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Revision 0
Page 1 of 4

BU-3167

MAINTENANCE INSTRUCTIONS FOR VALVE 20V122V-HT-ATC8

TABLE OF CONTENTS

<u>SECTION</u>	<u>TITLE</u>	<u>PAGE NO.</u>
1.0	Reference	2
2.0	Purpose	2
3.0	Scope	2
4.0	Instructions	2
5.0	Record of Revision	4



1.0 REFERENCE:

- 1.1 Valve assembly drawing D-1013, latest revision.
- 1.2 Air actuator assembly drawing B-2327, latest revision.

2.0 PURPOSE:

- 2.1 To establish maintenance instruction for the 20V122V-HT-ATC8 valve.

3.0 SCOPE:

- 3.1 This maintenance procedure to be used for all 20V122V-HT-ATC8 valves.

4.0 INSTRUCTIONS:

CAUTION: Vent all pressure from system before removing valve for maintenance.

4.1 DISASSEMBLY:

- 4.1.1 Loosen side connections and remove valve from system.
- 4.1.2 Place valve assembly in a vise equipped with "soft jaws". Loosen and remove all four cap screws (Item 12) holding the bottom plate (Item 28) to the body.
- 4.1.3 Loosen coupling (Item 20) and rotate actuator and bottom plate subassembly counterclockwise until coupling disengages from the stem (Item 3).
- 4.1.4 Remove actuator and bottom plate subassembly from valve body (Item 1). Refer to BU-3057 for instructions on the maintenance of the actuator assembly.
- 4.1.5 Place an appropriate open-ended wrench on the flats of the locknut (Item 5) and loosen. Loosen the packing gland (Item 4).
- 4.1.6 Place an appropriate open-ended wrench on the flats of the housing (Item 2). Loosen and remove the housing and stem sub-assembly from body. Remove the cone ring (Item 11) and bearing (Item 27).
- 4.1.7 Remove packing gland (Item 4) from the housing. Grasp the housing and carefully push the lower stem (Item 10) through the housing. The upper stem (Item 3), top packing washer (Item 7), the packing (Item 8) and bottom washer (Item 9) will be attached.



4.2 ASSEMBLY:

- 4.2.1 The assembly technician shall, as a minimum, check all repair kit components for cleanliness, nicks, dents and/or scratches. Replace any damaged components.
- 4.2.2 The assembly technician shall lubricate all components of the stem assembly (sub-assembly) with an approved lubricant as follows:
- 4.2.2.1 Bottom washer (Item 9) shall be lightly lubricated on the outside diameter.
- 4.2.2.2 Packing gland (Item 4) shall be lightly lubricated on the first three external threads.
- 4.2.2.3 The housing (Item 2) shall be lightly lubricated on the first three external threads and the bearing surface where it contacts the cone ring (Item 11).
- 4.2.2.4 Lightly lubricate both sides of the cone ring (Item 11).
- 4.2.3 Place the housing (Item 2) into the vise equipped with "soft jaws". Gasp the lubricated stem assembly with installed packing and top and bottom washers and insert the sub-assembly into the housing.
- 4.2.4 Slip the packing gland (Item 4) over the upper stem (Item 3) and tighten into the housing. Be sure the packing components are properly aligned and the locknut (Item 5) is disengaged. Using a torque wrench, tighten the packing gland to approximately 80 lb-ft. Secure with the locknut.
- 4.2.5 Remove the housing/stem sub-assembly from the vise.
- 4.2.6 Install the body (Item 1) into the vise. Insert the bearing (Item 27) and cone ring (Item 11).
- 4.2.7 Carefully align the housing/stem sub-assembly with the opening in the body and tighten. Using a torque wrench tighten to approximately 80 lb-ft.
- 4.2.7 Lift actuator/bottom plate sub-assembly over housing to engage the stem (item 3) with the coupling (item 20). Rotate the actuator/bottom plate subassembly clockwise until the bottom plate (item 28) contacts the body.
- 4.2.8 Install and tighten the four cap screws (item 12) that hold the bottom plate to the body.

General Note: Butech Pressure Systems recommends that refurbished valve be pressure tested before being returned to service.



RECORD OF REVISIONS

REV NO	DESCRIPTION OF CHANGES	DATE	BY	APPR
0	Original document	6/27/00	DTG	DTG