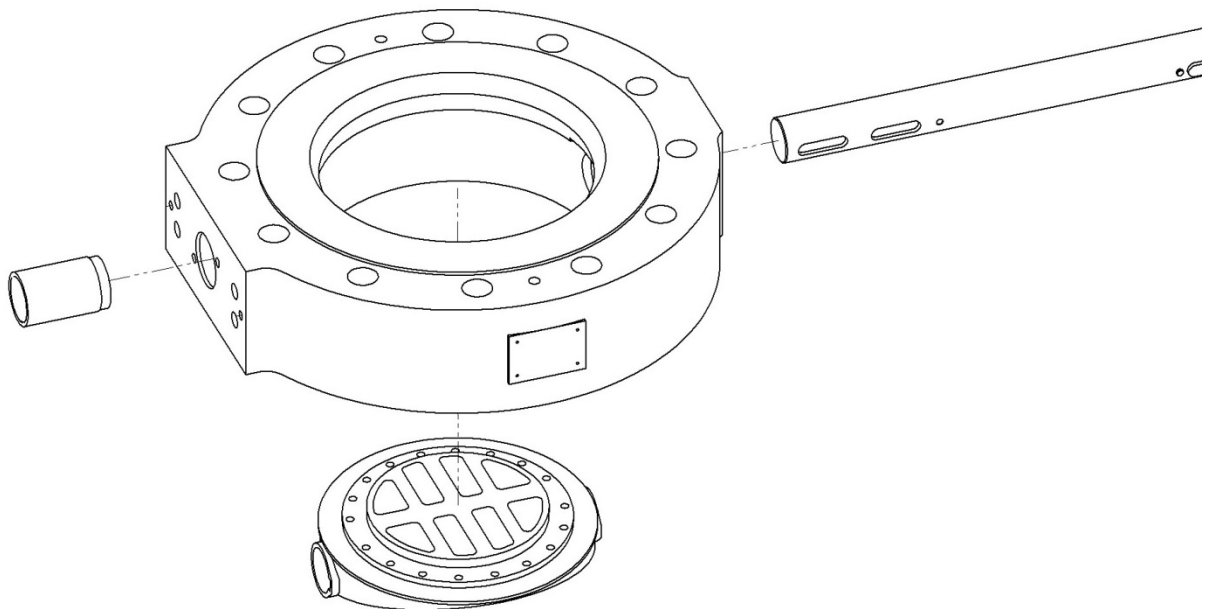


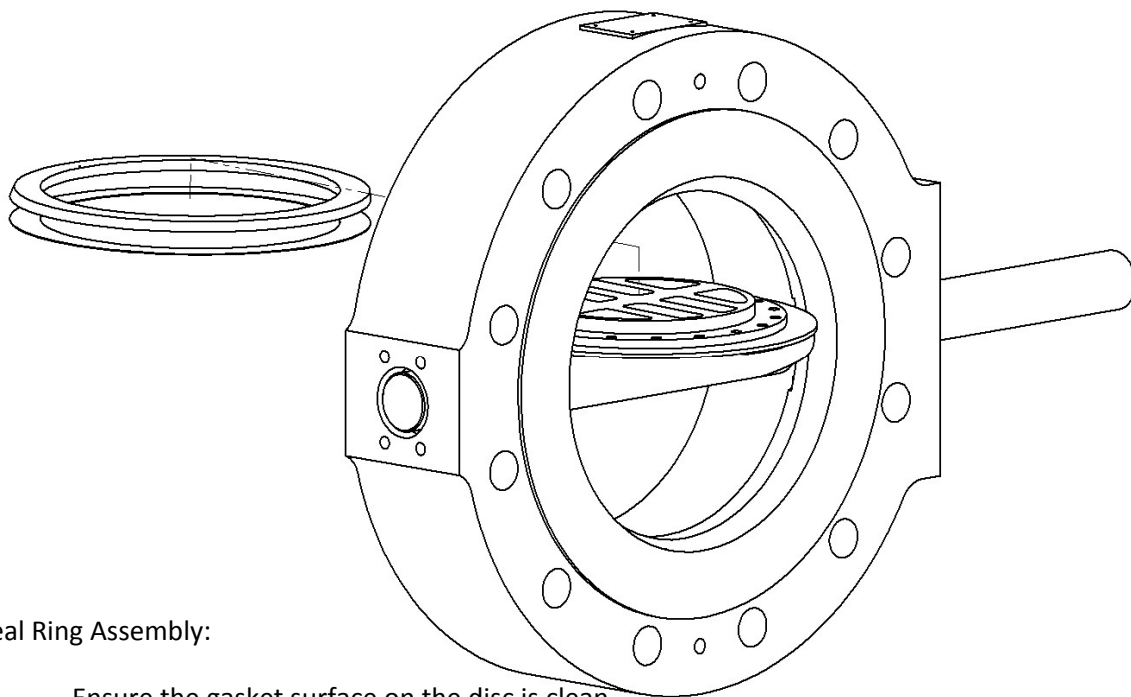
Shaft assembly:

- Preassemble on the shaft:
 - o Anti-blowout pin
 - o Drive keys
 - o Bottom bearing bushing
 - o Ring
 - Insert the cross pin
-



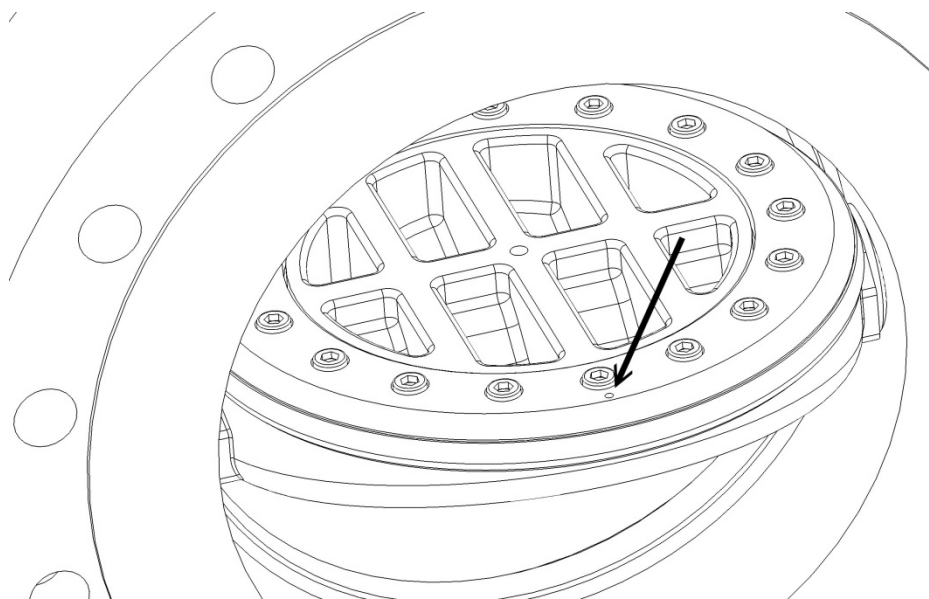
Disc assembly:

- Keyway of the disc must be on the nameplate side
 - Align the disc in the valve body
 - Insert the shaft into the bottom of the valve body, passing through the bore of the disc
 - Install upper bushing
 - Continue inserting until it until it stops
-



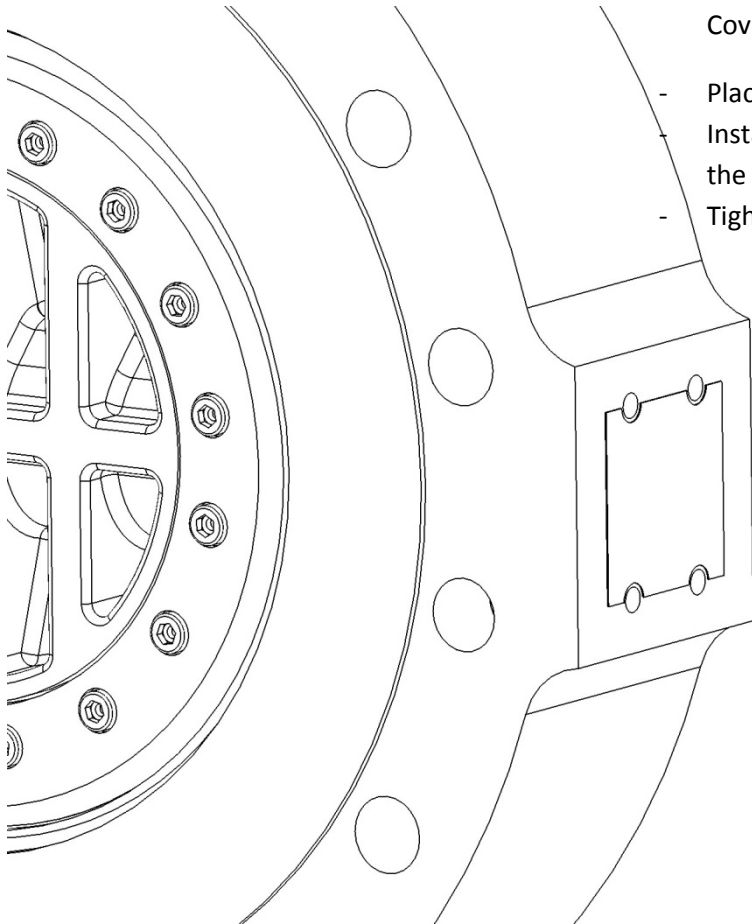
Seal Ring Assembly:

- Ensure the gasket surface on the disc is clean
 - Place the seal ring gasket onto the disc
 - Place the seal ring onto the seal ring
-



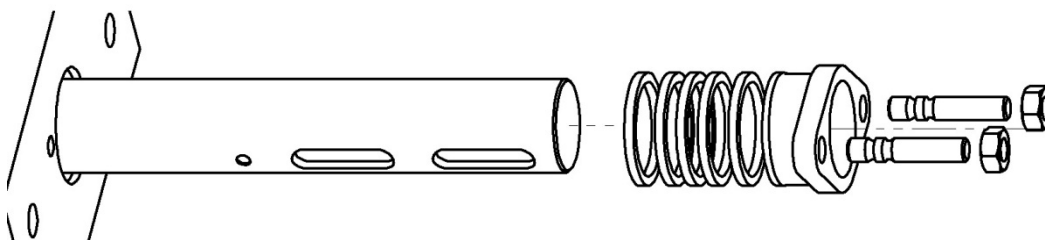
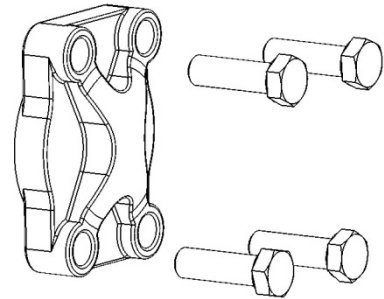
Clamping Ring Assembly:

- Align the seal ring so the marking on the disc, the seal ring, and the clamping ring match (arrow)
 - Place the clamping ring onto the seal ring
 - Insert the clamping ring screws and tighten them finger tight
 - Close the disc slightly a couple times allowing the seal ring to find the correct position
 - Once adjusted, tighten the clamping ring screws slightly more than finger tight
-



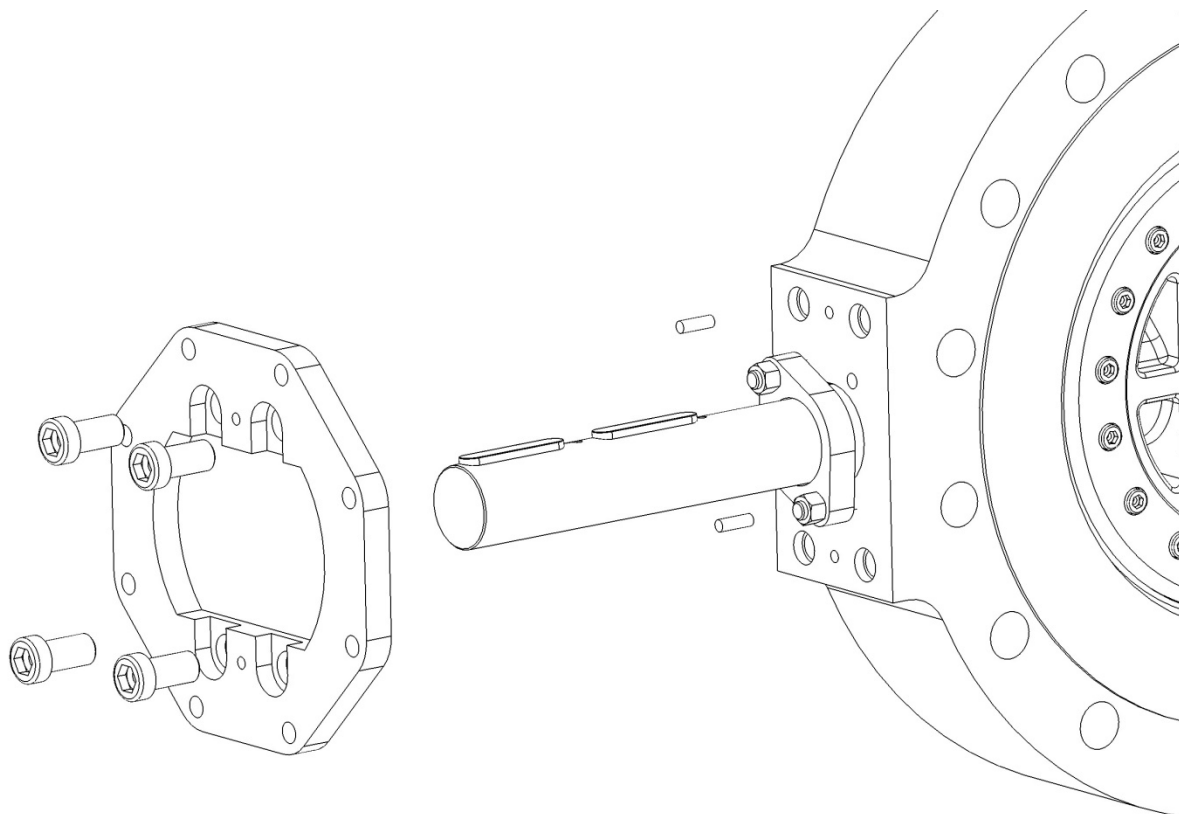
Cover Plate Installation:

- Place the flat gasket on the lid
- Install the cover on the valve body with the supplied bolting
- Tighten the screws to the torque specified



Stem Packing Installation:

- Insert one piece of the graphite braid lining up the angled ends to fit
- Insert the three solid graphite rings
- With the angled ends on the opposite side from of the first braid, insert the remaining braid
- Install the packing studs
- Install the packing gland
- Install the packing nuts (if live-loaded, install the Bellville washers before installing the packing nuts)
- Tighten the packing nuts to the torque specified



Install Mounting Ring:

- Insert the dowel pins into the valve body
 - Place the mounting ring on the pins
 - Insert the screws and tighten to the specified torque
 -
-

Tighten the clamping ring screws:

- Install the operator and close the flap with a small torque
- Slightly tighten clamping ring screws in a "star pattern"
- Open disc
- Tighten clamping ring screws in a "star pattern" with torque
- Close disc
- Tighten the clamping ring screws to final torque – again in a "star pattern"