



**NOTES:**

THIS PROCEDURE TO BE PERFORMED IN A CLEAN AND DRY AREA. ALL PARTS TO BE BLOWN CLEAN AND DRY WITH NITROGEN BEFORE ASSEMBLY.

10 PORT VALVE ASSEMBLY INSTRUCTIONS

1. Assembly is to be accomplished by building the valve in the upside down position using production fixture.
2. Inspect the primary plate, Item #1, to insure that the tubing ports are clean and that the sealing surface has no scratches or pits. Then place it in the fixture with the sealing surface facing up.
3. Insert .125 Dia. guide pin, Item #11, and .093 Dia. guide pin, Item #10, in the locating holes in the plate.
4. Place the amber sealing diaphragm ( has no holes in the actuating plane) over the guide pins and align.
5. Place the white cushion diaphragm (has same hole pattern as sealing diaphragm in step 4) over the sealing diaphragm and align.
6. Place the upper piston plate, Item #6, over the guide pins with the piston recess holes facing up.
7. Load 5 each of the short pistons, Item #4, into the recess holes of the plate.
8. Place 2 each of the amber upper actuator diaphragms ( has 5 large holes for long pistons to feed through) over the guide pins and align.
9. Place the lower piston plate, Item #3, over the guide pins with the piston recess holes facing up.
10. Load 5 each of the long pistons, Item #5, into the recess holes of the plate.
11. Place two amber lower actuator diaphragms over the guide pins and align.
12. Place base plate, item #4 over the guide pins and align.
13. Place washer, Item #9, over bolt, Item #8, and insert the bolt from the bottom up through the valve assembly, tighten bolt Item #8 to 30 Ft. LBS. Remove from fixture and install into Unit.

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	2-4-0710-058	PRIMARY PLATE CE-22013	1
2	2-4-0710-057	UPPER PISTON PLATE CE-22012	1
3	2-4-0710-056	LOWER PISTON PLATE CE-22011	1
4	2-4-0710-059	BASE PLATE CE-22014	1
5	2-4-0710-104	LONG PISTONS BE-22066	5
6	2-4-0710-105	SHORT PISTONS BE-22067	5
7	2-4-0710-171	DIAPHRAGM KIT	1
8	2-4-9216-177	BOLT, 5/16-24 x 1 3/4" LG.	1
9	2-4-9550-154	WASHER, FLAT STEEL L9 HARD	1
10	2-4-0710-169	Ø .093 GUIDE PIN	1
11	2-4-0710-170	Ø .125 GUIDE PIN	1
12	2-9-9960-148	SCREEN	10
13	2-4-9550-114	WASHER	10

SI METRIC						
THIRD ANGLE PROJECTION						
MATERIAL: SEE ORDER						
B	08-20-08	HM	ECO-XX-5004044	HB	NP	
A	06-20-08	HM	ECO-XX-5003758	EM	NP	
REV	DATE	DRN	DESCRIPTION	CHKD	APPD	
PROJ. FILE NO. - NONE						
FILE NAME: CE22016B1.SLDDRW, DATE: 08-20-08, TIME: 8:10 A.M.						

THIS DRAWING IN DESIGN AND DETAIL IS OUR PROPERTY AND MUST NOT BE USED EXCEPT IN CONNECTION WITH OUR WORK. IT SHALL NOT BE REPRODUCED AND SHALL BE RETURNED TO US ON DEMAND. ALL RIGHTS ARE RESERVED.

GEOMETRIC TOLERANCES & DIMENSIONS PER ANSI Y14.5 LATEST REVISION

UNLESS OTHERWISE NOTED ALL DIMENSIONS IN INCHES

X.XXX ±.015  
X.XXX ±.005  
ANGULAR ±0° 30'  
FINISH 200 RA MAX

BREAK ALL SHARP CORNERS TO .003-.015 RADIUS AND REMOVE ALL BURRS

**EMERSON**  
Process Management

TITLE: **ASSEMBLY 10 PORT VALVE MODEL 700XA**

DRN	MANCHA	DATE	10/17/06	DWG NO.	CE-22016	REV	B
CHKD	EM	DATE	06/20/08	SCALE	2:1	P/N	2-3-0710-052
APPD	NP	DATE	06/20/08	SHT	1 OF 1		