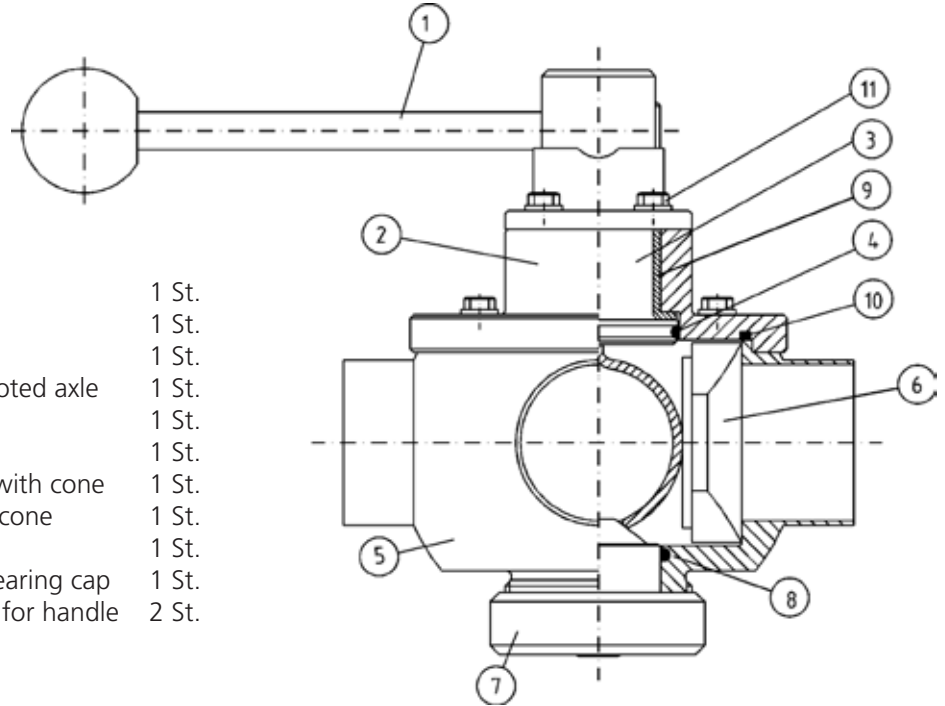


Assembling & Maintenance

Inox Arc Valve Parts List

- | | |
|----------------------------|-------|
| 1 Handle | 1 St. |
| 2 Bearing cap | 1 St. |
| 3 Pivoted axle | 1 St. |
| 4 O-ring for pivoted axle | 1 St. |
| 5 Valve casing | 1 St. |
| 6 Shutter | 1 St. |
| 7 Pinching nut with cone | 1 St. |
| 8 O-ring to the cone | 1 St. |
| 9 Bearing bush | 1 St. |
| 10 O-ring for bearing cap | 1 St. |
| 11 Fixing screw for handle | 2 St. |



Spare Parts

Pos.	Description
06	Shutter (PTFE/EPDM)
09	Bearing bush
04/08/10	O-Ring Set EPDM DN65 (1x O-ring for pivoted axle, 1x for bearing cap, 1x for cone)

Inox Arc Valve Lubrication plan

O-ring gaskets getting in contact with product (material – EPDM):

Klüber Paraliq GTE 703 Food Grade USDA H1 – Registration for the food industry

Lubrication of the Inox fixing screws DIN 912 and DIN 933:

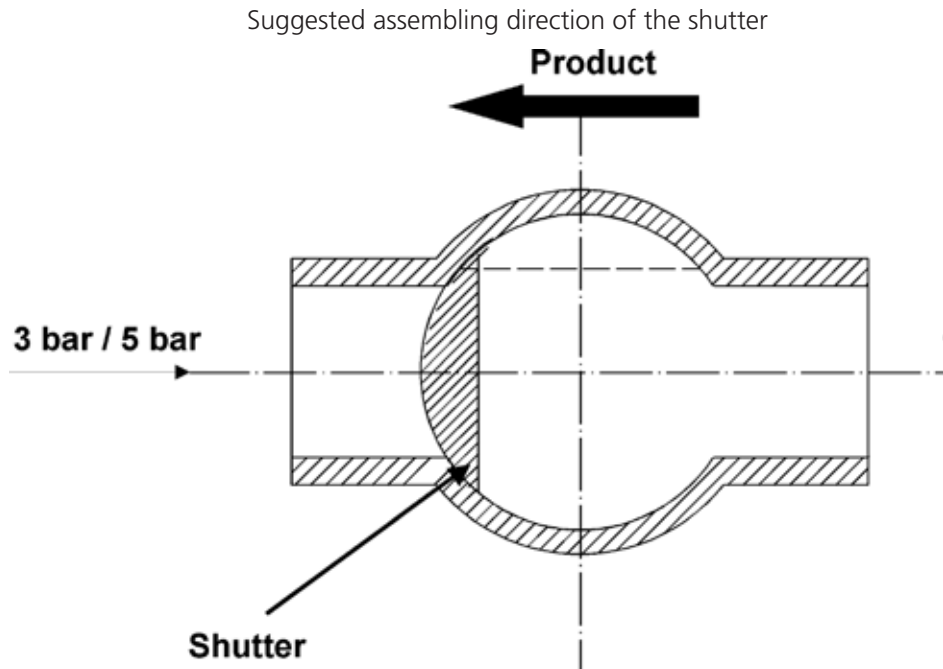
Klüberplex BEM 34-132

Südmo North America, Inc. reserves the right to make changes in the technical specifications at any time.

2- / 3- way Arc Valves

Assembling & Maintenance

Disassembling of Inox Arc Valve for maintenance



Attention! Valve must not be under pressure.

1. Loosen the fixing screw of the pinching nut.
2. Loosen the pinching nut with cone (7).
3. Remove the bearing cap (2), by releasing first its fixing screws.
4. Remove the shutter (6) from the valve casing (5).
5. Loosen the fixing screws of the handle (11) in order to remove the handle (1).
6. Pull out the pivoted axle (3) from the bearing cap (2).

Maintenance:

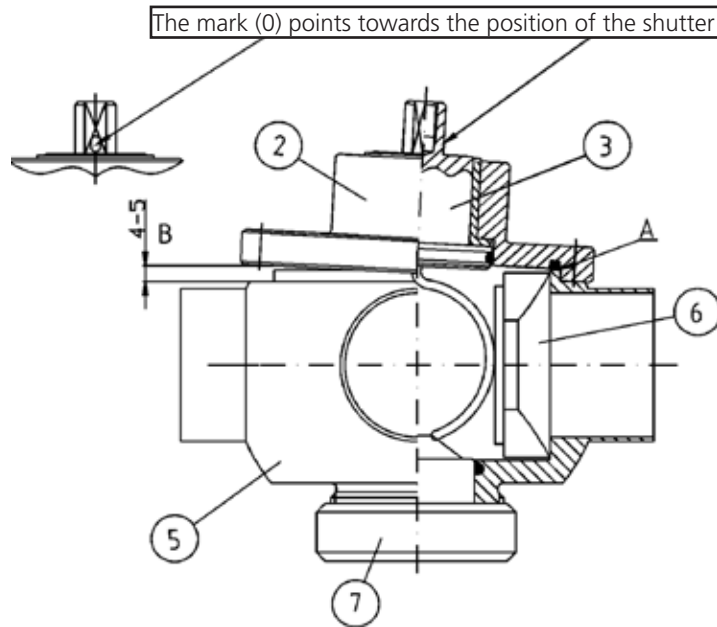
1. Check the functional condition of the surface of the valve casing and clean it properly.
2. Replace O-ring (10) to the bearing cap.
3. Replace O-ring (4) and (8) (lubricated with food grade grease Molykote111).
4. Check the functional condition of the bearing bush (9), replace with new one if necessary.
5. Check the functional condition of the shutter (6), replace with new one if necessary.
6. The pinching nut with cone (7) is assembled together with the conical axle by factory. Do not try to disassemble it!
7. Follow assembling instructions on next page.

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2- / 3- way Arc Valves

Assembling & Maintenance

Assembling of Inox Arc Valve after maintenance



1. Before assembling the valve check the cleanliness and good condition off all piece-parts.
2. Screw on the pinching nut with cone (7) to the bottom of the valve casing (5) until the cone contacts the O-ring (8).
3. Reassemble the pivoted axle (3) to the bearing cap (2). Observe the sign (0) marked on the square shaft of the pivoted axle (3) showing the side of the axle where the shutter (6) is situated inside the valve.
4. Insert the shutter (6) into the valve.
5. Mount the pivoted axle (3) together with the bearing cap (2), to the valve casing (5) as follows:
 - The arc plate of the pivoted axle (3) is shaped by factory in order to give an initial tightness to the shutter (6) when assembled together.
 - When the shutter (6) is in the valve, place the bearing cap (2) to the valve as detail "A" shows.
 - The correct position is achieved when the arc plate is pressed against the shutter (3) and on the detail "B" the cap (2) still has a clearance of 4-5 mm.
 - To avoid damages to the shutter (6), do not place the shutter (6) in front of an exit during assembling.
 - Now replace the fixing screws of the bearing cap (2) and tighten crosswise until the cap (2) is completely closed to the valve.
 - Fix the handle (1) in its right position.
 - Turn the handle around (1) a few time and you'll feel that the shutter (6) is tight.
6. Tighten finally the pinching nut (7) by hand (without using a tool) until the cone is pressing to the arc plate and tighten more with a key by turning it about 90° clockwise.
7. Tighten the fixing screw of the pinching nut (7)

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2- / 3- way Arc Valves

Assembling & Maintenance



Assembling/welding of the Inox Arc Valve into the product line

Before welding process:

1. Loosen the fixing screw of the pinching nut with cone (17).
2. Loosen and disassemble the pinching nut with cone (17) with the bore wrench.
3. Loosen fixing screws of the bearing cap (2) and remove the complete valve top assembling (including the actuator or handle) from the valve casing (5). Attention to the O-ring (10) and the shutter (6).

After welding process:

1. Clean the valve casing (5). If necessary lubricate the O-rings with Klüber Paraliq GTE 703 Food Grade.
2. Place the shutter (6) in the valve casing (5) (not in front of an exit) down to the bottom. Fix the bearing cap (2) with the pivoted axle (3) on the valve casing (5). Attention to the O-ring (10).

As shown in the sketch (see chapter 4.5) there is a clearance of about 4-5 mm between the bearing cap (2) and the valve casing (5). This is because of the spring characteristic of the pivoted axle (3).

3. Fix the bearing cap (2) with fixing screws by tighten them carefully crosswise.
4. Tighten finally the pinching nut with cone (7) by hand (without using a tool) until the cone is pressing to the arc plate and tighten more with a key by turning it about 90° clockwise.
5. Tighten the fixing screw of the pinching nut.

Südmo North America, Inc.

1330 Anvil Drive, Rockford, IL 61115 USA

T 815.639.0322 • F 815.639.1135

E info@sudmona.com • I www.sudmona.com

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2- / 3- way Arc Valves