

Assembly of Gearboxes



1.0 PURPOSE

1.1 The purpose of this document is to provide instructions for assembling gearboxes onto butterfly valves

2.0 SCOPE

2.1 Assembly of gearboxes onto butterfly valves

3.0 RESPONSIBILITY

3.1 The Quality Manager is responsible for the maintenance of this document.

4.0 TOOLS, GAUGES, FIXTURES

4.1 4mm T bar, 6mm T bar flat head screwdriver, pozi drive screwdriver, bolts x 4 (2" - 6" M8 x 25 / 8" - 12" M10 x 35) 4 x flat washers, 4 x spring washers

5.0 SAFETY REQUIREMENTS

5.1 Complete risk assessment of area prior to commencing work.

6.0 INSTRUCTIONS - Assembly

6.1 Pick valves (image 1) and gearboxes (image 2) from relevant location

Image 1



Image 2



6.2 Ensure that both valve and gearbox are set at “position 1” as per image 3 and image 4

Image 3

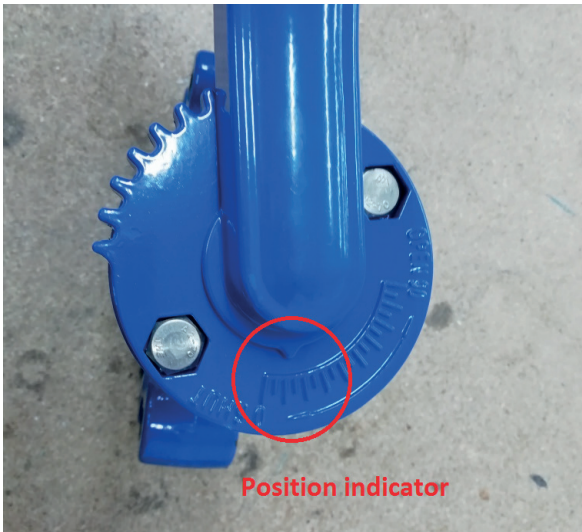


Image 4



6.3 Remove lever operation handle from valve as per image 5

6.4 Assemble gearbox to valve by removing and using pre fitted bolts and washers as per image 6 and image 7

Image 5

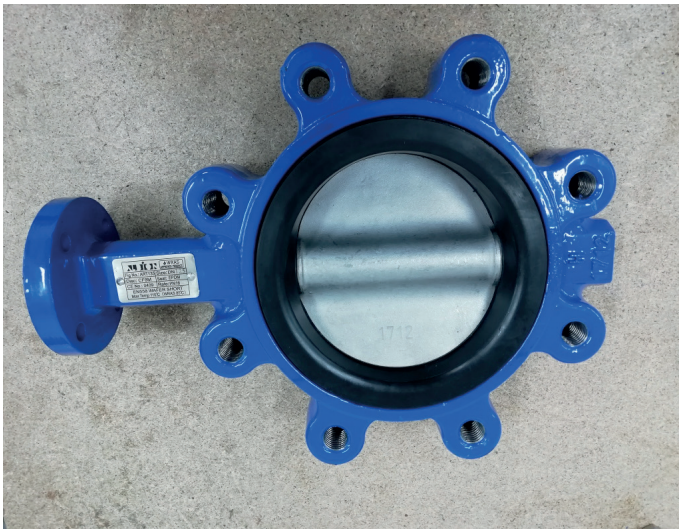


Image 6



Image 7



7.0 INSTRUCTIONS - Setting

7.1 The start and end position of the valve can be adjusted by using the setting adjustment screws that are located inside the gearbox as per image 8 and image 9. The setting screw nearest the handwheel can be used to adjust the closing position and the setting screw furthest away from the handwheel can be used to adjust the opening position.

Do not overtighten the screws when resistance is met.

Image 8

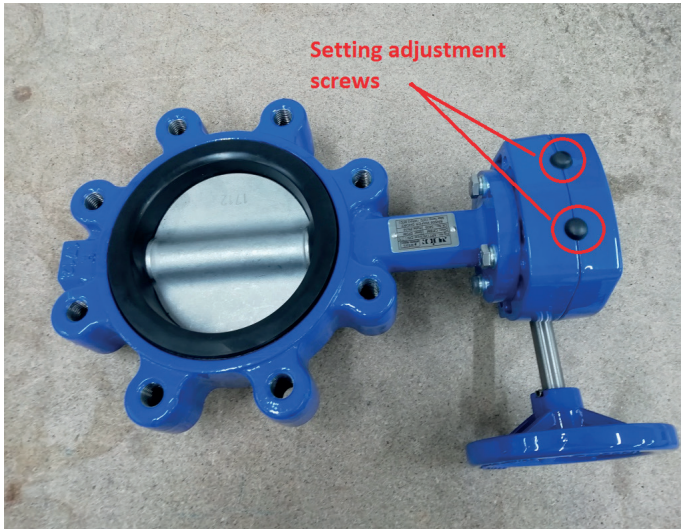


Image 9



7.2 Review the valve in both a fully open and fully closed position to ensure full and correct operation as per image 10 and 11

Image 10

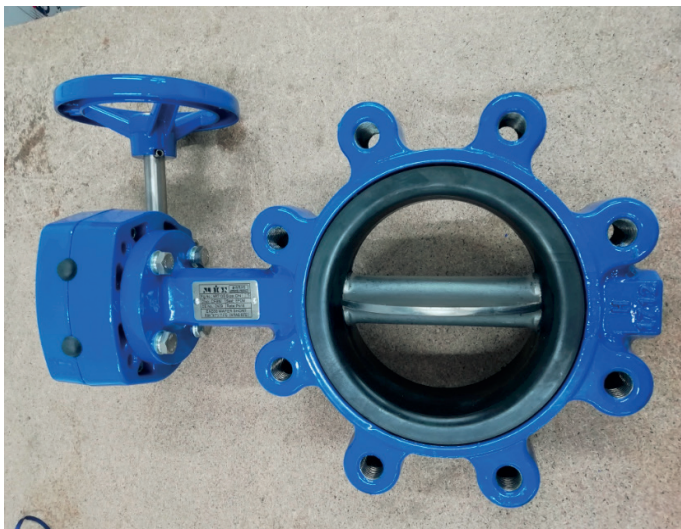
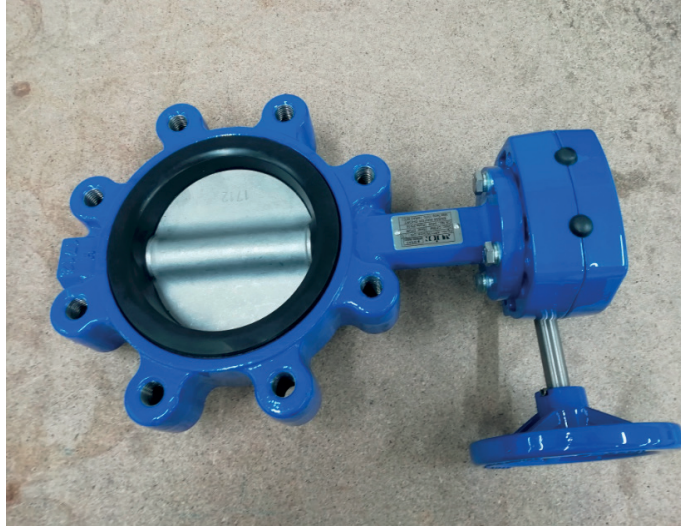


Image 11



7.3 Set the valve at position 1 for shipping as per image 12

Image 12



7.4 The valves can now be packed for shipment

AMBION



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