



**NOTES:**

6 PORT VALVE ASSEMBLY INSTRUCTIONS

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

- ASSEMBLY IS ACCOMPLISHED IN THE UPSIDE DOWN POSITION.
- PLACE ITEM 9, PRIMARY PLATE INTO SHOP ASSEMBLY FIXTURE AND INSTALL ITEM 3, LARGE DOWEL PIN AND ITEM 2, SMALL DOWEL PIN.
- PLACE ITEM 10, AMBER SEALING DIAPHRAGM ( HAVING NO ACTUATOR HOLES) ALIGN LARGE AND SMALL DOWEL PIN HOLES.
- PLACE ITEM 10, WHITE NOMEX CUSHION DIAPHRAGM (HAVING NO ACUATOR HOLES) ALIGN LARGE AND SMALL DOWEL PIN HOLES.
- PLACE ITEM 5, UPPER PISTON PLATE OVER DOWEL PINS.
- PLACE ITEM 6, SHORT PISTONS IN PISTON PLATE 3 PLACES. PISTON SHAFT MUST FALL THROUGH HOLES. DO NOT FORCE.
- PLACE ITEM 10, AMBER UPPER ACTUATOR DIAPHRAGMS WITH LARGE ACTUATOR HOLES OVER DOWEL PINS 2 PLACES. ALIGN WITH LARGE AND SMALL DOWEL PINS.
- PLACE ITEM 1, LOWER PISTON PLATE OVER DOWEL PINS.
- PLACE ITEM 4, LONG PISTONS IN PISTON PLATE 3 PLACES. PISTON SHAFT MUST FALL FREELY THROUGH HOLES. DO NOT FORCE.
- PLACE ITEM 10, AMBER LOWER ACTUATOR DIAPHRAGMS WITH SMALL ACTUATOR HOLES OVER DOWEL PINS 2 PLACES. ALIGN WITH LARGE AND SMALL DOWEL PINS.
- PLACE ITEM 10, BLACK VITON GASKET, OVER DOWEL PINS. ALIGN WITH LARGE AND SMALL DOWEL PINS.
- INSTALL ITEM 8, BOLT AND ITEM 7, FLAT WASHER UP THRU PRIMARY PLATE. REMOVE FROM FIXTURE AND INSTALL INTO UNIT.
- IF THE ASSEMBLED VALVE IS TO BE SHIPPED AS A SPARE OR REPLACEMENT VALVE, INSTALL PLASTIC RETAINER DISK (2-4-700-191).
- TORQUE THE BOLT (ITEM 8) TO 30 FT. LBS. WHEN THE VALVE IS INSTALLED ON THE ANALYZER.

SI METRIC	G	08/13/10	CC	ECO-XX-5005838	EM	HS
THIRD ANGLE PROJECTION	F	7-6-06	HM	ECO-XX-5001969	EM	NP
	E	4-2-06	HM	ECO-XX-5001716	EM	NP
	D	2-25-05	HM	ECO-XX-5000518	EM	BLB
MATERIAL: SEE ORDER	C	8-3-04	HM	ECO-XX-212474	EM	HS
	B	6-29-04	DLT	ECO-XX-209763	EM	DLT
FINISH: BLOCK N/A	A	10-17-03	HM	REL'D ECO 189137	DLT	BLB
	REV	DATE	DRN	DESCRIPTION	CHKD	APPD
PROJ. FILE NO. G-00001	FILE NAME: CE20931G1.SLDDRW, DATE: 08/13/10, TIME: 8:45 A.M.					

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GEOMETRIC TOLERANCES & DIMENSIONS PER ANSI Y14.5 LATEST REVISION

UNLESS OTHERWISE NOTED ALL DIMENSIONS IN INCHES

XXX +.015  
XXXX +.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  
RADIAL 6 PORT VALVE, KIOSK OVEN  
MODEL 700 G.C.**

DRN	HM	DATE	8-19-02	DWG NO.	CE-20931	REV	G
CHKD	DLT	DATE	10-17-03	SCALE		1:1	
APPD	BLB	DATE	10-17-03	P/N		2-3-0700-107	