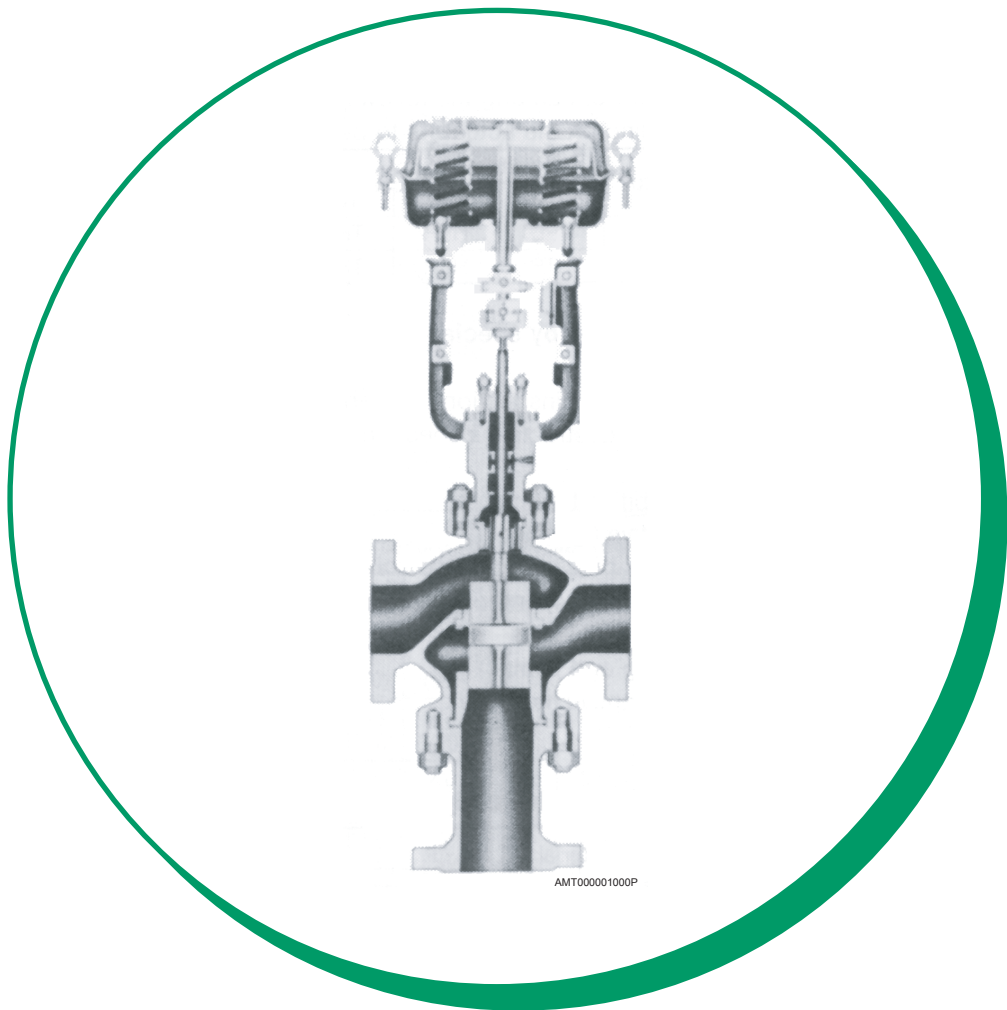


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**CV3000 Series
Control Valves
Model: AMT**

User's Manual



Yamatake Corporation

CM2-AMT100-2001
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1. GENERAL

1.1 Scope

This manual covers the instructions for the Three-way Control Valves.
Model AMT Mixing Valves and Model HDT Diverting Valves.

For the valve positioners, refer the following operators manuals.

- Model VPE OM2-8310-0410 Pneumatic valve positioner for small actuators
- Model HTP OM2-83 10-0200 Pneumatic valve positioner (Single Acting type)
- Model HEP 15, 16, 17 OM2-8313-0100 Electro-Pneumatic Valve Positioner (Single Acting Type)
- Model AVP 300/301/302/200/201/202
CM2-AVP300-2001 Smart valve positioner
- Model AVP 303/203 CM2-AVP303-2001 Smart valve positioner

1.2 Major Components of Control Valves

Each control valve is comprised of two major components, namely, a valve body and an actuator. Various combinations of valve body and actuator are available to meet various type of uses with different valve sizes, pressure ratings, types of connections, types of materials, and actuator sizes.

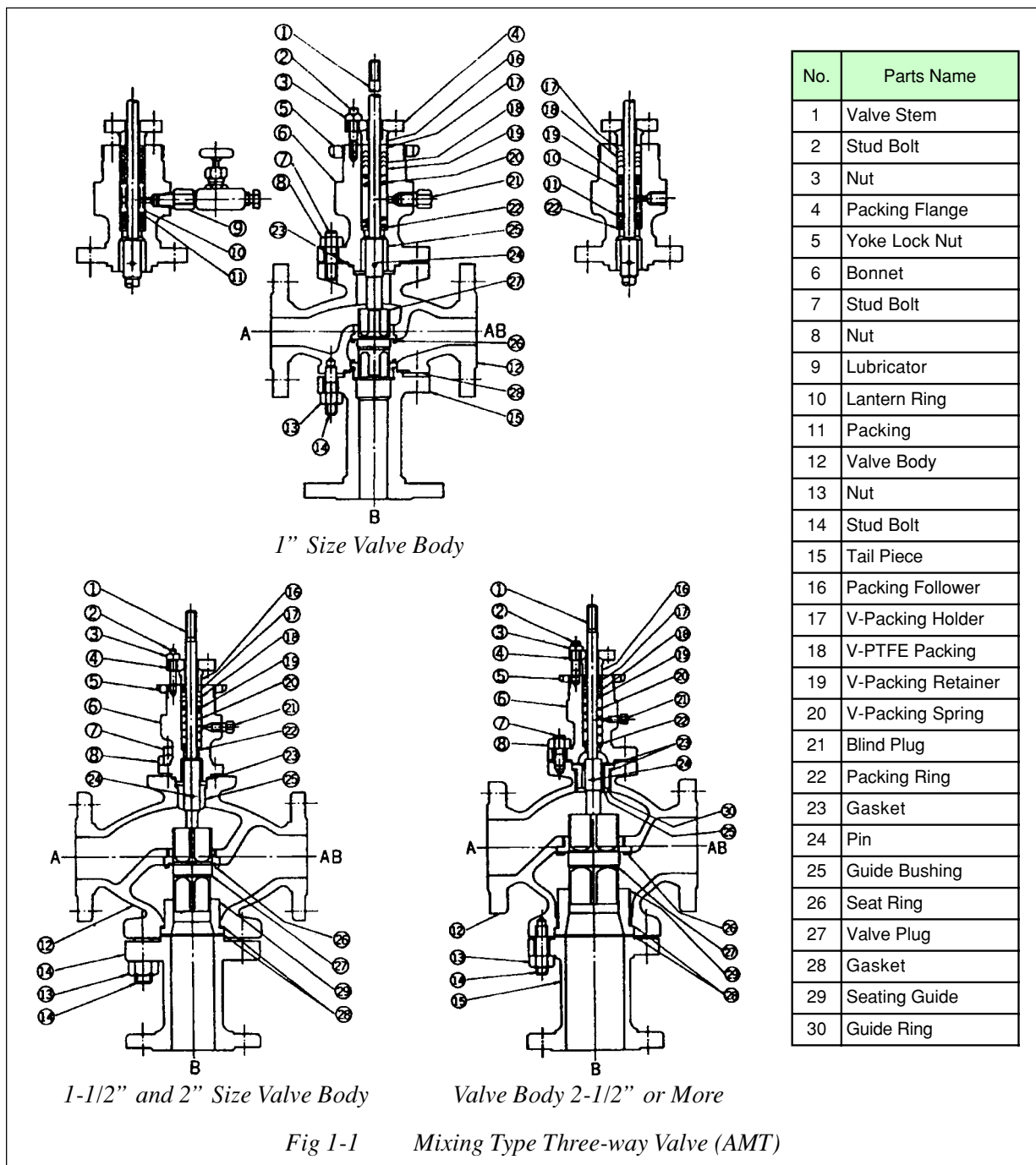
(For details of specifications, refer to Specification Sheets SS2-8113-4100.)

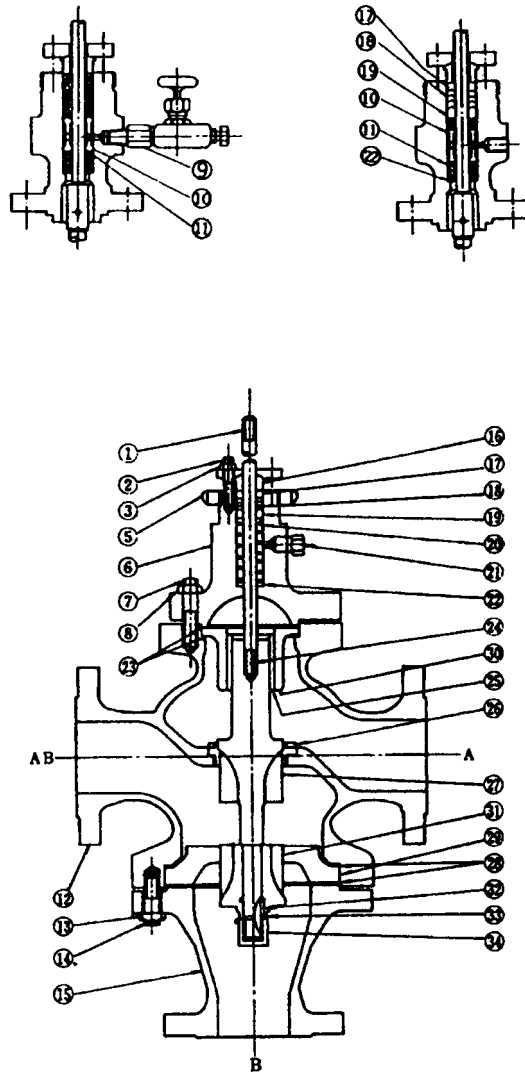
1.3 Structures

The structures of typical CV3000 Series control valves are shown in Fig. 1-1 and 1-2.

The valve body is connected to the bonnet with stud bolts and nuts. Gaskets are provided at the connection section to seal against the internal fluid or to let the valve body make up a pressure vessel. The valve plug is supported by the guide ring and cage, and driven by the actuator. The actuator has multiple springs and a diaphragm, and converts the pneumatic control signal into a mechanical (positional) control signal with which to position the valve plug.

In the illustrations, for mixing service, the left and bottom ports are inlets and the right port is outlet. For diverting service, the right port is inlet.





No.	Parts Name
1	Valve Stem
2	Stud Bolt
3	Nut
4	Packing Flange
5	Yoke Lock Nut
6	Bonnet
7	Stud Bolt
8	Nut
9	Lubricator
10	Lantern Ring
11	Packing
12	Valve Body
13	Nut
14	Stud Bolt
15	Tail Piece
16	Packing Follower
17	V-Packing Holder
18	V-PTFE Packing
19	V-Packing Retainer
20	V-Packing Spring
21	Blind Plug
22	Packing Ring
23	Gasket
24	Pin
25	Guide Bushing
26	Seat Ring
27	Valve Plug A
28	Gasket
29	Seating Guide
30	Guide Ring
31	Valve Plug B
32	Key
33	Lock
34	Nut

Fig 1-2 Diverting Type Three-way Valve (HDT)

1.4 Nameplate

A nameplate as shown in Fig. 1-3 is posted on each control valve. The nameplate indicates the model number, valve size, pressure rating, trim material, date of manufacture and other major specifications of the control valve. Before installing the control valve, make sure that the specifications indicated on the nameplate conform with the conditions of use. The nameplate indicate also the product number (PROD.NO.) of the control valve. Please mention this number also when consulting your Yamatake Corporation agent for replacement of parts or other modification of the control valve.



Fig. 1-3 Nameplate

2. INSTALLATION

2.1 Maximum Lifting Loads of Eyebolts

The diaphragm case has a pair of lifting eyebolts. These eyebolts primarily are for lifting the actuator alone. When using the eyebolts for other purposes (such as lifting an actuator bed to its valve body or other components), note that the allowable maximum lifting loads of the eyebolts are as shown in the following table.

Table 2-1. Maximum Lifting Loads of Eyebolts

Actuator Model No.	Allowable Maximum Lifting Load of Eyebolts	Weight of Actuator Alone
PSA1	160kg	8kg
HA2	160kg	16kg
HA3	160kg	32kg
HA4	220kg	68kg

Note: The eyebolts may be used to lift the actuator together with its valve buy (cast globe valve) of up to pressure rating “Class 600”. When doing this, be extremely careful so that no shock or other abnormal force is applied to the actuator or the valve body.

2.2 Installing Valve in Process Pipe

- (1) Before installing the valve in the process pipe, remove foreign matter (such as scales and welding chips) from both upstream and downstream sides of the process pipe.
- (2) Confirm that the direction of process fluid flow conforms with that of the arrowhead mark provided on the valve body.
- (3) Pay attention so that the pipe connection gaskets do not extrude into the process pipe inside. Be sure to use gaskets made of material which is suitable for the process fluid. The welding type of valve employ no gaskets.
- (4) Pay attention so that no excessively large stress is conveyed from the process pipe to the valve body. Uniformly tighten the bolts of the process pipe connection flange. The high pressure type of valves have no flanges, since they are connected to the process by welding.
- (5) Before connecting the air pipes to the actuator and positioner, blow the pipes to clean them.
- (6) Do not install any heating or cooling provisions on the bonnet.

2.3 Item to be Checked After Installation and Before Starting Operation

- (1) Check that there is no leak from air piping.
- (2) Check that the bolts and nuts of the diaphragm case are not loose. Standard tightening torques are as follows:
 - For HA2, HA3 (M8) : 12 N.m { 120 kgf-cm }
 - For HA4 (M12) : 42 N.m { 420 kgf-cm }
- (3) Tighten the packing flange nuts to prevent leak from the gland packing section. Standard tightening torques are as shown in Table 2-2.

Table 2-2. Tightening Torques of Packing Flange Nuts

Valve Stem Diameter (mm)	Graphite Packing (N.m {kgf-cm})	Metallic Filament Reinforced Graphite Packing (N.m {kgf-cm})	V PTFE Packing (N.m {kgf-cm})
10	3 {30}	7 {70}	0.8 {8}
13	5 {50}	12 {120}	
16	8 {80}	18 {180}	
20	10 {100}	25 {250}	
25	15 {150}	40 {400}	
30	20 {200}	50 {500}	

Note: The tightening torques mentioned in the above are only to give you reference values. Note that tightening torques may vary depending on the type of packing.

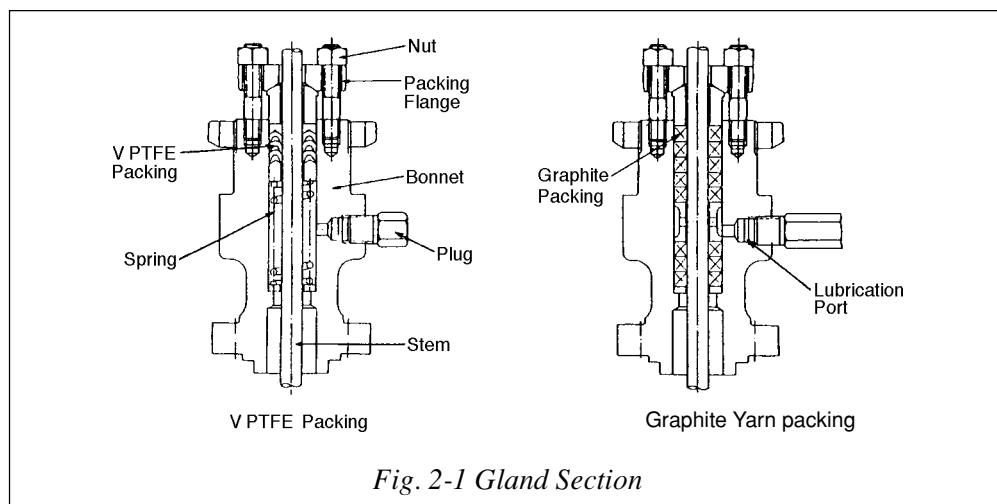


Fig. 2-1 Gland Section

- (4) If the valve is provided with a lubricator as shown in Fig. 2-2, check whether the bonnet section has been lubricated or not. To do this, loosen the lubricator handwheel and turn the squeeze screw. If the squeeze screw turn lightly, and grease in the lubricating procedure mentioned below. (If the squeeze screw turns heavily, this means that grease has been applied.)

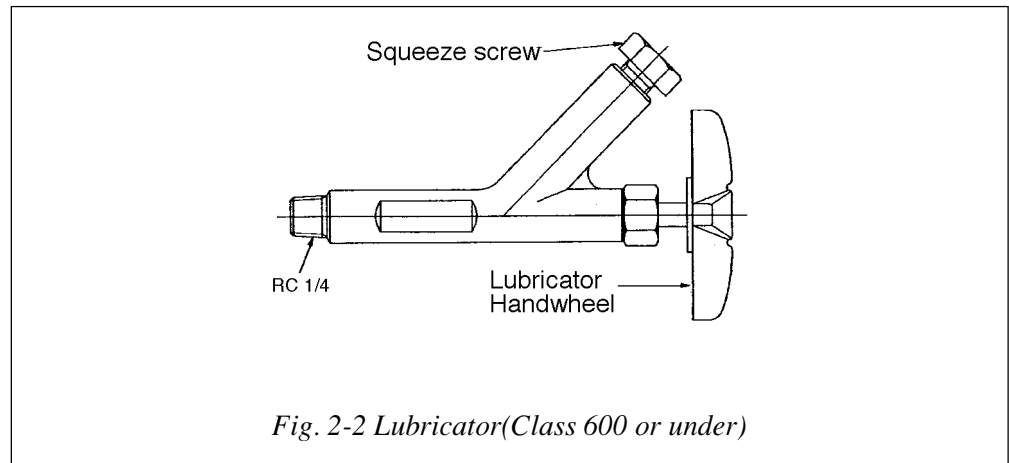


Fig. 2-2 Lubricator(Class 600 or under)

Lubricating Procedure

- (a) prepare grease of the type indicated on the nameplate.
 - (b) Tightly close the lubricator handwheel.
 - (c) Remove the squeeze screw, apply grease, and set the squeeze screw.
 - (d) Loosen the lubricator handwheel and drive grease by turning the squeeze screw.
 - (e) Repeat the procedure of (b), (c) and (d) until turning of the squeeze screw becomes heavier. Tightly close lubricator handwheel.
- (5) When raising temperature of a valve which is used for high temperature service, raise temperature gradually (standard rate is 100 °C per hour) and do not operate the valve when its temperature is being raised.

3. INSPECTION AND MAINTENANCE

Inspect and service the actuator as follows:

- (1) Tightening the gland:
Tighten the gland once in every 6 months or thereabout.
The tightening procedure is as given in Section 2-3-(3).
- (2) Lubricating the gland:
Lubricating the gland once in every 6 months or thereabout.
The lubricating procedure is as given in Section 2-3-(4).
- (3) Check for hunting of valve Position:
Refer to Section 10 “TROUBLESHOOTING.”
- (4) Check for abnormal noise and vibration:
Refer to Section 10 “TROUBLESHOOTING.”

4. DISASSEMBLY AND ASSEMBLY

This section covers the disassembly and assembly procedures of the actuator for its overhaul or modification.

4.1 Detaching Actuator from Valve Body

See Fig. 4-5.

- (1) Apply to the actuator an air pressure so that the valve position pointer is at a point of 10% - 20% above the fully closed point.
- (2) Loosen the clamping-bolts of the stem connector, remove the stem connector, and detach the actuator stem from the valve stem.
- (3) Remove the clamping-nut of the yoke.
- (4) Raise the actuator to detach it from the valve body.

Precautions: For detaching the actuator from the valve body which is kept installed in the process pipe, be sure to shut down the process for and release the process pressure before detaching the actuator.

4.2 Disassembly and Assembly of Valve Body

To disassemble or assemble the valve body, refer to Fig. 4-1 through 4-4 and proceed as described below.

Disassembly Procedure

• AMT (Mixing) Type (Refer to Fig.4-1, 4-2, 4-3)

- (1) Apply an air pressure to the diaphragm so that the pointer indicates slightly below the position AB-B for direct acting actuator provided or indicates slightly above the position AB-A for reverse acting actuator and hold it in either case so that the valve plug does not touch the seat ring.
- (2) Remove the stem connector to separate the actuator stem from the valve stem.
- (3) Release an air pressure from the diaphragm and disconnect the air piping.
- (4) Remove the yoke nut by turning it with a chisel and detach (pull up) the actuator from the valve body.
- (5) Remove the tail piece from the valve body by loosening the bottom nuts on the body.
- (6) Pull down the seating guide from the valve body. However, for 1" valve, unscrew and remove the seat ring from the tail piece as required.
- (7) Loosen the gland packing flange nuts and remove the valve plug from the bottom of the valve body.
- (8) Remove the bonnet assembling nuts and pull out the bonnet.
- (9) To remove the seat ring, use the "special tool* for mounting and removing the seat ring."
*:Separately ordered.

•HDT (Diverfing) Type (Refer to Fig.4-4)

- (1) Apply an air pressure to the diaphragm so that the pointer indicates slightly below the position AB-A for direct acting actuator provided or indicates slightly above the position AB-B for reverse acting actuator and hold it in either case so that the valve plug do not touch the seat ring.
- (2) Remove the stem connector to separate the actuator stem from the valve stem.
- (3) Release an air pressure from the diaphragm and disconnect the air piping.
- (4) Remove the yoke nut by turning it with a chisel and detach (pull up) the actuator from the valve body.
- (5) Remove the tail piece from the valve body by loosening the bottom nuts on the body. When doing this, be careful not to drop the seating guide lest the seating surface of valve plug B should be damaged.
- (6) Remove the bottom nut on the valve plug and pull the valve plug downward. Then pull down the seating guide.
- (7) Remove the bonnet mounting nuts and pull out the bonnet by loosening the gland packing flange nuts.
- (8) Pull upward the valve plug A and the guide ring.
- (9) To remove the seat ring, use the “special tool* for mounting and removing the seat ring.”
*:Separately ordered.

Inspection

Inspect the disassembled parts for damage. If any damage is found, replace the parts. (When ordering parts, mention also the Prod. No. of the valve which is indicated on the nameplate.)

- (1) Do not re-use the removed gland packing. Use fresh packing when assembling the valve. (When assembling, a vacuum service valve, pay special attention to the packing assembly method.)
- (2) Check that the seating surfaces of plug, seat ring and cage are not damaged.
- (3) Check that the gasket-contacting surfaces of valve body, bonnet and guide ring cage are not damaged. Do not re-use the removed gasket. Use fresh gasket when assembling the valve.
- (4) Check that the plug guide section, the stem, and the guiding sections of guide bushing, seat ring and seating guide are not damaged.

Assembly Procedure

•AMT (Diverfing) Type (Refer to Figs. 4-1, 4-2, 4-3)

To assemble the valve, follow the disassembly procedure in the reverse order.

- (1) To mount the seat ring, use the “special tool for mounting and removing the seat ring.” (The tool is optional.)
For the tightening torques, see Table 4-1.
- (2) Insert the valve plug (with valve stem mounted) from the tail piece side.
- (3) Mount the seating guide and two gasket (one for 1” valve). (For 1” valve, seat ring should be inserted in the tail piece in advance.)

- (4) Mount the guide ring and two gaskets (since 1” valve has the guide mounted in the bonnet and 1 1/2” and 2” valve in the valve body, only one gasket is used) from the top of the valve body and install the bonnet.

For assembling the tail piece and the bonnet with nuts, first tighten all nuts lightly with a and further, gradually tighten them with a wrench evenly not to cause uneven tightness.

- (5) Insert the gland packing into the gland. (See Fig. 2-1.)
 Note: When installing yarn packings, stack them sheet by sheet with the cut sections of the mutually adjoining sheets making up the right angle (90 degrees).
- (6) Install the packing follower and packing flange, and tighten the nut. For the tightening torque, see Table 2-2.

•HDT (Diverfing) Type (Refer to Fig.4-4.)

To assemble the valve, follow the disassembly procedure in the reverse order.

- (1) To mount the seat ring, use the “special tool for mounting and removing the seat ring.” For the tightening torques, see Table 4-1.
- (2) Insert the valve plug A (with valve stem mounted) from the top of the bonnet.
- (3) Insert the gasket and seating guide from the tail piece side and, then,fasten the valve pulg B with the lock nut.
- (4) Insert the gasket and assemble the tail piece.
- (5) Mount the guide ring and two gaskets from the top of the valve body and assemble the bonnet.

For assembling the tail piece and the bonnet with nuts, first tighten all nuts lightly with a and further, gradually tighten them with a wrench evenly not to cause uneven tightness. For the tightening torque, see Table 4-2.

- (6) Insert the gland packing into the gland. (See Fig. 2-1.)
 Note: When installing yarn packings, stack them sheet by sheet with the cut sections of the mutually adjoining sheets making up the right angle (90 degrees).
- (7) Install the packing follower and packing flange, and tighten the nut. For the tightening torque, see Table 2-2.

Size (in.)	Torque (N.m{kgf-cm})
1	180 {1,800}
1-1/2	260 {2,600}
2	390 {3,900}
2-1/2	520 {5,200}
3	650 {6,500}
4	800 {8,000}
5	1,000 {10,000}

Table 4-1 Seat Ring Tightening Torques

Bolt	Torque (N.m{kgf-cm})
M12	60 {600}
M16	100 {1,000}
M20	150 {1,500}
M22	200 {2,000}
M24	250 {2,500}
M27	350 {3,500}
M30	500 {5,000}
M33	660 {6,600}
M36	850 {8,500}
M39	1,000 {10,000}
M42	1,200 {12,000}
M45	1,400 {14,000}

Table4-2 Tightening Torque of Bonnet Stud Bolts

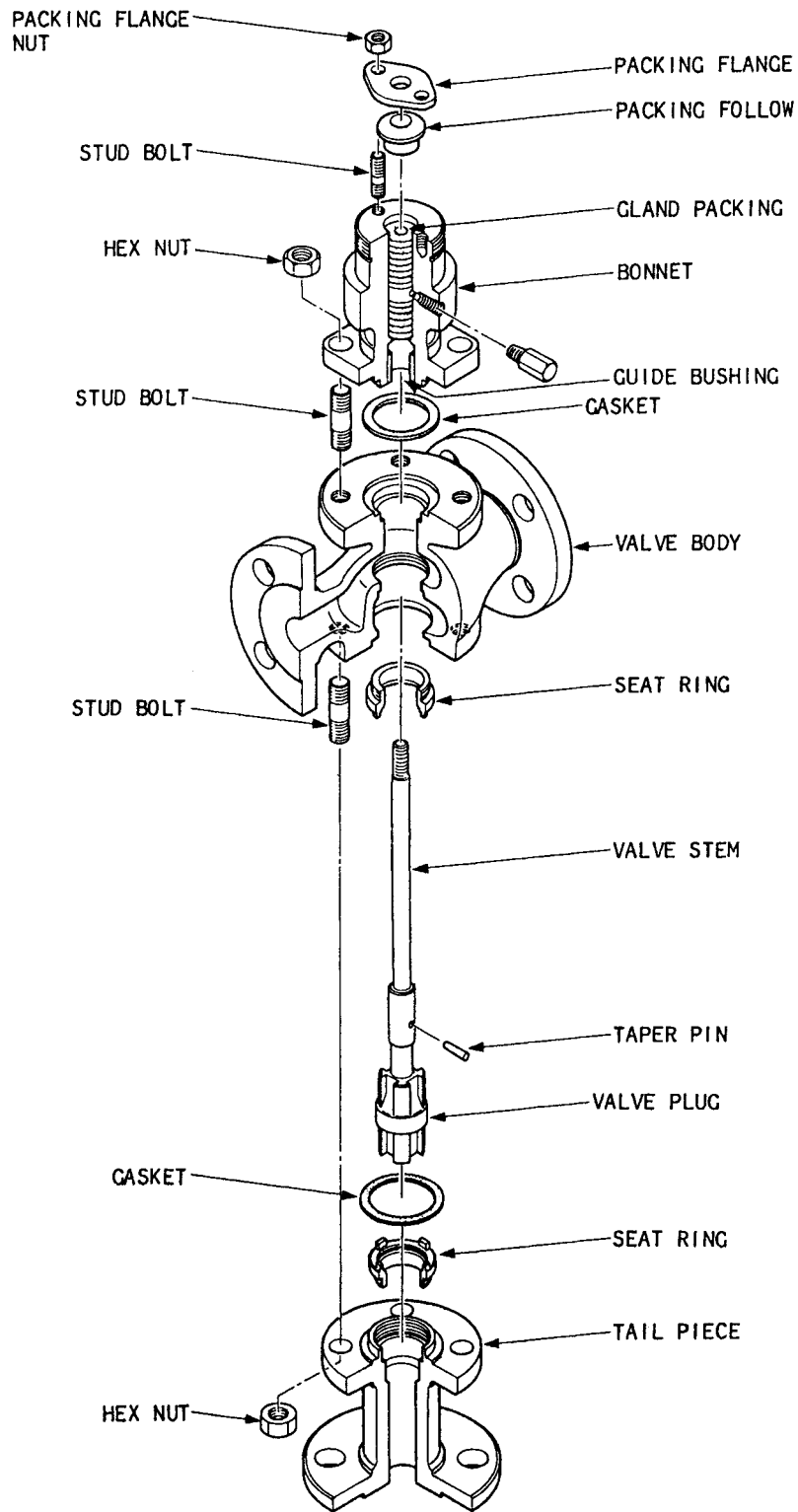


Fig. 4-1 Model AMT 1"

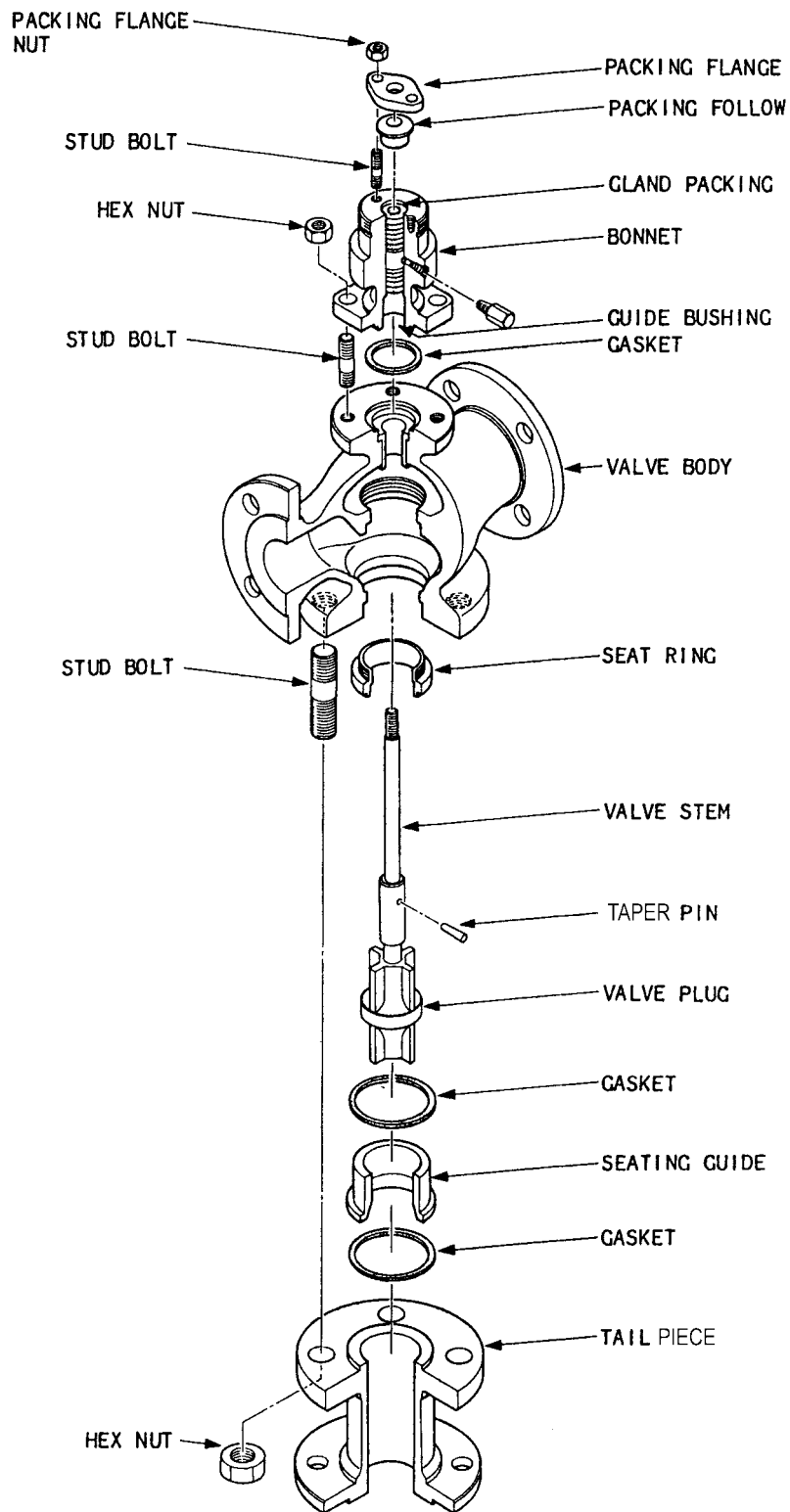


Fig. 4-2 Model AMT 1 1/2", 2"

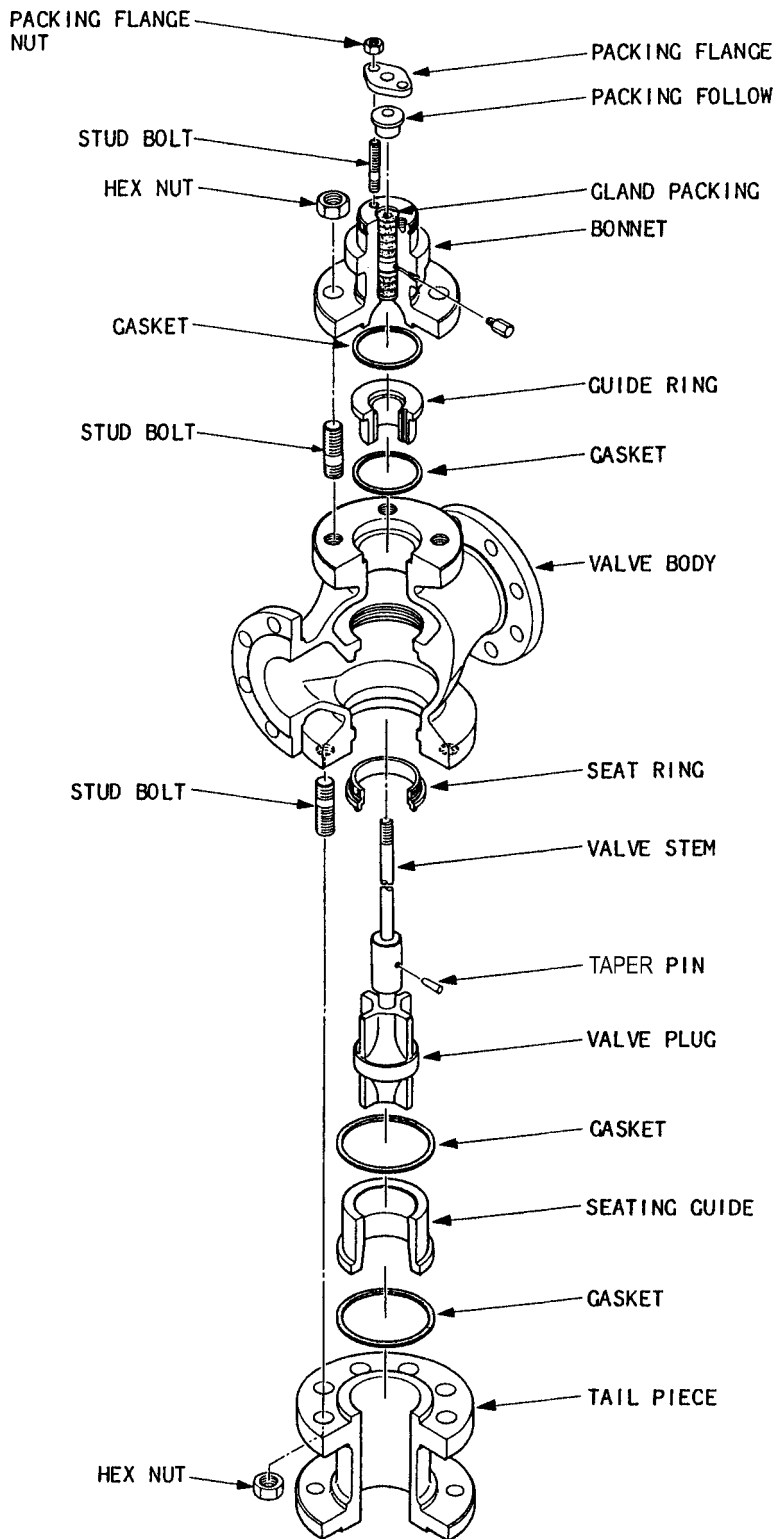


Fig. 4-3 Model AMT 2 1/2" - 6"

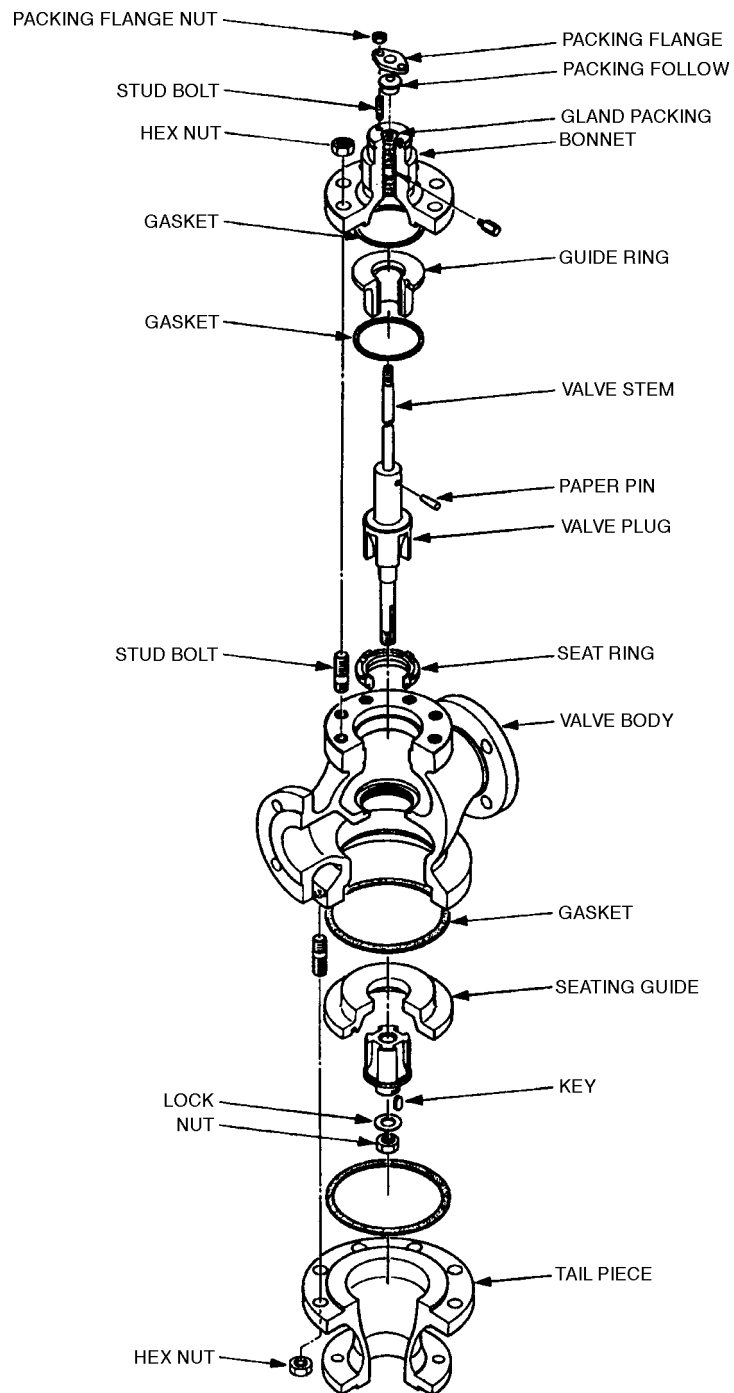
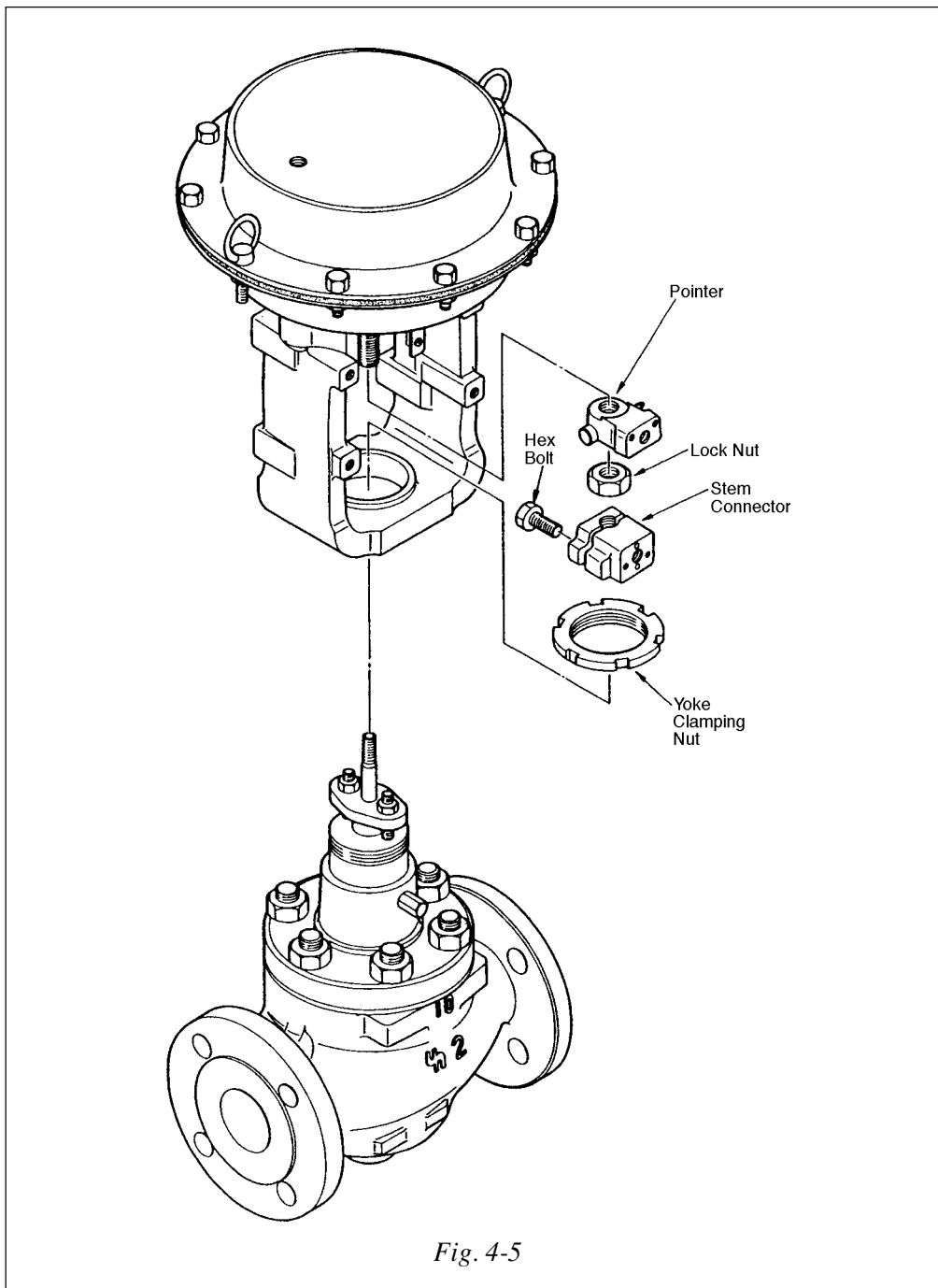


Fig. 4-4 Model HDT

4.3 Disassembly and Assembly of Actuator

Normally the actuator requires no adjustment. However, it should be disassembled and assembled when installing it on a valve body, when modifying its specifications, or when replacing damaged parts. The disassembly and assembly procedure of the actuator for such purposes are covered in Sections 4-4 and 4-5.

To disassemble the actuator, refer to fig.4-11 and Fig.4-19.



When disassembling or assembling the actuator, keep it in the vertical attitude. For the tightening torques of bolts and nuts, see Tables 4-5.

For the names of the parts, see Figs.4-11 and 4-19.

Notes for Disassembly

1. The nuts for the eyebolts are made of stainless steel. Discriminate these nuts from other nuts when assembling the diaphragm case.
2. It is recommendable to make locating marks on the top and bottom diaphragm cases before disassembly. This will help you to find easily the air piping connector location.
3. Store the removed parts in a clean place.

<p>Caution: Never loosen or remove carelessly the bolts and nuts of the actuator. The actuator employs powerful compressed springs and if you remove the bolts and nuts carelessly, the springs may leap out causing hazards. When removing the bolts and nuts, be sure to observe the instructions given for disassembly and assembly procedures of the actuator and top handwheel.</p>

4.4 Disassembly and assembly of model PSA 1

Disassembly procedure

A. Direct action model (see Figure 4-6)

- (1) Disconnect the air piping and detach the accessories from the actuator.
- (2) Remove the stem connector.
- (3) Remove the clamping bolts (except the pair of eyebolts) from the diaphragm case.
- (4) Alternately and evenly loosen the pair of eyebolts. The initial setting of the springs is achieved using these eyebolts.
- (5) Removing the diaphragm case. Pull the actuator rod upward and out together with the diaphragm.
- (6) Take out the springs.

B. Reverse action model (see Figure 4-7)

- (1) Disconnect the air piping and detach the accessories from the actuator
- (2) Remove the stem connector.
- (3) Remove the clamping bolts (except the pair of eyebolts) from the diaphragm case.
- (4) Alternately and evenly loosen the pair of eyebolts. The initial setting of the springs is achieved using the eyebolts.
- (5) Remove the diaphragm case. Take on the springs.
- (6) Pull the actuator rod upward and out together with the diaphragm.

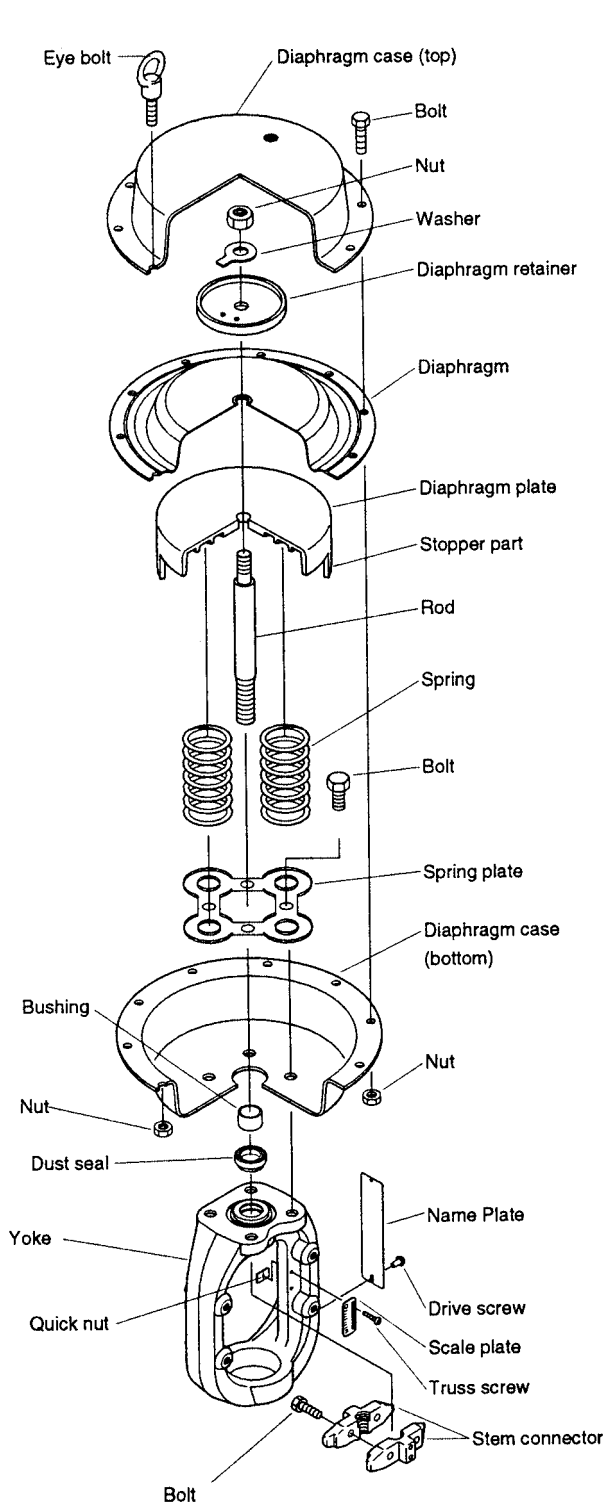


Fig. 4-6 Direct Action model PSAID

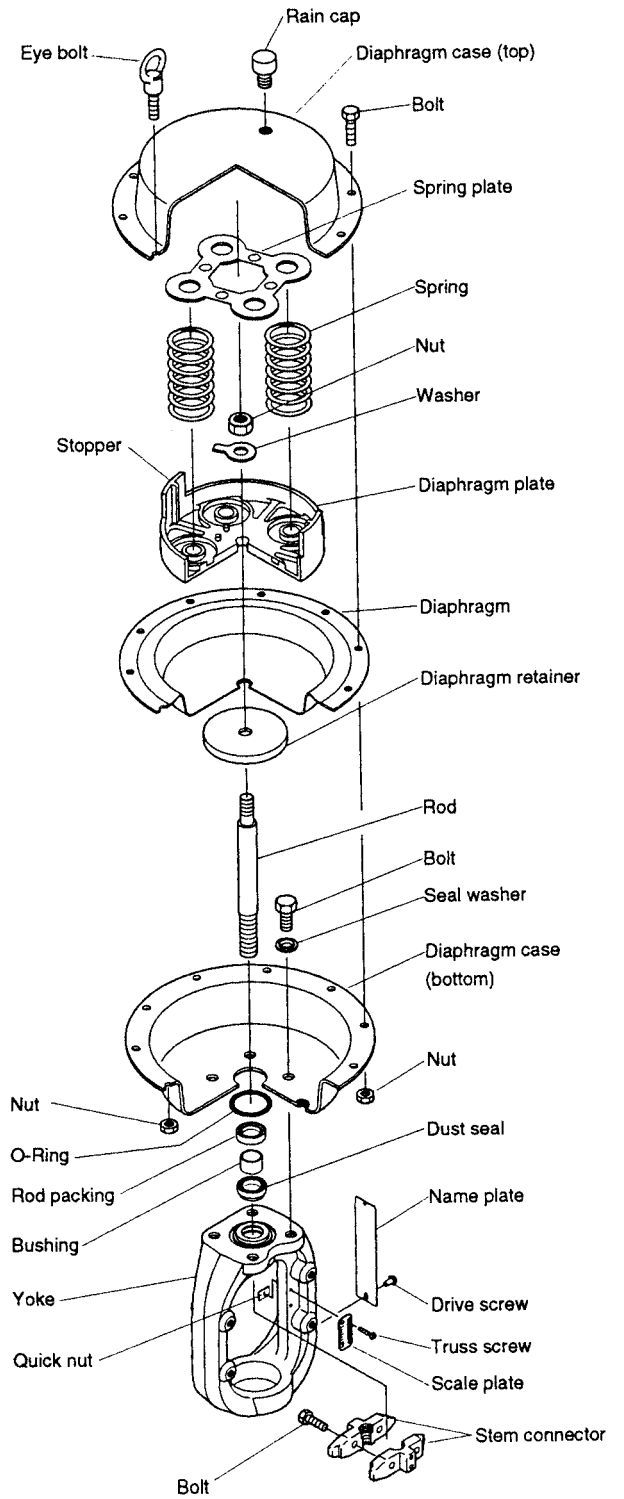


Fig. 4-7 Reverse Action model PSAIR

Assembly


Before assembly, check the parts for scratches, damage, deformation, peeling paint or any other abnormalities. To assemble the actuator, proceed as follows:

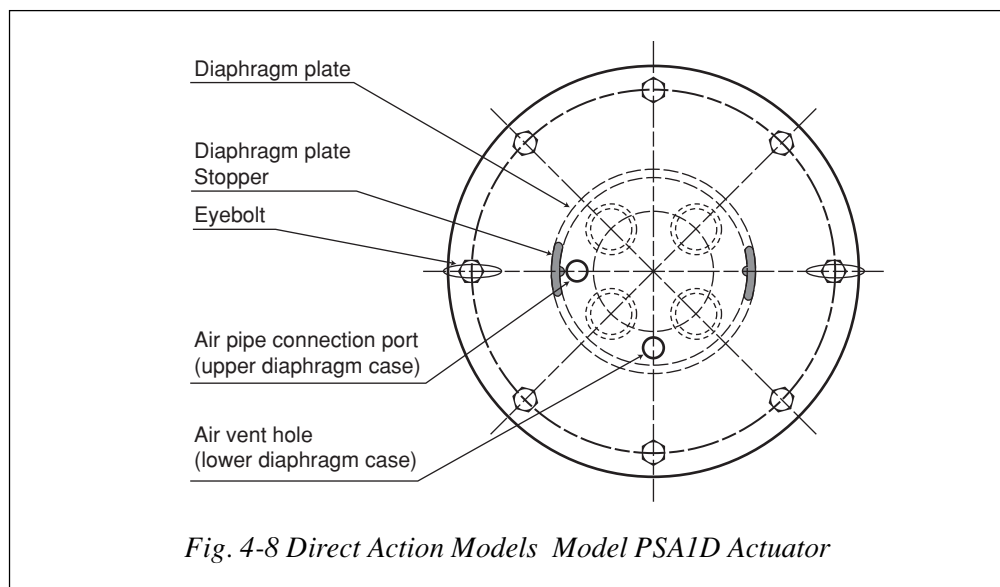
A. Direct action models

- (1) Secure the diaphragm case (bottom) with the four bolts to the yoke. At the same time, set the air vent hole as in Fig. 4-8. For PSA1D actuator, secure the spring plate to the diaphragm case and yoke.
- (2) Fasten the spring place and install the springs onto the spring plate (see Fig. 4-8).
- (3) Insert the actuator rod (with diaphragm connected) into the bushing. Be careful to prevent the bushing's inside surface or dust seal form being damaged by the threaded section of the rod. If possible, cover the threaded section with adhesive tape.
- (4) Rotate the actuator rod, locating the diaphragm plate stopper as shown in Fig.4-8.
- (5) Place the top diaphragm case and secure it with the pair of eyebolts.

Note: Set the air pipe connection port to the location shown in Fig. 4-8. Tighten the pair of eyebolts uniformly and alternately. The initial setting of the springs is completed by tightening these eyebolts.

- (6) Clamp the diaphragm case with clamping bolts.
- (7) Install the stem connector. Connect the air pipe to its connection port at the top diaphragm case.
- (8) After completing assembly, check the following:
 - Apply air pressure of 490 kPa { 5 kgf/cm² } through the air pipe connection port at the top diaphragm case, and check the diaphragm periphery for air leakage with soapy water.
 - Check that the actuator operates smoothly through to its full stroke by operating it as an independent unit.

 CAUTION
Install packing for the rod and dustseal in the correct direction. Refer to Fig.4-6.




B. Revers action models

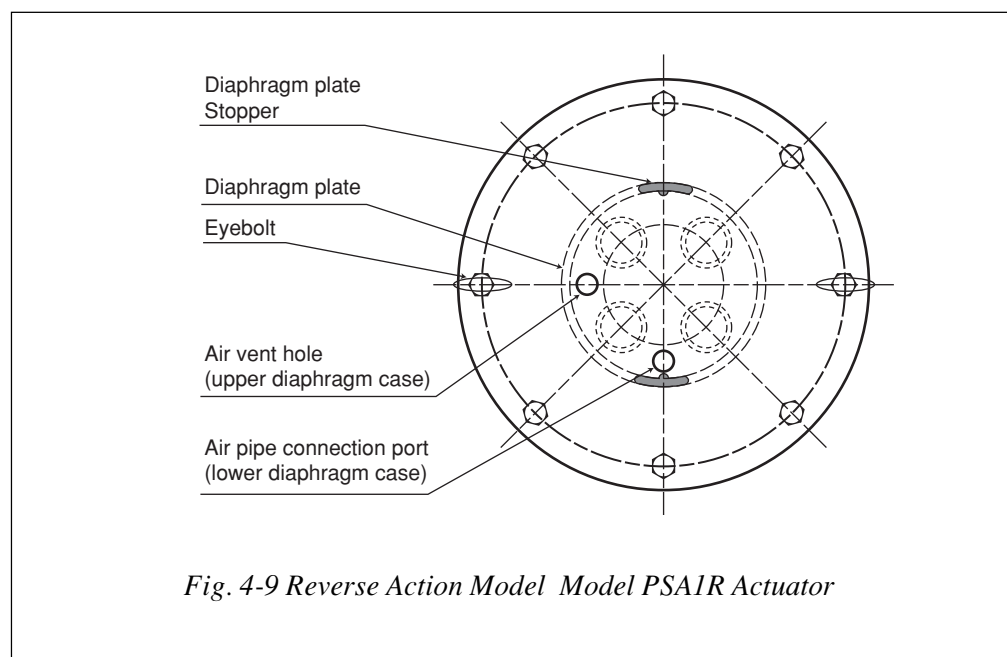
- (1) Secure the bottom diaphragm case with the four bolts to the yoke. At the same time, set the air pipe connection port in the location shown in the Fig. 4-9.
- (2) Insert the actuator rod (with diaphragm connected) into the bushing. Be careful to prevent the bushing 's inside surface or dust seal from being damaged by the threaded section of the rod. If possible, cover the threaded section with adhesive tape.
- (3) Rotate the actuator rod, locating its diaphragm plate stopper as shown in Fig. 4-9.
- (4) Fasten the spring plate and install the springs onto the spring plate.
(see Fig. 4-9).
- (5) Place the top diaphragm case and secure it with the pair of eyebolts.

Note: Set the air vent hole to the location shown in Fig. 4-9. Uniformly and alternately tighten the eyebolts. The initial setting of the springs is completed by tightening these eyebolts.

- (6) Clamp the diaphragm case with clamping bolts.
- (7) Install the stem connector.
- (8) Install the stem cap onto the air vent port.
- (9) Connect the air pipe to its connection port at the bottom diaphragm case.
- (10)After completing of assembly, check the following.
 - Apply air pressure of 490 kPa { 5 kgf/cm² }through the air pie connection port at the diaphragm case, and check the diaphragm periphery for air leakage with soapy water.
 - Check that the actuator operates smoothly through to its full stroke by operating the actuator as an independent unit.

 **CAUTION**

Install packing for the rod and dustseal in the correct direction.
Refer to Fig.4-7.



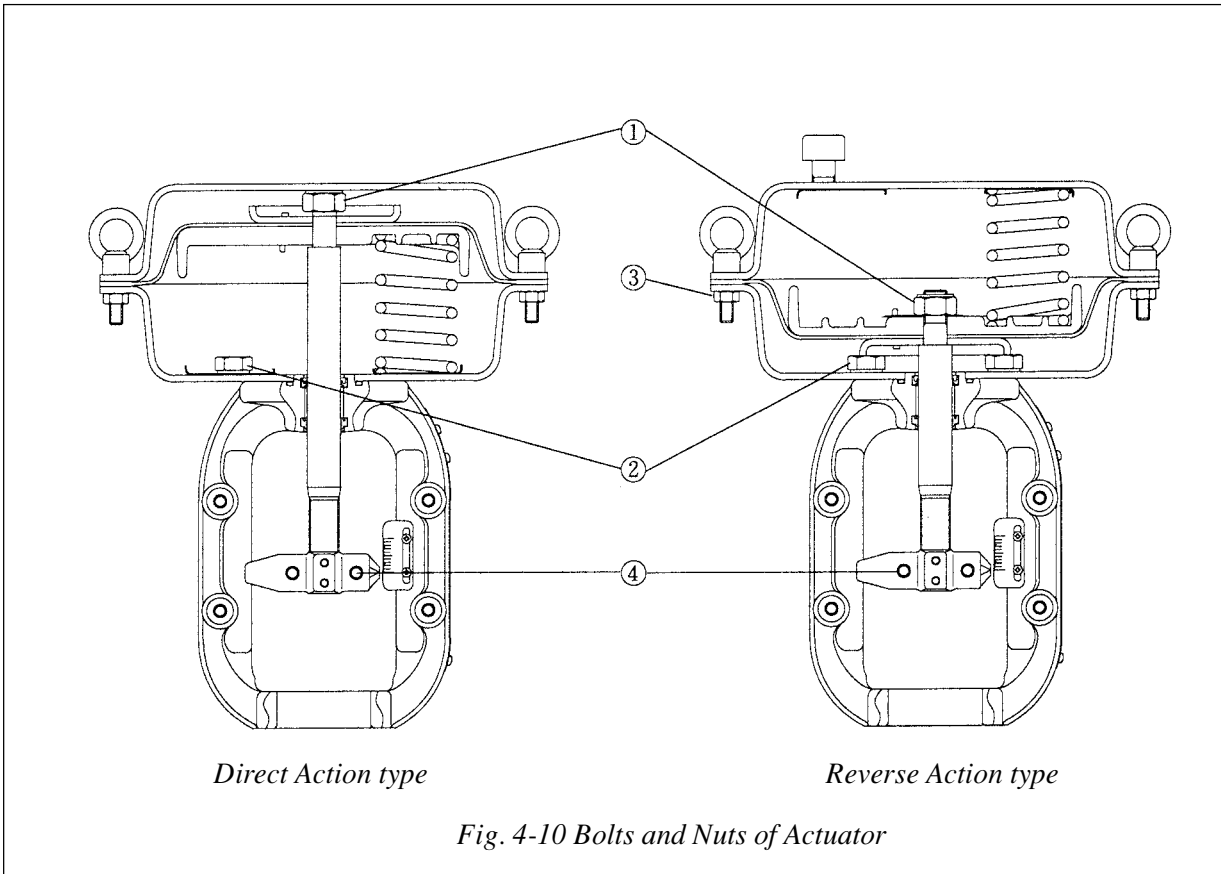


Fig. 4-10 Bolts and Nuts of Actuator

Table 4-5 Tightening Torques of Bolts and Nuts of Actuator

Unit:(N.m){kgf-cm}

No.	Materials	PSA1	
1	SK5 S45C	M14	45-70
			{460-710}
2	S30C	M12	35-50
			{360-510}
3	SUS304	M8	15-20
			{150-200}
4	SUS304	M8	10-15
			{100-150}

Note: Install the rain cap on the reverse actuator as follows. Drive the cap into the diaphragm case until the shoulder (brim) of the cap is brought into contact with the diaphragm case, then drive the cap further into the diaphragm case by half a turn.

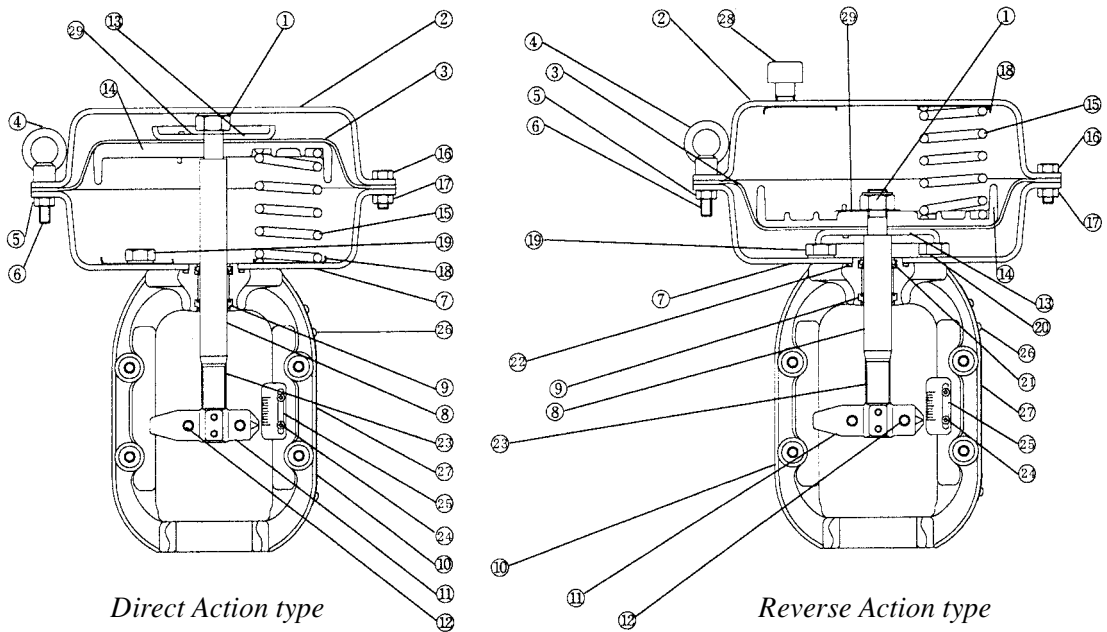


Fig. 4-11 Model PSA Actuator

No.	Item	Material
1	Nut	S45C, SK5
2	Diaphragm case(Top)	SAPH370
3	Diaphragm	EPDM, Polyaimid
4	Eyebolt	SUS304
5	Nut	SUS304
6	Bolt	SUS304
7	Diaphragm case(Bottom)	SAPH370
8	Bushing	SPCC, Bronze, PTFE, Lead
9	Dust seal	NBR
10	Yoke	A216WBC(SCPH2)
11	Stem connector	SCS13A
12	Bolt	SUS304
13	Diaphragm retainer	SS400
14	Diaphragm plate	AC4A/AC4C
15	Spring	SWOSM-B, SWOSC-V

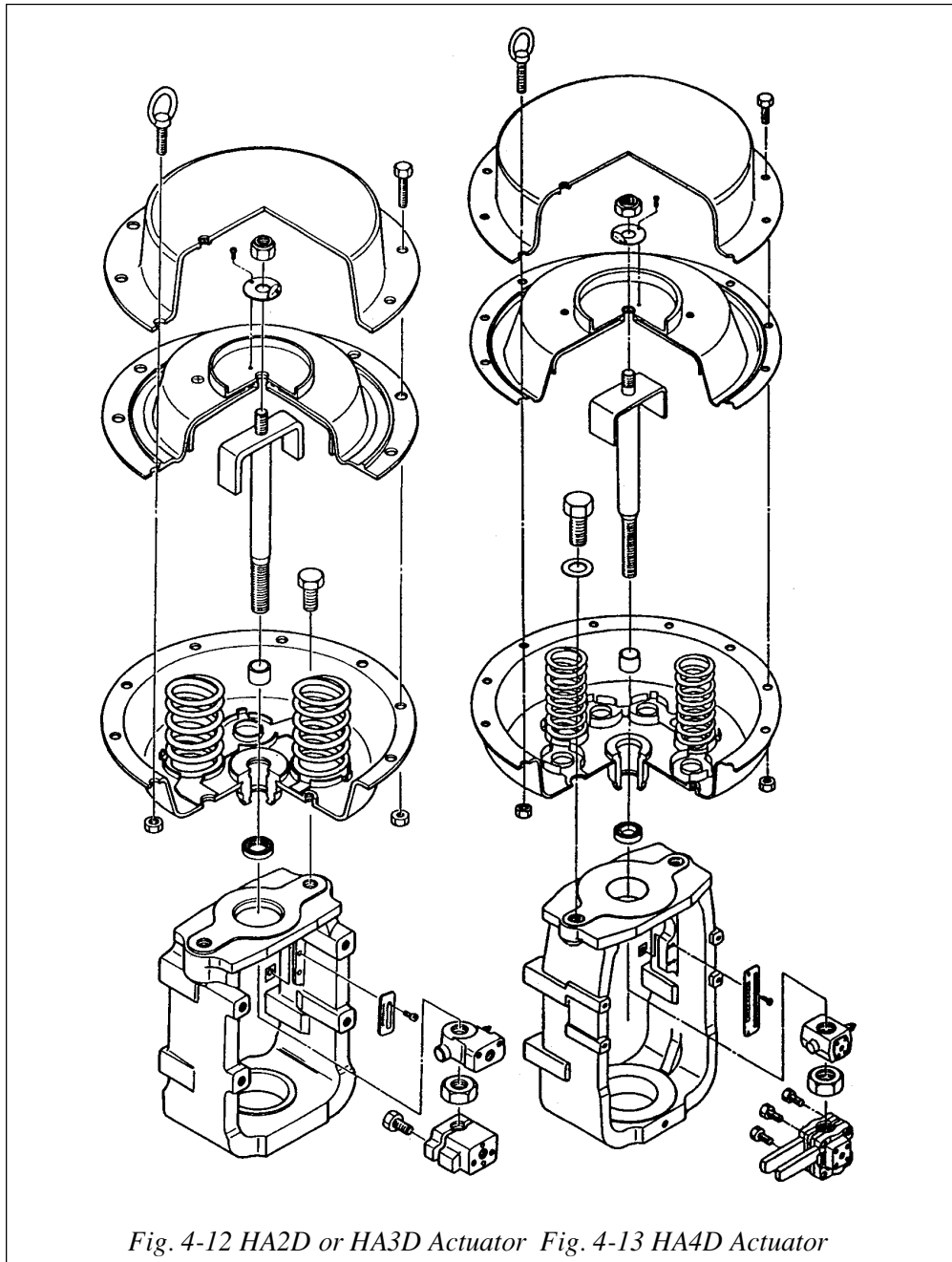
No.	Item	Material
16	Bolt	SUS304
17	nut	SUS304
18	Spring plate	SUS304CP
19	Bolt	S30C
20	Seal washer	NBR, SPCC
21	Packing for rod	NBR
22	O-Ring	NBR
23	Rod	SUS304
24	Truss screw	SUS304, SK5
25	Scale plate	SUS304
26	Drive screw	SUS304
27	Nameplate	SUS304
28	Rain cap	SUS304
29	Washer	SUS304

4.5 Disassembly and Assembly of Model HA2, HA3, or HA4 Actuator

Disassembly Procedure

(a) Direct Action Type

- (1) Disconnect the air piping and detach the accessories from the actuator.
- (2) Remove the stem connector, pointer and lock nut. (See Fig. 4-19.)
- (3) Remove the clamping-bolts (except the pair of eyebolts) of the diaphragm case.
- (4) Loosen evenly and alternately the pair of eyebolts. (The initial setting of the springs is done by these eyebolts.)
- (5) Remove the diaphragm case. Pull out upward the actuator rod together with the diaphragm.
- (6) Take out the springs.



(b) Reverse Action Type

- (1) Disconnect the air piping and detach other external items from the actuator.
- (2) Remove the stem connector, pointer and lock nut. (See Fig. 4-19.)
- (3) Remove the clamping-bolts (except the pair of eyebolts) of the diaphragm case.
- (4) Loosen evenly and alternately the pair of eyebolts. (The initial setting of the springs is done by these eyebolts.)
- (5) Remove the diaphragm case. Take out the springs.
- (6) Pull out upward the actuator rod together with the diaphragm.

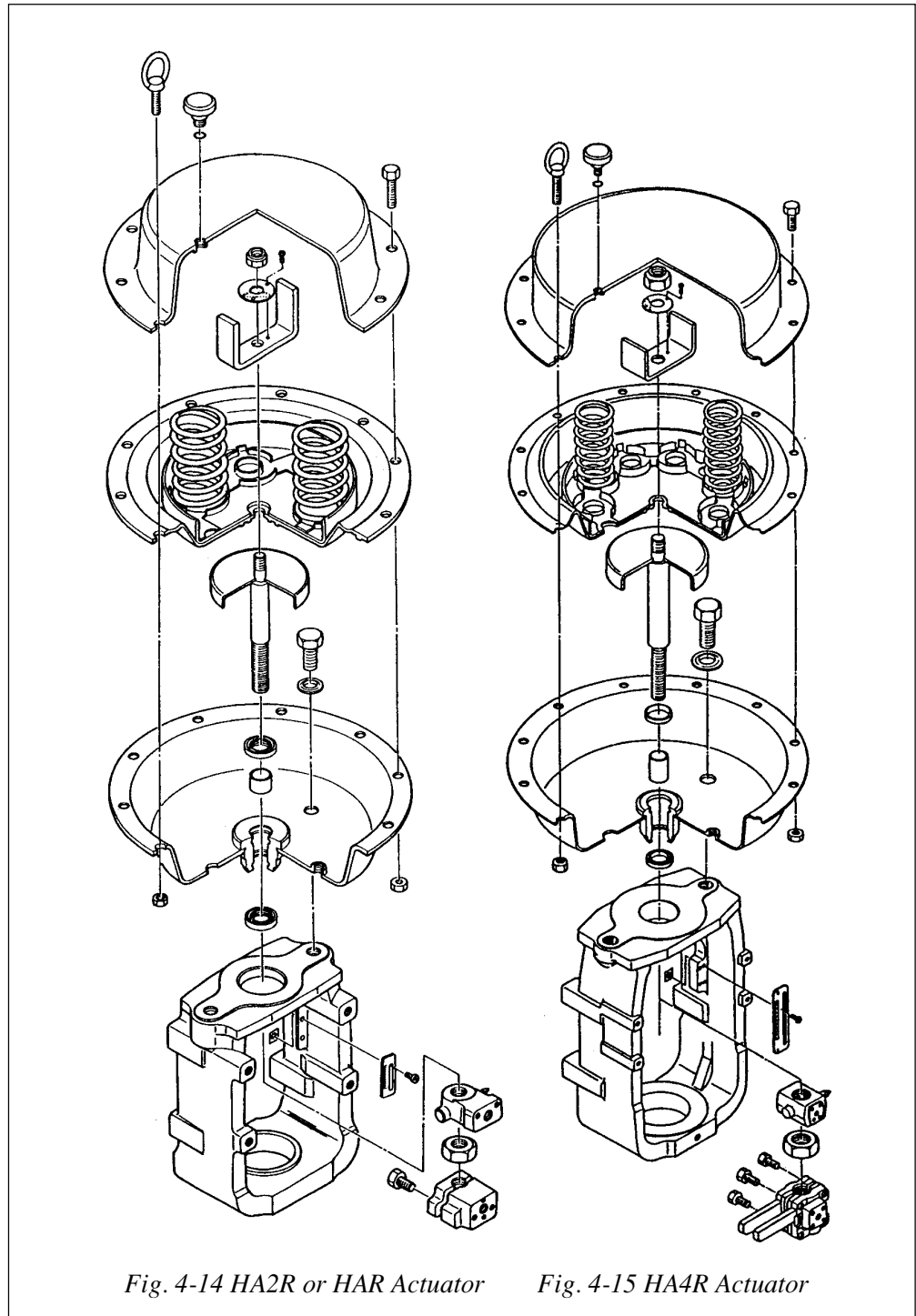


Fig. 4-14 HA2R or HAR Actuator

Fig. 4-15 HA4R Actuator

Assembly Procedure

Before assembly, check the parts for scrapes, damage, deformation, peeling off of paint, and other abnormality. To assemble the actuator, proceed as follows:

(a) Direct Action Type

- (1) Fix the bottom diaphragm case and yoke with the bolts. (For models HA2D and HA3D, install the diaphragm case and spring plate together.)
- (2) Install the springs on the spring plate. The quantities of springs are as follows;
 - HA2.....4 springs
 - HA3, HA4..... 8 springs

Except particular models as follows:

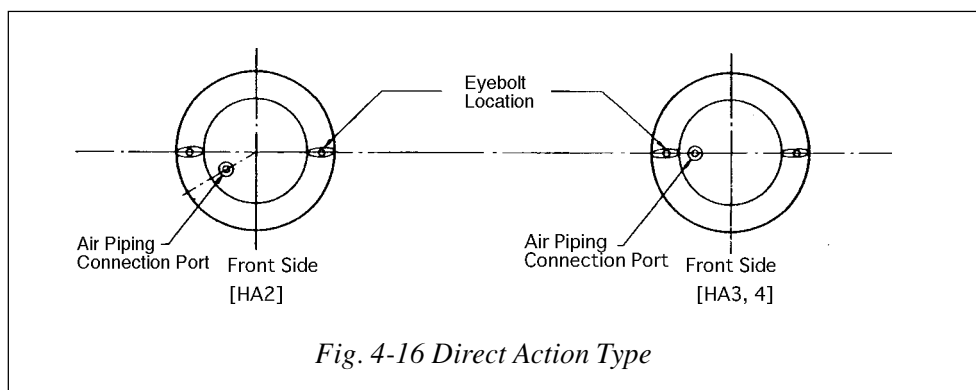
HA2, 38 mm stroke,
80 - 240 kPa (0.8 - 2.4 kgf/cm²).....Total 8 springs (with double springs)

HA3, 50 mm stroke,
80 - 240 kPa (0.8 - 2.4 kgf/cm²)..... Total 16 springs (with double springs)

HA4, 75 mm stroke,
80 - 240 kPa (0.8 - 2.4 kgf/cm²)..... Total 16 springs (with double springs)

- (3) Insert the actuator rod (to which the diaphragm is connected) into the bushing, exercising care not to damage the bushing inside surface or dust seal with the threaded section of the rod. (For example, cover the threaded section with adhesive tape to prevent damaging the bushing.) Set the stopper in parallel with the yoke.
- (4) Place the top diaphragm case and fix it with the pair of eyebolts.

- Notes:
- Set the air piping connection port in the location shown in the illustration. (Fig. 4-16)
 - Tighten the pair of eyebolts uniformly by tightening them alternately. The initial setting of the springs is complete by tightening of these eyebolts.

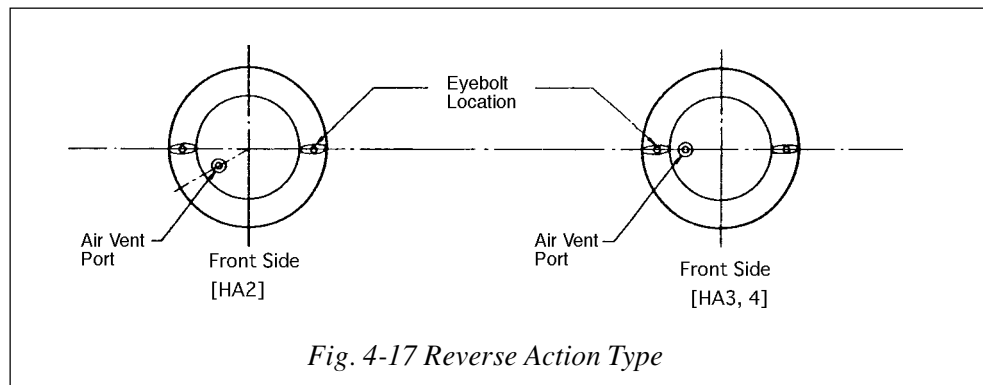


- (5) Clamp the diaphragm case with other clamping-bolts than the pair of eyebolts.
- (6) Install the pointer, secure the lock nut, and install the stem connector. (Connect the air pipe to the air piping connection port of the top diaphragm case.)
- (7) After the assembly is complete as above, check the following.
 1. Applying an air pressure of 490 kPa (5kgf/cm²) via the air piping connection port of the top diaphragm case, check the diaphragm periphery for air leak by using soapsuds.
 2. Check that the actuator smoothly operates for its full stroke.

Note: Check this operation by operating the actuator as an independent unit.

(b) Reverse Action Type

- (1) Fix the bottom diaphragm case and yoke with the bolts.
- (2) Insert the actuator rod (to which the diaphragm is connected) into the hushing, exercising care not to damage the bushing inside surface or dust seal with the thread section of the rod. (For example, cover the threaded section with adhesive tape to prevent damaging the bushing.)
- (3) Make the stopper (in the diaphragm plate) in parallel with the yoke by turning the rod.
- (4) Install the springs on the spring plate. The quantities of springs are as follows:
 HA2.....4 springs
 HA3, HA4.....8 springs
 Except particular models as follows:
 HA2, 38 mm stroke,
 80 - 240 kPa (0.8 - 2.4 kgf/cm²).....Total 8 springs (with double springs)
 HA3, 50 mm stroke,
 80 - 240 kpa (0.8 - 2.4 kgycm²)..... Total 16 springs (with double springs)
 HA4, 75 mm stroke,
 80 - 240 kPa (0.8 - 2.4 kgf/cm²)..... Total l6 springs (with double springs)
- (5) Place the top diaphragm case and fix it with the pair of eyebolts. Set the air vent hole in the location shown in the illustration (Fig. 4-17). Uniformly and alternately tighten the eyebolts. The initial setting of the springs is complete by tightening of these eyebolts.



- (6) Clamp the diaphragm case with other clamping-bolts than the pair of eyebolts.
- (7) Install the pointer, secure the lock nut, and install the stem connector.
- (8) Install the rain cap on the air vent port.
- (9) Connect the air pipe to the air piping connection port of the bottom diaphragm case.
- (10)After the assembly is complete as above, check the following.
 - 1.Applying an air pressure of 490kPa (5kgf/cm²) via the air Piping connection port of the bottom diaphragm case, check the diaphragm periphery for air leak by using soapsuds.
 - 2.Check that the actuator smoothly operates for its full stroke.
 Note: Check this operation by operating the actuator as an independent unit.

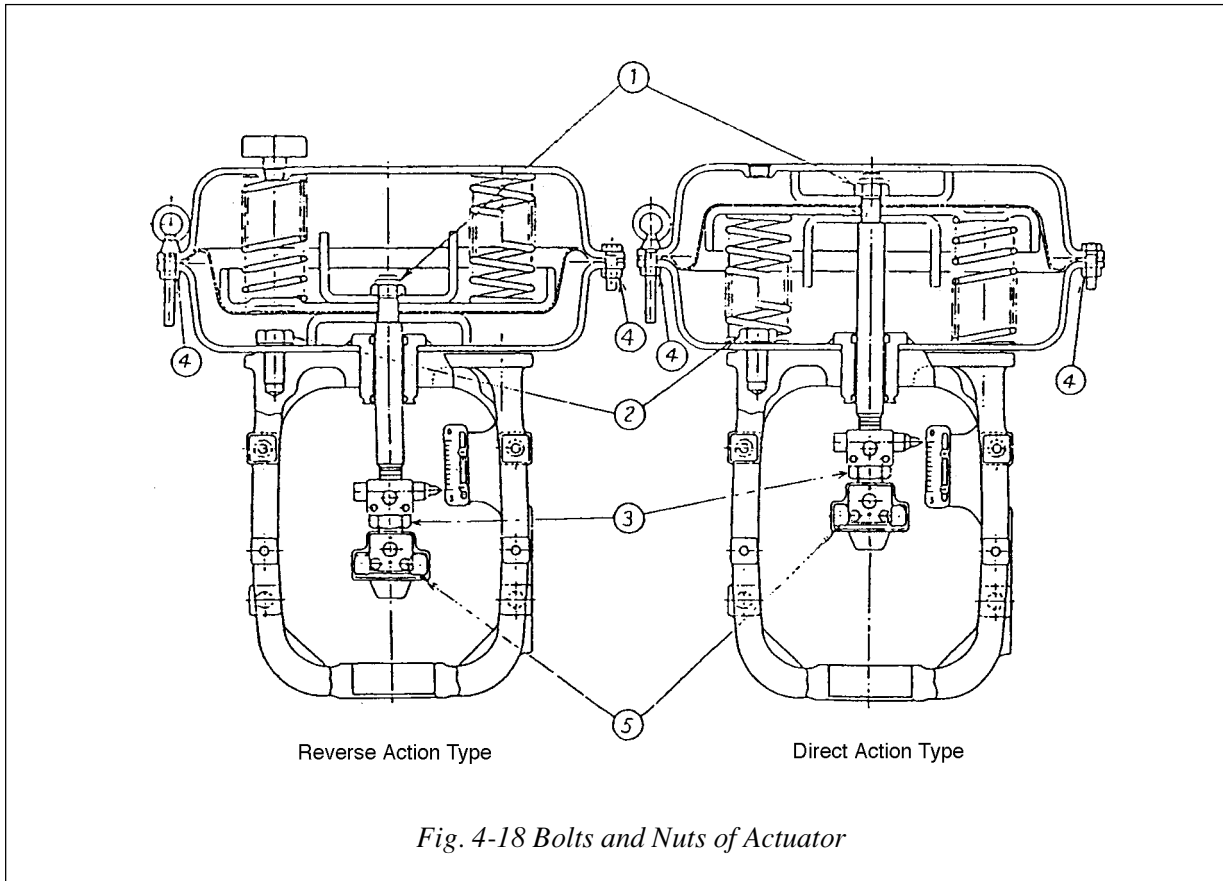
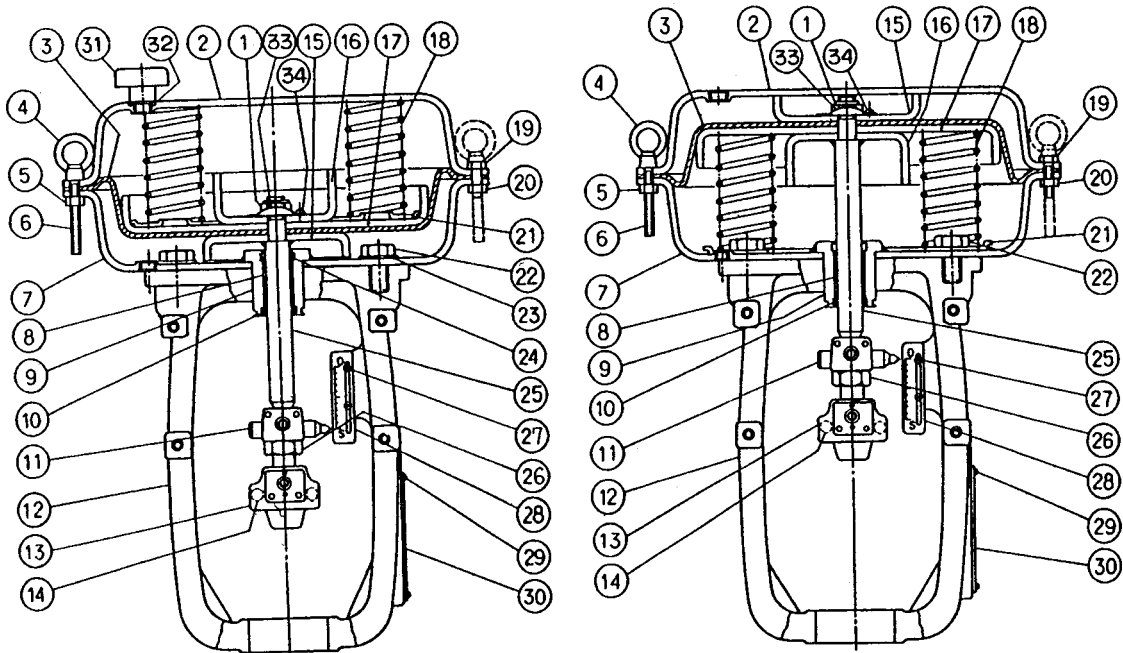


Fig. 4-18 Bolts and Nuts of Actuator

Table 4-6 Tightening Torques of Bolts and Nuts of Actuator

Unit:(N.m{kgf-cm})

No.	Materials	For HA2		For HA3		For HA4	
		M10	37{370}	M14	105{1,050}	M20	310{3,170}
1	SK5 S45C	M10	37{370}	M14	105{1,050}	M20	310{3,170}
2	S30C	M12	42{420}	M16	105{1,050}	M24	360{3,360}
3	S20C	M14	69{690}	M18	140{1,450}	M30	710{7,160}
4	SUS304	M8	18{185}	M8	18{185}	M12	63{630}
5	SUS304	M10	56{560}	M10	56{560}	M12	63{630}



Reverse Action Type (Model HA□R)

Direct Action Type (Model HA□D)

No.	Parts Name
1	Nut
2	Diaphragm Case(Top)
3	Diaphragm
4	Eye Bolt
5	Nut
6	Bolt
7	Diaphragm Case(Bottom)
8	Bushing
9	Bearing
10	Dust Seal
11	Pointer
12	Yoke
13	Stem Connector
14	Bolt
15	Diaphragm Retainer
16	Stopper
17	Diaphragm Plate

No.	Parts Name
18	Coil Spring
19	Bolt
20	Nut
21	Spring Plate
22	Bolt
23	Washer
24	Packing
25	Rod
26	Lock Nut
27	Trus Screw (Washer, Nut)
28	Scale Plate
29	Screw
30	nameplate
31	Cap
32	O-Ring
33	Washer
34	Tapping Screw

Fig. 4-19 Cut View of Actuator

5. ADJUSTMENT AND CALIBRATION

Normally, the diaphragm-type control valve requires no adjustment or calibration. When it is serviced for overhaul or parts replacement, however, it should be adjusted and calibrated as described in this section.

AMT Type (Mixing Type)

(a) Lift Adjustment

•For Valve with Direct-action Actuator

Keeping the stem connector disconnected, make air piping to apply an air pressure to the diaphragm. Apply an air pressure to the actuator so that the actuator stem (pointer) is pressed downward by 2mm and, in this state, set the open reference point of the scale to the pointer. Next, increase the air pressure until the pointer indicates the AB-A point of the scale. On the other hand, press down the valve stem until the valve plug is seated on the lower seat ring. Now connect the actuator stem to the valve stem with the stem connector.

By adjusting the air pressure applied to the diaphragm, check that the lift (stroke) of the valve is normal.

Next, with the valve position at a midposition of the stroke, slightly loosen the screw of the stem connector so that it can be rotated with your hand. By adjusting the air pressure, let the valve plug seated on the upper and lower seat rings. The seated state can be known as the stem cannot be rotated with your hand when in this state. If the stem connector can be rotated with your hand, this means that the valve plug is not seated on the seat. If this is the case, repeat the adjustment all over again.

•For Valve with Reverse-action Actuator

Keeping the stem connector disconnected, make air piping to apply an air pressure to the diaphragm. Apply an air pressure to the actuator so that the actuator stem (pointer) is pressed downward by 2mm and, in this state, set the open reference point of the scale to the pointer. Next, increase the air pressure until the pointer indicates the AB-A point of the scale. On the other hand, press down the valve stem until the valve plug is seated on the lower seat ring. Now connect the actuator stem to the valve stem with the stem connector.

By adjusting the air pressure applied to the diaphragm, check that the lift (stroke) of the valve is normal.

Next, with the valve position at a midposition of the stroke, slightly loosen the screw of the stem connector so that it can be rotated with your hand. By adjusting the air pressure, let the valve plug seated on the upper and lower seat rings. The seated state can be known as the stem connector cannot be rotated with your hand when in this state. If the stem connector can be rotated with your hand, this means that the valve plug is not seated on the seat. If this is the case, repeat the adjustment all over again.

HDT Type (Diverting Type)

(a) Lift Adjustment

• For Valve with Direct-action Actuator

Keeping the stem connector disconnected, make air piping to apply an air pressure to the diaphragm. Apply an air pressure to the actuator so that the actuator stem (pointer) is pressed down by 2mm and, in this state, set the AB-A point of the scale to the pointer. Next, increase the air pressure until the pointer indicates the AB-B point on the scale. On the other hand, press down the valve stem until the valve plug is seated on the upper seat ring. Now connect the actuator stem to the valve stem with the stem connector.

By adjusting the air pressure applied to the diaphragm, check that the lift (stroke) is normal.

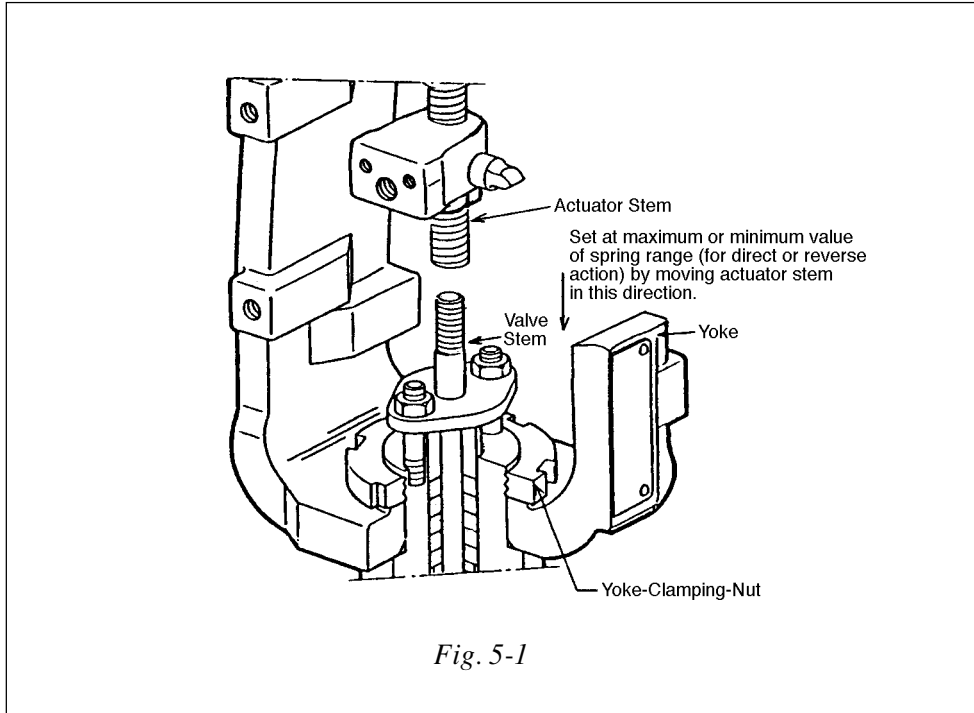
Next, with the valve position at a midposition of the stroke, slightly loosen the screw of the stem connector so that it can be rotated with your hand. By adjusting the air pressure, let the valve plug seated on the upper and lower seat rings. The seated state can be known as the stem cannot be rotated with your hand when in this state. If the stem connector can be rotated with your hand, this means that the valve plug is not seated on the seat. If this is the case, repeat the adjustment all over again.

• For Valve with Reverse-action Actuator

Keeping the stem connector disconnected, make air piping to apply an air pressure to the diaphragm. Apply an air pressure to the actuator so that the actuator stem (pointer) is pressed down by 2mm and, in this state, set the AB-B point of the scale to the pointer. On the other hand, press down the valve stem until the valve plug is seated on the upper seat ring. Now connect the actuator stem to the valve stem with the stem connector.

By adjusting the air pressure applied to the diaphragm, check that the lift (stroke) is normal.

Next, with the valve position at a midposition of the stroke, slightly loosen the screw of the stem connector so that it can be rotated with your hand. By adjusting the air pressure, let the valve plug seated on the upper and lower seat rings. The seated state can be known as the stem cannot be rotated with your hand when in this state. If the stem connector can be rotated with your hand, this means that the valve plug is not seated on the seat. If this is the case, repeat the adjustment all over again.



6. DIRECT/REVERSE ACTION TYPE CONVERSION AND SPRING RANGE CHANGE OF ACTUATOR

6.1 Direct/Reverse Action Change

As a general rule it is most recommendable to prepare separately the direct type and reverse type of actuators and not to convert actuators into different types. However, when it has become unavoidable to convert actuators into other types, conversions may be done by using the parts mentioned below (Table 6-1 and Table 6-2). The parts marked “+” are the ones which are newly needed and those marked “-” are ones which are not used.

Table 6-1 To Convert the Direct-Action Thpe into the Reverse Action Type

PSA1D -> PSA1R			
Parts neme	Q'ty		
Rod unite	+1	82559228-102	14.3mm
		82559228-101	25mm
Rod	-1	82559229-102	14.3mm
		82559229-101	25mm
Seal washer	+4	82521069-101	
Rod packing	+1	82521067-102	
Rain cap	+1	82553334-101	
Washer	+1	82592235-596	
"O" ring	+1	82553318-101	

HA2D -> HA2R			
Part name	Q'ty	For stroke 14.3mm, 25mm	For stroke 38mm
Seal washers	+2	82521069-101	82521069-101
Rod packing	+1	82521067-101	82521067-101
Rod unit	+1	82521431-101 (14.3mm)	82521431-103
		82521431-102 (25mm)	
Rain cap	+1	82553334-101	82553334-101
Rod	(-1)	82521427-101 (14.3mm)	82521427-103
		82521427-102 (25mm)	

HA3D -> HA3R				
Part name	Q'ty	For stroke 14.3mm	For stroke 25mm, 38mm	For stroke 38mm
Seal washers	+2	82521069-102	82521069-102	82521069-102
Rod packing	+1	82521067-102	82521067-102	82521067-102
Rod unit	+1	82521431-201	82521431-202 (25mm)	82521431-204
			82521431-203 (38mm)	
Rain cap	+1	82553334-101	82553334-101	82553334-101
Rod	(-1)	82521428-101	82521428-102 (25mm)	82521428-104
			82521428-103 (38mm)	

HA4D -> HA4R			
Part name	Q'ty	For stroke 25mm	For stroke 38mm, 50mm, 75mm
Seal washers	+2	82521069-103	82521069-103
Rod packing	+1	82521067-103	82521067-103
Rod unit	+1	82521431-302	82521431-303
Rain unit	(-1)	82521429-102	82521429-103 (38mm)
			82521429-104 (50mm)
			82521429-105 (75mm)
Rain cap	+1	82553334-101	82553334-101
Flat washers	(-2)	82592131-201	82592131-201

Table 6-2 To Convert the Reverse Action Type into the Direct Action Type

PSA1R -> PSA1D			
Parts name	Q'ty		
Rod unite	+1	82559229-102	14.3mm
		82559229-101	25mm
Rod	-1	82559228-102	14.3mm
		82559228-101	25mm
Seal washer	-4	82521069-101	
Rod packing	-1	82521067-102	
Rain cap	-1	82553334-101	
Washer	-1	82592235-596	
"O" ring	+1	82553318-101	

HA2R -> HA2D			
Part name	Q'ty	For stroke 14.3mm, 25mm	For stroke 38mm
Seal washers	(-2)	82521069-101	82521069-101
Rod packing	(-1)	82521067-101	82521067-101
Rod unit	+1	82521427-101 (14.3mm)	82521427-103
		82521427-102 (25mm)	
Rod	(-1)	82521431-101 (14.3mm)	82521431-103
		82521431-102 (25mm)	
Rain cap	(-1)	82553334-101	82553334-101

HA3R -> HA3D				
Part name	Q'ty	For stroke 14.3mm	For stroke 25mm, 38mm	For stroke 50mm
Seal washers	(-2)	82521069-102	82521069-102	82521069-102
Rod packing	(-1)	82521067-102	82521067-102	82521067-102
Rod unit	+1	82521428-101	82521428-102 (25mm)	82521428-104
			82521428-103 (38mm)	
Rod	(-1)	82521431-201	82521431-202 (25mm)	82521431-204
			82521202-203 (38mm)	
Rain cap	(-1)	82553334-104	82553334-104	82553334-104

HA4R -> HA4D			
Part name	Q'ty	For stroke 25mm	For stroke 38mm, 50mm, 75mm
Seal washers	(-2)	82521069-103	82521069-103
Flat washers	+2	82592131-201	82592131-201
Rod packing	(-1)	82521067-103	82592131-103
Rod unit	(-1)	82521431-302	82521431-303
Rod	+1	82521429-102	82521429-103 (38mm)
			82521429-104 (50mm)
			82521429-105 (75mm)
Rain cap	(-1)	82553334-104	82553334-104

For the conversion procedure, refer to Section 4 “DISASSEMBLY AND ASSEMBLY”

6.2 Stroke And Range Spring Change

As a general rule it is most recommendable to prepare separate actuators for different strokes and spring ranges to avoid modifications. However, modifications can be done by using the parts mentioned below.

Of Models HA2 and HA3, there are two different diameters of bonnet connection sections. For these models, note the following:

Of Model HA, modification for change between rated stroke of 14.3 or 25mm and that of 38mm cannot be done.

Of Model HA3, modification for change between rated stroke of 25 or 38mm and that of 50mm cannot be done.

Table 6-3 Parts Required for Respective Stroke Ranges

Note: spring force is equivalent to air pressure (kPa {kgf/cm²})

Actuator		PSA1D -> PSA1R		
Part name		Q'ty	For Stroke 25mm -> 14.3mm	For Stroke 14.3mm -> 25mm
Scale plate		1	82559230-102	82559230-101
Spring	20-98{0.2-0.1}	4	82521340-101	82521340-104
	80-240{0.8-2.4}	4	82521340-102	82521340-103
Rod unit	R (Reverse action)	1	82559228-102	82559228-101
	D (Direct action)	1	82559229-102	82559229-101
Washer		1	82553318-101	82553318-101

Actuator		HA2D -> HA2R		
Part name		Q'ty	For Stroke 25mm -> 14.3mm	For Stroke 14.3mm -> 25mm
Scale plate		1	80225032-164	80225037-164
Spring	20-98{0.2-0.1}	4	82521205-101	82521205-103
	80-240{0.8-2.4}	4	82521205-102	82521208-101
Rod unit	R (Reverse action)	1	82521431-101	82521431-102
	D (Direct action)	1	82521427-101	82521427-102

Actuator		HA3D -> HA3R		
Part name		Q'ty	For Stroke 38mm -> 25mm	For Stroke 25mm -> 38mm
Scale plate		1	80225037-164	80225039-164
Spring	20-98{0.2-0.1}	8	82521206-101	82521206-103
	80-240{0.8-2.4}	8	82521206-102	82521209-101
Rod unit	R (Reverse action)	1	82521431-202	82521431-203
	D (Direct action)	1	82521428-102	82521428-103

Actuator		HA4D -> HA4R				
Part name		Q'ty	For Stroke 25mm	For Stroke 38mm	For Stroke 50mm	For Stroke 75mm
Scale plate		1	80225037-164	80225039-164	80225041-164	80224425-164
Spring	20-98{0.2-0.1}	8	82521244-104	82521207-101	82521207-102	82521210-103
	80-240{0.8-2.4}	8	82521244-106	82521210-101	82521210-102	82521210-104* 82521210-105*
Rod unit	R (Reverse action)	1	82521429-102	82521429-103	82521429-104	82521429-105
	D (Direct action)	1	82521431-302	82521431-303	82521431-303	82521431-303

*:The quantity of springs is 8 set, with 2 springs for each set, or total 16 springs.

Color Codes and Dimensions of the Springs of Model HA Actuators

The color codes and dimensions of the springs of Model HA Actuators are as shown in the following table. The color codes may help you confirm springs when disassembling and assembling actuators for modification or other purpose.

Table 6-4 Color Codes and Dimensions of Springs

Rated stroke	Model		PSA1	HA2	HA3	HA4
	Range					
14.3	20-98 {0.2-1.0}		Red 64.6	Red 86	Yellow and Green 99.2	
	80-240 {0.8-2.4}		Blue 69.8	Blue 90	Red and Green 103.6	
25	20-98 {0.2-1.0}		Green 68.7	Yellow 91.4	Red 99.3	Yellow and Green 148.1
	80-240 {0.8-2.4}		Purple 78.8	Brown 99	Blue 107	Red and Green 155.3
38	20-98 {0.2-1.0}			Green 95	Yellow 102.9	Red 152.8
	80-240 {0.8-2.4}			Purple 107	Brown 114.9	Blue 163.7
50	20-98 {0.2-1.0}				Green 106.5	Yellow 156.3
	80-240 {0.8-2.4}				Purple 122.2	Brown 170.6
75	20-98 {0.2-1.0}					Green 163.4
	80-240 {0.8-2.4}					Purple NOTE 1 182, 186.7*

- Note: 1. Each set is comprised of two springs.
 2. "0.2-1.0" and "0.8-2.4" are spring forces corresponding to air pressures in the unit of kPa{kgf/cm²}.
 3. The dimensions indicated are free lengths of springs.

7. INSTRUCTIONS FOR TOP HANDWHEEL OF ACTUATOR

7.1 Model PSA1 Actuator

7.1.1 Operating Instructions

To manually operate the actuator, refer to Fig. 7-1 and Fig. 7-2 and proceed as follows:

- (1) Loosen the lock nut of the handwheel and turn the handwheel in the direction indicated by the corresponding arrowhead mark.

As you turn the handwheel clockwise, the actuator stem moves downward regardless of whether the actuator is of the direct action type or reverse action type. The handwheel bears the "SHUT" mark to indicate that the valve is closed as the handwheel is turned clockwise and the "OPEN" mark to indicate that the valve is made open as the handwheel is turned counterclockwise.

- (2) For automatic operation of the actuator, fully raise the handwheel if the actuator is of the direct action type or fully lower the handwheel if the actuator is of reverse action type, and then tighten the lock nut to secure the handwheel in such position.

Precautions: If you forcefully turn the handwheel after it has reached the mechanical stop position, the valve stem may be damaged. Do not turn the handwheel with forces larger than 16 kgf at the outermost periphery of the handwheel.

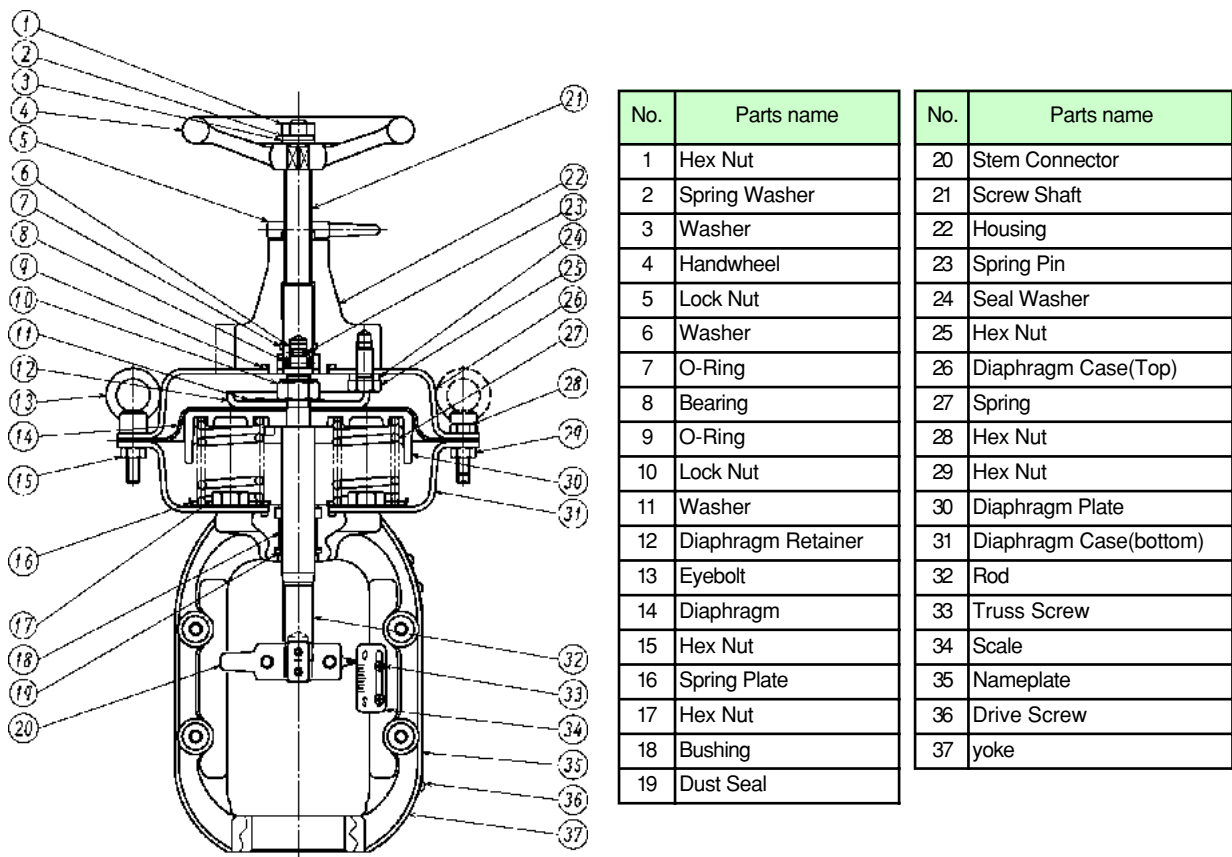
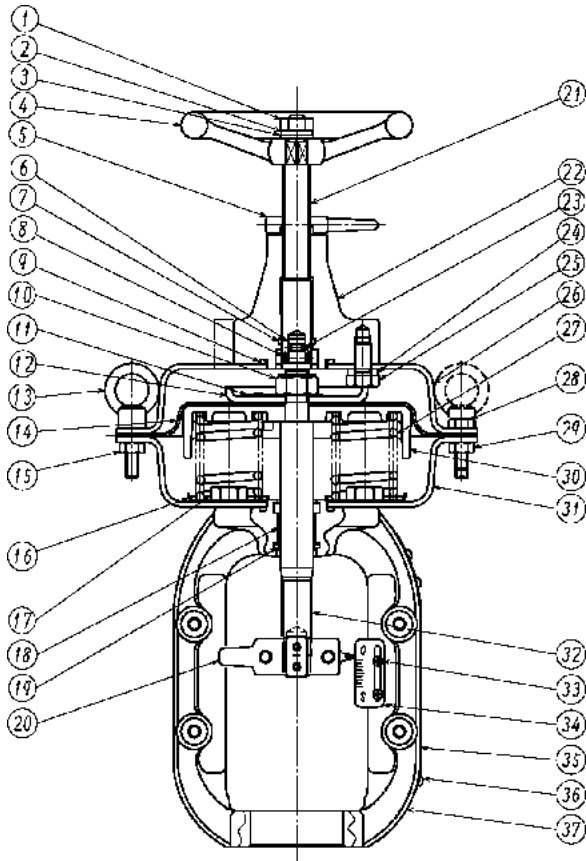


Fig. 7-1 Model PSA1 Actuator with Top Handwheel (Direct Action Type)



No.	Parts name	No.	Parts name
1	Hex Nut	21	Screw Shaft
2	Spring Washer	22	Bearing Washer
3	Washer	23	Bearing
4	Handwheel	24	Nut
5	Lock Nut	25	Bearing Case
6	Housing	26	Spring Plate
7	Spring Pin	27	Hex Nut
8	Cap	28	Setscrew
9	Spring	29	Hex Bolt
10	Diaphragm Case(Top)	30	Hex Nut
11	Eyebolt	31	Diaphragm Case(bottom)
12	Hex Nut	32	Connector
13	Diaphragm Plate	33	Diaphragm Retainer
14	Diaphragm	34	Hex Nut
15	Washer	35	Seal Washer
16	O-Ring	36	Rod
17	Rod Packing	37	Truss Screw
18	Bushing	38	Scale
19	Dust Seal	39	Nameplate
20	Stem Connector	40	Drive Screw
		41	yoke

Fig. 7-2 Model PSAI Actuator with Top Handwheel (Reverse Action Type)

7.1.2 Disassembly and Assembly of Top Handwheel

To disassemble or assemble the top handwheel, refer to Fig. 7-3 through 7-4 and proceed as described in this section. For disassembly work, keep the actuator in the vertical attitude.

(a) Direct Action Type

- (1) Disconnect the air piping.
- (2) Set the handwheel shaft in the automatic operation position (fully raise the handwheel shaft).
- (3) Remove the top diaphragm case. When doing this, loosen the pair of eyebolts uniformly and alternately, after removing all other clamping-bolts of the diaphragm case.
- (4) Sufficiently insert the handwheel shaft by turning it and then remove the handwheel and the lock nut. Insert the shaft further and then remove the screw shaft from the housing.
- (5) Remove the O-ring.

To assemble the top handwheel, follow the disassembly procedure in the reverse order.

(b) Reverse Action Type

- (1) Disconnect the air piping.
- (2) Set the handwheel shaft in the automatic operation position (fully lower the handwheel shaft).
- (3) Remove the handwheel and the lock nut. Insert the shaft into the housing by means of the threading until the threaded sections are disengaged.
- (4) Remove the top diaphragm case. When doing this, loosen the pair of eyebolts uniformly and alternately, after removing all other clamping-bolts of the diaphragm case.
- (5) Remove the housing by loosening its clamping-screw.
- (6) Remove the setscrew and then remove the bearing case.
- (7) Remove the spring pin and then remove the castle nut.
- (8) Remove the bearing retainer and then remove the bearing.

To assemble the top handwheel, follow the disassembly procedure in the reverse order.

(c) Inspection After Assembly

- (1) Check that the handwheel turns smoothly for the full stroke.
- (2) For the direct action type of actuator, check by means of soapsuds that there is no air leak from the connecting section of the top diaphragm case.

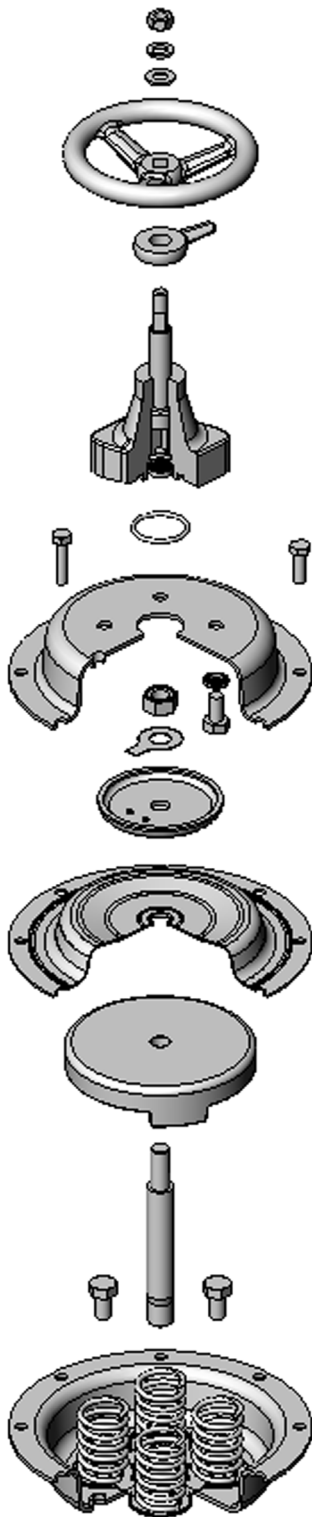


Fig. 7-3 Model PSA1 Direct Action Type

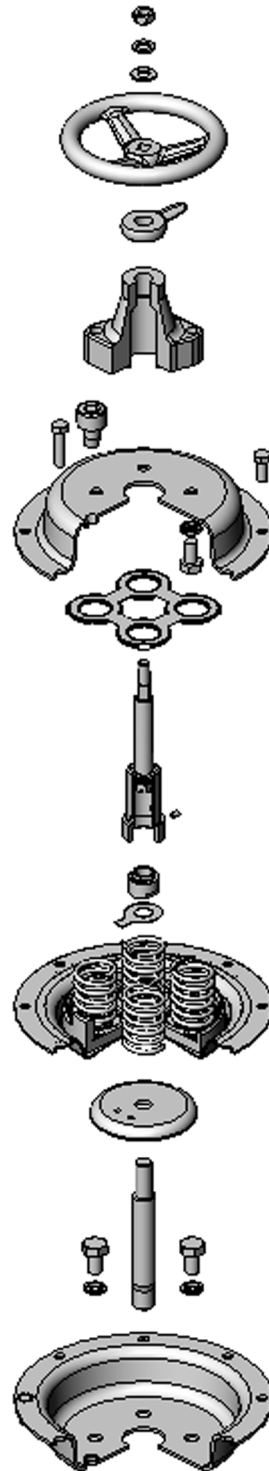


Fig. 7-4 Model PSA1 Reverse Action Type

7.2 Model HA2, HA3, or HA4 Actuator

7.2.1 Operating Instructions

To manually operate the actuator, refer to 'Fig. 7-5 through Fig. 7-8 and proceed as follows:

- (1) First, loosen the lock nut (which has a bar-shape handle and which locks the handwheel, and turn the handwheel in the direction indicated by the corresponding arrowhead mark.

As you turn the handwheel clockwise, the actuator stem moves downward regardless of whether the actuator is of the direct action type or reverse action type. The handwheel bears the "SHUT" mark to indicate that the valve is closed as the handwheel is turned clockwise and the "OPEN" mark to indicate that the valve is made open as the handwheel is turned counterclockwise.

- (2) For automatic operation of the actuator, fully raise the handwheel if the actuator is of the direct action type or fully lower the handwheel if the actuator is of the reverse action type, and then tighten the lock nut to secure the handwheel in such position.

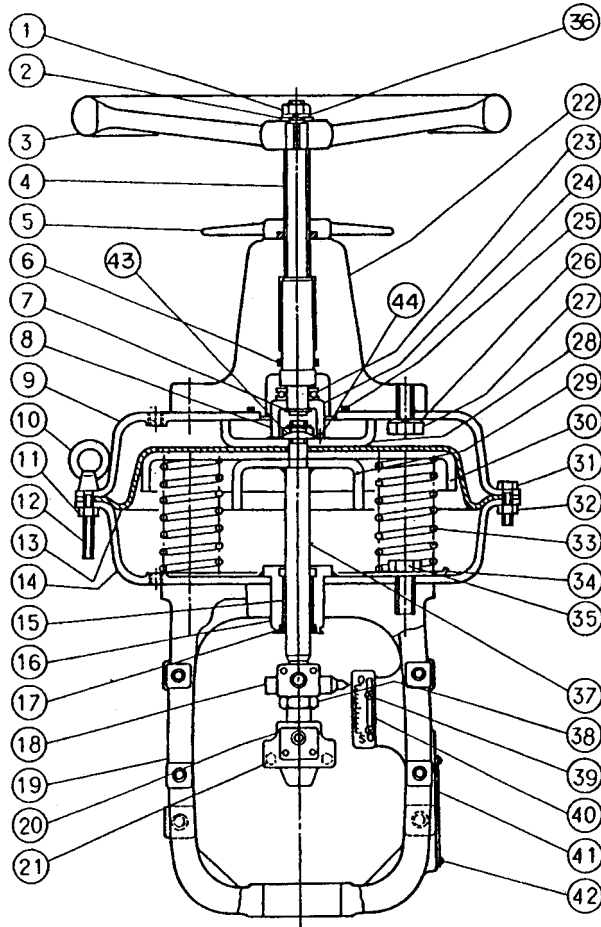
Precautions: If you forcefully turn the handwheel after it has reached the mechanical stop position, the valve stem may be damaged. Do not turn the handwheel with forces larger than the below-mentioned limits.

Model HA2: 190N {19kgf}

Model HA3: 260N {26 kgf}

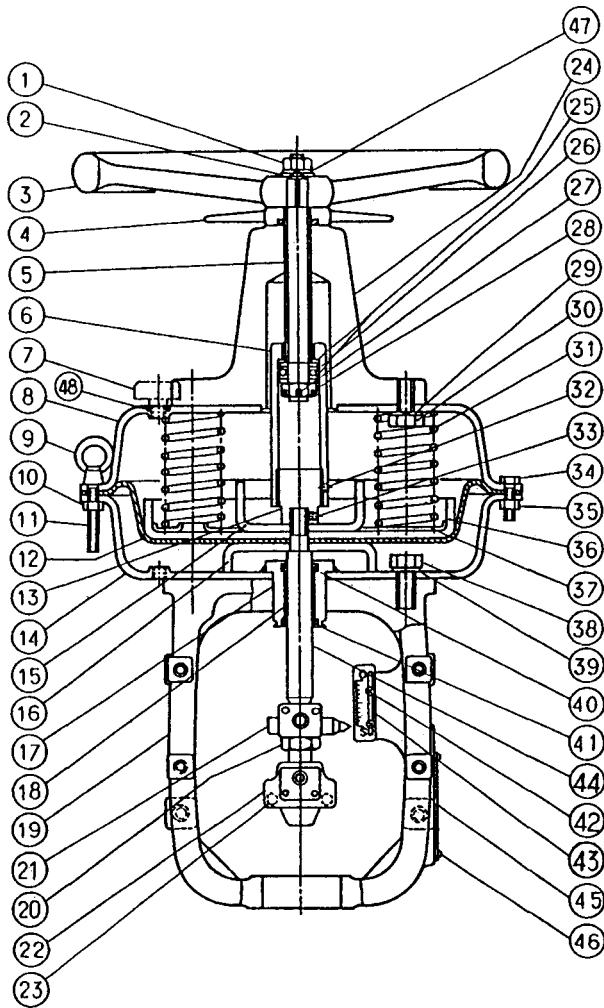
Model HA4: 410N {41 kgf}

(at the outermost periphery of the handwheel)



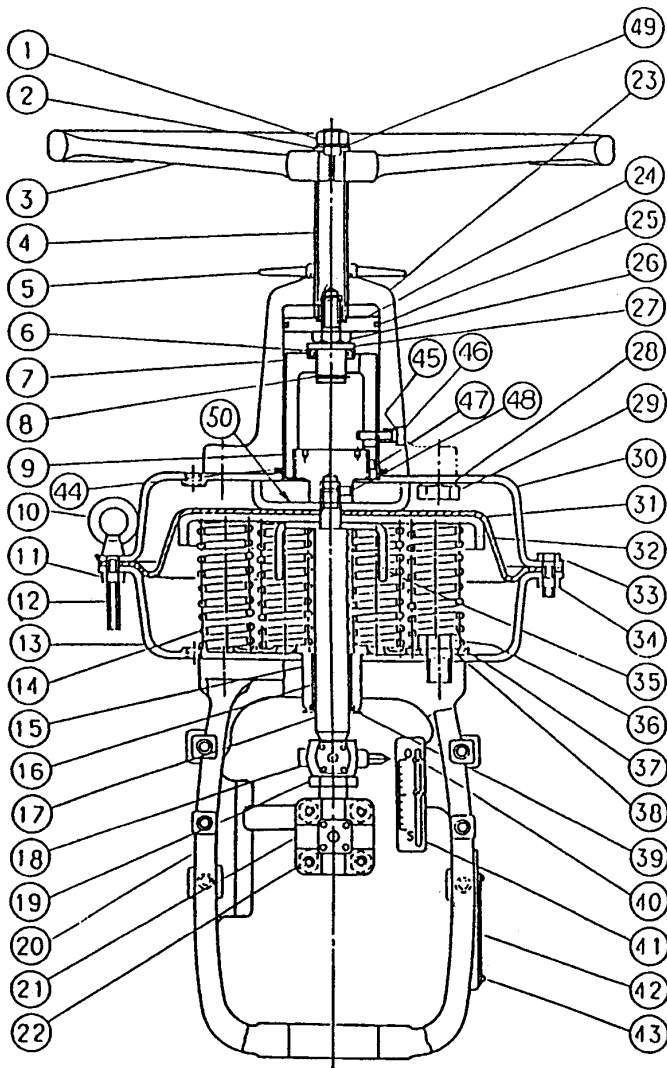
No.	Parts name
1	Nut
2	Washer
3	Handwheel
4	Screw Shaft
5	Lock Nut
6	O-Ring
7	Cotter
8	nut
9	Diaphragm Case(Top)
10	Eyebolt
11	Nut
12	Through Bolt
13	Diaphragm
14	Diaphragm Case(Bottom)
15	Bushing
16	Bearing
17	Dust seal
18	Pointer
19	Yoke
20	Stem Connector
21	Stem Connector Bolt
22	Housing
23	Bearing
24	Spring Retainer
25	O-Ring
26	Seal Washer
27	Bolt
28	Diaphragm Retainer
29	Stopper
30	Diaphragm Plate
31	Bolt
32	Nut
33	Compressed Coil Spring
34	Spring Plate
35	Bolt
36	Spring Washer
37	Rod
38	Lock Nut
39	Truss Screw, Spring Washer Nut, or Speed Nut
40	Scale
41	Nameplate
42	Drive screw
43	Washer
44	Tapping Screw

Fig. 7-5 Model HA2/3 Actuator with Top Handwheel (Direct Action Type)



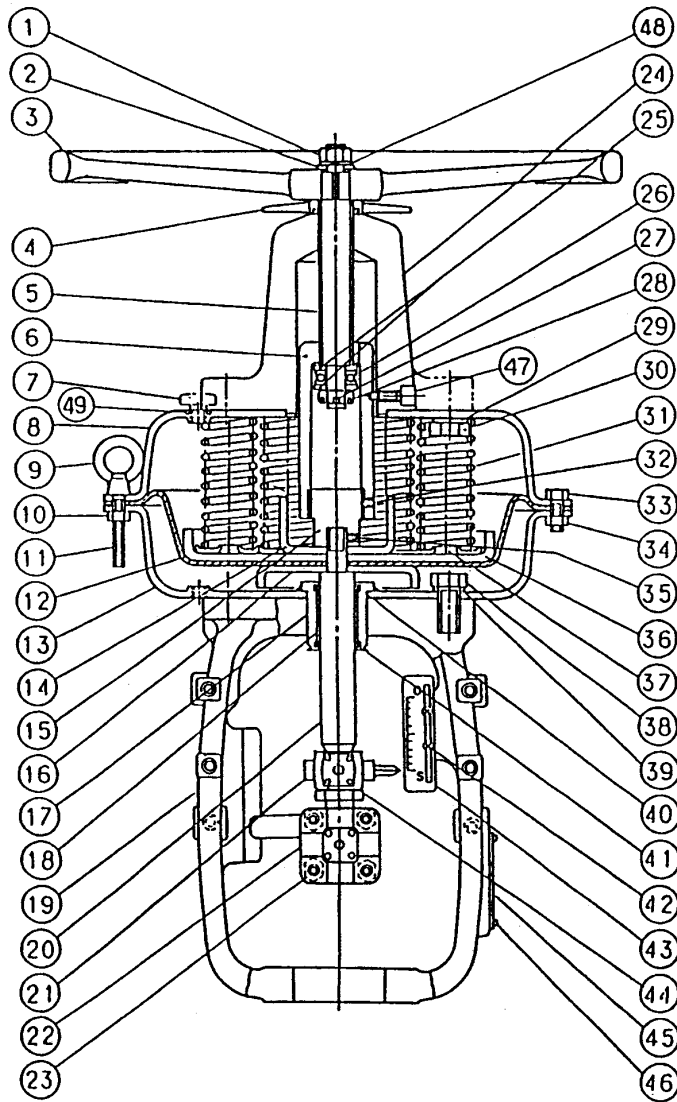
No.	Parts name
1	Nut
2	Washer
3	Handwheel
4	Lock Nut
5	Screw Shaft
6	Bearing Case
7	Cap
8	Diaphragm Case(Top)
9	Eyebolt
10	Nut
11	Through Bolt
12	Diaphragm
13	Connector
14	Diaphragm Case(Bottom)
15	Stopper
16	Diaphragm Retainer
17	Bearing
18	Bushing
19	Yoke
20	Lock Nut
21	Pointer
22	Stem Connector
23	Stem Connector Bolt
24	Housing
25	Bearing Washer
26	Bearing
27	Cotter Pin
28	Castle Nut
29	Seal Washer
30	Bolt
31	Compressed Coil Spring
32	Setscrew
33	Setscrew
34	Bolt
35	Nut
36	Diaphragm Plate
37	Spring Plate
38	Bolt
39	Seal Washer
40	Packing For Rod
41	Dust Seal
42	Truss Screw, Spring Washer Nut, or Speed Nut
43	Scale
44	Rod
45	Nameplate
46	Drive Screw
47	Spring Washer
48	O-Ring

Fig. 7-6 Model HA2/3 Actuator with Top Handwheel (Reverse Action Type)



No.	Parts name
1	Nut
2	Washer
3	Handwheel
4	Screw Shaft
5	Lock Nut
6	Bearing
7	Bearing Case
8	Cotter
9	Connector
10	Eyebolt
11	Nut
12	Through Bolt
13	Diaphragm Case(Bottom)
14	Coil Spring
15	Bearing
16	Bushing
17	Rod
18	Pointer
19	Lock Nut
20	Yoke
21	Stem Connector
22	Stem Connector Bolt
23	Housing
24	Piston Plate
25	O-Ring
26	Bolt
27	Bearing Retainer
28	Seal Washer
29	Bolt
30	Diaphragm Case(Top)
31	Diaphragm
32	Diaphragm Plate
33	Bolt
34	Nut
35	Stopper
36	Bolt
37	Spring Plate
38	Washer
39	Dust Seal
40	Truss Screw, Speed Nut
41	Scale
42	Nameplate
43	Drive Screw
44	O-Ring
45	Seal Washer
46	Keybolt
47	Setscrew
48	Setscrew
49	Spring Washer
50	Diaphragm Retainer

Fig. 7-7 Model HA4 Actuator with Top Handwheel (Direct Action Type)



No.	Parts Name
1	Nut
2	Washer
3	Handwheel
4	Lock Nut
5	Screw Shaft
6	Bearing Case
7	Cap
8	Diaphragm Case(Top)
9	Eyebolt
10	Nut
11	Through Bolt
12	Diaphragm
13	Diaphragm Case(Bottom)
14	Stopper
15	Connector
16	Diaphragm Retainer
17	Bearing
18	Bushing
19	Yoke
20	Rod
21	Pointer
22	Stem Connector
23	Stem Connector Bolt
24	Housing
25	Washer
26	Bearing
27	Bearing
28	Cotter Pin
29	Seal Washer
30	Bolt
31	Coil Spring
32	Setscrew
33	Bolt
34	Nut
35	Setscrew
36	Diaphragm Plate
37	Spring Plate
38	Bolt
39	Seal Washer
40	Packing
41	Dust Seal
42	Truss Screw, Speed Nut
43	Scale
44	Lock Nut
45	Nameplate
46	Drive Screw
47	Keybolt
48	Spring Washer
49	O-Ring

Fig. 7-8 Model HA4 Actuator with Top Handwheel (Reverse Action Type)

7.2.2 Disassembly and Assembly of Top Handwheel

To disassemble or assemble the top handwheel, refer to Fig. 7-5 through 7-10 and proceed as described in this section. For disassembly and assembly work, keep the actuator in the vertical attitude.

(a) Direct Action Type

- (1) Disconnect the air piping.
- (2) Set the handwheel shaft in the automatic operation position (fully raise the handwheel shaft).
- (3) Remove the top diaphragm case. When doing this, loosen the pair of eyebolts uniformly and alternately, after removing all other clamping-bolts of the diaphragm case.
- (4) Sufficiently insert the handle shaft by turning it and then remove the handwheel and the lock nut. Insert the shaft further and then remove the screw shaft from the housing.
- (5) Remove the O-ring.

To assemble the top handwheel, follow the disassembly procedure in the reverse order.

(b) Reverse Action Type

- (1) Disconnect the air piping.
- (2) Set the handwheel shaft in the automatic operation position (fully lower the handwheel shaft).
- (3) Remove the handwheel and the lock nut. Insert the shaft into the housing by means of the threading until the threading sections are disengaged.
- (4) Remove the top diaphragm case. When doing this, loosen the pair of eyebolts uniformly and alternately, after removing all other clamping-bolts of the diaphragm use.
- (5) Remove the housing by loosening its clamping-screws.
- (6) Remove the setscrew and then remove the bearing case.
- (7) Remove the pin and then remove the castle nut.
- (8) Remove the bearing retainer and then remove the bearing.

To assemble the top handwheel, follow the disassembly procedure in the reverse order.

(c) Inspection After Assembly

- (1) Check that the handwheel turns smoothly for the full stroke.
- (2) For the direct action type of actuator, check by means of soapsuds that there is no air leak from the connecting sections of the housing and top diaphragm case.

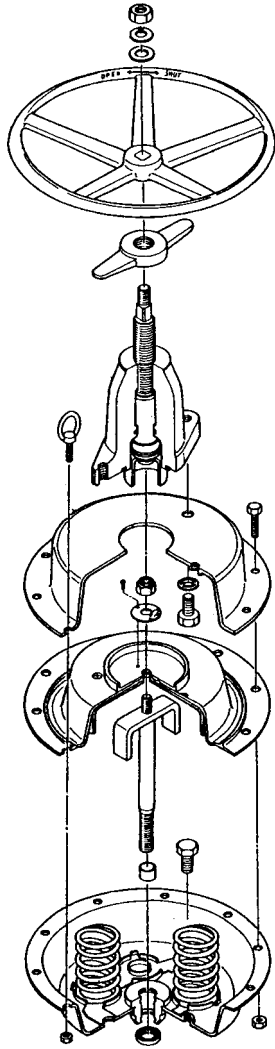


Fig. 7-9 Direct Action Type

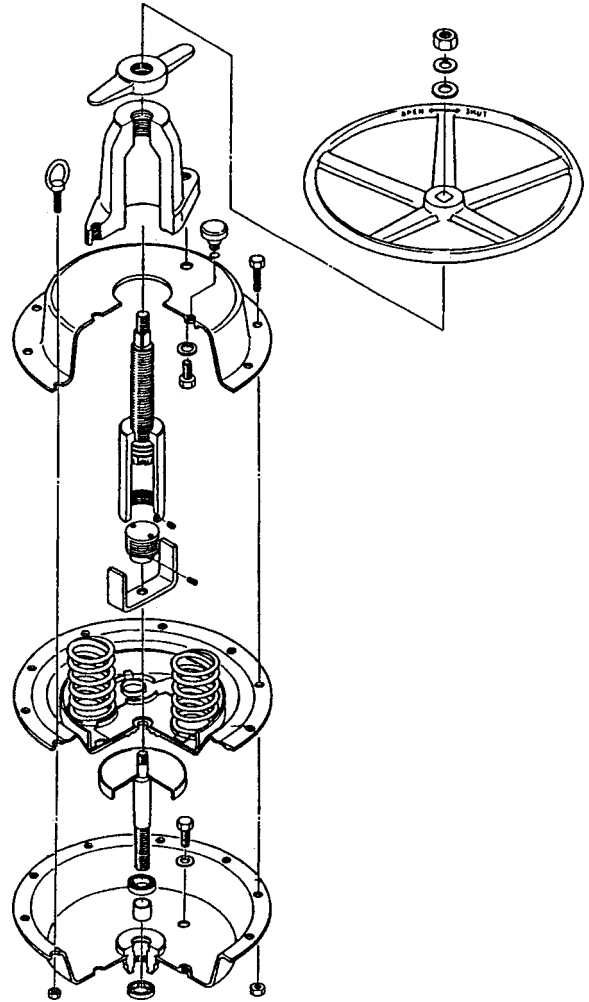


Fig. 7-10 Reverse Action Type

8. INSTRUCTIONS FOR SIDE HANDWHEEL OF ACTUATOR

As you turn the handwheel clockwise, the actuator stem moves downward regardless of whether the actuator is of the direct action type or reverse action type. The handwheel bears the "SHUT" mark to indicate that the valve is closed as the handwheel is tuned clockwise and the "OPEN" mark to indicate that the valve is made open as the handwheel is tuned counterclockwise.

8.1 Installation Procedure

To install the side handwheel, refer to Fig. 8-1 and proceed as follows:

- (1) Prepare a manual operation kit (a side handwheel set and its mounting accessories).
To install the handwheel, no machining or other physical processing on the actuator is necessary.
- (2) By turning the handwheel, set the pointer of the operation nut at the AUTO position.
- (3) Loosen the bolt (item number 6 as-show in Fig. 8-1) and widen the distance between levers.
- (4) Install the handwheel on the mounting pad at the back of the actuator, with the mounting-bolts.
- (5) Engage the holes at the end of two levers to the pointer boss and engage those of the other ends to the boss of the operation nut, and then tighten the bolt.
- (6) When the control valve is in the automatic mode of operation, set the pointer of the operation nut at the AUTO position and keep the handwheel locked.

8.2 Operating Instructions

- (1) To manually operate the actuator, remove the handwheel lock (the fork-shaped component) which locks the handwheel and turn the handwheel in the direction indicated by the corresponding arrowhead mark.
- (2) To return to the automatic operation, turn the handwheel so that the pointer of the operation nut is set at the AUTO position and then apply the handwheel lock.

Precautions: If you forcefully turn the handwheel after it has reached the mechanical stop position, the valve stem may be damaged. Do not turn the handwheel with forces larger than the below-mentioned limits.

Model PSA1:	80N {8kgf}
Model HA2:	190N {19kgf}
Model HA3:	290N {29kgf}
Model HA4:	460N {46kgf}

(at the outermost periphery of the handwheel)

8.3 Disassembly of Side Assembly of Side Handwheel

Before starting disassembly, check that the pointer is set at the AUTO position. (Refer to Fig. 8-1)

- (1) Loosen the bolt 6 which connects the levers 2 and then disengage the levers from the pointer.
- (2) Undo the mounting-bolts 1 of the side handwheel unit and detach it from the actuator.
- (3) Remove the lock nut of the handwheel and then remove the handwheel.
- (4) Loosen the bolt 8 of the bearing holder and then remove the feed shaft 7.

To assemble the side handwheel, refer to Fig. 8-1 and follow the disassembly procedure in the reverse order.

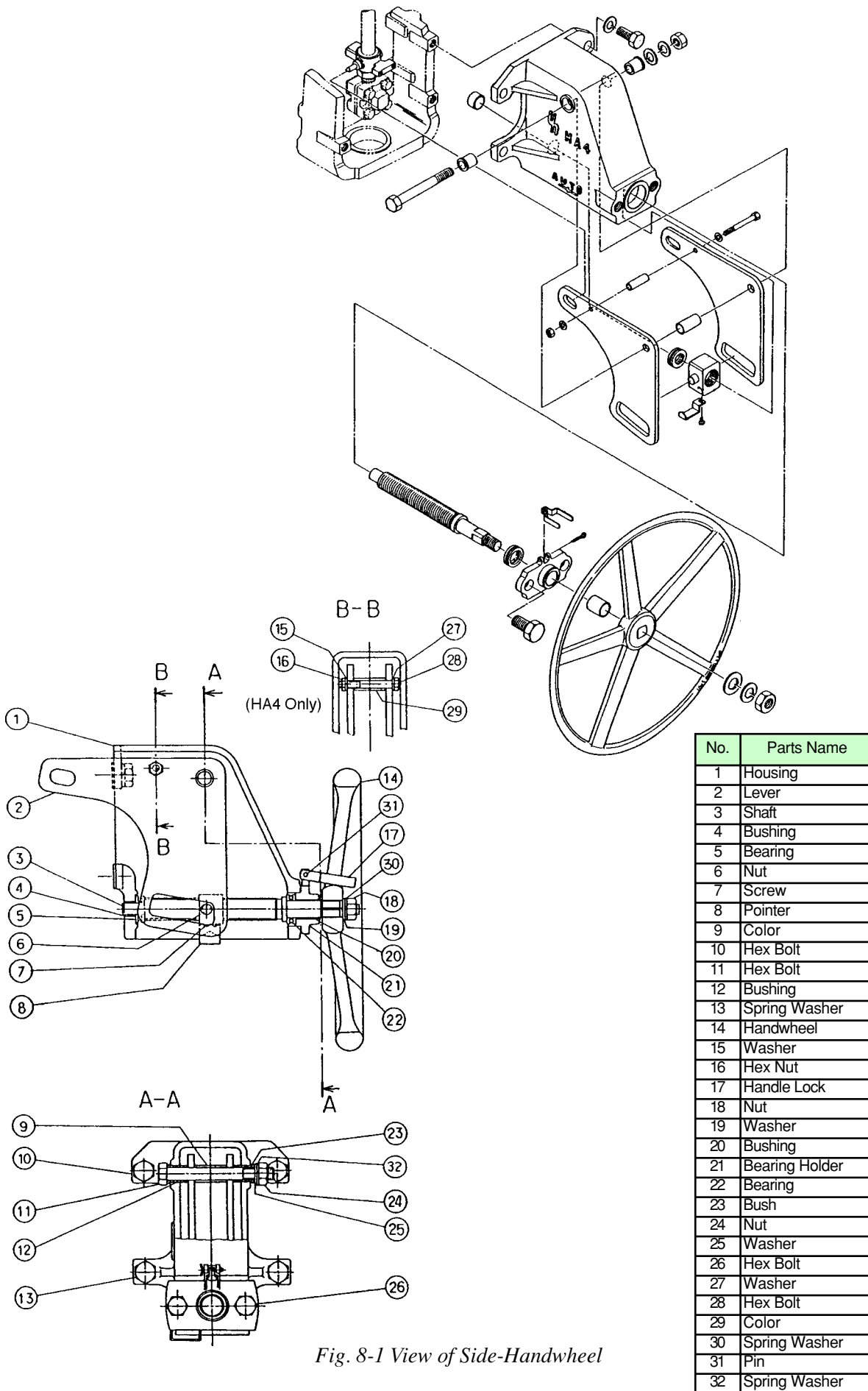


Fig. 8-1 View of Side-Handwheel

9. Mechanical stopper

Refer to “Fig.9-1” on page 52 for details of construction. This device can be used as MIN. stopper or MAX. stopper as required. Also, it can be used as MIN/MAX stopper.

The MIN. stopper (limits valve’s minimum opening for direct acting valve) regulates the maximum suction of stopper shaft, and the MAX stopper (limits valve’s maximum opening of valve opening for direct acting valve) regulates maximum extrusion of stopper shaft 4.

9-1. Adjustment of MIN. stopper

- (1) Loosen detent 2 and remove MAX. stopper 1 (adjust cover) from housing 5.
- (2) Loosen hexnut 3 for MIN. stopper and remove from stopper shaft 4. Although the stopper does not function in this condition, the valve can operate across the rated range of lift.
- (3) Manipulate positioner signal, supply air pressure or manual handle to set the valve at the stopper’s set position.
- (4) Lock the detent at the position when it hits housing 5 while the valve is set.
- (5) Assemble and lock MAX. stopper and detent 2 at the position where they do not hit the maximum protruding position of stopper shaft 4.

9-2. Adjustment of MAX. stopper

- (1) Loosen detent 2 and remove MAX. stopper 1 (adjust cover) from housing 5.
- (2) Loosen hexnut 3 for MIN. stopper and remove from stopper shaft 4. Although the stopper does not function in this condition, the valve can operate across the rated range of lift.
- (3) Manipulate positioner signal, supply air pressure or manual handle to set the valve at fully open position.
- (4) Screw on hex head nut for MIN. stopper 3 onto stopper shaft 4. The hexnut for MIN. stopper 3 should be locked at the top end of the stopper shaft 4 to make the distance between the lower face of the hexnut 3 and housing 5 larger than the rated lift.
- (5) Manipulate positioner signal, supply air pressure or manual handle to set the valve at the stopper’s set position.
- (6) Screw MAX. stopper 1 onto housing 5, and when MAX. stopper 1 seats against hexnut for MIN. stopper 3 or stopper shaft 4, lock MAX. stopper 1 with detent 2.

9-3. Adjustment of dual MIN. MAX. stopper

Perform adjustments as described in both “9-1:Adjustment of MIN. stopper” and “9-2:Adjustment of MAX. stopper”.

Described below is a normally expected maljunction during operation.

CAUTION
<p>When hexnut for MIN. stopper is tightened or loosened, apply wrenches on top and bottom of the nut so that no excessive torque is applied to stopper shaft 4.</p>

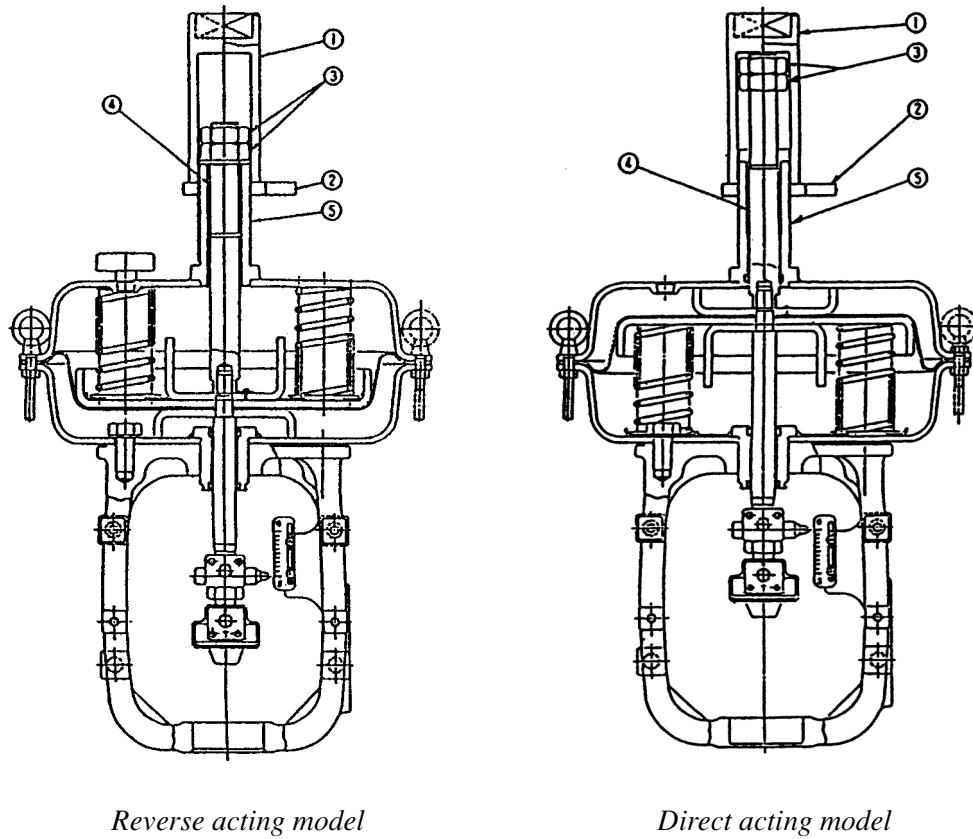


Fig. 9-1

No.	Nomenclature
1	MAX. stopper (adjust cover)
2	Detent
3	Hex nut for MIN. stopper
4	Stopper shaft
5	Housing

No.	Nomenclature
1	MAX. stopper (adjust cover)
2	Detent
3	Hex nut for MIN. stopper
4	Stopper shaft
5	Housing

10. TROUBLESHOOTING

This section covers the symptoms, causes and remedies of most probable types of troubles. Parts may be required to be replaced depending on the type of trouble.

For further troubles, please order your Yamatake Corporation agent for repair.

Table 10-1. Troubleshooting

Symptom	Cause and Remedy
<p>Unstable valve operation</p> <ul style="list-style-type: none"> Valve position hunting occurs when almost fully closed. Air supply pressure is unstable. Signal pressure is unstable. Valve position hunting occurs even when signal pressure is stable. 	<ul style="list-style-type: none"> Cv value is too large. Reduce Cv value. For a single seat Valve, the valve is installed in the reverse flow direction. Large air consuming equipment is hooked up to the same air supply line. Check that the air supply capacity piping capacity and restriction capacity are appropriate. Supply air pressure regulator is inadequate or not operating properly. Controller is not properly tuned. Properly tune the controller (properly set the proportional band and other parameters). Check that the controller output does not change abnormally. Hunting of output of positioner itself. Check and repair or replace the positioner. Being affected by pressure change of process fluid as power of the actuator is insufficient. Replace the actuator with a larger one.
<p>Vibration of valve</p> <ul style="list-style-type: none"> Valve vibrates (generate noise) at any position of valve plug. Valve vibrates (generate noise) only when valve plug is set at a certain position. 	<ul style="list-style-type: none"> Piping is vibrating. Securely fix the piping. Check for other sources of vibration. Worn valve plug or guides. Check the parts and replace them as required. Check for change in process fluid flow conditions (change in restriction orifice, Cv value, etc.) Check for change in plug configuration (change in flow control characteristics.)
<p>Sluggish valve operation or inoperative Valve</p>	<ul style="list-style-type: none"> Air leak from piping Air leak from actuator Foreign matter entrapped in guide section of valve plug. Aged and hardened gland packing, causing increased hysteresis Malfunctioning positioner (Check the positioner by operating it directly on an air supply known to be operating normally.)
<p>Fluid leak from gland section</p>	<ul style="list-style-type: none"> Check for loose packing flange. Check for insufficient grease. Check for damaged valve shaft.
<p>Liquid leak from gasket section</p>	<ul style="list-style-type: none"> Check for loose nuts of bonnet. Check for defective gasket (deformed or damaged).

Yamatake Corporation

Symptom	Cause and Remedy
Even when valve plug is in closed position, large flow leaks to downstream side.	<ul style="list-style-type: none">• Air leak at actuator section.• For trial, apply the air supply pressure or atmospheric pressure to the actuator. (Check the air supply source and positioner.)• Check whether the valve plug is actually the closed position or not. (Check the valve plug lift)• Check the plug seat ring for corrosion and erosion.• Check the guide sections for binding.

11. RECOMMENDED SPARE PARTS

It is most recommendable to replace the following parts when servicing the control valve.

- **Valve Body**

Be sure to replace the following parts with fresh ones whenever the valve body is disassembled:

- Gland packing
- Gaskets

- **Actuator**

Replace the following Parts at every 5 years or thereabout.

- Diaphragm
 - Bushing
 - Cap
 - Seal washer
 - Dust seal
 - Rod seal
- } Be sure to replace these parts whenever the actuator is disassembly.

Of the bellows sealed type of control valves, the bellows seal assembly* must be replaced periodically. The period of replacement depends on temperature, pressure and other conditions of use. A typical service longevity of the bellows assembly is 10,000 vertical stroke cycles.

* The bellows seal assembly has the seal bellows and valve stem (including the bellows seat) assembled together.

Please mention the parts name and the product number indicated on the name plate when ordering those spare parts.

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