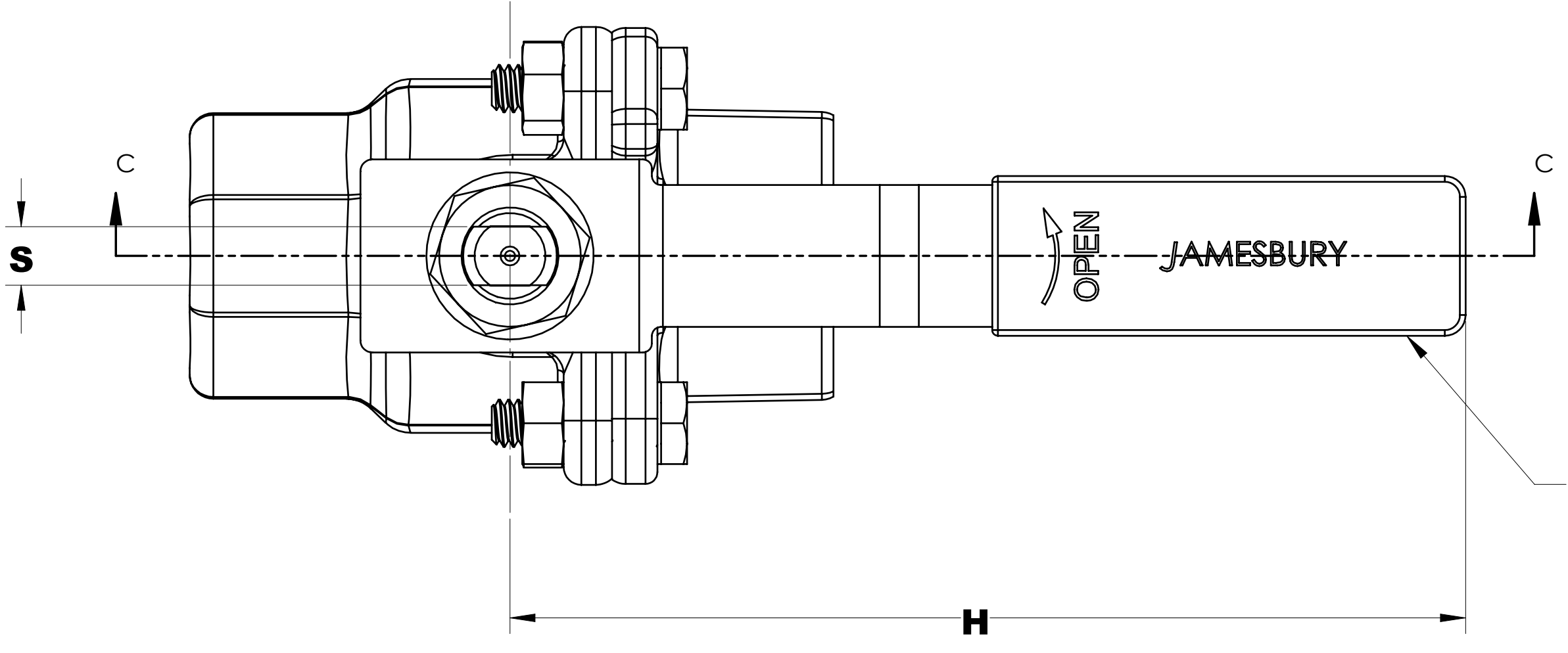


LET	ECN	REVISION	DRAWN	APPROVED	DATE
V	44371	REDRAWN IN SOLIDWORKS AND UPDATED BODY BOLT TORQUES	CQ	CPR	8/17/17

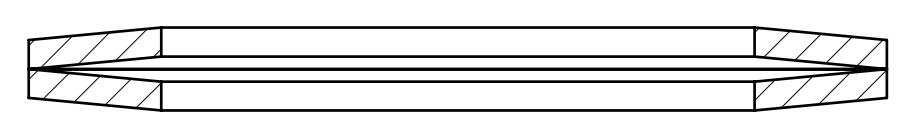
TABLE 1 BODY BOLT TORQUES		
VALVE SIZE	BOLT SIZE	ASSY TORQUE FT*LB
1/4 - 1	1/4-20	9-12
1 1/4	5/16-18	13-16
1 1/2 - 2	3/8-16	24-28

TABLE 2 NUT MATERAIL	
CODE	SPECIFICATION
20	ASTM A-194, GR 2H
22-24	CARBON STEEL
30	300 SERIES ST. ST'L
31	ASTM A-194 GP 8B, 8CB OR 8TB
71	QQ-N-286 CL. A OR B

TABLE 3 HANDLE NUT TORQUE	
VALVE SIZE	IN*LBS
1/4 - 3/4	30-40
1 - 1 1/4	70-80
1 1/2 - 2	160-170

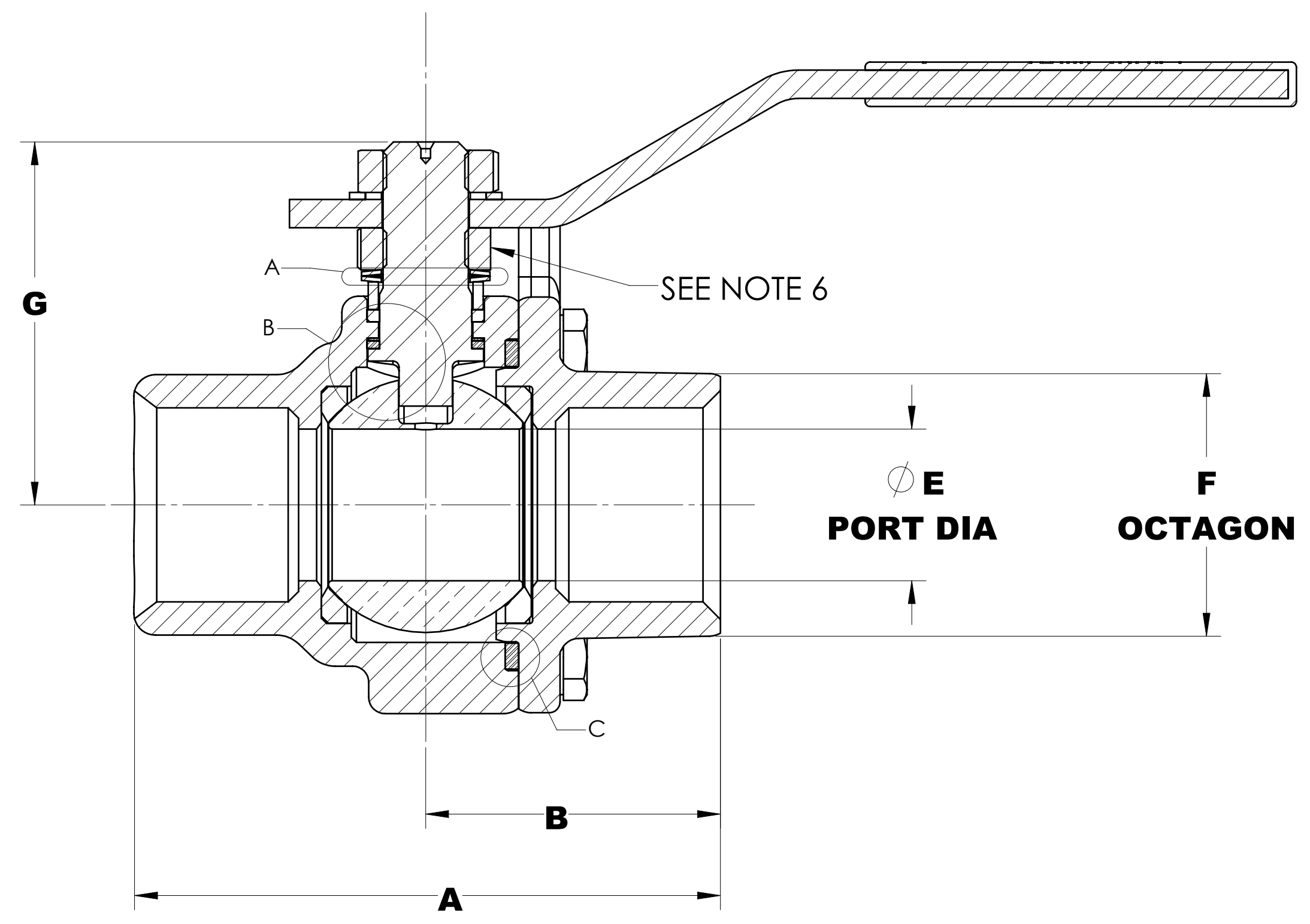


STAINLESS STEEL HANDLES TO BE USED FOR CHLORIDE SERVICE.

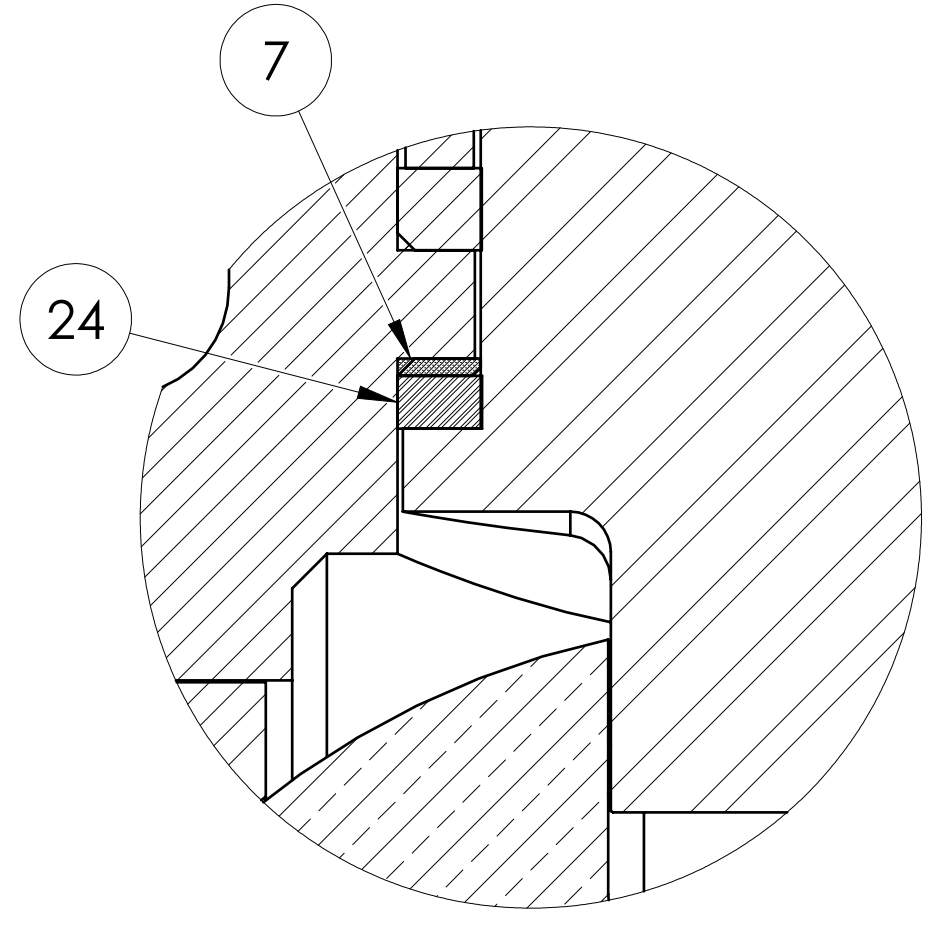


DETAIL A

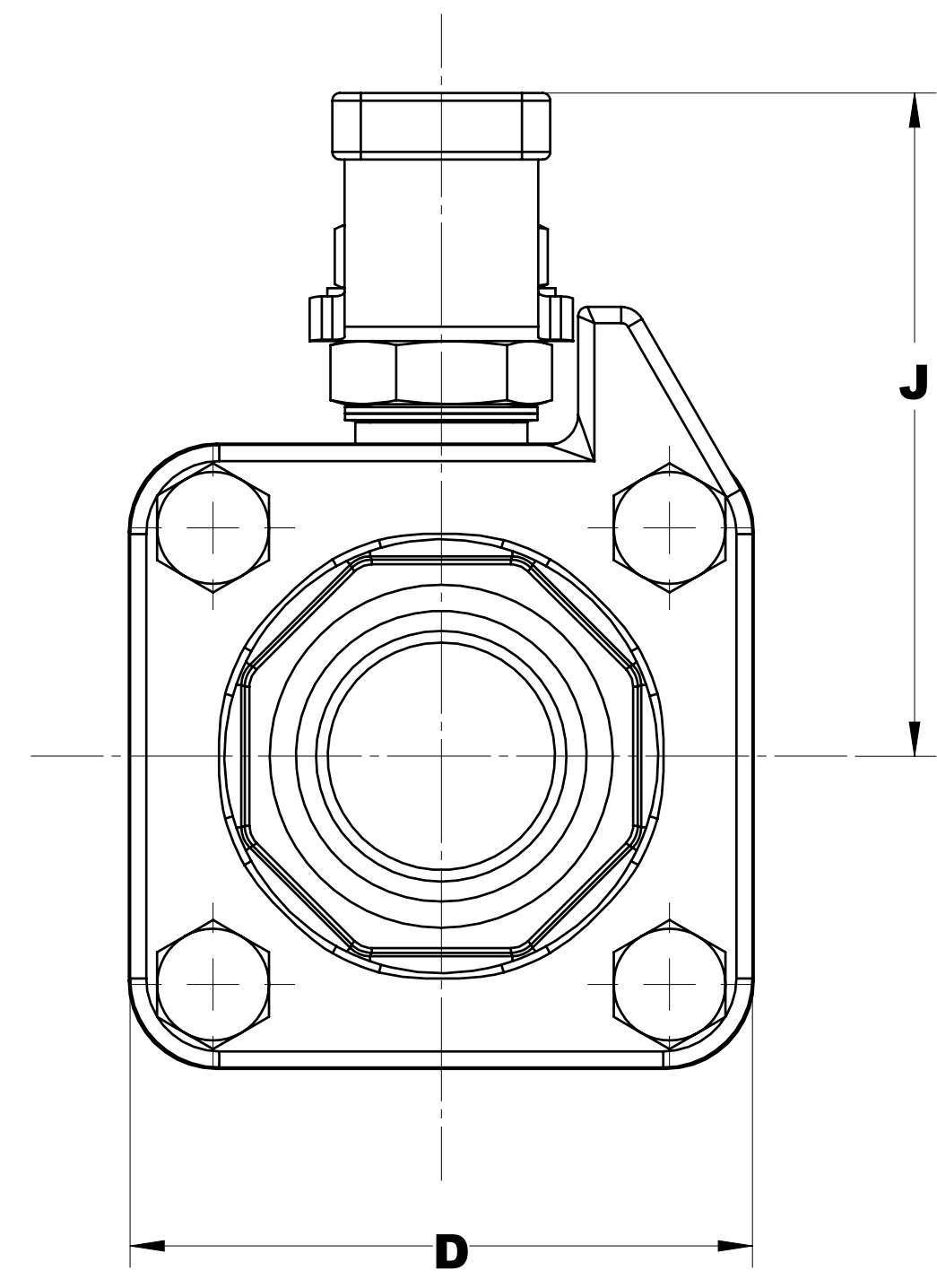
ASSEMBLE WITH SPRING WASHERS (31) AS SHOWN, THIGHTEN STEM NUT UNTIL WASHERS ARE NIOT USED, THIGHTEN NUT UNTIL THE STEM SEAL IS FULLY SEATED, THEN TIGHTEN THE NUT AN ADDITIONAL 0.25 TURN.



SECTION C-C

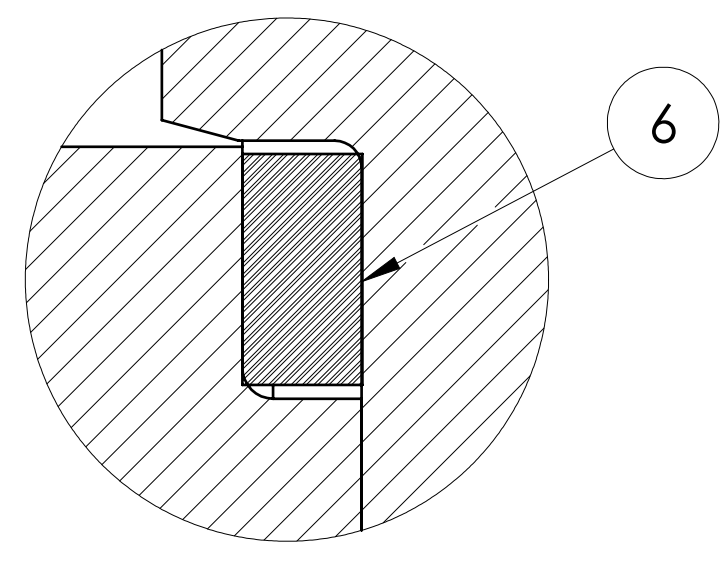


DETAIL B



\varnothing E
PORT DIA

F
OCTAGON



DETAIL C

NOMINAL DIMENSIONS - INCHES (TOL. \pm 0.0625)									
VALVE SIZE	A	B	D	E	F	G	H	J	S
1/4	2.5000	1.2500	1.8125	0.4375	1.0313	1.4688	4.0000	1.7813	0.1875
3/8	2.5000	1.2500	1.8125	0.5000	1.0313	1.4688	4.0000	1.7813	0.1875
1/2	2.5000	1.2500	1.8125	0.5000	1.0313	1.4688	4.0000	1.7813	0.1875
3/4	2.8125	1.4063	2.0000	0.6875	1.2500	1.6250	4.0000	1.9063	0.1875
1	3.4063	1.7031	2.4375	0.8750	1.5000	2.0938	5.0000	2.5000	0.3125
1 1/4	3.7500	1.8750	2.6875	1.0000	1.8750	2.2188	5.0000	2.6563	0.3125
1 1/2	4.0313	2.0156	3.2500	1.2500	2.1250	2.5938	6.0000	2.9688	0.3750
2	4.3750	2.1875	3.6250	1.5000	2.6250	2.7500	6.0000	3.1563	0.3750

NOTES:

1. VALVE TO BE ASSEMBLED PER JSA-01.
2. VALVE TO BE TESTED PER JST-02.
3. FOR INSTALLATION, MAINTENANCE AND OPERATING INSTRUCTIONS SEE IMO-11.
4. WHEN NUTS WITH RAISED MARKINGS ARE USED, ASSEMBLE WITH INDENTIFICATION VISIBLE.
5. ASTM A-193 GR. B8, B8C OR B8T ALL CLASS 2.
6. TORQUE STEM NUT TO 35 IN-LBS. PRIOR TO INSTALLATION OF HANDLE.

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UNLESS OTHERWISE NOTED DIMENSIONING, TOLERANCING, & DRAWING INTERPRETATION IS IN ACCORDANCE WITH ASME Y14.5M

ANGLES = \pm 5° FINISH $\sqrt{250}$ REMOVE SHARP EDGES AND CORNERS TO .02 - .03 RADIUS OR CHAMFER, DIMENSIONS IN INCHES.

SPECIFICATIONS TO BE USED IN CONJUNCTION WITH THIS DRAWING

MAKE FROM PART NO.

RESTRICTED

TITLE: ASSEMBLY 1/4" - 2" CLINCHER VALVE SERIES 2000 MODEL A

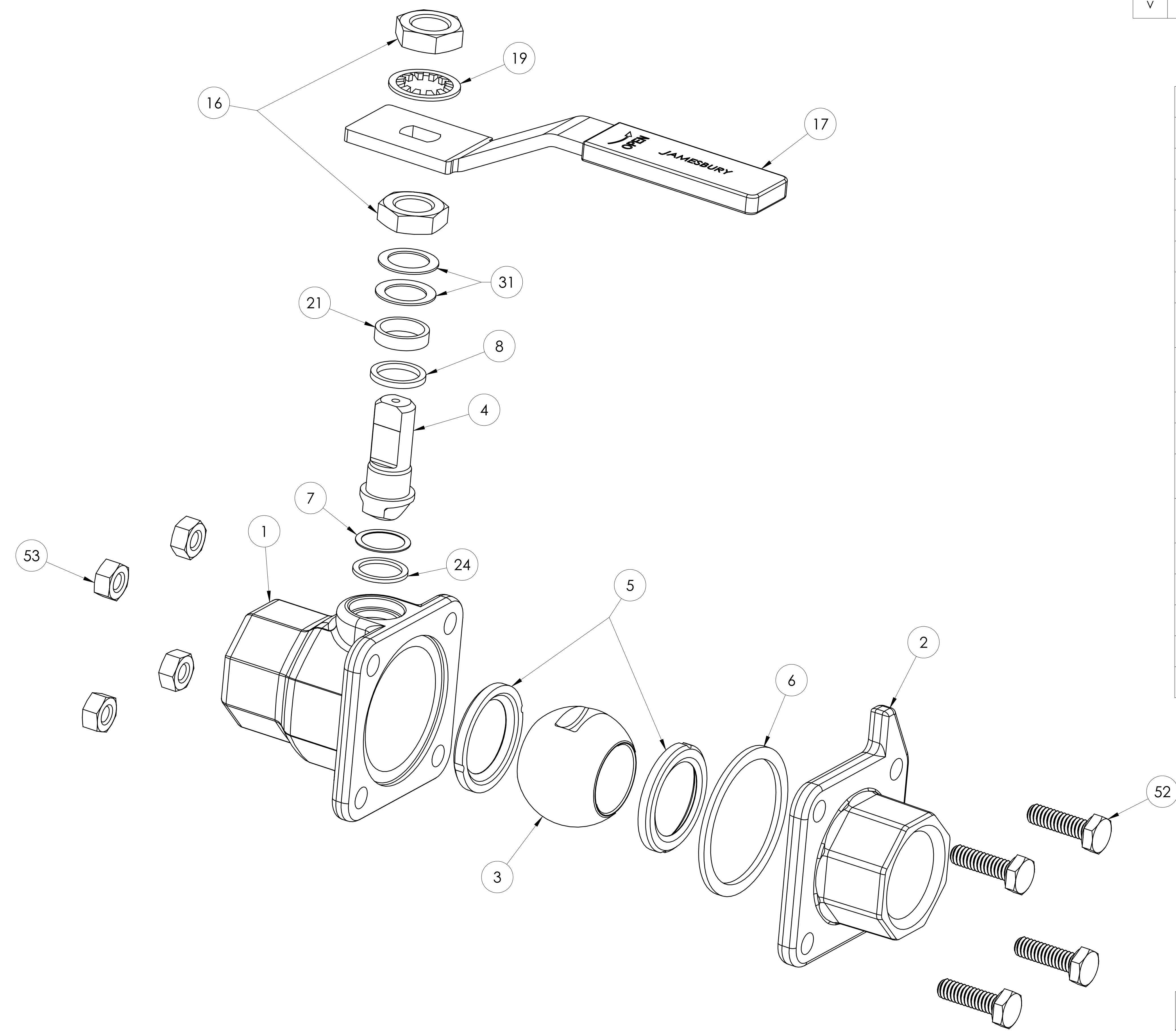
DRAWN: TP DATE: 5/8/75

APPVD: GRW DATE: 9/8/75

SIZE: D DWG NO: 3772 REV: V

SHREWSBURY, MASSACHUSETTS

LET	ECN	REVISION	DRAWN	APPROVED	DATE
V		REDRAWN IN SOLIDWORKS AND UPDATED BODY BOLT TORQUES	CQ	WP	



ITEM	DESCRIPTION	QTY.
1	BODY	1
2	BODY CAP	1
3	BALL	1
4	STEM	1
5	SEAT	2
6	BODY SEAL	1
7	SECONDARY STEM SEAL	1
8	UPPER STEM SEAL	1
16	STEM NUT	2
17	HANDLE	1
19	SHAKEPROOF WASHER	1
21	COMPRESSION RING	1
24	STEM BEARING	1
*31	SPRING WASHER	2
52	BODY BOLT	4
53	HEX NUT	4

*NOT USED ON 1/4 - 3/4 SIZES

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ANGLES = ±5° FINISH = 250 REMOVE SHARP EDGES AND CORNERS TO .02 - .03 RADIUS OR CHAMFER, DIMENSIONS IN INCHES.

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TITLE: ASSEMBLY 1/4" - 2" CLINCHER VALVE SERIES 2000 MODEL A

DRAWN: TP DATE: 5/8/75

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SIZE: D DWG NO: 3772 REV: V

metso SHREWSBURY, MASSACHUSETTS

SHEET 2 OF 2