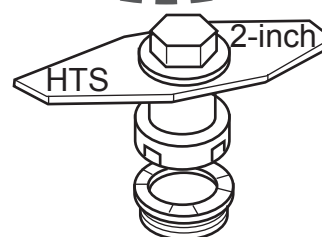
- Before disassembling the valve, ensure that the pressure within piping has been reduced to atmospheric pressure. Flow out of process fluid may cause physical injury.
- When disassembling the valve, flush out interior of the valve or replace fluid inside. Residual process fluid may cause physical injury,
- Do not disassemble pneumatic actuator with supply air on. Compressed air may cause physical injury.

Eye bolt

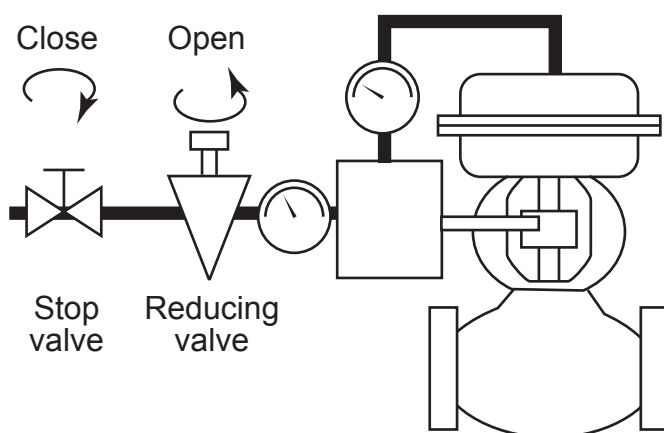
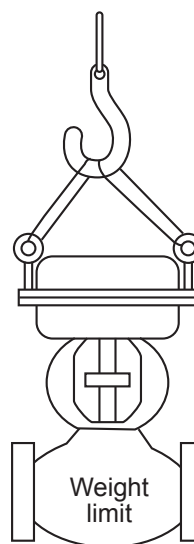
Spring



Specialized tool



Suspending



6. Assembly

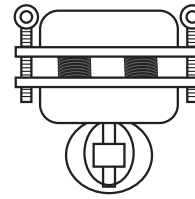
CAUTION

- When assembling the spring loaded actuator, adhere to the order of assembly procedure; install bolts and nuts as instructed. Disregard of procedure may result in malfunction.
- When installing a butterfly valve on a pipe line, fully close the valve (vane or disk). Tighten flange bolts and nuts diagonally and with even torque.
- When installing the valve the body, always use new gaskets. Old or reused gasket may cause leakage
- When assembling trim (inner valve), ensure that specialized tools are available and use only those which meet specifications.

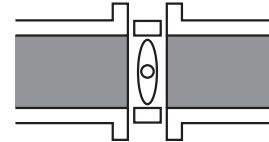
WARNING

- When assembling the valve, tighten bolts and nuts at a torque as specified in instruction manual. Any damage or corrosion on the bolts or nuts may cause destruction of control valve which will lead to physical injury. Always replace defective bolts and nuts with new ones.

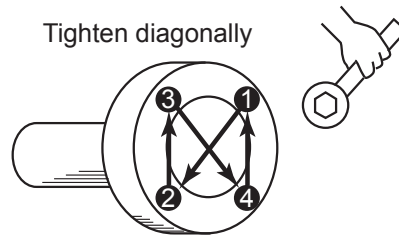
Follow assembly procedure



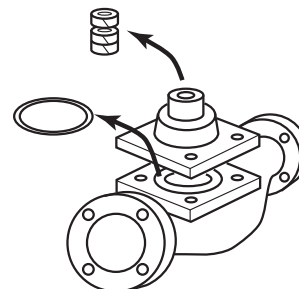
Install butterfly valve in fully closed position



Tighten diagonally



Replace packing / gasket



7. Maintenance and inspection

Adhere to the following items of Warning and Caution while conducting maintenance or inspection.

CAUTION

When leakage from a valve is found, do not come close to the valve until safety is assured of. A serious accident or physical injury may occur depending on the type of fluid.

WARNING

- Check gland daily and ensure that there is no leakage from it. Check valve operation daily, and confirm that it is not hunting.
- Make sure that there is no abnormal vibration or noise during operation,
- When the valve is repaired or disassembled, old parts should be properly disposed of as industrial waste. Otherwise, they may contaminate the environment.

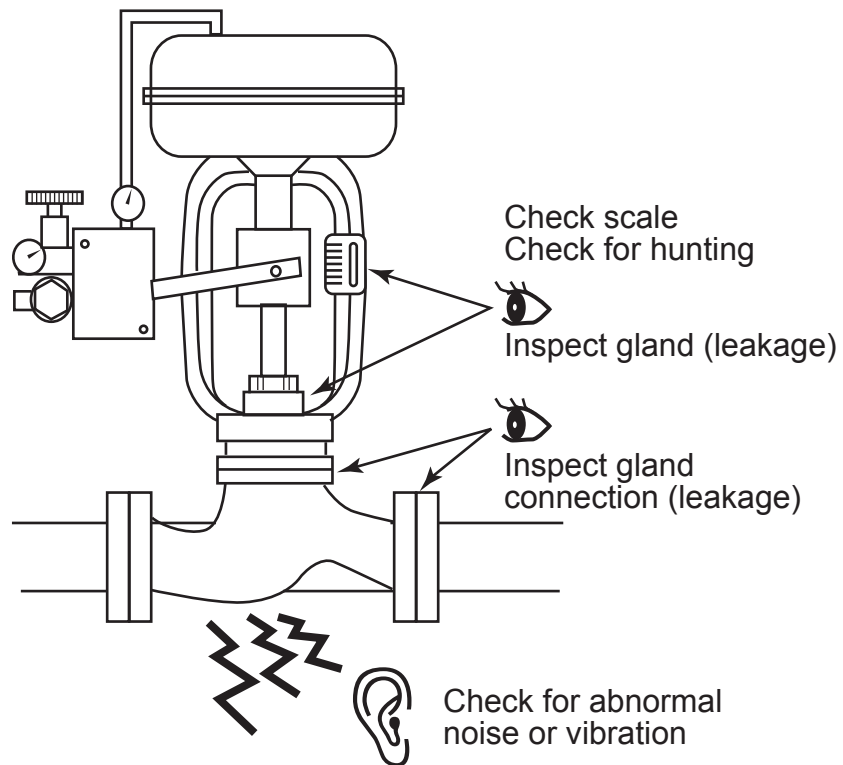


Fig. S-4.

Table of Contents

| | |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------|------|
| Chapter 1. General..... | 1-1 |
| 1-1. Scope | 1-1 |
| 1-2. Main components of control valves | 1-1 |
| 1-3. Structures | 1-2 |
| 1-4. Nameplate | 1-3 |
| Chapter 2. Installation | 2-1 |
| 2-1. Maximum lift limits of eyebolts..... | 2-1 |
| 2-2. Installing valve on process pipe | 2-1 |
| 2-3. Items to be checked after installation and before starting operation..... | 2-2 |
| Chapter 3. Inspection and Maintenance | 3-1 |
| Chapter 4. Disassembly and Assembly..... | 4-1 |
| 4-1. Detaching actuator from valve body | 4-1 |
| 4-2. Disassembly and assembly of valve body..... | 4-1 |
| 4-2-1. Disassembly and assembly of plain ($-17 \leq t < 230^{\circ}\text{C}$) and extension 1 ($-45 \leq t < 17^{\circ}\text{C}$) bonnet type valve body..... | 4-2 |
| 4-2-1-1. Disassembly procedure | 4-2 |
| 4-2-1-2. Inspection | 4-2 |
| 4-2-1-3. Assembly procedure | 4-3 |
| 4-2-2. Disassembly and assembly of extension1 bonnet type ($230 \leq t < 400^{\circ}\text{C}$) valve body | 4-6 |
| 4-2-2-1. Disassembly procedure | 4-6 |
| 4-2-2-2. Inspection | 4-8 |
| 4-2-2-3. Assembly procedure | 4-9 |
| 4-3. Disassembly and assembly of actuator | 4-11 |
| 4-3-1. Disassembly and assembly of model HA2, HA3 or HA4 actuator..... | 4-12 |
| 4-3-1-1. Disassembly procedure | 4-12 |
| 4-3-1-2. Assembly procedure | 4-15 |
| Chapter 5. Adjustment..... | 5-1 |
| 5-1. For direct action type | 5-1 |
| 5-2. For reverse action type | 5-1 |
| Chapter 6. Direct / Reverse Action type Conversion and Spring range Change of Actuator..... | 6-1 |
| 6-1. Direct / Reverse action change | 6-1 |
| 6-2. Stroke and range spring change | 6-4 |
| Chapter 7. Instructions for Top | 7-1 |
| 7-1. Model HA2, HA3, or HA4 actuator | 7-1 |
| 7-1-1. Disassembly and assembly of top handwheel..... | 7-4 |

| | |
|------------------------------------------------------------------------------|-------|
| Chapter 8. Instruction for Side Handwheel of Actuator | 8-1 |
| 8-1. Installation procedure | 8-1 |
| 8-2. Operating instructions | 8-2 |
| 8-3. Disassembly and assembly of side handwheel (Refer to Fig. 8-1)..... | 8-2 |
| Chapter 9. Instruction for Mechanical Flow Stopper of Actuator | 9-1 |
| 9-1. Adjustment for Minimum Flow Stopper | 9-1 |
| 9-2. Adjustment for Maximum Flow Stopper..... | 9-1 |
| 9-3. Adjustment for Minimum and Maximum Flow Stopper | 9-2 |
| Chapter 10. Instructions for Bellows Sealed type of Control Valves..... | 10-1 |
| 10-1. Structures..... | 10-2 |
| 10-2. Disassembly and assembly | 10-3 |
| Chapter 11. Azbil Low Emission standard-compliant gland packing | 11-1 |
| 11-1. Overview..... | 11-1 |
| 11-2. Structure..... | 11-1 |
| 11-3. Installation into the gland | 11-2 |
| 11-3-1. Preparation for installation..... | 11-2 |
| 11-3-2. Start of installation..... | 11-3 |
| 11-3-3. Retightening | 11-6 |
| 11-4. Parts List | 11-7 |
| Chapter 12. Certified ISO 15848-1 compliant low emission gland packing | 12-1 |
| 12-1. Overview..... | 12-1 |
| 12-2. Structure..... | 12-2 |
| 12-3. Starting Operation | 12-2 |
| 12-4. Assembling the parts of the gland | 12-3 |
| 12-4-1. Preparation for assembly..... | 12-3 |
| 12-4-2. Assembly..... | 12-5 |
| 12-5. Parts List | 12-9 |
| 12-6. Application to existing control valves | 12-13 |
| 12-7. Disposal..... | 12-13 |
| Chapter 13. Troubleshooting..... | 13-1 |
| Chapter 14. Recommended spare parts | 14-1 |

Chapter 1. General

1-1. Scope

This manual covers the instructions for:

- Mode ACPPressure-Balanced Cage-type Control Valves with piston ring
- Model ACNLow noise cage type control valves with piston ring

For the valve Positioners, refer to the following:

| | |
|----------------------------------------|-----------------|
| Model HTP | OM2-8310-0200 |
| Model HEP28/29 | CM2-HEP280-2001 |
| Model HEP18/19 | OM2-8313-0101 |
| Model HEP15/16/17 | OM2-8313-0100 |
| Model HEP10/11..... | CM2-HEP100-2001 |
| Model AVP300/301/302/200/201/202 | CM2-AVP300-2001 |
| Model AVP701/702 | CM2-AVP302-2001 |
| Model AVP703 | CM2-AVP303-2001 |

1-2. Main components of control valves

Each control valve is comprised of two main components, namely, a valve body and an actuator. Various combinations of valve body and actuator are available to meet various types of uses with different valve sizes, pressure ratings, types of connections, types of materials, and actuator sizes.

(For details on specifications, refer to Specification Sheets SS2-ACP110-0100 or SS2- ACN110-0100.)

1-3. Structures

The structures of typical control valves are shown in Fig. 1-1.

The valve body is connected to the bonnet with stud bolts and nuts. Two gaskets are provided at the connection section to seal the internal fluid or to let the valve body make up a pressure vessel. The valve plug is supported by the guide ring and cage, and driven by the actuator. The actuator has multiple springs and a diaphragm, and converts the pneumatic control signal into a mechanical (positional) control signal with which to position the valve plug.

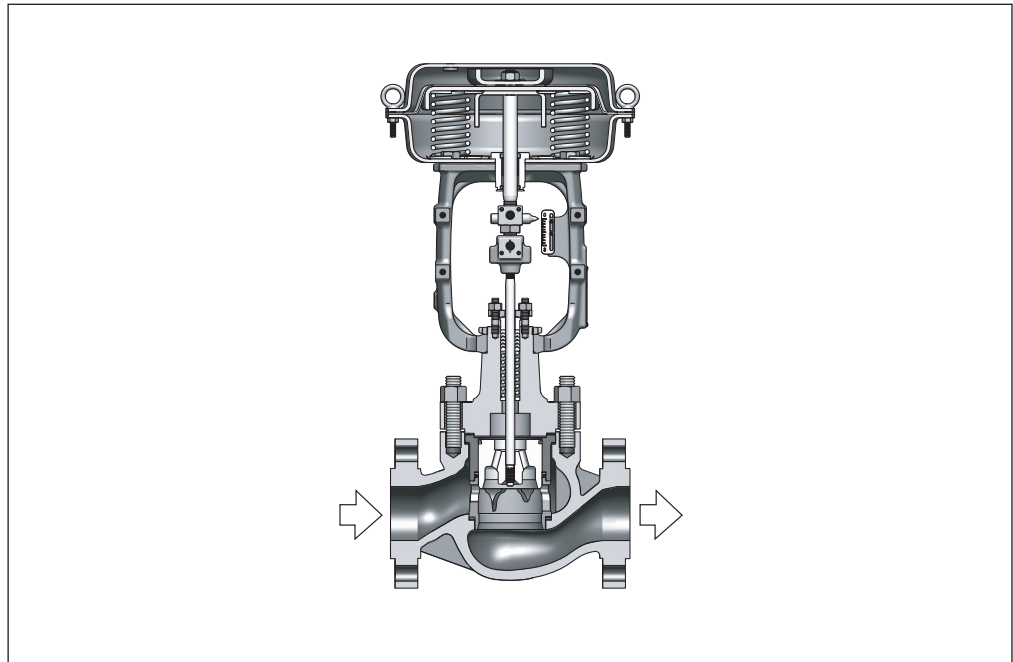


Fig. 1-1. Pressure-balanced cage-type control valve model ACP

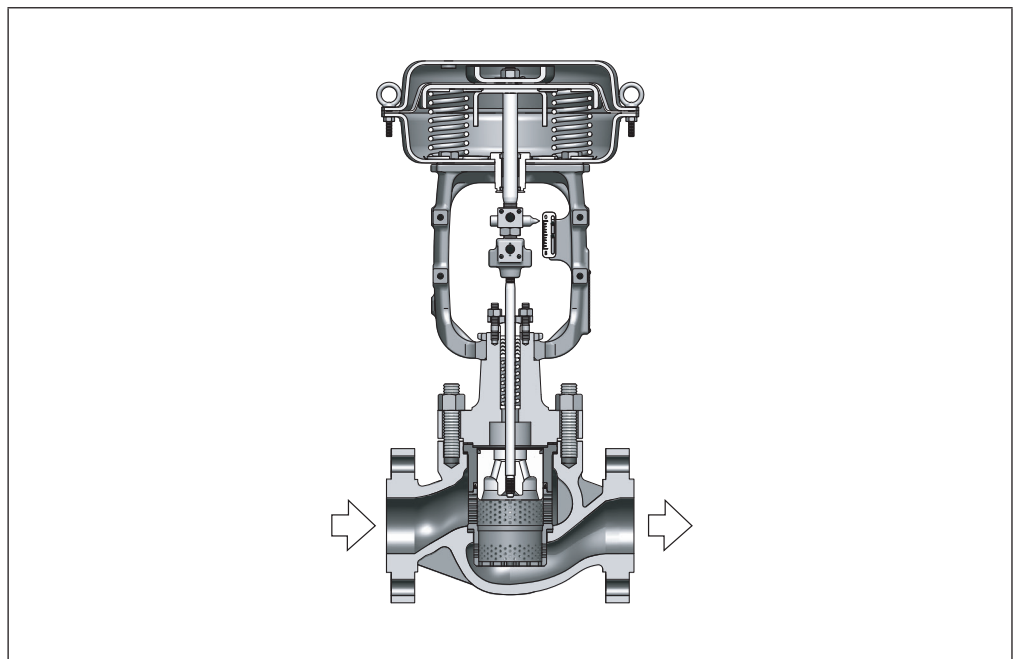


Fig. 1-2. Low-noise cage-type control valve model ACN

1-4. Nameplate

A nameplate, as shown in Fig. 1-3, is attached to each control valve. The nameplate indicates the model number, valve size, pressure rating, trim material, date of manufacture and other major specifications of the control valve. Before installing the control valve, make sure that the specifications indicated on the nameplate conform to the conditions of use. The nameplate also indicates the product number (PROD.NO.) of the control valve. Please mention this number also when consulting your Azbil Corporation agent for parts replacement or any other modification of the control valve.

The nameplate is a rectangular label with a black border and two circular mounting holes at the top. It features the **azbil** logo in the top left corner. The label contains the following fields for recording specifications:

- TAG NO. _____
- PROD.NO. _____
- MODEL _____ GREASE _____
- SIZE _____ LIFT _____mm
- RATING _____
- BODY _____
- TRIM _____
- PLUG _____
- GASKET _____
- PACKING _____
- ACTUATOR _____
- RANGE _____
- SUPPLY _____
- AIR TO _____ VALVE _____
- DATE _____

At the bottom right, it states **MADE IN JAPAN**.

Fig. 1-3. Nameplate

Chapter 2. Installation

2-1. Maximum lift limits of eyebolts

The diaphragm case has a pair of lifting eyebolts. These eyebolts primarily are for lifting the actuator alone. Before using the eyebolts for other purposes (such as lifting an actuator fixed to its valve body or other components), take note of the allowable maximum lifting loads of the eyebolts that are as shown in the following Table 2-1.

Table 2-1. Maximum lifting loads of eyebolts

| Actuator model No. | Allowable Maximum Lifting Load of Eyebolts | Weight of Actuator Alone |
|--------------------|--------------------------------------------|--------------------------|
| HA2, HA2R | 160 kg | 16 kg |
| HA3D, HA3R | 160 kg | 32 kg |
| HA4D, HA4R | 220 kg | 68 kg |

Note: The eyebolts may be used to lift the actuator together with its valve body (cast globe valve) of up to pressure rating "Class 600". When doing this, be extremely careful so that no shock or other abnormal force is applied to the actuator or the valve body.

2-2. Installing valve on process pipe

- (1) Before installing the valve on the process pipe, remove foreign substances (such as scales and welding chips) from both upstream and downstream sides of the process pipe.
- (2) Confirm that the direction of process fluid flow conforms with that of the arrow provided on the valve body.
- (3) Pay attention so that the pipe connection gaskets do not extrude into the process pipe inside. Be sure to use gaskets made of material which is suitable for the process fluid. The welded type of valve employ no gaskets.
- (4) Pay attention so that no excessively large stress is conveyed from the process pipe to the valve body. Uniformly tighten the bolts of the process pipe connection flanges. The high pressure type of valves have no flanges, since they are welded to the process pipe.
- (5) Before connecting the air pipes to the actuator and positioner, blow the pipes to clean them.
- (6) Do not install any heating or cooling provisions on the bonnet.

2-3. Items to be checked after installation and before starting operation

- (1) Check that there is no leak from air piping.
- (2) Check that the bolts and nuts of the diaphragm case are not loose. Standard tightening torques are listed below:
- (3) Tighten the packing flange nuts to prevent leak from the gland packing section. Standard tightening torques are given in Table 2-2

Table 2-2. Tightening torques of packing flange nuts

| Valve stem diameter (mm) | V PTFE Packing | PTFE Yarn Packing (P4519) | Graphite Yarn Packing P6610CH + P6528 P6610CH + M8590 T2200 + P6710CH (Type2) | V PTFE + PTFE Yarn Packing PTFE + V7233 PTFE + TK2006 |
|--------------------------|----------------|---------------------------|----------------------------------------------------------------------------------------|-------------------------------------------------------------|
| 10 | 1 {8} | 9 {90} | 5 {50} | 3 {30} |
| 13 | | 15 {150} | 8 {80} | 5 {50} |
| 16 | | 24 {240} | 13 {130} | 8 {80} |
| 20 | | 32 {320} | 18 {180} | 10 {100} |
| 25 | | - | 28 {280} | 15 {150} |
| 30 | | 66 {660} | 36 {360} | 20 {200} |

Note: The tightening torques mentioned in the above are only to given as reference values.

Note that tightening torques may vary depending on the type of packing.

Table 2-3. Tightening Torques of packing Flange Nuts for PTFE yarn (Certified ISO 15848-1-compliant low-emission gland packing)

| Model | Actuator model | Stem size | Tightening torque |
|----------|----------------|-----------|-------------------|
| ACP, ACN | HA2 | φ 10 mm | 12 N·m |
| | HA3 | φ 13 mm | 20 N·m |
| | HA3 | φ 16 mm | 33 N·m |
| | HA4 | φ 20 mm | 44 N·m |
| | PSA6 | φ 30 mm | 54 N·m |

Table 2-4. Tightening Torques of packing Flange Nuts for expanded graphite (Certified ISO 15848-1-compliant low-emission gland packing)

| Model | Actuator model | Stem size | Tightening torque |
|----------|----------------|-----------|----------------------------|
| ACP, ACN | HA2 | φ 10 mm | 12 → 0 (loosening) → 8 N·m |
| | HA3 | φ 13 mm | 20 → 0 (loosening) → 13N·m |
| | HA3 | φ 16 mm | 33 → 0 (loosening) → 22N·m |
| | HA4 | φ 20 mm | 44 → 0 (loosening) → 30N·m |
| | PSA6 | φ 30 mm | 54 → 0 (loosening) → 36N·m |

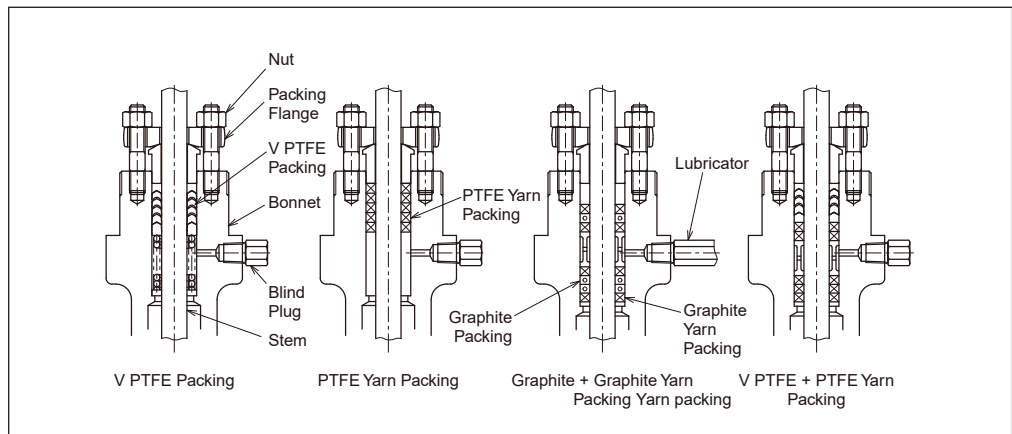


Fig. 2-1. Gland section

- (4) If the valve is provided with a lubricator as shown in Fig. 2-2, check whether the bonnet section has been lubricated or not. To do this, loosen the lubricator handwheel and turn the squeeze screw. If the squeeze screw turns easily, then apply grease following the lubricating procedure mentioned below. (If the squeeze screw turns stiffly, this means that grease has been applied.)

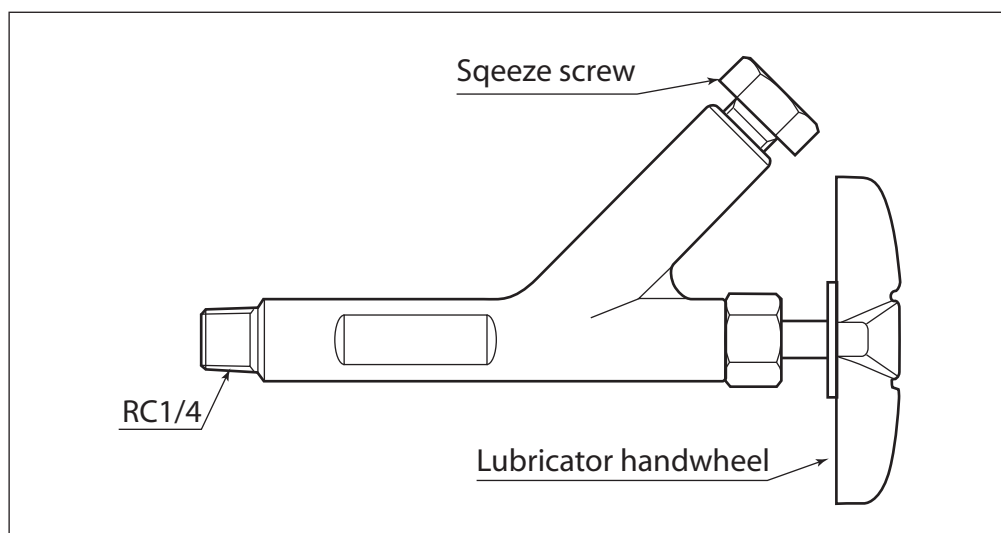


Fig. 2-2. Lubricator (Class 600 or under)

Lubricating Procedure

| Step | Procedure |
|------|----------------------------------------------------------------------------------------------------------------------------------|
| a | Prepare grease of the type indicated on the nameplate. |
| b | Tightly close the lubricator handwheel. |
| c | Remove the squeeze screw, apply grease, then reset the squeeze screw. |
| d | Loosen the lubricator handwheel and drive the grease by turning the squeeze screw. |
| e | Repeat the procedure of (b), (c) and (d) until turning of the squeeze screw becomes stiffer. Tightly close lubricator handwheel. |

- (5) When pressuring the valve, check that there is no leak from the gasket sections between the valve body and process pipe. If leakage is found, tighten the nuts. (Especially when the process fluid temperature is 400°C or higher, tighten the nuts again after raising temperature of the valve so that it may be in serve for a longer period without requiring immediate maintenance service.) Standard tightening torques are given in Table 2-2 on page 2-1, Table 4-1 on page 4-4.
- (6) When raising the temperature to a valve which is used for high temperature service, raise the temperature gradually (standard rate is 100°C per hour) and do not operate the valve while the temperature is being raised.

Chapter 3. Inspection and Maintenance

Inspection and service the actuator as follows:

Tightening the gland:

Tighten the gland about once in every 6 months. The tightening procedure is as given in Chapter 2-3(3) on page 2-2.

Lubricating the gland:

Lubricate the gland about once every 6 months. The lubricating procedure is as given in Chapter 2-3(4) on page 2-2.

Check for hunting of valve position:

Refer to "Chapter 13. Troubleshooting" on page 12-1.

Check for abnormal noise and vibration:

Refer to "Chapter 13. Troubleshooting" on page 12-1.

Chapter 4. Disassembly and Assembly

This chapter covers the disassembly and assembly procedures of the actuator for its overhaul or modification.

4-1. Detaching actuator from valve body

- (1) Apply to the actuator an air pressure so that the valve position pointer is at a point of 10% - 20% above the fully closed point.
- (2) Loosen the clamping-bolts of the stem connector, remove the stem connector, and detach the actuator stem from the valve stem.
- (3) Remove the clamping-nut of the yoke.
- (4) Raise the actuator to detach it from the valve body.

Precautions: To detach the actuator from the valve body which is kept installed in the process pipe, be sure to shut down the process fluid and release the process pressure before detaching the actuator

4-2. Disassembly and assembly of valve body

To disassemble or assemble the each temperature range valve body.

(For the handling of bellows sealed type (optional type) valves, See "Chapter 9. Instruction for Mechanical Flow Stopper of ActuatorInstructions for Bellows Sealed type of Control Valves")

4-2-1. Disassembly and assembly of plain ($-17 \leq t < 230\text{ }^{\circ}\text{C}$) and extension 1 ($-45 \leq t < 17\text{ }^{\circ}\text{C}$) bonnet type valve body

4-2-1-1. Disassembly procedure

| Step | Procedure |
|------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| 1 | Loosen the packing flange nut of the packing flange. |
| 2 | Remove the hex nuts (1) of the bonnet (extension bonnet). |
| 3 | Lift bonnet and remove. If the valve plug and cage (upper) are extracted together, turn the plug and cage (upper) to remove them from the bonnet, exercising care not to damage the stem. Then turn cage (upper) to extract plug from the cage (upper) exercising care not to damage seat ring. Seat ring and scraper ring may be damaged if the plug is extracted from the bottom of cage (upper). |
| 4 | Pull out the plug and then pull out the cage from the valve body. |

4-2-1-2. Inspection

Inspect the disassembled parts for damage. If any damages is found, replace the parts. (When ordering parts, mention also the Prod. No. of the valve which is indicated on the nameplate.)

- (1) Do not re-use the removed gland packing. Use fresh packing when reassembling the valve.
- (2) Check and ensure that there is no scar on sliding portions of plug, cage (upper) cage (lower), seat face and stem.
- (3) Check and ensure that there is no scar on sliding parts of seal ring and scraper ring. For a guideline on parts replacement, Refer to "Chapter 14. Recommended spare parts".
- (4) Check and ensure that there is no scar on body, bonnet and gasket faces. Do not reuse the gasket once its removed. Always use a new one when reassembling. For a guideline on parts replacement, Refer to "Chapter 14. Recommended spare parts".

4-2-1-3. Assembly procedure

| Step | Procedure |
|------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| 1 | Insert a spiral gasket into valve body. (Apply Never-seize* on all valves except degreased valve for oxygen application.) |
| 2 | Insert cage (lower) into the valve body. |
| 3 | Coat seal ring lightly with silicon grease, assemble on a slot on cage (upper) and insert plug into cage. (Apply Never-seize* on all valves except degreased valve for oxygen application.) |
| 4 | Insert gasket (lower) into valve body. (Apply Never-seize* on all gaskets except degreased valve for oxygen application.) |
| 5 | Coat scraper ring lightly with silicon grease, assemble on a slot above the plug and push the plug into the cage. (Apply Never-seize* on all gaskets except those for degreased valve for oxygen application.) When the plug's tip passes through seal ring, apply even load on the plug to push it in until the tip of the plug touches and sits against the seat on the cage (lower). |
| 6 | Insert gasket (upper) into cage (upper). (Apply Never-seize* on all gaskets except those for degreased valve for oxygen application.) |
| 7 | Put the bonnet on the valve body and check that the bonnet is correctly mated with the indented section of the valve body. Tighten the hex nuts uniformly, paying attention so that they are not tightened unevenly (tighten alternately the ones located at symmetrical positions). For tightening torques, see Table 4-1. |
| 8 | Insert the gland packing as shown in Fig. 2-1. Note: When yarn packing sheets are used, overlap sheets in such manner that their cut ends are positioned alternately. |
| 9 | Place the packing follower and packing flange, and tighten the nuts. For the tightening torques, See "Table 2-2. Tightening torques of packing flange nuts" on page 2-2. |

Table 4-1. Tightening torque of bonnet stud bolts

| Bolt | Torque (N·m {kgf·cm}) |
|-------------|------------------------------|
| M12 | 60 {600} |
| M16 | 100 {1,000} |
| M20 | 150 {1,500} |
| M22 | 200 {2,500} |
| M24 | 250 {2,500} |
| M27 | 350 {3,500} |
| M30 | 500 {5,000} |
| M33 | 660 {6,600} |

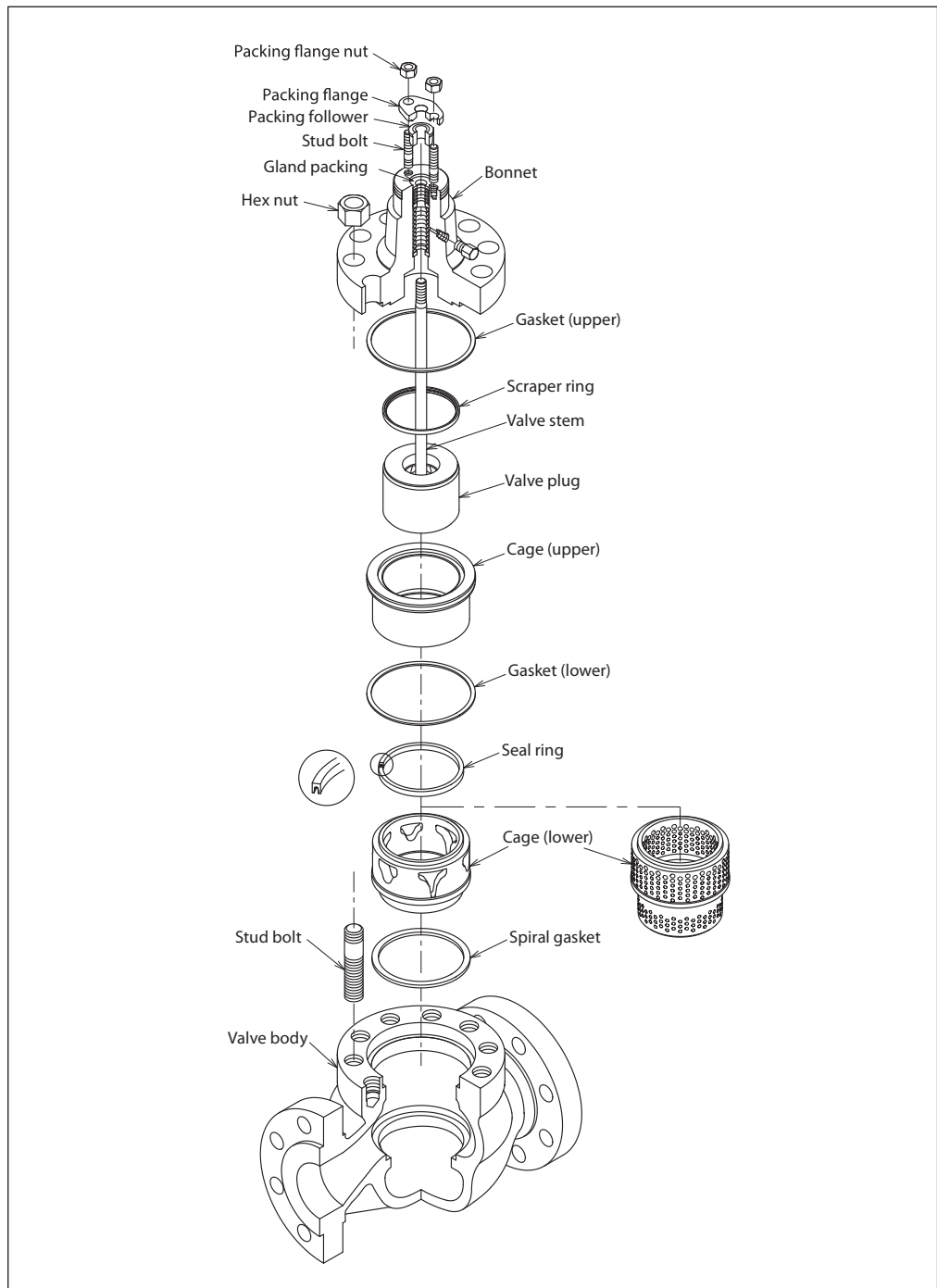
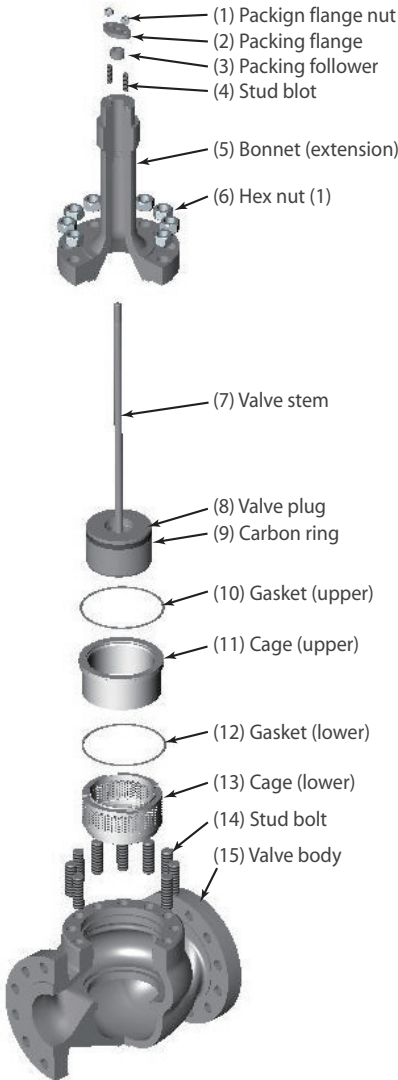
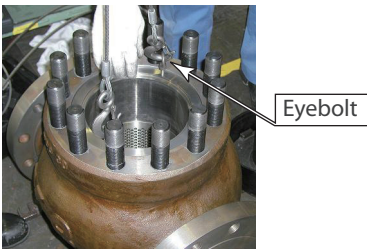
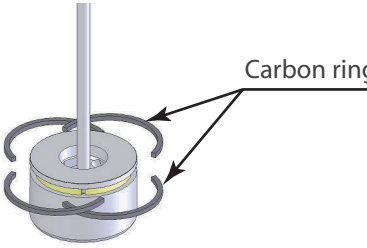
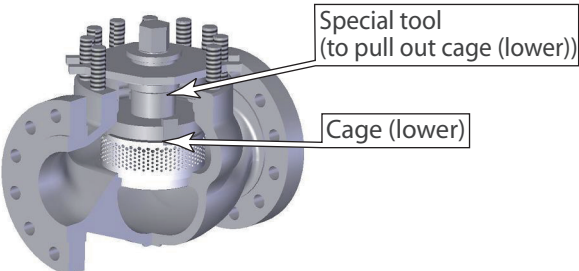


Fig. 4-1. Model ACP/ACN control valves

4-2-2. Disassembly and assembly of extension1 bonnet type ($230 \leq t < 400^{\circ}\text{C}$) valve body

4-2-2-1. Disassembly procedure

| Step | Procedure |
|------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| 1 | Loosen the packing flange nut of the packing Flange. |
| 2 | <p>Remove the hex nuts of the bonnet (extension 1 bonnet), using wrench.</p>  <p>Fig. 4-2. Extension 1 ($230 \leq t < 400^{\circ}\text{C}$)</p> |

| Step | Procedure |
|------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| 3 | <p>Lift the bonnet (5) and remove. Remove the gaskets (10)(12) which are attached to the upper and lower sides of the cage (upper) (11). If only the bonnet is extracted, remove cage (upper) from the body after removing the plug (8). When selecting a 4 inches or more size, remove using eyebolts. (Refer to Fig. 4-3.)</p> <p>If the valve plug and cage (upper) are extracted together, turn the plug and cage (upper) to remove them from the bonnet, exercising care not to damage the stem (7). Please take care not to drop the plug and cage (upper). Pull out the plug from the bonnet.</p>  <p>Fig. 4-3.</p> |
| 4 | <p>Pull out the carbon ring (9) from the plug, refer to Fig. 4-4. Since this breaks easily, be careful of handling.</p>  <p>Fig. 4-4.</p> |
| 5 | <p>Pull out the cage (lower) (12),using the special tools. (Refer to Fig. 4-5.)</p> |
| 6 | <p>Remove the packing flange nuts (1), and pull out the gland portions.</p>  <p>Fig. 4-5.</p> |

4-2-2-2. Inspection

Inspect the disassembled parts for damage. If any damages are found, replace the parts. (When ordering parts, mention also the Prod. No. of the valve which is indicated on the nameplate.)

- (1) Check and ensure that there is no scar on gland packing box.
- (2) Check and ensure that there is no scar on sliding portions of plug, cage (upper) cage (lower), seat face and stem.
- (3) Check and ensure that there is no scar on carbon ring. For a guideline on parts replacement, refer to "Chapter 14. Recommended spare parts".
- (4) Check and ensure that there is no scar on body, bonnet and gasket faces.

4-2-2-3. Assembly procedure

Do not reuse the gasket once its removed. Always use a new one when reassembling. For a guideline on parts replacement, refer to “Chapter 14. Recommended spare parts”.

| Step | Procedure |
|------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| 1 | Insert the cage (lower) into the valve body, using special tools, refer to Fig. 4-5. For tightening torques, see Table 4-1. |
| 2 | Insert gasket (12) into valve body. |
| 3 | Insert cage (upper) into valve body. |
| 4 | Attach a carbon ring to valve plug, refer to Fig. 4-4. |
| 5 | <p>Push the plug into the cage, using special tools, refer to Fig. 4-6. When the plug's tip passes through seal ring, apply even load on the plug to push it in until the tip of the plug touches and sits against the seat the cage (lower).</p> <div data-bbox="715 880 1054 1270"></div> <p>Special tool (for insert plug)</p> <p>Fig. 4-6.</p> |
| 6 | Insert the gasket (10) into cage (upper). |
| 7 | <p>Attach carefully not to throw bonnet at a stem.</p> <p>Put the bonnet on the valve body and check that the bonnet is correctly mated with the intended section of the valve body. Tighten the nuts uniformly, paying attention so that they are not tightened unevenly (tighten alternately the ones located at symmetrical positions). For tightening torques, see Table 4-1.</p> |
| 8 | <p>Insert the gland packing into the gland box, refer to Fig. 2-1.</p> <p>Note: In case of using yarn-packing, which must be attached as each cut end becomes by turns.</p> <p>Insert the packing follower (3) and packing flange (2), and tighten the nuts uniformly. For tightening torques, see Table 4-1.</p> |

Table 4-2. Tightening torque of cage (lower)

| Nominal size (inches) | Torque N·m |
|------------------------------|-------------------|
| 1-3/4 | 255 to 314 |
| 2 | 382 to 461 |
| 2-3/4 | 510 to 617 |
| 3 | 637 to 764 |
| 4 | 784 to 980 |
| 5 | 784 to 980 |
| 6 | 1176 to 1470 |
| 8 | 1470 to 1862 |

4-3. Disassembly and assembly of actuator

Normally the actuator requires no adjustment. However, it should be disassembled and assembled when installing it on a valve body, when modifying its specifications, or when replacing damaged parts. The disassembly and assembly procedure of the actuator for such purposes are covered in "Chapter 4-3-1. Disassembly and assembly of model HA2, HA3 or HA4 actuator" on page 4-12.

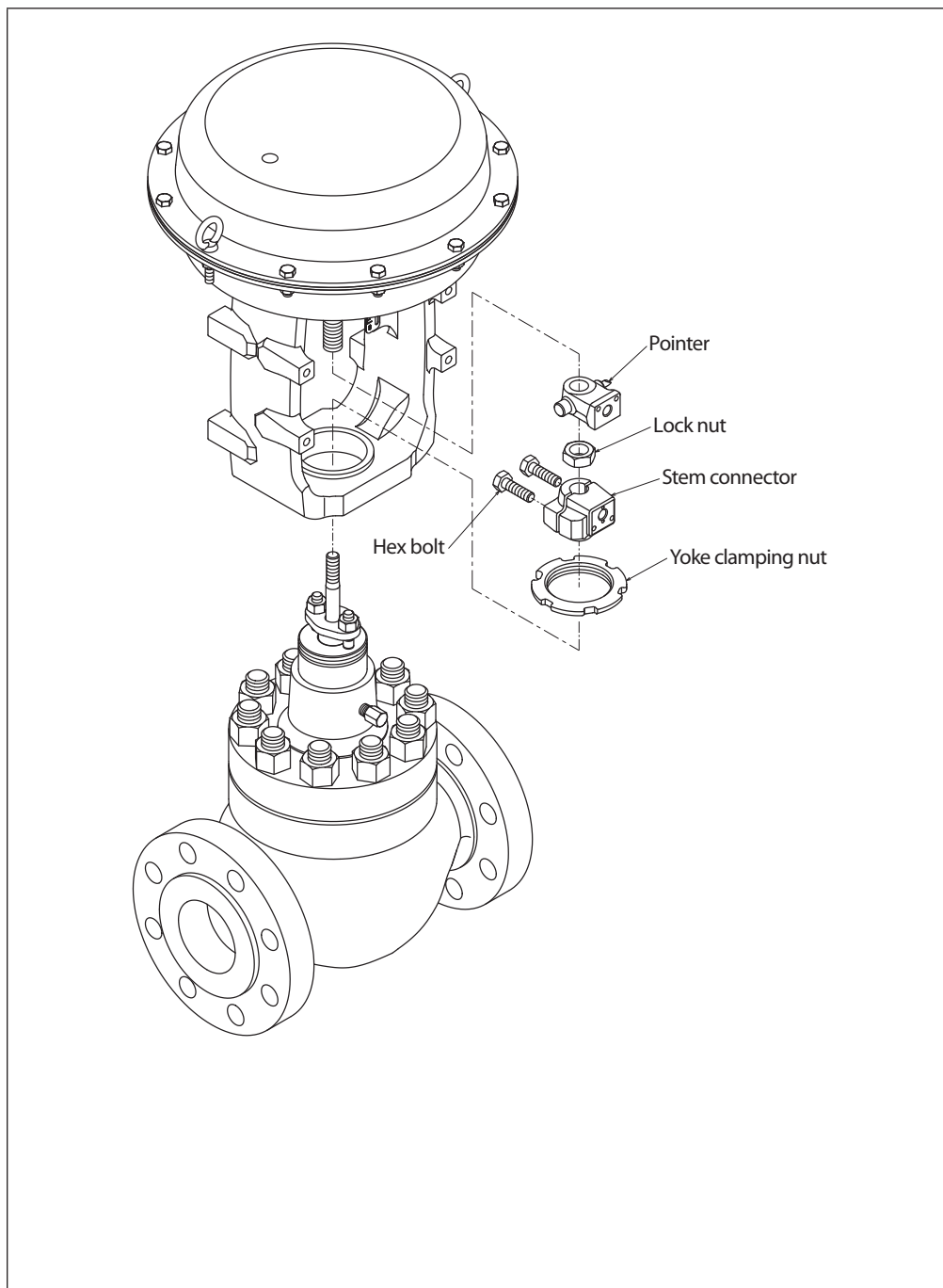



Fig. 4-7.

When disassembling or assembling the actuator, keep it in a vertical position. For the tightening torques of bolts and nuts, see Table 4-2 and Table 4-3.
For the names of parts, see Fig. 4-15.

Notes on Disassembly

- (1) The nuts for the eyebolts are made of stainless steel. Discriminate these nuts from other nuts when assembling the diaphragm case.
- (2) It is recommended to make locating marks on the top and bottom diaphragm cases before disassembly. This will help you to easily find the air piping connector location.
- (3) Store the removed parts in a clean place.

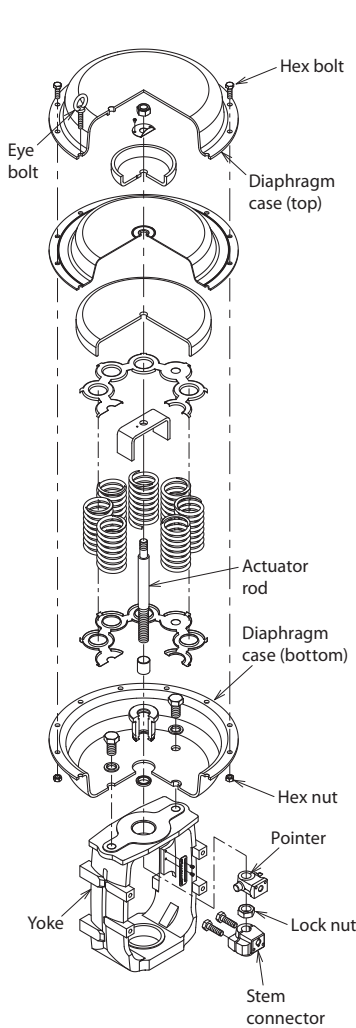
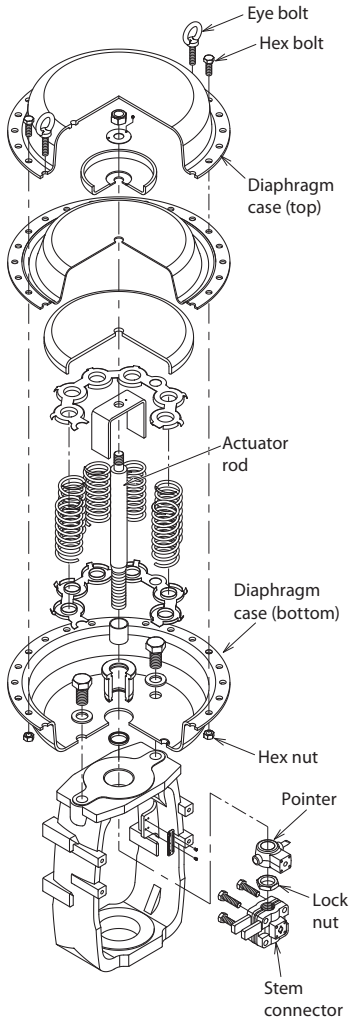
| |  CAUTION | |
|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------|--|
| Never loosen or remove carelessly the bolts and nuts of the actuator. The actuator employs powerful compressed springs and if you remove the bolts and nuts carelessly, the springs may leap out causing hazards. When removing the bolts and nuts, be sure to observe the instructions given for the disassembly and assembly procedures of the actuator and top handwheel.. | | |

4-3-1. Disassembly and assembly of model HA2, HA3 or HA4 actuator

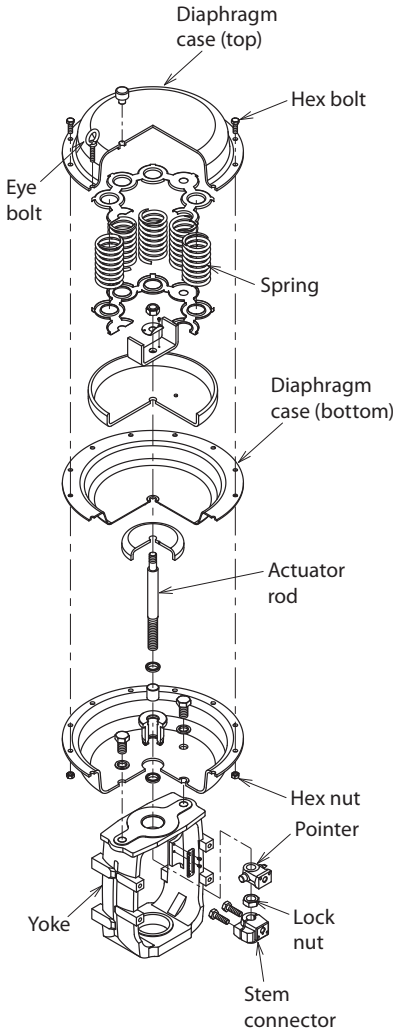
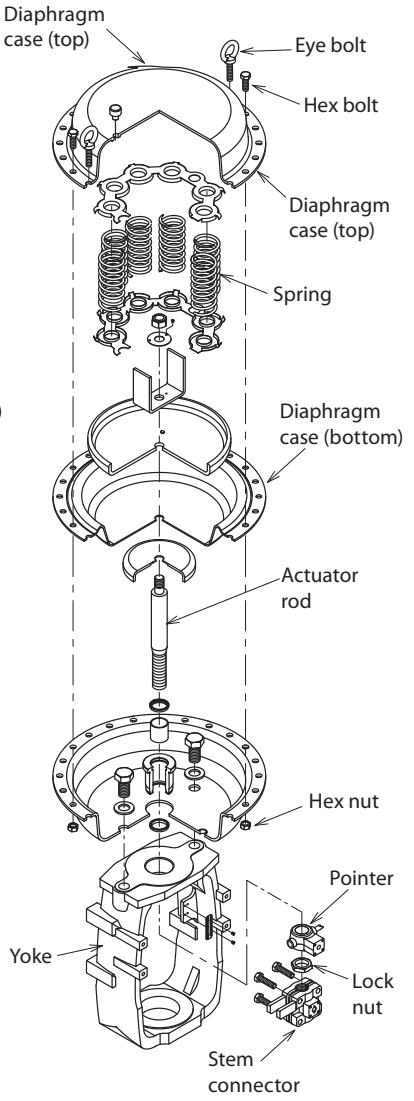
4-3-1-1. Disassembly procedure

(a) Direct action type (See Fig. 4-8 or Fig. 4-9)

| Step | Procedure |
|-------------|---------------------------------------------------------------------------------------------------------------------|
| 1 | Disconnect the air piping and detach the accessories from the actuator. |
| 2 | Remove the stem connector, pointer and lock nut. |
| 3 | Remove the hex-bolts (except the pair of eyebolts) and nuts of the diaphragm case. |
| 4 | Loosen evenly and alternately the pair of eyebolts. (The initial setting of the springs is done by these eyebolts.) |
| 5 | Remove the diaphragm case. Pull the actuator rod upward together with the diaphragm. |

| Step | Procedure |
|------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| 6 | <p data-bbox="584 271 802 300">Remove the springs.</p> <div data-bbox="655 320 1011 1344">  </div> <div data-bbox="1018 320 1369 1344">  </div> <div data-bbox="611 1379 963 1444"> <p>Fig. 4-8. Actuator Model HA2D or HA3D</p> </div> <div data-bbox="1050 1379 1399 1411"> <p>Fig. 4-9. Actuator Model HA4D</p> </div> |

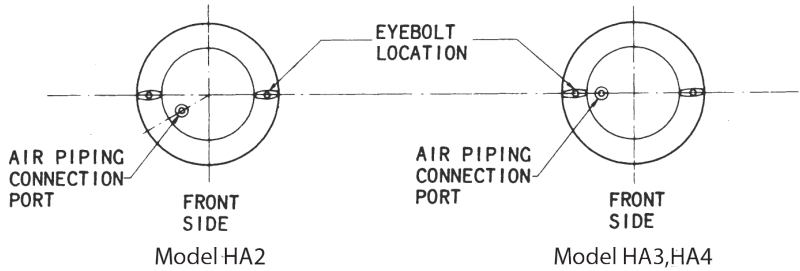
(b) Reverse action type (See Fig. 4-10 or Fig. 4-11)

| Step | Procedure |
|------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| 1 | Disconnect the air piping and detach other external items from the actuator. |
| 2 | Remove the stem connector, pointer and lock nut. |
| 3 | Remove the clamping-bolts (except the pair of eyebolts) of the diaphragm case. |
| 4 | Loosen evenly and alternately the pair of eyebolts. (The initial setting of the springs is done by these eyebolts.) |
| 5 | Remove the diaphragm case. Remove the springs. |
| 6 | <p>Pull the actuator rod upward together with the diaphragm.</p> <div style="display: flex; justify-content: space-around; align-items: flex-start;"> <div style="text-align: center;">  <p>Fig. 4-10. Actuator Model HA2R or HA3R</p> </div> <div style="text-align: center;">  <p>Fig. 4-11. Actuator Model HA4R</p> </div> </div> |

4-3-1-2. Assembly procedure

Before assembly, check the parts for scrapes, damage, deformation, peeling off of paint, or any other abnormalities. To assemble the actuator, proceed as follows:

(a) Direct action type

| Step | Procedure |
|------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| 1 | Fix the bottom diaphragm case and yoke with the bolts. (For models HA2D and HA3D, install the diaphragm case and spring plate together.) |
| 2 | <p>Install the springs on the spring plate. The quantities of springs are as follows:</p> <p>Model HA2 4 springs</p> <p>Model HA3, HA4 8 springs</p> <p>Except particular models as follows:</p> <p>Model HA2, 38 mm stroke, 80 - 240 kPa {0.8 - 2.4 kgf/cm²}..... Total 8 springs (with double springs)</p> <p>Model HA3, 50 mm stroke, 80 - 240 kPa {0.8 - 2.4 kgf/cm²}..... Total 16 springs (with double springs)</p> <p>Model HA4, 75 mm stroke, 80 - 240 kPa {0.8 - 2.4 kgf/cm²}..... Total 16 springs (with double springs)</p> |
| 3 | Insert the actuator rod (to which the diaphragm is connected) into the bushing, exercising care not to damage the bushing inside surface or dust seal with the threaded section of the rod. (For example, cover the threaded section with adhesive tape to prevent damaging the bushing.) Set the stopper in parallel with the yoke. |
| 4 | <p>Place the top diaphragm case and fix it with the pair of eyebolts.</p> <p>Note: Set the air piping connection port in the location shown in the illustration. (Fig. 4-12)</p> <p>Note: Tighten the pair of eyebolts uniformly by tightening them alternately. The initial setting of the springs is complete by tightening of these eyebolts.</p>  <p style="text-align: center;">Fig. 4-12. Direct action type</p> |
| 5 | Clamp the diaphragm case with clamping-bolts other than the pair of eyebolts. |
| 6 | Install the pointer, secure the lock nut, and install the stem connector. (Connect the air pipe to the air piping connection port of the top diaphragm case.) |

| Step | Procedure |
|------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| 7 | <p>After the assembly is complete as above, check the following.</p> <ol style="list-style-type: none"> 1. Applying an air pressure of 490 kPa {5 kgf/cm²} via the air piping connection port of the top diaphragm case, check the diaphragm periphery for air leak by using soapsuds. 2. Check that the actuator smoothly operates at its full stroke. <p>Note: Check this operation by operating the actuator as an independent unit.</p> |

(b) Reverse action type

| Step | Procedure |
|------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| 1 | Fix the bottom diaphragm case and yoke with the bolts. |
| 2 | Insert the actuator rod (to which the diaphragm is connected) into the bushing, exercising care not to damage the bushing inside surface or dust seal with the thread section of the rod. (For example, cover the threaded section with adhesive tape to prevent damaging the bushing.) |
| 3 | Make the stopper (in the diaphragm plate) in parallel with the yoke by turning the rod. |
| 4 | <p>Install the springs on the spring plate. The quantities of springs are as follows:</p> <p>Model HA2.....4 springs</p> <p>Model HA3, HA48 springs</p> <p>Except particular models as follows:</p> <p>Model HA2, 38 mm stroke, 80 - 240 kPa {0.8 - 2.4 kgf/cm²} Total 8 springs (with double springs)</p> <p>Model HA3, 50 mm stroke, 80 - 240 kPa {0.8 - 2.4 kgf/cm²} Total 16 springs (with double springs)</p> <p>Model HA4, 75 mm stroke, 80 - 240 kPa {0.8 - 2.4 kgf/cm²} Total 16 springs (with double springs)</p> |
| 5 | <p>Place the top diaphragm case and fix it with the pair of eyebolts. Set the air vent hole in the location shown in the illustration (Fig. 4-13). Uniformly and alternately tighten the eyebolts. The initial setting of the springs is complete by tightening these eyebolts.</p> <div data-bbox="601 1579 1380 1843" data-label="Image"> </div> <p style="text-align: center;">Fig. 4-13. Reverse action type</p> |
| 6 | Clamp the diaphragm case with other clamping-bolts other than the pair of eyebolts. |

| Step | Procedure |
|------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| 7 | Install the pointer, secure the lock nut, and install the stem connector. |
| 8 | Install the rain cap on the air vent port. |
| 9 | Connect the air pipe to the air piping connection port of the bottom diaphragm case. |
| 10 | <p>After the assembly is complete as above, check the following.</p> <ol style="list-style-type: none"> 1. Applying an air pressure of 490 kPa {5 kgf/cm} via the air piping connection port of the bottom diaphragm case, check the diaphragm periphery for air leak by using soapsuds. 2. Check that the actuator smoothly operates at its full stroke unit. <p>Note: Check this operation by operating the actuator as an independent.</p> |

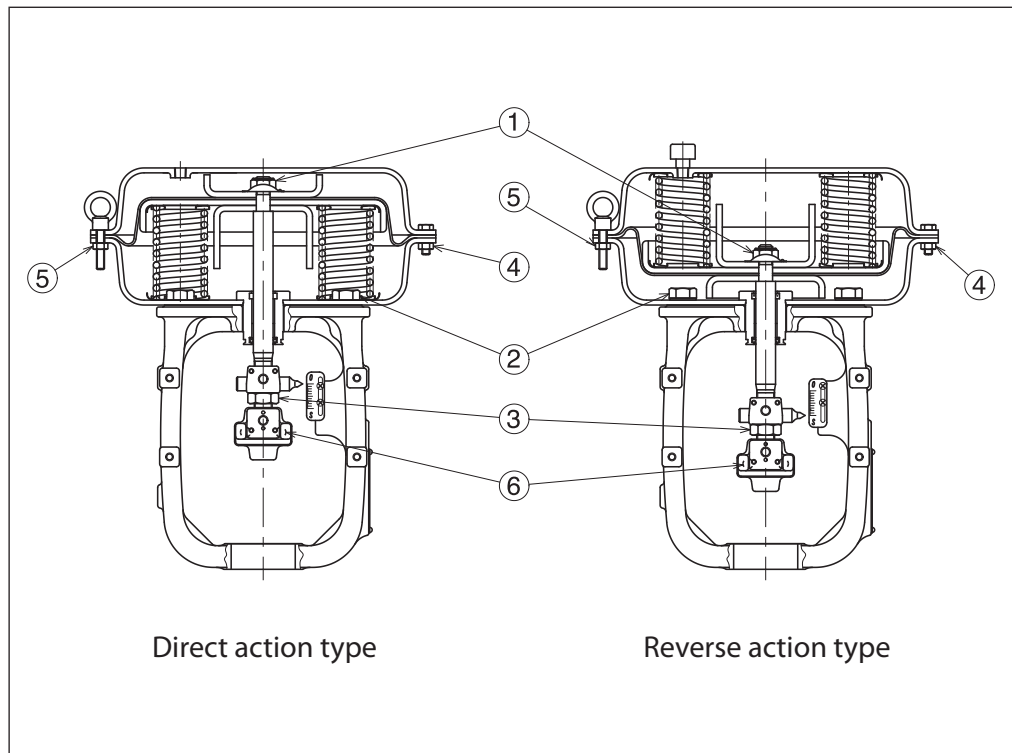


Fig. 4-14. Bolts and nuts of actuator

Table 4-3. Tightening torque bolts and nuts of actuator

[Unit: N·m {kgf/cm}]

| No. | Material | For Model HA2 | | For Model HA3 | | For Model HA4 | |
|-----|----------|---------------|----------|---------------|-------------|---------------|-------------|
| 1 | SK5 S45C | M10 | 37 {370} | M14 | 100 {1,050} | M20 | 310 {3,170} |
| 2 | S30C | M12 | 42 {420} | M16 | 100 {1,050} | M24 | 360 {3,600} |
| 3 | S20C | M14 | 69 {690} | M18 | 145 {1,450} | M30 | 700 {7,160} |
| 4 | S20C | M8 | 16 {160} | M8 | 16 {160} | M12 | 42 {420} |
| 5 | SUS304 | M8 | 18 {185} | M8 | 18 {185} | M12 | 63 {630} |
| 6 | S30C | M10 | 37 {375} | M10 | 37 {375} | M12 | 42 {420} |
| | | | 56 {560} | | 56 {560} | | 63 {630} |

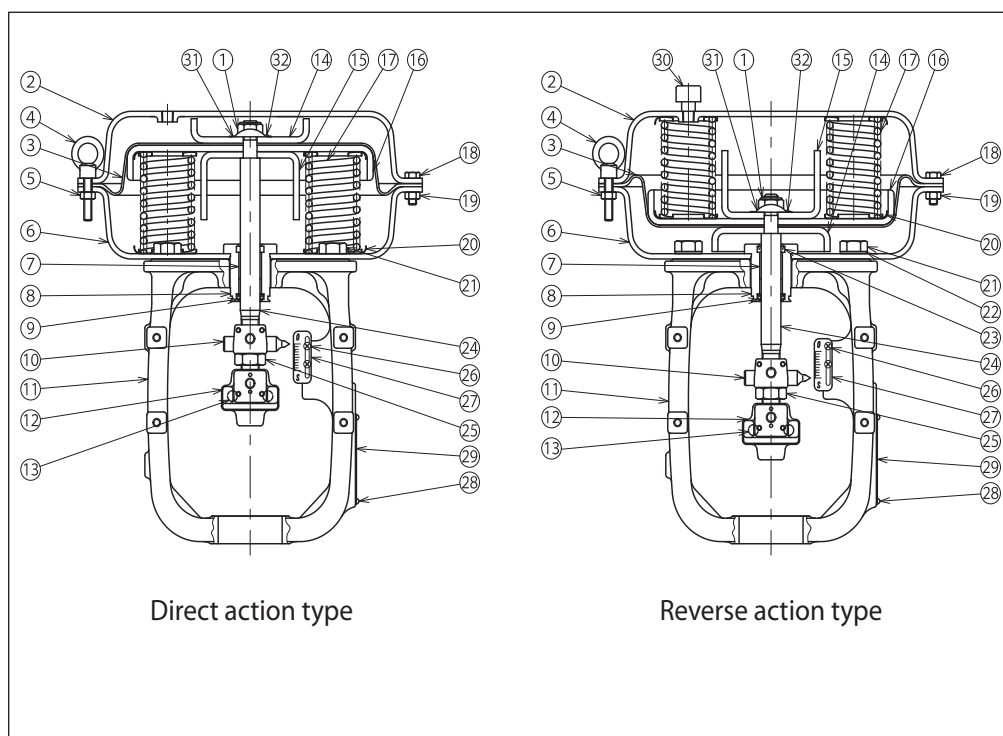


Fig. 4-15. Cut view of actuator

| No. | Parts name | Material | No. | Parts name | Material |
|-----|-------------------------|----------------|-----|-----------------------------------------|---------------------|
| 1 | Nut | S45C, SUS301 | 17 | Coil spring | SWOSM-B |
| 2 | Diaphragm case (top) | SAPH370 | 18 | Hex bolt | SUS304 |
| 3 | Diaphragm | EPDM, Nylon 66 | 19 | Hex nut | SUS304 |
| 4 | Eye bolt | SUS304 | 20 | Spring plate | SPCC |
| 5 | Hex nut | SUS304 | 21 | Hex bolt | S30C |
| 6 | Diaphragm case (bottom) | SAPH370 | 22 | Ssal Washer | NBR, SPCC |
| 7 | Bushing | SPCC, PTFE | 23 | Rod packing | NBR |
| 8 | Bearing | S20C | 24 | Rod | SUS304 |
| 9 | Dust seal | NBR | 25 | Lock nut | SUS304 |
| 10 | Pointer | S25C | 26 | Trus screw, spring washer, or speed nut | SUS304, SUS304, SK5 |
| 11 | Yoke | SCPH2 | 27 | Scale plate | SUS304 |
| 12 | Stem connector | S25C | 28 | Screw | SUS304 |
| 13 | Stem connector Bolt | SUS304,S30C | 29 | Nameplate | SUS304 |
| 14 | Diaphragm retainer | SS400 | 30 | Cap | SUS304 |
| 15 | Stopper | SS400 | 31 | Washer | SPCC |
| 16 | Diaphragm plate | SS400 | 32 | Tapping screw | S20C |

Chapter 5. Adjustment

As a general rule, diaphragm type control valves require no adjustment. However, when coupling an actuator to a valve body after removing the actuator for overhaul or other purposes, adjustment of the travel (stroke) is necessary. For this adjustment, refer to Fig. 4-7, Fig. 5-1 and proceed as follows:

- (1) Fix the actuator to the valve body by securely tightening the yoke clamping-nut (use a chisel and hammer).
- (2) Connect an adjustable air pressure (with a pressure regulator) to the actuator -- to the top diaphragm case for the direct action type or the bottom diaphragm case for the reverse action type.
- (3) Lower the valve seat and check that it is touching the valve seat.

5-1. For direct action type

- (4) Apply to the actuator the maximum air pressure corresponding to the spring range indicated on the nameplate.
- (5) Increase the air pressure once. Then increase it again to the maximum value corresponding to the spring range, in the increasing direction.
- (6) In the above state, align the actuator stem and valve stem in a straight line, adjust so that the thread of the stem connector mates with those of actuator stem and valve stem, and securely tighten the clamping-bolts of the stem connector.

5-2. For reverse action type

- (4) Apply to the actuator the minimum air pressure corresponding to the spring range indicated on the nameplate, and check that the actuator stem moves by 1~2 mm in response.
- (5) Increase the air pressure once. Then decrease it again to the minimum value corresponding to the spring range, in the decreasing direction.
- (6) Perform a procedure identical with that of Item (7) of “For Direct Action type”.

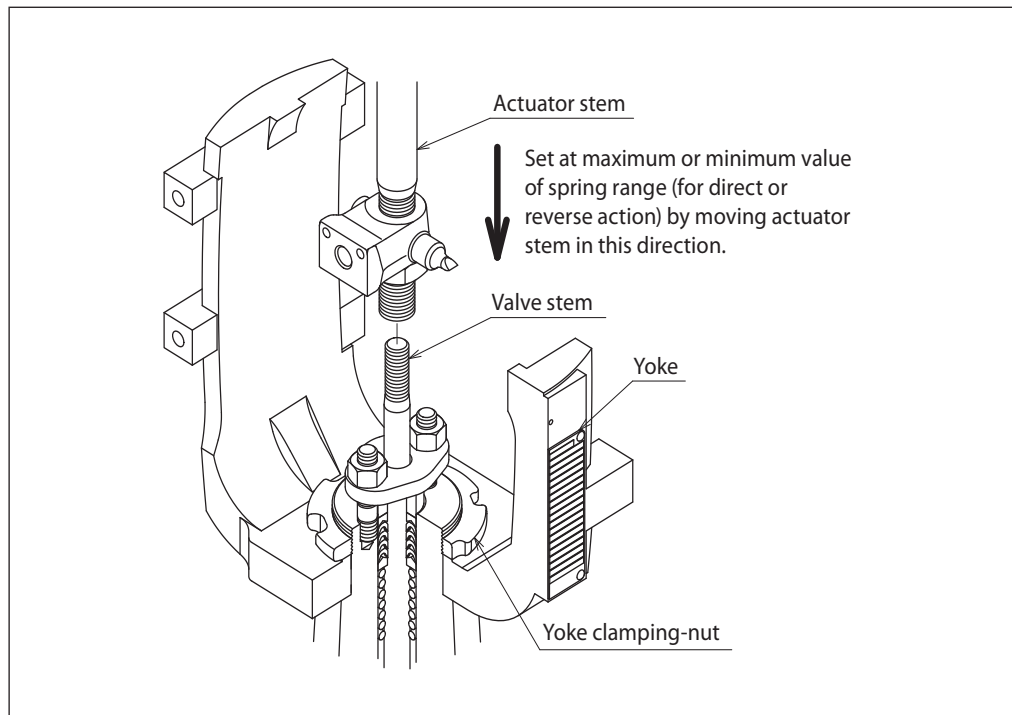


Fig. 5-1.

Chapter 6. Direct / Reverse Action type Conversion and Spring range Change of Actuator

6-1. Direct / Reverse action change

As a general rule it is most recommendable to prepare separately the direct type and reverse type of actuators and not to convert actuators into different types. However, when it has become unavoidable to convert actuators into other types, conversions may be done by using the parts mentioned below (Table 6-1 on page 6-2 and Table 6-2 on page 6-3). The parts marked “+” are the ones which are newly needed and those marked “-” are ones which are not used.

Table 6-1. To convert the direct action type into the reverse action type

| Model HA2D -> Model HA2R | | | |
|------------------------------------|------------|------------------------------------------------|-------------------------|
| Part name | Qty | For stroke 14.3 mm, 25 mm | For stroke 38 mm |
| Seal washers | +4 | 82521069-101 | 82521069-101 |
| Rod packing | +1 | 82521067-101 | 82521067-101 |
| Rod unit | +1 | 82521431-101 (14.3 mm) 82521431-102 (25 mm) | 82521431-103 |
| Rain cap | +1 | 82553334-101 | 82553334-101 |
| Rod | (-1) | 82521427-101 (14.3 mm) 82521427-102 (25 mm) | 82521427-103 |

| Model HA3D -> Model HA3R | | | | |
|------------------------------------|------------|---------------------------|----------------------------------------------|-------------------------|
| Part name | Qty | For stroke 14.3 mm | For stroke 14.3 mm, 25 mm | For stroke 38 mm |
| Seal washers | +2 | 82521069-102 | 82521069-102 | 82521069-102 |
| Rod packing | +1 | 82521067-102 | 82521067-102 | 82521067-102 |
| Rod unit | +1 | 82521431-201 | 82521063-103 (25 mm) 82521063-104 (38 mm) | 82521431-204 |
| Rain cap | +1 | 82553334-101 | 82553334-101 | 82553334-101 |
| Rod | (-1) | 82521428-101 | 82521428-102 (25 mm) 82521428-103 (38 mm) | 82521428-104 |

| Model HA4D -> Model HA4R | | | |
|------------------------------------|------------|-------------------------|----------------------------------------------------------------------|
| Part name | Qty | For stroke 25 mm | For stroke 38 mm, 50 mm, 75 mm |
| Seal washers | +2 | 82521069-103 | 82521069-103 |
| Rod packing | +1 | 82521067-103 | 82521067-103 |
| Rod unit | +1 | 82521431-302 | 82521431-303 |
| Rain unit | (-1) | 82521429-102 | 82521429-103 (38 mm) 82521429-104 (50 mm) 82521429-105 (75 mm) |
| Rain cap | +1 | 82553334-101 | 82553334-101 |
| Flat washers | (-2) | 82592131-201 | 82592131-201 |

Table 6-2. To convert the reverse action type into the direct action type

| Model HA2D -> Model HA2R | | | |
|------------------------------------|------------|------------------------------------------------|-------------------------|
| Part name | Qty | For stroke 14.3 mm, 25 mm | For stroke 38 mm |
| Seal washers | (-2) | 82521069-101 | 82521069-101 |
| Rod packing | (-1) | 82521067-101 | 82521067-101 |
| Rod unit | +1 | 82521427-101 (14.3 mm) 82521427-102 (25 mm) | 82521427-103 |
| Rain unit | (-1) | 82521431-101 (14.3 mm) 82521431-102 (25 mm) | 82521431-103 |
| Rain cap | (-1) | 82553334-101 | 82553334-101 |

| Model HA3D -> Model HA3R | | | | |
|------------------------------------|------------|---------------------------|----------------------------------------------|-------------------------|
| Part name | Qty | For stroke 14.3 mm | For stroke 14.3 mm, 25 mm | For stroke 38 mm |
| Seal washers | (-2) | 82521069-102 | 82521069-102 | 82521069-102 |
| Rod packing | (-1) | 82521067-102 | 82521067-102 | 82521067-102 |
| Rod unit | +1 | 82521428-101 | 82521428-102 (25 mm) 82521428-103 (38 mm) | 82521428-104 |
| Rain unit | (-1) | 82521431-201 | 82521431-202 (25 mm) 82521431-203 (38 mm) | 82521431-204 |
| Rain cap | (-1) | 82553334-101 | 82553334-101 | 82553334-101 |

| Model HA4D -> Model HA4R | | | |
|------------------------------------|------------|-------------------------|----------------------------------------------------------------------|
| Part name | Qty | For stroke 25 mm | For stroke 38 mm, 50 mm, 75 mm |
| Seal washers | (-2) | 82521069-103 | 82521069-103 |
| Flat washers | +2 | 82592131-201 | 82592131-201 |
| Rod packing | (-1) | 82521067-103 | 82521067-103 |
| Rod unit | (-1) | 82521431-302 | 82521431-303 |
| Rain unit | +1 | 82521429-102 | 82521429-103 (38 mm) 82521429-104 (50 mm) 82521429-105 (75 mm) |
| Rain cap | (-1) | 82553334-101 | 82553334-101 |

6-2. Stroke and range spring change

As a general rule it is most recommendable to prepare separate actuators for different strokes and spring ranges to avoid modifications. However, modifications can be done by using the parts mentioned below.

Of models HA2 and HA3, there are two different diameters of bonnet connecting sections. For these models, note the following:

Of model HA, modification for change between rated stroke of 14.3 or 25 mm and that of 38mm cannot be done.

Of model HA3, modification for change between rated stroke of 25 or 38 mm and that of 50mm cannot be done.

Table 6-3. Parts required for respective stroke range

| Actuator | | Model HA2D -> Model HA2R | | |
|------------------|---------------------|------------------------------------|----------------------------|----------------------------|
| Part name | | Qty | Stroke 25 → 14.3 mm | Stroke 14.3 → 25 mm |
| Scale plate | | 1 | 80225032-164 | 80225037-164 |
| Spring | 20-98 {0.2 -0.1} | 4 | 82521205-101 | 82521205-103 |
| | 80-240 {0.8-2.4} | 4 | 82521205-102 | 82521208-101 |
| Rod unit | R (reverse action) | 1 | 82521431-101 | 82821431-102 |
| | D (Direct action) | 1 | 82521427-101 | 82521427-102 |

| Actuator | | Model HA3D -> Model HA3R | | |
|------------------|---------------------|------------------------------------|----------------------------|----------------------------|
| Part name | | Qty | Stroke 25 → 14.3 mm | Stroke 14.3 → 25 mm |
| Scale plate | | 1 | 80225037-164 | 80225039-164 |
| Spring | 20-98 {0.2 -0.1} | 8 | 82521206-101 | 82521206-103 |
| | 80-240 {0.8-2.4} | 8 | 82521206-102 | 82521209-101 |
| Rod unit | R (reverse action) | 1 | 82521431-202 | 82821431-203 |
| | D (Direct action) | 1 | 82521428-102 | 82521428-103 |

| Actuator | | Model HA4D -> Model HA4R | | | | |
|------------------|---------------------|------------------------------------|---------------------|---------------------|---------------------|--------------------------------|
| Part name | | Qty | Stroke 25 mm | Stroke 38 mm | Stroke 50 mm | Stroke 75 mm |
| Scale plate | | 1 | 80225037-164 | 80225039-164 | 80225041-164 | 80224425-164 |
| Spring | 20-98 {0.2-0.1} | 8 | 82521244-104 | 82521207-101 | 82521207-102 | 82521210-103 |
| | 80-240 {0.8-2.4} | 8 | 82521244-106 | 82521210-101 | 82521210-102 | 82521210-104* 82521210-105* |
| Rod unit | R (reverse action) | 1 | 82521429-102 | 82521429-103 | 82521429-104 | 82521429-105 |
| | D (Direct action) | 1 | 82521431-302 | 82521431-303 | 82521431-303 | 82521431-303 |

Note: Spring force is equivalent to air pressure (kPa{kgf/cm²})

*: The quantity of springs is 8 set, with 2 springs for each set, or total 16 springs.

Color codes and dimensions of the springs of model HA actuators

The color codes and dimensions of the springs of model HA Actuators are as shown in the following table. The color codes may help you confirm springs when disassembling and assembling actuators for modification or other purpose.

Table 6-4. Color codes and dimensions of springs

| Rated stroke | Actuator Model | | PSA1 | HA2 | HA3 | HA4 |
|--------------|---------------------|----------------|----------------|---------------------------|------------------------------|-----|
| | Range | | | | | |
| 14.3 | 20-98 {0.2-1.0} | Red 64.6 | Red 86.1 | Yellow and 99.2 | | |
| | 80-240 {0.8-2.4} | Blue 69.8 | Blue 90.7 | Red and green 103.6 | | |
| 25 | 20-98 {0.2-1.0} | Green 68.7 | Yellow 89.8 | Red 100.3 | Yellow and green 148.1 | |
| | 80-240 {0.8-2.4} | Purple 78.8 | Brown 98.3 | Blue 108.1 | Red and green 155.3 | |
| 38 | 20-98 {0.2-1.0} | | Green 93.9 | Yellow 103.9 | Red 151.8 | |
| | 80-240 {0.8-2.4} | | Purple 107 | Brown 115.9 | Blue 162.7 | |
| 50 | 20-98 {0.2-1.0} | | | Green 107.5 | Yellow 155.3 | |
| | 80-240 {0.8-2.4} | | | Purple 123.2 | Brown 169.6 | |
| 75 | 20-98 {0.2-1.0} | | | | Green 162.4 | |
| | 80-240 {0.8-2.4} | | | | Purple (Note1) 181, 185.7 | |

Note: 1. Each set is comprised of two springs.

- “0.2-1.0” and “0.8-2.4” are spring forces corresponding to air pressures in the unit of kPa{kgf/cm²}.
- The dimensions indicated in the Table 6-4 are free lengths of springs.

Chapter 7. Instructions for Top

7-1. Model HA2, HA3, or HA4 actuator

Operating Instructions

To manually operate the actuator, refer to Fig. 7-1 through Fig. 7-6 and proceed as follows:

First, loosen the lock nut (which has a bar-shape handle and which locks the handwheel) and turn the handwheel in the direction indicated by the corresponding arrowhead mark.

As you turn the handwheel clockwise, the actuator stem moves downward regardless of whether the actuator is of the direct action type or reverse action type. The handwheel bears the “SHUT” mark to indicate that the valve is closed as the handwheel is turned clockwise and the “OPEN” mark to indicate that the valve is open as the handwheel is turned counterclockwise.

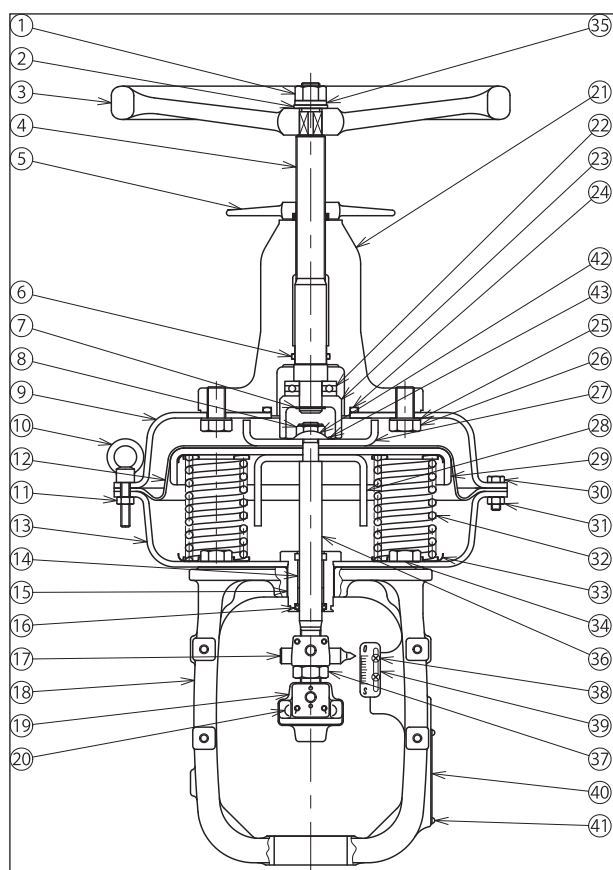
For automatic operation of the actuator, fully raise the handwheel if the actuator is of the direct action type or fully lower the handwheel if the actuator is of the reverse action type, and then tighten the lock nut to secure the handwheel to that position.

Precautions: If you force turn the handwheel after it has reached the mechanical stop position, the valve stem may be damaged. Do not turn the handwheel with forces larger than the mentioned below limits.

Model HA2: 190 N {19 kgf}

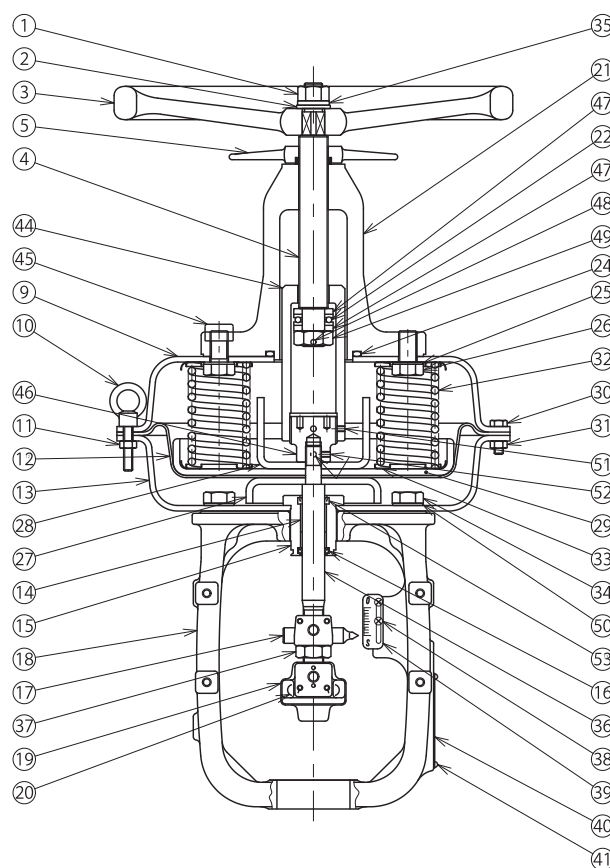
Model HA3: 260 N {26 kgf}

Model HA4: 410 N {41 kgf}



Direct action type

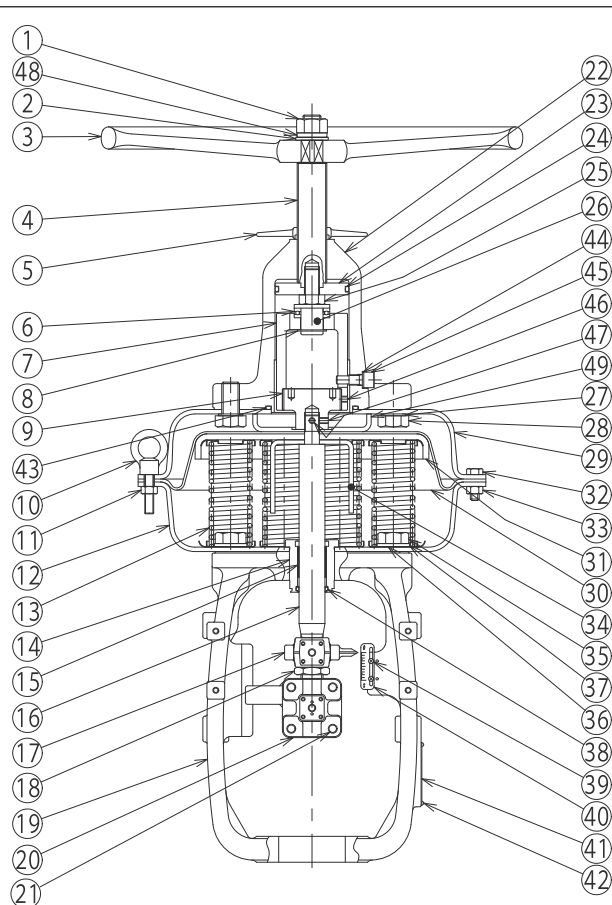
Fig. 7-1. Model HA 2/3 actuator with top handwheel
(Direct action type)



Reverse action type

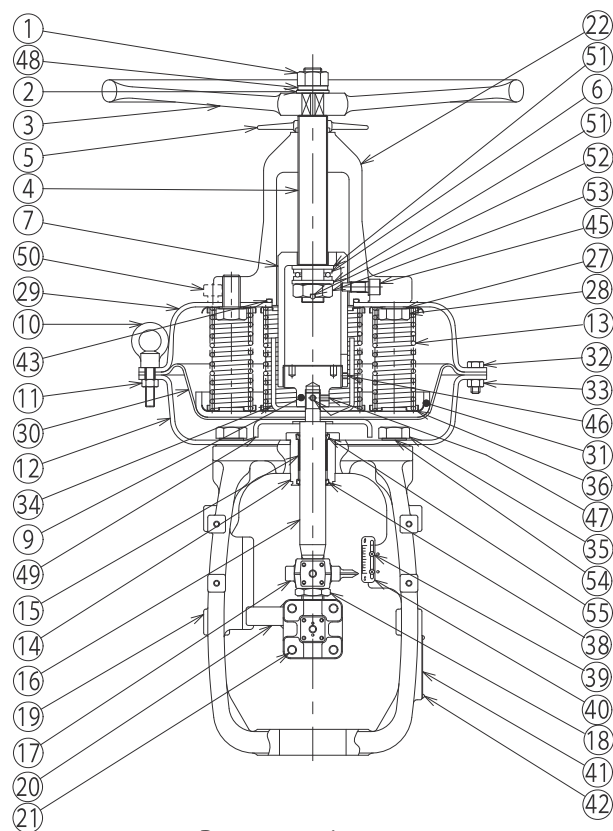
Fig. 7-2. Model HA2/3 actuator with top
handwheel(Reverse Action type)

| No | Parts name | No | Parts name | No | Parts name | No | Parts name |
|----|-------------------------|----|---------------------|----|------------------------------------------|----|-----------------|
| 1 | Hex nut | 15 | Bearing | 29 | Diaphragm plate | 43 | Tapping screw |
| 2 | Washer | 16 | Dust seal | 30 | Hex bolt | 44 | Bearing case |
| 3 | Handwheel | 17 | Pointer | 31 | Hex nut | 45 | Cap |
| 4 | Screw shaft | 18 | Yoke | 32 | Compressed coil spring | 46 | Connection |
| 5 | Lock nut | 19 | Stem connector | 33 | Spring plate | 47 | Bearing washer |
| 6 | O-ring | 20 | Stem connector bolt | 34 | Hex bolt | 48 | Cotter pin |
| 7 | Cotter | 21 | Housing | 35 | Spring washer | 49 | Castle nut |
| 8 | Nut | 22 | Bearing | 36 | Rod | 50 | Seal washer |
| 9 | Diaphragm case (top) | 23 | Spring retainer | 37 | Lock nut | 51 | Setscrew |
| 10 | Eye-bolt | 24 | O-ring | 38 | Truss screw, spring washer, or speed nut | 52 | Setscrew |
| 11 | Hex nut | 25 | Seal washer | 39 | Scale | 53 | Packing for rod |
| 12 | Diaphragm | 26 | Hex nut | 40 | Nameplate | | |
| 13 | Diaphragm case (bottom) | 27 | Diaphragm retainer | 41 | Drive screw | | |
| 14 | Bushing | 28 | Stopper | 42 | Washer | | |



Direct action type

Fig. 7-3. Model HA4 Actuator with top handwheel
(Direct action type)



Reverse action type

Fig. 7-4. Model HA4 actuator with top handwheel
(Reverse action type)

| No. | Parts name | No. | Parts name | No. | Parts name | No. | Parts name |
|-----|-------------------------|-----|---------------------|-----|------------------------------------------|-----|--------------------|
| 1 | Hex nut | 15 | Bushing | 29 | Diaphragm case (top) | 42 | Drive screw |
| 2 | Washer | 16 | Rod | 30 | Diaphragm | 43 | O-ring |
| 3 | Handwheel | 17 | Pointer | 31 | Diaphragm plate | 44 | Seal washer |
| 4 | Srew shaft | 18 | Lock nut | 32 | Hex bolt | 45 | Keybolt |
| 5 | Lock nut | 19 | Yoke | 33 | Hex nut | 46 | Setscrew |
| 6 | Bearing | 20 | Stem connector | 34 | Stopper | 47 | Setscrew |
| 7 | Bearing case | 21 | Stem connector bolt | 35 | Hex bolt | 48 | Spring washer |
| 8 | Cotter | 22 | Housing | 36 | Spring plate | 49 | Diaphragm retainer |
| 9 | Connection | 23 | Piston plate | 37 | Washer | 50 | Cap |
| 10 | Eye-bolt | 24 | O-ring | 38 | Dust seal | 51 | Washer |
| 11 | Hex nut | 25 | Hex bolt | 39 | Truss screw, spring washer, or speed nut | 52 | Cotter pin |
| 12 | Diaphragm case (bottom) | 26 | Bearing retainer | | | 53 | Castle nut |
| 13 | Compressed coil spring | 27 | Seal washer | 40 | Scale | 54 | Seal washer |
| 14 | Bearing | 28 | Hex bolt | 41 | Nameplate | 55 | Packing for rod |

7-1-1. Disassembly and assembly of top handwheel

To disassemble or assemble the top handwheel, refer to Fig. 7-1 through Fig. 7-6 and proceed as described in this Chapter. For disassembly and assembly work, keep the actuator in the vertical attitude.

(a) Direct action type

| Step | Procedure |
|------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| 1 | Disconnect the air piping. |
| 2 | Set the handwheel shaft to the automatic operation position (fully raise the handwheel shaft). |
| 3 | Remove the top diaphragm case. When doing this, loosen the pair of eyebolts uniformly and alternately, after removing all other clamping- bolts of the diaphragm case. |
| 4 | Sufficiently insert the handle shaft by turning it and then remove the handwheel and the lock nut. Insert the shaft further and then remove the screw shaft from the housing. |
| 5 | Remove the O-ring. |

To assemble the top handwheel, follow the disassembly procedure in the reverse order.

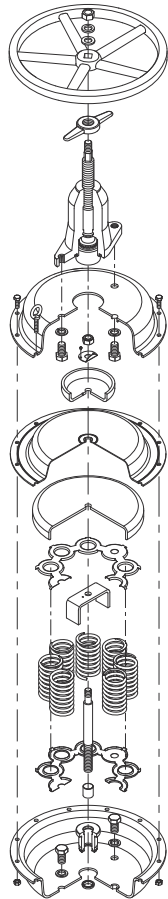
(b) Reverse action type

| Step | Procedure |
|------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| 1 | Disconnect the air piping. |
| 2 | Set the handwheel shaft to the automatic operation position (fully lower the handwheel shaft). |
| 3 | Remove the handwheel and the lock nut. Insert the shaft into the housing by uniformly and alternately, after removing all other clamping-bolt of the diaphragm case. |
| 4 | Remove the top diaphragm case. When doing this, loosen the pair of eyebolts uniformly and alternately, after removing all other clamping- bolts of the diaphragm case. |
| 5 | Remove the housing by loosening its clamping-screws. |
| 6 | Remove the setscrew and then remove the bearing case. |
| 7 | Remove the pin and then remove the castle nut. |
| 8 | Remove the bearing retainer and then remove the bearing. |

To assemble the top handwheel, follow the disassembly procedure in the reverse order.

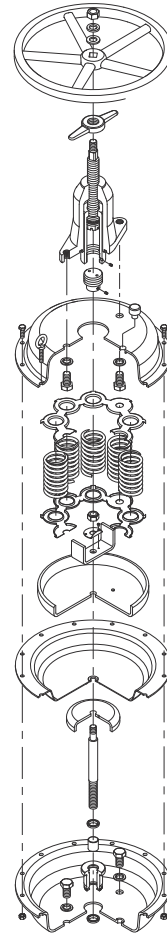
(c) Inspection after assembly

| Step | Procedure |
|------|------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| 1 | Check that the handwheel turns smoothly within its full stroke. |
| 2 | For the direct action type of actuator, check by means of soapsuds that there is no air leak from the connecting sections of the housing and top diaphragm case. |



Direct action type

Fig. 7-5.



Reverse action type

Fig. 7-6.

Chapter 8. Instruction for Side Handwheel of Actuator

As you turn the handwheel clockwise, the actuator stem moves downward regardless of whether the actuator is of the direct action type or reverse action type. The handwheel bears the “SHUT” mark to indicate that the valve is closed as the handwheel is turned clockwise and the “OPEN” mark to indicate that the valve is made open as the handwheel is turned counterclockwise.

8-1. Installation procedure

To install the side handwheel, refer to Fig. 8-1 and procedure as follows:

| Step | Procedure |
|------|---------------------------------------------------------------------------------------------------------------------------------------------------------------|
| 1 | Prepare a manual operation kit (a side handwheel set and its mounting accessories). |
| 2 | To install the handwheel, no machining or other physical processing on the actuator is necessary. |
| 3 | By turning the handwheel, set the pointer of the operation nut to the AUTO position. |
| 4 | Loosen the bolt (item number 6 as shown in Fig. 8-1) and widen the distance between levers. |
| 5 | Install the handwheel on the mounting pad at the back of the actuator, with the mounting-bolts. |
| 6 | Engage the holes at the end of two levers to the pointer boss and engage those of the other ends to the boss of the operation nut, and then tighten the bolt. |
| 7 | When the control valve is in the automatic mode of operation, set the pointer of the operation nut at to AUTO position and keep the handwheel locked. |

8-2. Operating instructions

- (1) To manually operate the actuator, remove the handwheel lock (the fork-shaped component) which locks the handwheel and turn the handwheel in the direction indicated by the corresponding arrowhead mark.
- (2) To return to the automatic operation, turn the handwheel so that the pointer of the operation nut is set AUTO position and then apply the handwheel lock.

Precautions: If you forcefully turn the handwheel after it has reached the mechanical stop position, the valve stem may be damaged. Do not turn the handwheel with forces larger than the below-mentioned limits.

Model HA2: 190 N {19 kgf}

Model HA3: 290 N {29 kgf}

Model HA4: 460 N {46 kgf}

(at the outmost periphery of the handwheel)

8-3. Disassembly and assembly of side handwheel (Refer to Fig. 8-1)

Before starting disassembly, check that the pointer is set to the AUTO position.

| Step | Procedure |
|------|--------------------------------------------------------------------------------------------------------------|
| 1 | Loosen the bolt 6 which connects the levers 2 and then disengage the levers from the pointer. |
| 2 | Undo the mounting-bolts 1 of the side handwheel unit and detach it from the actuator. |
| 3 | Remove the lock nut of the handwheel and then remove the handwheel. |
| 4 | Loosen the bolt 8 of the bearing holder and then remove the feed shaft 7. |
| 5 | To assemble the side handwheel, refer to Fig. 8-1 and follow the disassembly procedure in the reverse order. |

Chapter 9. Instruction for Mechanical Flow Stopper of Actuator

Refer to Fig. 9-1. This flow stopper can be used as minimum flow stopper and maximum flow stopper as necessary.

9-1. Adjustment for Minimum Flow Stopper

- (1) Loosen the whirl-stop to remove the adjust cover for maximum flow stopper from the housing.
- (2) Loosen the hex nuts for minimum flow stopper to remove them from the shaft stopper. Valve can move in full stroke because the flow stoppers don't work in this state.
- (3) Set the valve position to the desired point of flow stopper.
- (4) Screw the hex nuts for minimum flow stopper to the shaft stopper until hitting the housing.
- (5) Tighten the adjust cover for maximum flow stopper and the whirl-stop. Please don't hit the maximum stopper and the whirl-stop to the shaft stopper when tightening them.
- (6) Lock the whirl-stop.

9-2. Adjustment for Maximum Flow Stopper

- (1) Loosen the whirl-stop to remove the adjust cover for maximum flow stopper from the housing.
- (2) Loosen the hex nuts for minimum flow stopper to remove them from the shaft stopper. Valve can move in full stroke because the flow stoppers don't work in this state.
- (3) Set the valve position to full open.
- (4) Screw the hex nuts for minimum flow stopper to the shaft stopper. In this case, adjust the distance between the hex nut for minimum flow stopper (lower) and the housing to be greater than rated lift.
- (5) Set the valve position to the desired point of flow stopper.
- (6) Screw the hex nuts for minimum flow stopper to the shaft stopper until hitting the hex nuts for minimum flow stopper or the shaft stopper.
- (7) Lock the whirl-stop.

9-3. Adjustment for Minimum and Maximum Flow Stopper

Adjust with the procedure of section 9-1 and 9-2

Note: When tightening or loosening the hex nuts for minimum flow stopper, please don't apply the excessive torque to the shaft stopper.

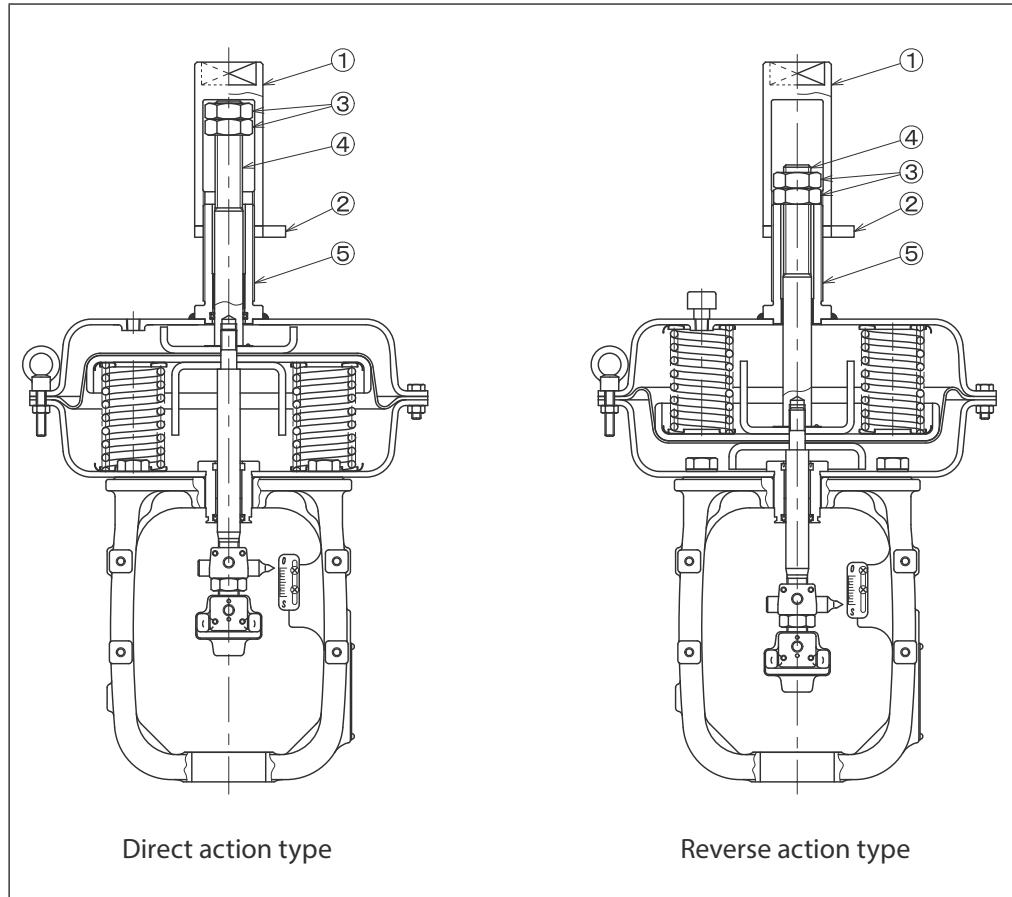


Fig. 9-1. Cut view of actuator with mechanical flow stopper

| No. | Parts name |
|-----|---------------------------------------|
| 1 | Adjust cover for maximum flow stopper |
| 2 | Whirl-stop |
| 3 | Hex nut for minimum flow stopper |
| 4 | Shaft stopper |
| 5 | Housing |

Chapter 10. Instructions for Bellows Sealed type of Control Valves

The bellows sealed type of control valves differ from other control valves in that the former employ a bellows for a seal. This Chapter covers primarily the particular items related to bellows sealed type of control valves.

Note: The bellows seal assembly should be replaced periodically. The frequency of replacements depends on the conditions of use. When handling a mechanism which as a bellows seal assembly, exercise care so that the mechanism is not twisted. Note that the bellows is not highly resistant against torsion.

10-1. Structures

The structures of Model ACP/ACN Control Valves are shown in Fig. 10-1.

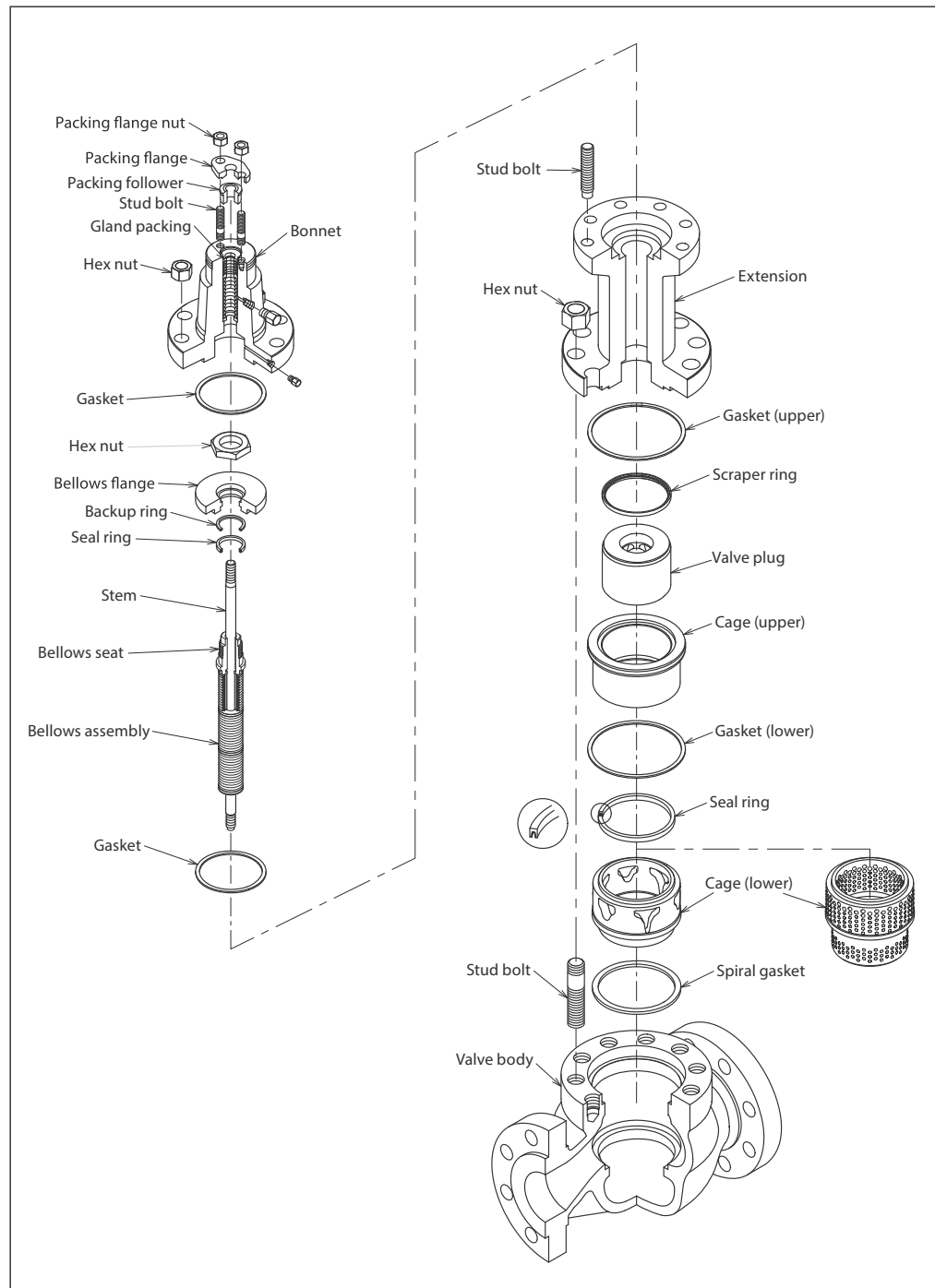


Fig. 10-1. Model ACP/ACN Control Valve

10-2. Disassembly and assembly

| Step | Procedure |
|------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| 1 | Detach the actuator from the valve as described in 4-1: Detaching actuator from valve body. |
| 2 | Loosen the packing flange nut. |
| 3 | Loosen the hex nut of the bonnet, using wrench. |
| 4 | Raise the bonnet and remove the gasket. Note: When raising the bonnet, press the stem down so that it will not come up together with the bonnet. |
| 5 | Remove the hex nut which fixes the bellows flange and bellows seat. Note: When loosening the nut, hold the bellows seat stationary so that no unreasonably large torsion is applied to the bellows, which is not highly resistant against torsion. |
| 6 | Remove the bellows flange and gasket. Note: The bellows seat can be readily detached by lightly tapping its top. (The most effective method is to tap it by passing a pipe onto the stem.) |
| 7 | Remove the hex nut which fixes the extension, with a wrench. Detach the extension from the valve body. |
| 8 | Remove the stem and plug. Note: The stem section has a valve plug, bellows seat and bellows assembly, which are welded together. |
| 9 | For disassembly of cage part, please refer to Chapter 4. |

For assembly of the control valve, follow the disassembly procedure in the reverse order.

Chapter 11. Azbil Low Emission standard-compliant gland packing

11-1. Overview

Azbil low emission gland packing is a gland structure that employs a Live Load structure to its performance for a long period of time. In order to meet the emission regulations for Volatile Organic Compounds (VOC) required by the U.S. Clean Air Act Amendments (CAAA), we confirmed that the amount of gland leakage was not more than 500 ppm in terms of the atmospheric concentration of the equivalent methane value on the basis of Azbil Corporation's own evaluation criteria. * For the structure of the gland, refer to the structural drawing of Azbil low emission gland packing in Fig. 11-1.

* In Japan and overseas as of October, 2005, there are no industry standards that lay down any evaluation method for gland leakage.

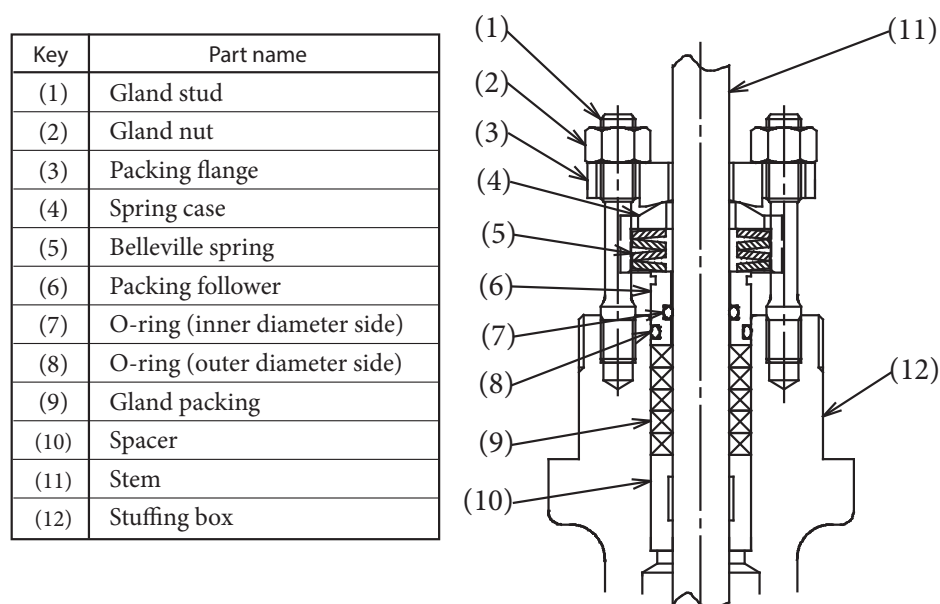


Fig. 11-1. Structural drawing of Azbil low emission gland packing

11-2. Structure

The gland packing P4519 for use in Azbil low emission gland packing is woven PTFE yarn with carbon fiber core. This gland packing provides asbestos-free properties in addition to low sliding friction and adaptability to heat cycles, and is adaptable to a wide range of fluids. This gland packing is fastened with a Live Load structure comprised of Belleville springs. The Belleville springs are made to be tight compressing at the time of initial fastening. As a valve is operated, the seal performance of the gland packing becomes deteriorated because of strain release, but the restoring force of the Belleville springs automatically retightens it to maintain seal performance. The Belleville springs are installed in the spring case for the purposes of positioning and environmental protection. The loading conditions of the Belleville springs can be determined by checking a front window and scale marks of the spring case.

The set of parts can be added to an existing product without any change of its main body or actuator if it is an applicable control valve.

11-3. Installation into the gland

11-3-1. Preparation for installation

1. Checking for the surface conditions of parts

If there is any flaw or the like on the surface of a part, the total amount of gland leakage may exceed a specified value because of fluid leakage from the periphery. For this reason, check the surface conditions of the following parts:

Table 11-1. Parts whose surface conditions need to be checked

| Part name | Finding: | Assumption |
|---------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------|
| Stem | <ul style="list-style-type: none">• No flaws or defects, including scratches and dents• No rust or corrosion• The finished surface should be uniform over its entire area.• No burrs• Clean, without adhesion of any coating material, powdery material, or dirt• When necessary, measures should be taken, such as cleaning with alcohol. | The total amount of gland leakage may exceed the specified value because of fluid leakage from the periphery of a flaw . |
| Stuffing box | | |
| Both ends of the spacer | | |
| Packing follower | | |
| Packing contact surface | | |
| O-ring groove | | |
| Packing flange | <ul style="list-style-type: none">• When necessary, measures should be taken, such as cleaning with alcohol. | The amount of gland leakage may exceed the specified value because of insufficient tightening. |
| Gland nut contact surface | | |
| Packing flange | <ul style="list-style-type: none">• No flaws, rust, or defects. | Damage to the control valve may be caused, and may lead to physical injury. |
| Entire surface Gland stud | | |
| Gland nut | | |

2. Preparation of new parts

Be sure to prepare new parts at the time of the first installation or reinstallation of the following parts.

Table 11-2. Parts that need to be renewed

| Part name | Finding | Assumption |
|-------------------|-----------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------|
| Gland packing | No flaws, coating materials, or dirt on the surface | The amount of leakage may exceed the specified value because of fluid leakage from the periphery of a flaw or the like. |
| Belleville spring | | The amount of gland leakage may exceed the specified value in a short period of time because of overtightening or insufficient tightening. |

3. Preparation of lubricating grease and anti-seize compound

Prepare proper amounts of lubricating grease and anti-seize compound indicated in the following table. (Equivalents also can be used.)

Table 11-3. Lubricating grease and anti-seize compound

| Product name | Area to be coated |
|------------------------------------------------------------------|-------------------------------------------|
| Silicone grease G40M made by Shin-Etsu Chemical Co., Ltd. | Entire surface of the gland packing |
| Plastilube No. 3 made by Sulflo, Inc., in the U.S. | Entire surface of the backup O-rings |
| Anti-seize compound Never-Seez made by Bostik, Inc., in the U.S. | Surface of the threads of the gland studs |
| | Bearing surface of the gland nuts |

11-3-2. Start of installation

1. Coating with lubricating grease

Step 1: Apply a thin film (not more than 0.3 mm thick) of the grease indicated in Table 11-3 [G40M made by Shin-Etsu Chemical Co., Ltd.] to the entire surface of all the gland packing.

Step 2: Apply the grease indicated in Table 11-3 [Plastilube No. 3 made by Sulflo, Inc., in the U.S.] to each of the two backup O-rings on the inner diameter side and the outer diameter side of the packing follower.

2. Installation of parts

Step 1:

With reference to Fig. 11-2, check the direction of the gland studs. After applying the anti-seize compound indicated in Table 11-3 [Never-Seez made by Bostik, Inc., in the U.S.] to the surface of the threads, install them into the stuffing box.

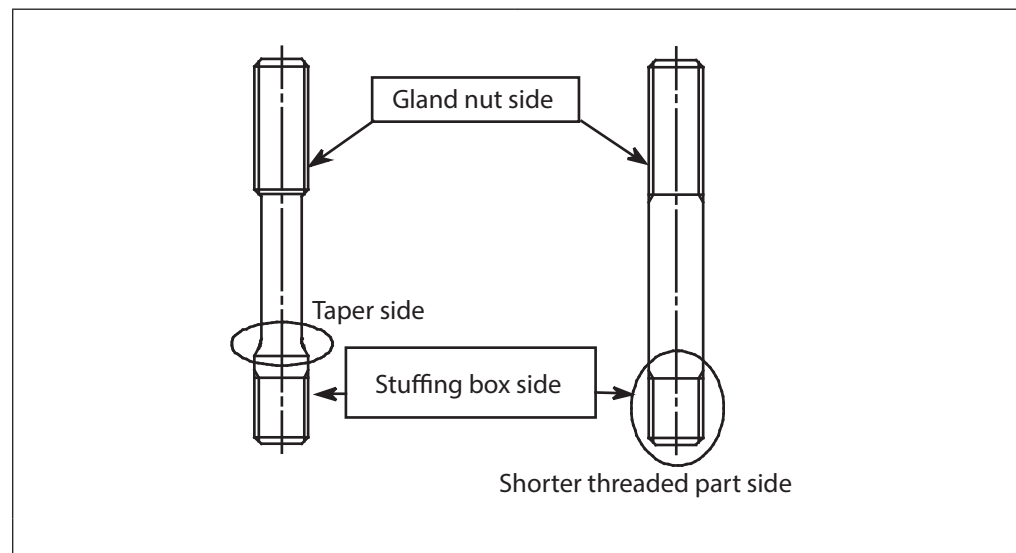


Fig. 11-2. Direction of the gland studs

Step 2:

Being careful not to damage the surface of the stem, install the spacer first.

Step 3:

Next, install one piece of the gland packing. Be sure to note how to open indicated in Fig.10-3. Insert it tightly with a pipe or the like. Finally, press it lightly.

Insert the second and subsequent pieces, with the gap position shifted by 180 degrees.

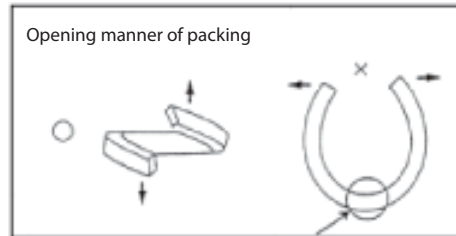


Fig. 11-3. How to handle gland packing

Step 4:

Next, check the direction of the packing follower. (See Fig. 11-1.) The outside O-ring side is the packing side.) Install it while being careful not to damage the surface of the stem.

Step 5:

With reference to Fig. 11-1, install the Belleville springs while being careful not to damage the surface of the stem.

Step 6:

With reference to Fig. 11-4, install the spring case in such a manner that two opposed side grooves are guided with the gland studs. (Two pairs of opposed side grooves are the same in dimension.) At the time of the installation, be careful not to damage the surface of the stem. Incidentally, when the Belleville springs are set in the spring case, they do not come into contact with the stem.

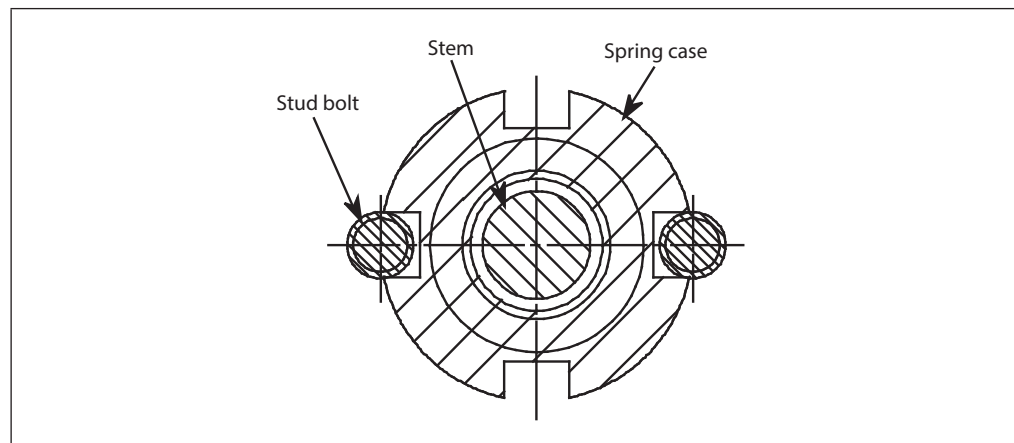


Fig. 11-4. Installation of the spring case Top view

Step 7:

Being careful not to damage the surface of the stem, install the packing flange.

Step 8:

After applying the anti-seize compound indicated in Table 11-3 [Never-Seez made by Bostik, Inc., in the U.S.] to the surface of the threads of the stud bolts and the bearing surface of the nuts, tighten them by hand.

3. Tightening**Step 1:**

With reference to Fig. 11-5, check the position of the Belleville springs through the front window of the spring case. When the Belleville springs are set properly, the lower edge of the outer diameter of the lowest Belleville spring almost coincides with the lower scale mark of the spring case. (In some cases, it does not exactly coincide because of the dimensional tolerance of the Belleville springs.)

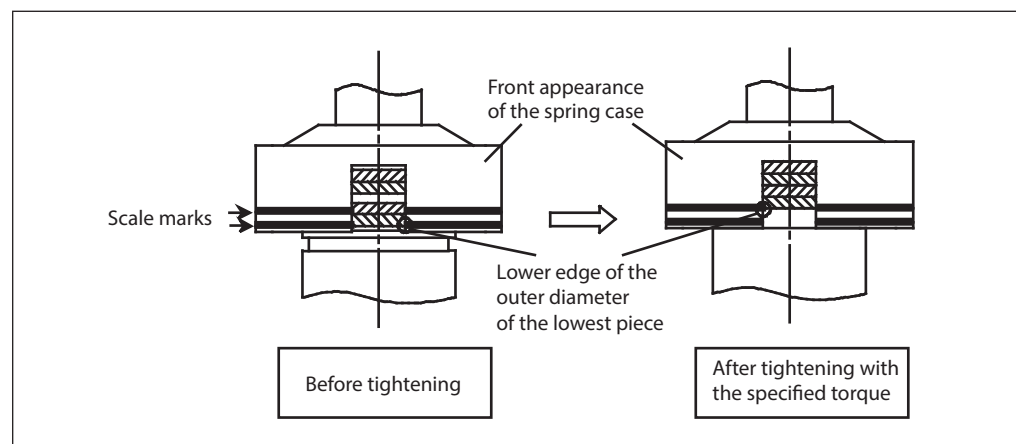


Fig. 11-5. Loading conditions of the Belleville springs

Step 2:

Tighten each of the right and left gland nuts by half a turn alternately to the specified torque. Table 11-4 shows the tightening torque.

If the tightening torque is less than the specified value, be aware that the amount of leakage may exceed the specified value because of insufficient tightening.

If the tightening torque is more than the specified value, be aware that the amount of leakage may exceed the specified value in a short period of time because of the accelerated wear of the gland packing, in addition to the increased sliding friction of the stem.

Table 11-4. Tightening torque of the gland nuts

| Actuator model | Stem size | Tightening torque |
|----------------|-----------|-------------------|
| PSA1, HA2 | φ 10 mm | 8 to 10 N·m |
| HA2, HA3 | φ 13 mm | 13 to 16 N·m |
| HA3 | φ 16 mm | 22 to 26 N·m |
| HA4 | φ 20 mm | 29 to 35 N·m |

11-3-3. Retightening

In the following cases, retighten the gland nuts with the specified torque:

- a) At the time of an inspection before the installation of the control valve
- b) At the time of a test operation or start-up operation of the equipment
- c) In case the leakage amount of the gland exceeds the specified value during operation of the equipment.

If the leakage amount of the gland still exceeds the specified value after retightening, reinstall the complete set of gland parts. In addition, it is recommended that the gland packing and the Belleville springs be replaced with new parts.

11-4. Parts List

| Part name | Actuator model | Stem size | Material | Part No. | Qty. |
|---------------------------------|----------------|-----------|-----------|--------------|------|
| Main packing | PSA1 | φ10 mm | P4519 | 80255384-111 | 5 |
| Belleville spring | | | SUS304 | 82571710-101 | 4 |
| O-ring (small) | | | Viton | 82592220-897 | 1 |
| O-ring (large) | | | Viton | 82592221-897 | 1 |
| Stem connector | | | SCS13A | 82557767-101 | 1 |
| Gland stud | | | SUS304 | 82559311-012 | 2 |
| Gland nut | | | SUS304 | 82592448-163 | 2 |
| Spring case | | | SUS304 | 82571708-101 | 1 |
| Packing follower | | | SUS304 | 82571711-101 | 1 |
| Packing follower for O-ring use | | | SUS304 | 82571715-101 | 1 |
| Spacer | | | SUS304 | 82555645-066 | 1 |
| Spacer for O-ring use | | | SUS304 | 82555645-566 | 1 |
| Main packing | HA2 | φ10 mm | P4519 | 80255384-111 | 5 |
| Belleville spring | | | SUS304 | 82571710-101 | 4 |
| O-ring (small) | | | Viton | 82592220-897 | 1 |
| O-ring (large) | | | Viton | 82592221-897 | 1 |
| Stem connector | | | S20C/S25C | 82520978-201 | 1 |
| Gland stud | | | SUS304 | 82559311-012 | 2 |
| Gland nut | | | SUS304 | 82592448-163 | 2 |
| Spring case | | | SUS304 | 82571708-101 | 1 |
| Packing follower | | | SUS304 | 82571711-101 | 1 |
| Packing follower for O-ring use | | | SUS304 | 82571715-101 | 1 |
| Spacer | | | SUS304 | 82555645-066 | 1 |
| Spacer for O-ring use | | | SUS304 | 82555645-566 | 1 |
| Main packing | HA2 | φ13 mm | P4519 | 80255385-111 | 5 |
| Belleville spring | | | SUS304 | 82559308-101 | 4 |
| O-ring (small) | | | Viton | 82592221-497 | 1 |
| O-ring (large) | | | Viton | 82592222-297 | 1 |
| Stem connector | | | S20C/S25C | 82520978-206 | 1 |
| Gland stud | | | SUS304 | 82571706-011 | 2 |
| Gland nut | | | SUS304 | 82592448-173 | 2 |
| Spring case | | | SUS304 | 82559309-101 | 1 |
| Packing follower | | | SUS304 | 82571712-101 | 1 |
| Packing follower for O-ring use | | | SUS304 | 82571716-101 | 1 |
| Spacer | | | SUS304 | 82555645-166 | 1 |
| Spacer for O-ring use | | | SUS304 | 82555645-666 | 1 |
| Main packing | HA3 | φ13 mm | P4519 | 80255385-111 | 5 |
| Belleville spring | | | SUS304 | 82559308-101 | 4 |
| O-ring (small) | | | Viton | 82592221-497 | 1 |
| O-ring (large) | | | Viton | 82592222-297 | 1 |
| Stem connector | | | S20C/S25C | 82571706-011 | 1 |
| Gland stud | | | SUS304 | 82571706-011 | 2 |
| Gland nut | | | SUS304 | 82592448-173 | 2 |
| Spring case | | | SUS304 | 82559309-101 | 1 |
| Packing follower | | | SUS304 | 82571712-101 | 1 |
| Packing follower for O-ring use | | | SUS304 | 82571716-101 | 1 |
| Spacer | | | SUS304 | 82555645-166 | 1 |
| Spacer for O-ring use | | | SUS304 | 82555645-666 | 1 |

| Part name | Actuator model | Stem size | Material | Part No. | Qty. |
|---------------------------------|----------------|-----------|-----------|--------------|------|
| Main packing | HA3 | φ16 mm | P4519 | 80255386-111 | 5 |
| Belleville spring | | | SUS304 | 82559308-102 | 4 |
| O-ring (small) | | | Viton | 82592221-797 | 1 |
| O-ring (large) | | | Viton | 82592222-897 | 1 |
| Stem connector | | | S20C/S25C | 82521091-201 | 1 |
| Gland stud | | | SUS304 | 82559312-011 | 2 |
| Gland nut | | | SUS304 | 82592448-013 | 2 |
| Spring case | | | SUS304 | 82559310-101 | 1 |
| Packing follower | | | SUS304 | 82571713-101 | 1 |
| Packing follower for O-ring use | | | SUS304 | 82571717-101 | 1 |
| Spacer | | | SUS304 | 82555645-766 | 1 |
| Spacer for O-ring use | | | SUS304 | 82555645-101 | 1 |
| Main packing | HA4 | φ20 mm | P4519 | 80255387-111 | 5 |
| Belleville spring | | | SUS304 | 82571710-201 | 4 |
| O-ring (small) | | | Viton | 82592221-997 | 1 |
| O-ring (large) | | | Viton | 82592223-397 | 1 |
| Stem connector | | | S20C/S25C | 82551348-202 | 1 |
| Gland stud | | | SUS304 | 82571707-011 | 2 |
| Gland nut | | | SUS304 | 82592448-023 | 2 |
| Spring case | | | SUS304 | 82571709-101 | 1 |
| Packing follower | | | SUS304 | 82571714-101 | 1 |
| Packing follower for O-ring use | | | SUS304 | 82571718-101 | 1 |
| Spacer | | | SUS304 | 82555645-866 | 1 |
| Spacer for O-ring use | | | SUS304 | 82555645-201 | 1 |

Chapter 12. Certified ISO 15848-1 compliant low emission gland packing

12-1. Overview

Certified ISO 15848-1 low emission gland packing employs a live-loaded packing system to maintain valve seal performance for a long period of time. The gland packing system has acquired third-party certification for compliance with ISO15848-1, which is the international standard for low-emission performance of valves. For the structure of the gland, see Fig. 12-1 and Fig. 12-2.

| No. | Name |
|------|------------------------------------------------------|
| (1) | Gland stud |
| (2) | Gland nut |
| (3) | Packing flange |
| (4) | Belleville spring |
| (5) | Packing follower |
| (6) | Carbon ring (P6210C2FS) |
| (7) | Adapter packing (P6720) |
| (8) | Main packing (P4519) |
| (9) | Spacer |
| (10) | Stem |
| (11) | O-ring for inner side of packing follower (optional) |
| (12) | O-ring for outer side of packing follower (optional) |
| (13) | Stuffing box |

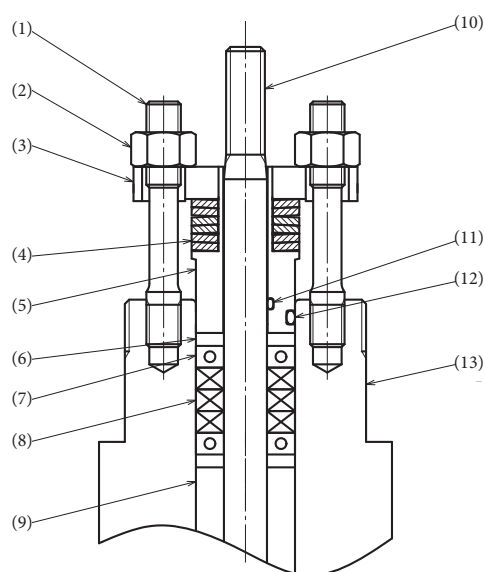


Fig. 12-1. Structure of Certified ISO 15848-1 low emission gland packing (for PTFE yarn)

| No. | Name |
|------|----------------------------------------------------------|
| (1) | Gland stud |
| (2) | Gland nut |
| (3) | Packing flange |
| (4) | Belleville spring |
| (5) | Packing follower |
| (6) | Carbon ring (P6210) |
| (7) | Adapter packing (P6720) |
| (8) | Main packing (P6617CL) |
| (9) | Spacer |
| (10) | Stem |
| (11) | O-ring for inner side of packing follower (optional) |
| (12) | O-ring for outer side of the packing follower (optional) |
| (13) | Stuffing box |

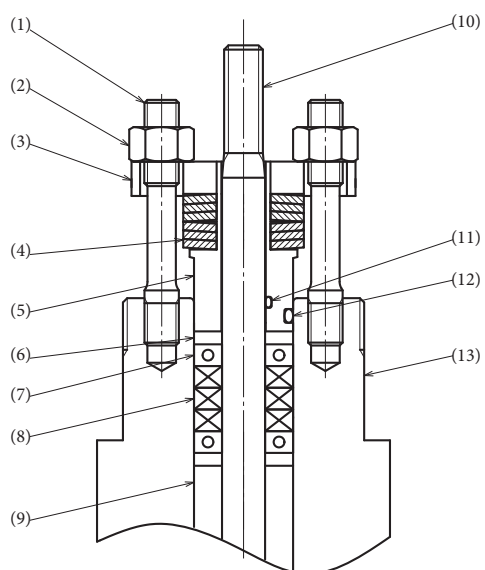


Fig. 12-2. Structure of Certified ISO 15848-1 low emission gland packing (for expanded graphite)

12-2. Structure

The main packing (No. P4519) is PTFE yarn with a carbon fiber core. It features low friction and can be used for various types of fluids. The main packing (No. P6617CL) is an expanded graphite packing. The part of it that slides is aligned with an expanded graphite sheet that was specially modified and lubricated. The adapter packing (No. P6720) is made by braiding expanded graphite yarn reinforced with PTFE fiber, and features low friction.

These gland packings are tightened by the live-loaded packing system, which is composed of Belleville springs and other parts. With other systems, in the course of valve operation, seal performance deteriorates due to loosening of the gland packing. The force of the Belleville springs reduces the release of tension to maintain the seal. The load on the Belleville springs can be observed from the position of the packing flange and packing follower.

12-3. Starting Operation

Before operating the valve, tighten (or retighten) the gland. For instructions, refer to 12-4-2, “(3) Tightening”.

If leakage from the gland continues even after proper tightening, obtain and prepare parts as indicated in “12-4-1. Preparation for assembly”, and follow the procedure given in “12-4-2. Assembly”.

12-4. Assembling the parts of the gland

12-4-1. Preparation for assembly

(1) Checking the surface condition of the parts

Any flaw or the like on the surface of the parts may cause leakage from that area, resulting in a total amount of leakage from the gland that exceeds the specified value. Therefore, check the surface of the following parts.

Table 12-1. Parts to be checked for surface condition

| Part | Checkpoints | Possible problems |
|---------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------|
| Stem | <ul style="list-style-type: none">• No flaws or defects, including scratches and dents• No rust or corrosion• The entire surface is even.• No burrs• Clean surface, with no adhering coating material, powder, or dirt.• If necessary, take necessary measures such as cleaning with alcohol. | If the problems stated on the left remain, fluid leaks from flawed areas may cause the total amount of leakage from the gland to exceed the specified value. |
| Stuffing box | | |
| Both ends of the spacer | | |
| Packing follower | | |
| Packing contact surface | | |
| O-ring groove | <ul style="list-style-type: none">• No flaws, rust, or defects | The total amount of leakage from the gland may exceed the specified value because of insufficient tightening. |
| Packing flange | | |
| Gland nut contact surface | | |
| Packing flange (entire surface) | | The problems on the left, if they remain, can cause control valve damage, leading to injuries. |
| Gland stud | | |
| Gland nut | | |

(2) New parts

When assembling or reassembling, for the parts indicated in the table below, be sure to use new parts.

Table 12-2. Parts requiring treatment

| Part name | Checkpoints | Possible problems |
|-----------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------|
| Gland packing (main packing and adapter packing) Carbon ring | <ul style="list-style-type: none">• No flaws.• No coating materials or dirt stuck to the surface. | Fluid leaks from flawed areas can cause the total amount of leakage from the gland to exceed the specified value. |
| Belleville spring | | The total amount of leakage from the gland may exceed the specified value in a short period of time because of insufficient tightening. |

(3) Lubricating grease and anti-seizing agent

Have an appropriate amount of the following lubricating grease and anti-seizing agent (or equivalent) on hand.

Table 12-3. Lubricating grease and anti-seizing agent

| Product name | Applied area | Gland for PTFE yarn | Gland for expanded graphite |
|-----------------------------------------------------------|------------------------------------------------------------------------|---------------------|-----------------------------|
| Krytox GPL207 fluoropolymer grease made by DuPont Co. | Entire surface of the gland packing (main packing and adapter packing) | Needed | - |
| Plastilube No. 3 non-dripping grease, made by Sulflo Inc. | Entire surface of the O-rings | Needed | Needed |
| Never-Seez anti-seizing agent, made by Bostik Inc. | Threads of the gland studs | Needed | Needed |
| | Bottom of the gland nuts | Needed | Needed |

12-4-2. Assembly

(1) Applying lubricating grease

Step 1

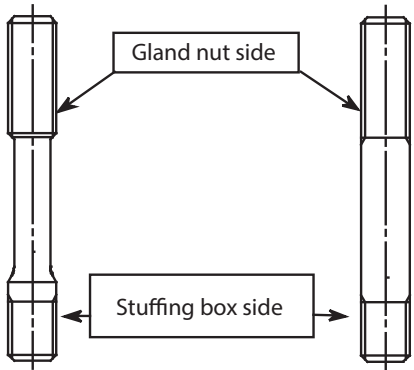
For Certified ISO 15848-1 low emission gland packing for PTFE yarn, apply a thin film of grease Krytox GPL207 indicated in Table 12-3 to the surface of all gland packings (main packing and adapter packing). For Certified ISO 15848-1 low emission gland packing for expanded graphite, greasing is not necessary.

Step 2

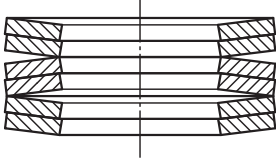
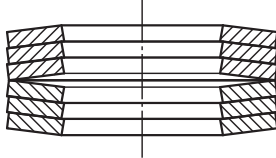
For Certified ISO 15848-1 low emission gland packing with two O-rings, which are placed inner and outer sides of the packing follower, apply grease Plastilube No.3 made by Sulflo Inc. indicated in Table 12-3 to both rings.

(2) Assembling

(1/3)

| Step | Procedure |
|------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| 1 | <p>Check the correct direction of the gland studs in Fig. 12-3. Apply Never-Seez anti-seizing agent made by Bostik Inc. (indicated in Table 12-3) to the threads on the stuffing box end of the studs, and screw them into the stuffing box.</p>  <p style="text-align: center;">Gland stud end with fewer threads</p> <p style="text-align: center;">Fig. 12-3. Direction of the gland stud</p> |
| 2 | First, insert the spacer, paying extra attention not to damage the surface of the stem. |
| 3 | Gently insert a carbon ring all the way to the bottom with a pipe, etc., taking care not to damage the ring. |

| Step | Procedure |
|------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| 4 | <p>[Certified ISO 15848-1 low emission gland packing for PTFE yarn]</p> <p>Insert one adapter packing ring, without opening the gap, all the way to the bottom with a pipe, etc., and push it lightly.</p> <p>Open the gap of the main packing rings as illustrated in Fig. 12-4 and insert one of them all the way to the bottom with a pipe, etc., and push it lightly. Insert the remaining two main packing rings with the gap position shifted by 180°.</p> <p>Insert one adapter packing ring, without opening the gap, all the way to the bottom with a pipe, etc., and push it lightly.</p> <div data-bbox="746 589 1203 819" data-label="Image"> </div> <p>Fig. 12-4. How to open the main packing rings</p> <p>[Certified ISO 15848-1 low emission gland packing for expanded graphite]</p> <p>Insert one adapter packing ring, without opening the gap, all the way to the bottom with a pipe, etc., and push it lightly.</p> <p>Insert one of the main packing rings, without opening the gap, with the marking facing upward, all the way to the bottom with a pipe, etc., and push it lightly. Insert the remaining two main packing rings in the same manner.</p> <p>Insert one adapter packing ring, without opening the gap, all the way to the bottom with a pipe, etc., and push it lightly.</p> |
| 5 | Gently insert a carbon ring all the way to the bottom with a pipe, etc., taking care not to damage the ring. |
| 6 | Check the correct mounting orientation of the packing follower in Fig. 12-1. or Fig. 12-2. Insert it, paying extra attention not to damage the surface of the stem. |

| Step | Procedure |
|------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| 7 | <p>Stack the Belleville spring washers as shown in Fig. 12-5, and insert them into the packing follower.</p> <div style="display: flex; justify-content: space-around; align-items: center;"> <div style="text-align: center;">  <p>2 same-direction washers × 3</p> <p>[For PTFE yarn]</p> </div> <div style="text-align: center;">  <p>3 same-direction washers × 2</p> <p>[For expanded graphite]</p> </div> </div> <p style="text-align: center;">Fig. 12-5.</p> |
| 8 | Place the packing flange onto the packing follower. |
| 9 | Apply anti-seizing agent Never-Seez made by Bostik Inc. (Table 12-3) to the threads on the gland nut end of the gland studs, and screw the nuts on by hand. |

(3) Tightening

| Step | Procedure | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|----------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------|----------------------------|-------------------|-------------------|----------|-----|---------|--------|-----|---------|--------|-----|---------|--------|-----|---------|--------|------|---------|--------|-------|----------------|-----------|-------------------|----------|-----|---------|----------------------------|-----|---------|----------------------------|-----|---------|----------------------------|-----|---------|----------------------------|------|---------|----------------------------|
| 1 | <p>Tighten the left and right gland nuts alternately, making approximately a half turn each, until the torque indicated in Table 12-4 or Table 12-5 is reached. Note that if the tightening torque is insufficient, the amount of leakage may exceed the specified value. On the other hand, tightening the gland nuts with excessive torque increases the friction on the stem and causes the gland packing to wear out faster, which may lead to an amount of leakage exceeding the specified value in a short period of time.</p> <p>Table 12-4. Gland nut tightening torque (for PTFE yarn)</p> <table><tr><th>Model</th><th>Actuator model</th><th>Stem size</th><th>Tightening torque</th></tr><tr><td rowspan="5">ACP, ACN</td><td>HA2</td><td>φ 10 mm</td><td>12 N·m</td></tr><tr><td>HA3</td><td>φ 13 mm</td><td>20 N·m</td></tr><tr><td>HA3</td><td>φ 16 mm</td><td>33 N·m</td></tr><tr><td>HA4</td><td>φ 20 mm</td><td>44 N·m</td></tr><tr><td>PSA6</td><td>φ 30 mm</td><td>54 N·m</td></tr></table> <p>Table 12-5. Gland nut tightening torque (for expanded graphite)</p> <table><tr><th>Model</th><th>Actuator model</th><th>Stem size</th><th>Tightening torque</th></tr><tr><td rowspan="5">ACP, ACN</td><td>HA2</td><td>φ 10 mm</td><td>12 → 0 (loosening) → 8 N·m</td></tr><tr><td>HA3</td><td>φ 13 mm</td><td>20 → 0 (loosening) → 13N·m</td></tr><tr><td>HA3</td><td>φ 16 mm</td><td>33 → 0 (loosening) → 22N·m</td></tr><tr><td>HA4</td><td>φ 20 mm</td><td>44 → 0 (loosening) → 30N·m</td></tr><tr><td>PSA6</td><td>φ 30 mm</td><td>54 → 0 (loosening) → 36N·m</td></tr></table> | Model | Actuator model | Stem size | Tightening torque | ACP, ACN | HA2 | φ 10 mm | 12 N·m | HA3 | φ 13 mm | 20 N·m | HA3 | φ 16 mm | 33 N·m | HA4 | φ 20 mm | 44 N·m | PSA6 | φ 30 mm | 54 N·m | Model | Actuator model | Stem size | Tightening torque | ACP, ACN | HA2 | φ 10 mm | 12 → 0 (loosening) → 8 N·m | HA3 | φ 13 mm | 20 → 0 (loosening) → 13N·m | HA3 | φ 16 mm | 33 → 0 (loosening) → 22N·m | HA4 | φ 20 mm | 44 → 0 (loosening) → 30N·m | PSA6 | φ 30 mm | 54 → 0 (loosening) → 36N·m |
| | Model | Actuator model | Stem size | Tightening torque | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| ACP, ACN | HA2 | φ 10 mm | 12 N·m | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | HA3 | φ 13 mm | 20 N·m | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | HA3 | φ 16 mm | 33 N·m | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | HA4 | φ 20 mm | 44 N·m | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | PSA6 | φ 30 mm | 54 N·m | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Model | Actuator model | Stem size | Tightening torque | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| ACP, ACN | HA2 | φ 10 mm | 12 → 0 (loosening) → 8 N·m | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | HA3 | φ 13 mm | 20 → 0 (loosening) → 13N·m | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | HA3 | φ 16 mm | 33 → 0 (loosening) → 22N·m | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | HA4 | φ 20 mm | 44 → 0 (loosening) → 30N·m | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| | PSA6 | φ 30 mm | 54 → 0 (loosening) → 36N·m | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |

| Step | Procedure |
|------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| 2 | <p>By tightening the gland nuts to the torque indicated in Table 12-4 or Table 12-5, the top of the packing flange and packing follower will be at almost the same level, as illustrated in Fig. 12-6 below (the level may not be exactly the same due to the tolerance of the Belleville springs and friction on the gland studs or gland nuts).</p> <p>If the Belleville springs are mounted in the wrong direction, or if the gland nuts are tightened to a torque that does not comply with the torque specified in Table 12-4 and Table 12-5, the level of the top of the packing flange and packing follower will not be the same (see Fig. 12-7). Check if the direction of washers of the Belleville springs and the tightening torque are correct.</p> <div data-bbox="651 593 1251 907"> </div> <p>Fig. 12-6. Load on Belleville springs (correctly assembled)</p> <div data-bbox="798 974 1117 1254"> </div> <p>Fig. 12-7. Load on Belleville springs (incorrectly assembled)</p> |
| 3 | <p>View the assembly from above to check that the space between the stem and the packing follower is even (see Fig. 12-8).</p> <div data-bbox="547 1411 1372 1814"> </div> <p>Fig. 12-8. Top view</p> |

12-5. Parts List

Table 12-6. Parts list For PTFE yarn

| Part name | Actuator model | Material | Part No. | Qty. |
|---------------------------------|--------------------|--------------|---------------|------|
| Main packing | HA2 | P4519 | 80255384- 111 | 3 |
| Adapter packing | | P6720 | 82573475- 101 | 2 |
| Carbon ring | | P6210C2FS | 82573484- 001 | 2 |
| Belleville spring | | SUS304 | 82573462- 101 | 6 |
| O-ring (small) | | Viton | 82592220- 897 | 1 |
| O-ring (large) | | Viton | 82592221- 897 | 1 |
| Gland stud | | A193 GrB8CL2 | 82559311- 012 | 2 |
| Gland nut | | SUS304 | 82592448- 163 | 2 |
| Packing flange | | SCS13 | 82573456- 101 | 1 |
| Packing follower | | SUS304 | 82573463- 101 | 1 |
| Packing follower for O-ring use | | SUS304 | 82573464- 101 | 1 |
| Spacer | | SUS304 | 82573476- 110 | 1 |
| Main packing | HA3 (except 6B) | P4519 | 80255385- 111 | 3 |
| Adapter packing | | P6720 | 82573475- 102 | 2 |
| Carbon ring | | P6210C2FS | 82573484- 002 | 2 |
| Belleville spring | | SUS304 | 82573462- 102 | 6 |
| O-ring (small) | | Viton | 82592221- 497 | 1 |
| O-ring (large) | | Viton | 82592222- 297 | 1 |
| Gland stud | | A193 GrB8CL2 | 82571706- 012 | 2 |
| Gland nut | | SUS304 | 82592448- 173 | 2 |
| Packing flange | | SCS13 | 82573457- 101 | 1 |
| Packing follower | | SUS304 | 82573465- 101 | 1 |
| Packing follower for O-ring use | | SUS304 | 82573466- 101 | 1 |
| Spacer | | SUS304 | 82573476- 111 | 1 |
| Stem connector | | S25C/S20C | 82571732- 101 | 1 |

Table 12-6. Parts list For PTFE yarn

| Part name | Actuator model | Material | Part No. | Qty. |
|---------------------------------|----------------|--------------|---------------|------|
| Main packing | HA3 (6B) | P4519 | 80255386- 111 | 3 |
| Adapter packing | | P6720 | 82573475- 103 | 2 |
| Carbon ring | | P6210C2FS | 82573484- 003 | 2 |
| Belleville spring | | SUS304 | 82573462- 103 | 6 |
| O-ring (small) | | Viton | 82592221- 797 | 1 |
| O-ring (large) | | Viton | 82592222- 897 | 1 |
| Gland stud | | A193 GrB8CL2 | 82559312- 012 | 2 |
| Gland nut | | SUS304 | 82592448- 013 | 2 |
| Packing flange | | SCS13 | 82573458- 101 | 1 |
| Packing follower | | SUS304 | 82573467- 101 | 1 |
| Packing follower for O-ring use | | SUS304 | 82573468- 101 | 1 |
| Spacer | | SUS304 | 82573476- 112 | 1 |
| Main packing | HA4 | P4519 | 80255387- 111 | 3 |
| Adapter packing | | P6720 | 82573475- 104 | 2 |
| Carbon ring | | P6210C2FS | 82573484- 004 | 2 |
| Belleville spring | | SUS304 | 82573462- 104 | 6 |
| O-ring (small) | | Viton | 82592221- 997 | 1 |
| O-ring (large) | | Viton | 82592223- 397 | 1 |
| Gland stud | | A193 GrB8CL2 | 82571707- 012 | 2 |
| Gland nut | | SUS304 | 82592448- 023 | 2 |
| Packing flange | | SCS13 | 82573459- 101 | 1 |
| Packing follower | | SUS304 | 82573469- 101 | 1 |
| Packing follower for O-ring use | | SUS304 | 82573470- 101 | 1 |
| Spacer | | SUS304 | 82573476- 113 | 1 |
| Main packing | PSA6R | P4519 | 82571048- 109 | 3 |
| Adapter packing | | P6720 | 82573475- 204 | 2 |
| Carbon ring | | P6210C2FS | 82573484- 010 | 2 |
| Belleville spring | | SUS304 | 82573462- 105 | 6 |
| O-ring (small) | | Viton | 82592223- 397 | 1 |
| O-ring (large) | | Viton | 82592224- 197 | 1 |
| Gland stud | | A193 GrB8CL2 | 82592006- 769 | 2 |
| Gland nut | | SUS304 | 82592448- 033 | 2 |
| Packing flange | | SCS13 | 82573460- 101 | 1 |
| Packing follower | | SUS304 | 82573471- 101 | 1 |
| Packing follower for O-ring use | | SUS304 | 82573472- 101 | 1 |
| Spacer | | SUS304 | 82553331- 781 | 1 |

Table 12-7. Parts list For expanded graphite

| Part name | Actuator model | Material | Part No. | Qty. |
|------------------------------------|--------------------|--------------|---------------|------|
| Main packing | HA2 | P6617CL | 82573489- 001 | 3 |
| Adapter packing | | P6720 | 82573475- 101 | 2 |
| Carbon ring | | P6210 | 82573488- 001 | 2 |
| Belleville spring | | SUS304 | 82571711- 101 | 6 |
| O-ring (small) | | Viton | 82592220- 897 | 1 |
| O-ring (large) | | Viton | 82592221- 897 | 1 |
| Gland stud | | A193 GrB8CL2 | 82559311- 012 | 2 |
| Gland nut | | SUS304 | 82592448- 163 | 2 |
| Packing flange | | SCS13 | 82573456- 101 | 1 |
| Packing follower | | SUS304 | 82573463- 201 | 1 |
| Packing follower for O-ring use | | SUS304 | 82573464- 201 | 1 |
| Spacer | | SUS304 | 82573476- 114 | 1 |
| Main packing | HA3 (except 6B) | P6617CL | 82573489- 002 | 3 |
| Adapter packing | | P6720 | 82573475- 102 | 2 |
| Carbon ring | | P6210 | 82573488- 002 | 2 |
| Belleville spring | | SUS304 | 82573462- 107 | 6 |
| O-ring (small) | | Viton | 82592221-497 | 1 |
| O-ring (large) | | Viton | 82592222-297 | 1 |
| Gland stud | | A193 GrB8CL2 | 82571706- 012 | 2 |
| Gland nut | | SUS304 | 82592448- 173 | 2 |
| Packing flange | | SCS13 | 82573457- 101 | 1 |
| Packing follower | | SUS304 | 82573465- 201 | 1 |
| Packing follower for O-ring use | | SUS304 | 82573466- 201 | 1 |
| Spacer | | SUS304 | 82573476- 115 | 1 |
| Stem connector | | S25C/S20C | 82571732- 101 | 1 |

Table 12-7. Parts list For expanded graphite

| Part name | Actuator model | Material | Part No. | Qty. |
|---------------------------------|----------------|--------------|---------------|------|
| Main packing | HA3 (6B) | P6617CL | 82573489- 003 | 3 |
| Adapter packing | | P6720 | 82573475- 103 | 2 |
| Carbon ring | | P6210 | 82573488- 003 | 2 |
| Belleville spring | | SUS304 | 82559308- 102 | 6 |
| O-ring (small) | | Viton | 82592221- 797 | 1 |
| O-ring (large) | | Viton | 82592222- 897 | 1 |
| Gland stud | | A193 GrB8CL2 | 82559311- 012 | 2 |
| Gland nut | | SUS304 | 82592448- 163 | 2 |
| Packing flange | | SCS13 | 82573458- 101 | 1 |
| Packing follower | | SUS304 | 82573467- 201 | 1 |
| Packing follower for O-ring use | | SUS304 | 82573468- 201 | 1 |
| Spacer | | SUS304 | 82573476- 116 | 1 |
| Main packing | HA4 | P6617CL | 82573489- 004 | 3 |
| Adapter packing | | P6720 | 82573475- 104 | 2 |
| Carbon ring | | P6210 | 82573488- 004 | 2 |
| Belleville spring | | SUS304 | 82573462- 108 | 6 |
| O-ring (small) | | Viton | 82592221- 997 | 1 |
| O-ring (large) | | Viton | 82592223- 397 | 1 |
| Gland stud | | A193 GrB8CL2 | 82571707- 012 | 2 |
| Gland nut | | SUS304 | 82592448- 023 | 2 |
| Packing flange | | SCS13 | 82573459- 101 | 1 |
| Packing follower | | SUS304 | 82573469- 201 | 1 |
| Packing follower for O-ring use | | SUS304 | 82573470- 201 | 1 |
| Spacer | | SUS304 | 82573476- 117 | 1 |
| Main packing | PSA6R | P6617CL | 82573489- 009 | 3 |
| Adapter packing | | P6720 | 82573475- 204 | 2 |
| Carbon ring | | P6210 | 82573488- 010 | 2 |
| Belleville spring | | SUS304 | 82573462- 109 | 6 |
| O-ring (small) | | Viton | 82592223- 397 | 1 |
| O-ring (large) | | Viton | 82592224- 197 | 1 |
| Gland stud | | A193 GrB8CL2 | 82592006- 769 | 2 |
| Gland nut | | SUS304 | 82592448- 033 | 2 |
| Packing flange | | SCS13 | 82573460- 101 | 1 |
| Packing follower | | SUS304 | 82573471- 201 | 1 |
| Packing follower for O-ring use | | SUS304 | 82573472- 201 | 1 |
| Spacer | | SUS304 | 82553331- 779 | 1 |

12-6. Application to existing control valves

If Certified ISO 15848-1 low emission gland packing is used for an existing control valve, please note the following:

- If there are scratches on the inner surface of the stuffing box or the surface of the stem of the current valve, the specified seal performance of Certified ISO 15848-1 low emission gland packing may not be achieved. If scratches are found, replace the affected parts with new ones.
- Check if Certified ISO 15848-1 low emission gland packing can be used for the current valve and actuator by referring to the specification sheet for Certified ISO 15848-1 low emission gland packing (SS2-SSL100-0100) or by contacting us. Because the resistance to sliding of Certified ISO 15848-1 low emission gland packing is greater than general gland packing systems, it may not be possible to use Certified ISO 15848-1 low emission gland packing with the current actuator. In addition, if it is used with the actuator, the shutoff differential pressure will decrease. If supply air pressure to the actuator is increased in order to meet the required shutoff differential pressure, check that the specifications for the pressure gauge of the positioner and pressure reducing valve are satisfied and that there is no effect on the pressure at the source.
- Check if the operating temperature range of the gland packing (main packing and adapter packing) of Certified ISO 15848-1 low emission gland packing meets the temperature requirements of the current control valve. Attention is needed for expanded graphite Certified ISO 15848-1 low emission gland packing in particular, because the operating temperature high limit of the main packing used for this packing system is lower than that of general expanded graphite packings.

12-7. Disposal

If this product is no longer needed, dispose of it appropriately as industrial waste, in accordance with local regulations. Do not reuse all or any part of it.

Chapter 13. Troubleshooting

This Chapter covers problem, causes and remedial actions regarding most probable types of troubles. Parts may be required to be replaced depending on the type of. For further problem, please contact an Azbil Corporation agent for repair.

Table 13-1. Troubleshooting

| Problem | Cause and Remedial Action |
|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| Unstable valve operation <ul style="list-style-type: none"> Valve position hunting occurs when almost fully closed. Air supply pressure is unstable. Signal pressure is unstable. Valve position hunting occurs even when signal pressure is stable | <ul style="list-style-type: none"> Cv value is too large. Reduce Cv value For a single seat valve, the valve is installed in the reverse flow direction. Large air consuming equipment is hooked up to the same air supply line. Check that the air supply capacity, piping capacity and restriction capacity are appropriate. Supply air pressure regulator is inadequate or not operating properly. Controller is not properly tuned. Property tune the controller (properly set the proportional band and other parameters). Check that the controller output does not change abnormally. Hunting of output of positioner itself. Check and repair or replace the positioner. Being affected by pressure change of process fluid as power of the actuator is insufficient. Replace the actuator with a larger one. |
| Vibration of valve <ul style="list-style-type: none"> Valve vibrates (generate noise) at any position of valve plug Valve vibrates (generate noise) only when valve plug is set at a certain position. | <ul style="list-style-type: none"> Piping is vibrating. Securely fix the piping. Check for other sources of vibration. Worn valve plug or guides. Check for change in process fluid flow conditions. (Change in restriction orifice, Cv value, etc.) Check for change in plug configuration (change in flow control characteristics.) |

Table 13-1. Troubleshooting

| Problem | Cause and Remedial Action |
|-----------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| Sluggish valve operation or inoperative valve | <ul style="list-style-type: none"> • Air leak from piping • Air leak from actuator • Foreign matter entrapped in guide section of valve plug • Aged and hardened gland packing, causing increased hysteresis • Malfunctioning positioner • (Check the positioner by operating it directly on an air supply know to be operating normally.) |
| Fluid leak from gland section | <ul style="list-style-type: none"> • Check for loose packing flange. • Check for insufficient grease. • Check for damaged valve shaft. |
| Liquid leak from gasket section | <ul style="list-style-type: none"> • Check for loose nuts of bonnet. • Check for defective gasket (deformed or damaged). |
| Even when valve plug is in closed position, large flow leaks to downstream side. | <ul style="list-style-type: none"> • Air leak at actuator section • For trial, apply the air supply pressure or atmospheric pressure to the actuator. (Check the air supply source pressure to the actuator.) • Check whether the valve plug is actually in the closed position or not.(Check the valve plug lift.) • Check the plug seat ring for corrosion and erosion. • Check the guide sections for binding. • Check for damaged seal ring. |

Chapter 14. Recommended spare parts

It is recommended to replace the following parts when servicing the control valve.

Valve Body

Be sure to replace the following parts with new ones whenever the valve body is disassembled:

- Gland packing
- Gaskets

The frequency of replacement of seal ring or scraper ring differs drastically depending upon such conditions as type of flow fluid, fluid temperature or pressure. As a general rule, replace them once every 100,000 full stroke cycles or once every three years.

The frequency of replacement of carbon ring differs drastically depending upon such conditions as type of flow fluid, fluid temperature or pressure. As a general rule, replace them once every totalized stroke of 2.5 km or once every three years.

Actuator

Replace the following parts at every 5 years or thereabouts:

| | | |
|-------------|---|----------------------------------------------------------------------|
| Diaphragm | } | Be sure to replace these parts whenever the actuator is disassembled |
| Bushing | | |
| Seal washer | | |
| Dust seal | | |
| Rod seal | | |

Of the bellows sealed type of control valves, the bellows seal assembly* must be replaced periodically. The period of replacement depends on temperature, pressure and order conditions of use. A typical service longevity of the bellows assembly is 10,000 vertical stroke cycles.

Note: *The bellows seal assembly has the seal bellows and valve stem (including the bellows seat) assembled together.

Please mention the parts name and the product number indicated on the name plate when ordering spare parts.

Terms and Conditions

We would like to express our appreciation for your purchase and use of Azbil Corporation's products.

You are required to acknowledge and agree upon the following terms and conditions for your purchase of Azbil Corporation's products (system products, field instruments, control valves, and control products), unless otherwise stated in any separate document, including, without limitation, estimation sheets, written agreements, catalogs, specifications and instruction manuals.

1. Warranty period and warranty scope

1.1 Warranty period

Azbil Corporation's products shall be warranted for one (1) year from the date of your purchase of the said products or the delivery of the said products to a place designated by you.

1.2 Warranty scope

In the event that Azbil Corporation's product has any failure attributable to azbil during the aforementioned warranty period, Azbil Corporation shall, without charge, deliver a replacement for the said product to the place where you purchased, or repair the said product and deliver it to the aforementioned place. Notwithstanding the foregoing, any failure falling under one of the following shall not be covered under this warranty:

- (1) Failure caused by your improper use of azbil product (noncompliance with conditions, environment of use, precautions, etc. set forth in catalogs, specifications, instruction manuals, etc.);
- (2) Failure caused for other reasons than Azbil Corporation's product;
- (3) Failure caused by any modification or repair made by any person other than Azbil Corporation or Azbil Corporation's subcontractors;
- (4) Failure caused by your use of Azbil Corporation's product in a manner not conforming to the intended usage of that product;
- (5) Failure that the state-of-the-art at the time of Azbil Corporation's shipment did not allow Azbil Corporation to predict; or
- (6) Failure that arose from any reason not attributable to Azbil Corporation, including, without limitation, acts of God, disasters, and actions taken by a third party.

Please note that the term "warranty" as used herein refers to equipment-only-warranty, and Azbil Corporation shall not be liable for any damages, including direct, indirect, special, incidental or consequential damages in connection with or arising out of Azbil Corporation's products.

2. Ascertainment of suitability

You are required to ascertain the suitability of Azbil Corporation's product in case of your use of the same with your machinery, equipment, etc. (hereinafter referred to as "Equipment") on your own responsibility, taking the following matters into consideration:

- (1) Regulations and standards or laws that your Equipment is to comply with.
- (2) Examples of application described in any documents provided by Azbil Corporation are for your reference purpose only, and you are required to check the functions and safety of your Equipment prior to your use.
- (3) Measures to be taken to secure the required level of the reliability and safety of your Equipment in your use

Although azbil is constantly making efforts to improve the quality and reliability of Azbil Corporation's products, there exists a possibility that parts and machinery may break down. You are required to provide your Equipment with safety design such as fool-proof design,*1 and fail-safe design*2 (anti-flame propagation design, etc.), whereby preventing any occurrence of physical injuries, fires, significant damage, and so forth. Furthermore, fault avoidance,*3 fault tolerance,*4 or the like should be incorporated so that the said Equipment can satisfy the level of reliability and safety required for your use.

*1. A design that is safe even if the user makes an error.

*2. A design that is safe even if the device fails.

*3. Avoidance of device failure by using highly reliable components, etc.

*4. The use of redundancy.

3. Precautions and restrictions on application

3.1 Restrictions on application

Please follow the table below for use in nuclear power or radiation-related equipment.

| | Nuclear power quality*5 required | Nuclear power quality*5 not required |
|---------------------------------------|----------------------------------------------------------------|----------------------------------------------------------------|
| Within a radiation controlled area*6 | Cannot be used (except for limit switches for nuclear power*7) | Cannot be used (except for limit switches for nuclear power*7) |
| Outside a radiation controlled area*6 | Cannot be used (except for limit switches for nuclear power*7) | Can be used |

*5. Nuclear power quality: compliance with JEAG 4121 required

*6. Radiation controlled area: an area governed by the requirements of article 3 of "Rules on the Prevention of Harm from Ionizing Radiation," article 2 2 4 of "Regulations on Installation and Operation of Nuclear Reactors for Practical Power Generation," article 4 of "Determining the Quantity, etc., of Radiation-Emitting Isotopes," etc.

*7. Limit switch for nuclear power: a limit switch designed, manufactured and sold according to IEEE 382 and JEAG 4121.

Any Azbil Corporation's products shall not be used for/with medical equipment.

The products are for industrial use. Do not allow general consumers to install or use any Azbil Corporation's product. However, azbil products can be incorporated into products used by general consumers. If you intend to use a product for that purpose, please contact one of our sales representatives.

3.2 Precautions on application

you are required to conduct a consultation with our sales representative and understand detail specifications, cautions for operation, and so forth by reference to catalogs, specifications, instruction manual, etc. in case that you intend to use azbil product for any purposes specified in (1) through (6) below. Moreover, you are required to provide your Equipment with fool-proof design, fail-safe design, anti-flame propagation design, fault avoidance, fault tolerance, and other kinds of protection/safety circuit design on your own responsibility to ensure reliability and safety, whereby preventing problems caused by failure or nonconformity.

- (1) For use under such conditions or in such environments as not stated in technical documents, including catalogs, specification, and instruction manuals
- (2) For use of specific purposes, such as:
 - * Nuclear energy/radiation related facilities
[When used outside a radiation controlled area and where nuclear power quality is not required]
[When the limit switch for nuclear power is used]
 - * Machinery or equipment for space/sea bottom
 - * Transportation equipment
[Railway, aircraft, vessels, vehicle equipment, etc.]
 - * Antidisaster/crime-prevention equipment
 - * Burning appliances
 - * Electrothermal equipment
 - * Amusement facilities
 - * Facilities/applications associated directly with billing
- (3) Supply systems such as electricity/gas/water supply systems, large-scale communication systems, and traffic/air traffic control systems requiring high reliability
- (4) Facilities that are to comply with regulations of governmental/public agencies or specific industries
- (5) Machinery or equipment that may affect human lives, human bodies or properties
- (6) Other machinery or equipment equivalent to those set forth in items (1) to (5) above which require high reliability and safety

4. Precautions against long-term use

Use of Azbil Corporation's products, including switches, which contain electronic components, over a prolonged period may degrade insulation or increase contact-resistance and may result in heat generation or any other similar problem causing such product or switch to develop safety hazards such as smoking, ignition, and electrification. Although acceleration of the above situation varies depending on the conditions or environment of use of the products, you are required not to use any Azbil Corporation's products for a period exceeding ten (10) years unless otherwise stated in specifications or instruction manuals.

5. Recommendation for renewal

Mechanical components, such as relays and switches, used for Azbil Corporation's products will reach the end of their life due to wear by repetitious open/close operations.

In addition, electronic components such as electrolytic capacitors will reach the end of their life due to aged deterioration based on the conditions or environment in which such electronic components are used. Although acceleration of the above situation varies depending on the conditions or environment of use, the number of open/close operations of relays, etc. as prescribed in specifications or instruction manuals, or depending on the design margin of your machine or equipment, you are required to renew any Azbil Corporation's products every 5 to 10 years unless otherwise specified in specifications or instruction manuals. System products, field instruments (sensors such as pressure/flow/level sensors, regulating valves, etc.) will reach the end of their life due to aged deterioration of parts. For those parts that will reach the end of their life due to aged deterioration, recommended replacement cycles are prescribed. You are required to replace parts based on such recommended replacement cycles.

6. Other precautions

Prior to your use of Azbil Corporation's products, you are required to understand and comply with specifications (e.g., conditions and environment of use), precautions, warnings/cautions/notices as set forth in the technical documents prepared for individual Azbil Corporation's products, such as catalogs, specifications, and instruction manuals to ensure the quality, reliability, and safety of those products.

7. Changes to specifications

Please note that the descriptions contained in any documents provided by azbil are subject to change without notice for improvement or for any other reason. For inquiries or information on specifications as you may need to check, please contact our branch offices or sales offices, or your local sales agents.

8. Discontinuance of the supply of products/parts

Please note that the production of any Azbil Corporation's product may be discontinued without notice. After manufacturing is discontinued, we may not be able to provide replacement products even within the warranty period.

For repairable products, we will, in principle, undertake repairs for five (5) years after the discontinuance of those products. In some cases, however, we cannot undertake such repairs for reasons, such as the absence of repair parts. For system products, field instruments, we may not be able to undertake parts replacement for similar reasons.

9. Scope of services

Prices of Azbil Corporation's products do not include any charges for services such as engineer dispatch service. Accordingly, a separate fee will be charged in any of the following cases:

- (1) Installation, adjustment, guidance, and attendance at a test run
- (2) Maintenance, inspection, adjustment, and repair
- (3) Technical guidance and technical education
- (4) Special test or special inspection of a product under the conditions specified by you

Please note that we cannot provide any services as set forth above in a nuclear energy controlled area (radiation controlled area) or at a place where the level of exposure to radiation is equivalent to that in a nuclear energy controlled area.

| | |
|-------------------------|----------------------------------------------------------|
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