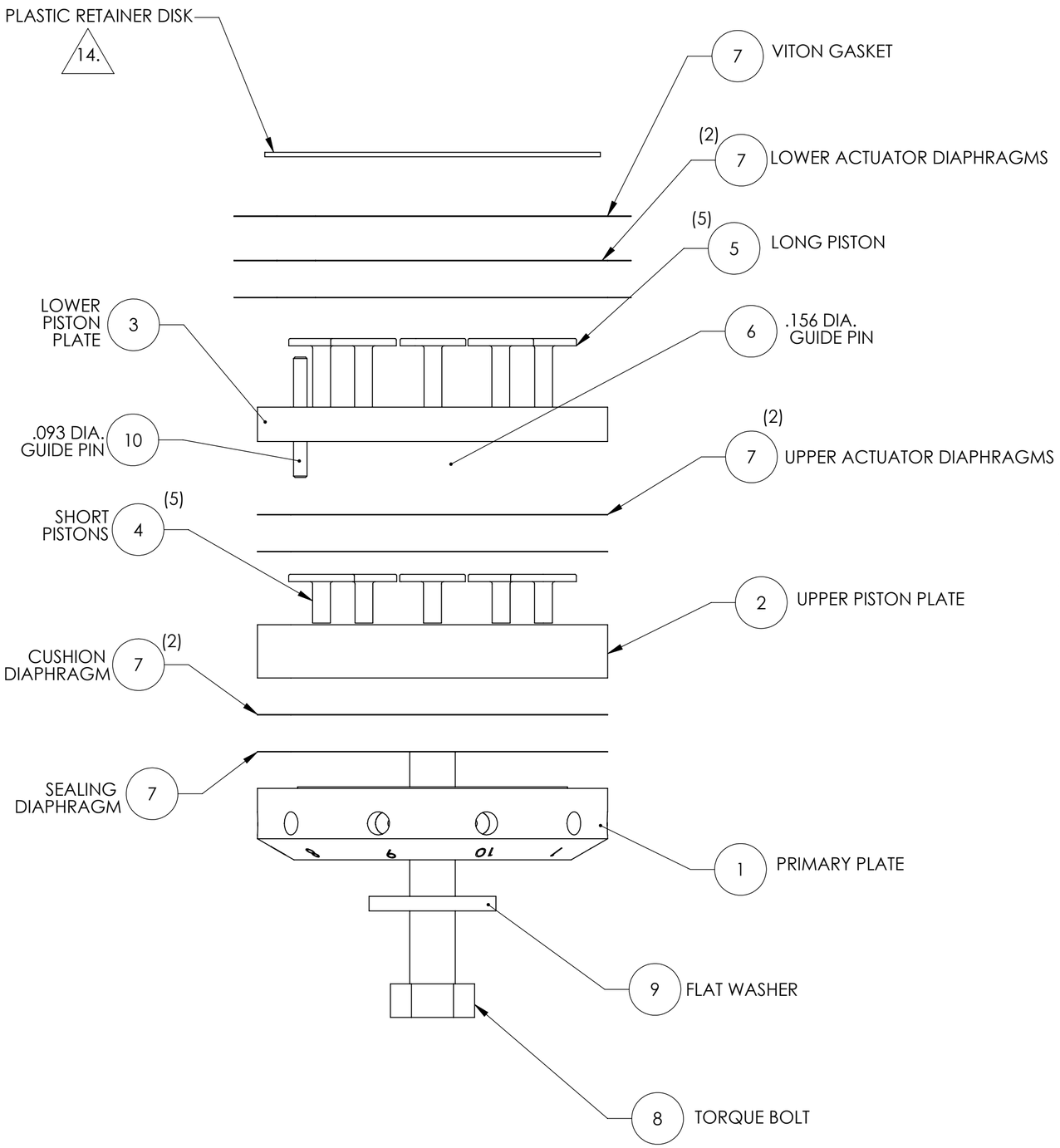

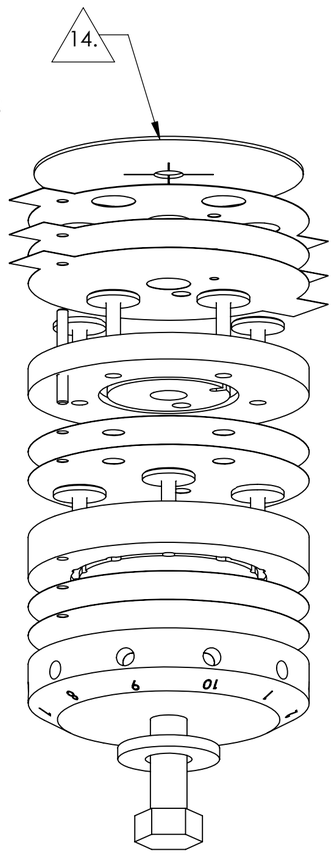

NOTES:

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 .156 Dia. guide pin, Item #6, 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 #2, 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 (with extended ears) over the guide pins and align.
12. Place black viton gasket 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. Remove from fixture and Install into Unit.

14. If the assembled valve is to be shipped as a spare or replacement valve, install plastic retainer disk (2-4-0700-191).

15. TORQUE THE BOLT (ITEM 8) TO 30 FT. LBS. WHEN THE VALVE IS INSTALLLED ON THE ANALYZER.

SI METRIC	H	08/13/10	CC	ECO-XX-5005838	EM	HS
THIRD ANGLE PROJECTION	G	7-6-06	HM	ECO-XX-5001969	EM	NP
	F	4-2-06	HM	ECO-XX-5001716	EM	NP
	E	2-25-05	HM	ECO-XX-5000518	EM	BLB
MATERIAL: SEE ORDER	D	8-3-04	HM	ECO-XX-212474	EM	HS
	C	6-29-04	HM	ECO-XX-209763	EM	DLT
FINISH: BLOCK N/A	B	11-11-03	HM	ECO-XX-190965	EM	BLB
PROJ. FILE NO. G-00001	REV	DATE	DRN	DESCRIPTION	CHKD	APPD

FILE NAME: CE20958H1.SLDDRW, DATE: 08/13/10, TIME: 8:15 A.M.

GEOMETRIC TOLERANCES & DIMENSIONS PER ANSI Y14.5 LATEST REVISION

UNLESS OTHERWISE NOTED ALL DIMENSIONS IN INCHES

X.XX	±.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 700 G.C.

DRN	HM	DATE	10/1/03	DWG NO.	CE-20958	REV H
CHKD	DLT	DATE	10-17-03			
APPD	BLB	DATE	10-17-03	SCALE 1:1	P/N 2-3-0700-118	SHT 1OF1