



NOTES:

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

6 PORT XA VALVE ASSEMBLY INSTRUCTIONS

1. Assembly is to be accomplished by building the valve in the upside down position using production fixture.
2. Inspect the primary plate, Item #1, to insure that the tubing ports are clean and that the sealing surface has no scratches or pits. Then place it in the fixture with the sealing surface facing up.
3. Insert .125 Dia. guide pin, Item #11, and .093 Dia. guide pin, Item #10, in the locating holes in the plate.
4. Place the amber sealing diaphragm (has no holes in the actuating plane) over the guide pins and align.
5. Place the white cushion diaphragm (has same hole pattern as sealing diaphragm in step 4) over the sealing diaphragm and align.
6. Place the upper piston plate, Item #2, over the guide pins with the piston recess holes facing up.
7. Load 3 each of the short pistons, Item #6, into the recess holes of the plate.
8. Place two amber upper actuator diaphragms (has 3 large holes for long pistons to feed through) over the guide pins and align.
9. Place the lower piston plate, Item #3, over the guide pins with the piston recess holes facing up.
10. Load 3 each of the long pistons, Item #5, into the recess holes of the plate.
11. Place two amber lower actuator diaphragms over the guide pins and align.
12. Place base plate, item #4 over the guide pins and align.
13. Place washer, Item #13, over bolt, Item #8, and insert the bolt from the bottom up through the valve assembly, tighten bolt Item #8 to 20 Ft. LBS. Remove from fixture and Install into Unit.

ITEM NO	PART NUMBER	DESCRIPTION	QTY
1	2-4-0710-232	PRIMARY PLATE (W/O BOSS)	1
2	2-4-0710-233	UPPER PISTON PLATE(WITH BOSS)	1
3	2-4-0710-234	LOWER PISTON PLATE	1
4	2-4-0710-235	BASE PLATE	1
5	2-4-0710-246	LONG PISTONS	3
6	2-4-0710-247	SHORT PISTONS	3
7	2-4-0710-248	DIAPHRAGM KIT	1
8	2-4-9216-060	BOLT, HEX HEAD, 1/4-28 x 1-3/4", L9 ALLOY ZINC-YELLOW	1
10	2-4-0710-169	DIAMETER .093 GUIDE PIN (18-8 SS)	1
11	2-4-0710-170	DIAMETER .125 GUIDE PIN (18-8 SS)	1
13	2-4-1518-047	1/4" FLAT WASHER (18-8 SS)	1

SI METRIC						
THIRD ANGLE PROJECTION						
MATERIAL:	SEE ORDER	D	10/26/09	CC	ECO-XX-5005171	EM NP
		C	08-3-09	HM	ECO-XX-5004955	EM NP
		B	07-13-09	HM	ECO-XX-5004881	EM NP
		A	05-16-09	JDB	ECO-XX-5004744	HVB HVB/NP
FINISH:	N/A	REV	DATE	DRN	DESCRIPTION	CHKD APPD
PROJ. FILE NO.	- NONE	FILE NAME: CE-22260D1.SLDDRW, DATE: 10/26/09, TIME: 2:06 A.M.				

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GEOMETRIC TOLERANCES & DIMENSIONS PER ANSI Y14.5 LATEST REVISION

UNLESS OTHERWISE NOTED ALL DIMENSIONS IN INCHES
 X.XX ±.015
 X.XXX ±.005
 ANGULAR ±0° 30'
 FINISH 200 RA MAX

BREAK ALL SHARP CORNERS TO .003-.015 RADIUS AND REMOVE ALL BURRS



TITLE		REV	
ASSEMBLY 6 PORT XA VALVE MODEL 700XA		D	
DRN	JDB	DATE	04/17/09
CHKD	HVB	DATE	04/17/09
APPD	HVB/NP	DATE	04/17/09
DWG NO. CE-22260		SCALE	2:1
P/N 2-3-0710-100		SHT	1 OF 1