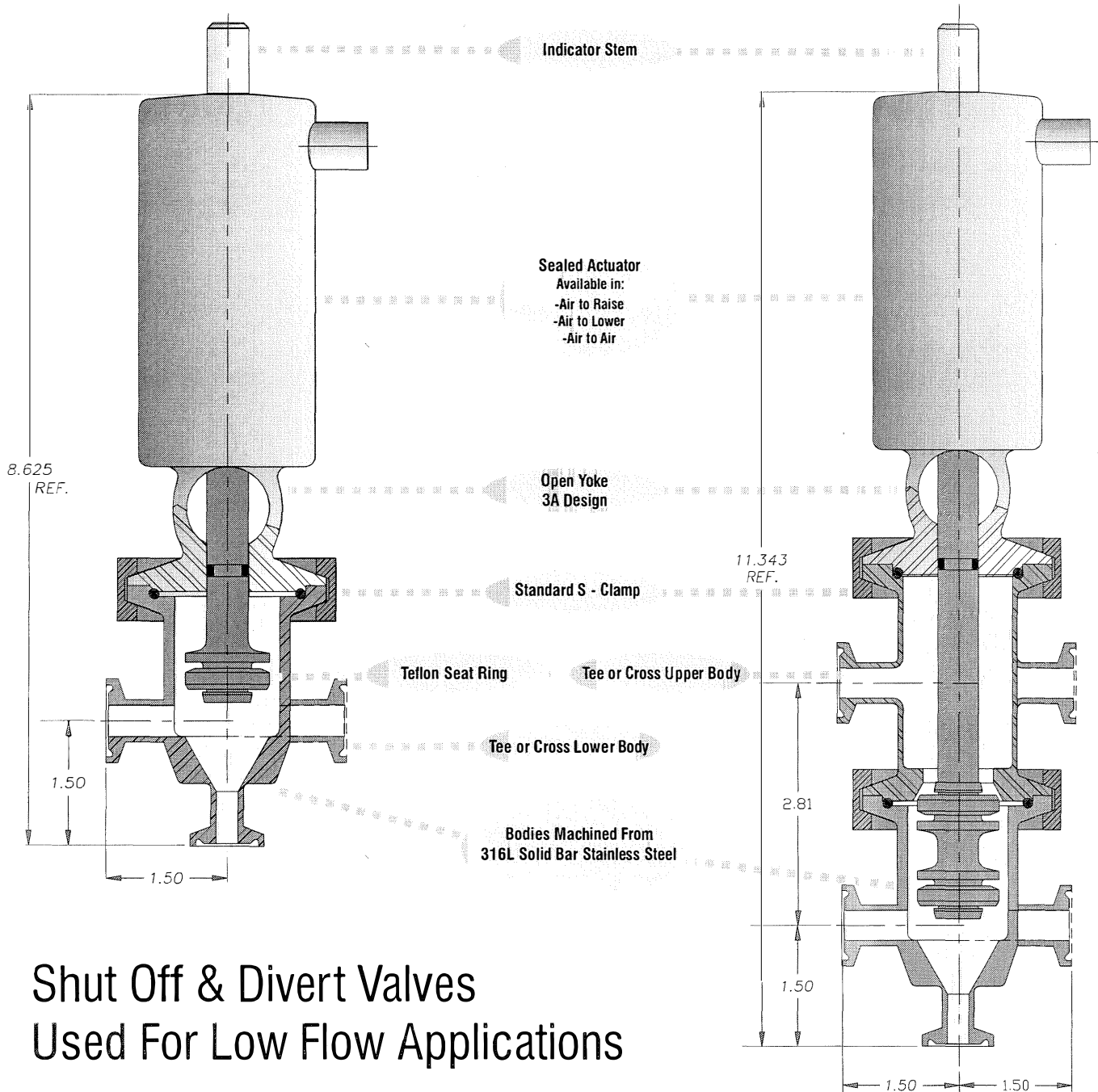


Waukesha Cherry-Burrell

FlowMaster Mini 1/2 and 3/4 inch Valves



Shut Off & Divert Valves
Used For Low Flow Applications



**Waukesha
Cherry-Burrell**



(417) 881-6114
cs@fandh.com
WWW.FANDH.COM



Fractional Air Valves. Series K67 & K67-7. 1/2- 3/4" Stem Removal.

These valves have "sealed" actuators. This means that the actuator is welded shut at the factory. There are no customer maintainable parts in this actuator.

These valves have "Self Coupling" stems.

There are no threads or clips to contend with when coupling the stem to the actuator.

The procedure is as below;

To replace/remove the stem.

For an AR actuator.

1. Apply air to lift the stem off the valve seat.
2. Remove the body clamp & take off the body.
3. Release the air, allowing the actuator to push the stem down, this causes the stem to "over travel" since the body is not there to stop it, and uncouples the stem from within the actuator.
4. The stem can now be pulled from the actuator.
5. To replace the stem, apply air to the actuator.
6. Insert the stem into the act. Leave the air on.
7. Put the body and clamp back on.
8. Then release the air which will push the stem down and when the stem hits the valve seat, the stem will self couple.

Your valve is now ready to be put back into service.

For an AL actuator.

1. Remove the body and clamp.
2. Apply air to the actuator while holding the stem, as the actuator piston moves all the way down, it will self uncouple and the stem will come off in your hand
3. To replace the stem, apply air to the actuator to move the piston all the way down which will allow the stem to be inserted.
4. With the stem inserted, slowly release the air while holding the stem in. The internal self coupler will now hold the stem.
5. Replace the body and clamp and your valve is ready.

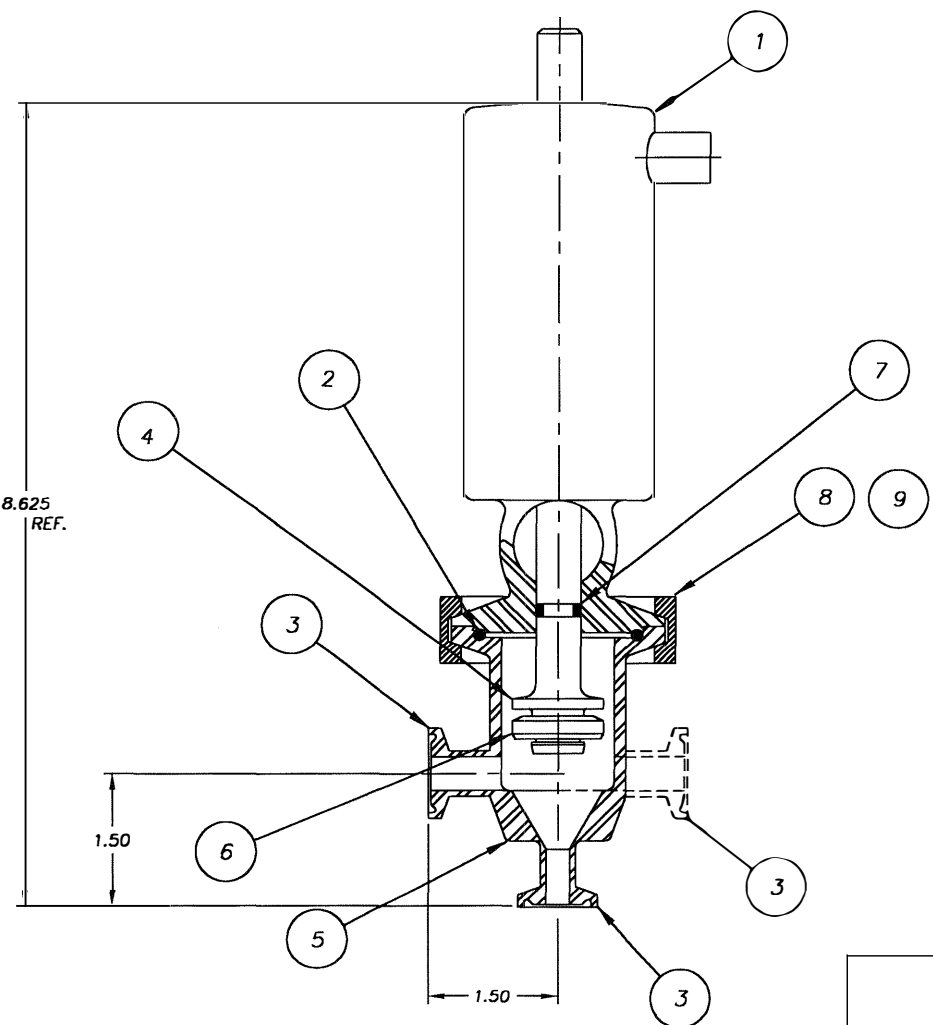
For Divert valves. AR or AL

The instructions above also apply to the divert valves.

The upper body does not have to be removed to perform any of the operations.

Until we can include this with each valve, please fax it to the customer upon order placement.

DRAWING AT FULL SCALE, PLOT AT 0.750=1!!!



ITEM	DESCRIPTION	QTY.
1	ACTUATOR	1
2	O-RING	1
3	S-LINE CONNECTION	AR
4	STEM	1
5	BODY	1
6	SEAT RING	AR
7	O-RING	1
8	CLAMP	1
9	WING NUT	AR

- 1. STANDARD AIR ACTUATOR SHOWN. ALL ACTUATOR ASSEMBLIES, STANDARD, MICROSWITCH, ETC., ASSEMBLE TO THE VALVE THE SAME AS STANDARD.
- 2. APPLY MODEL AND SERIAL NUMBER LABEL TO SIDE OF ACTUATOR CYLINDER.
- 3. TEE BODY SHOWN AS STANDARD, SEE DRAWING 112-1265X FOR DETAILS ON END CONNECTIONS, WELDING, AND FINISH, IF NECESSARY.
- 4. CROSS BODY SHOWN AS OPTION, SEE 112-1363X FOR DETAILS ON END CONNECTIONS, WELDING, AND FINISH, IF NECESSARY.
- 5. TEF-FLOW SEAT SHOWN AS STANDARD SEE SPEC169 FOR SEAT RING INSTALLATION DETAILS.
- 6. SEE SPEC171 FOR PERFORMANCE TEST DETAILS.



Waukesha
Cherry-Burrell

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PART NUMBER
115424

W05752 6/19/01 SB RELEASE

ECO NO.	DATE	BY	DESCRIPTION

TITLE
**VALVE ASSEMBLY - SHUT-OFF
67 1/2" & 3/4" TEF-FLOW SEAT**

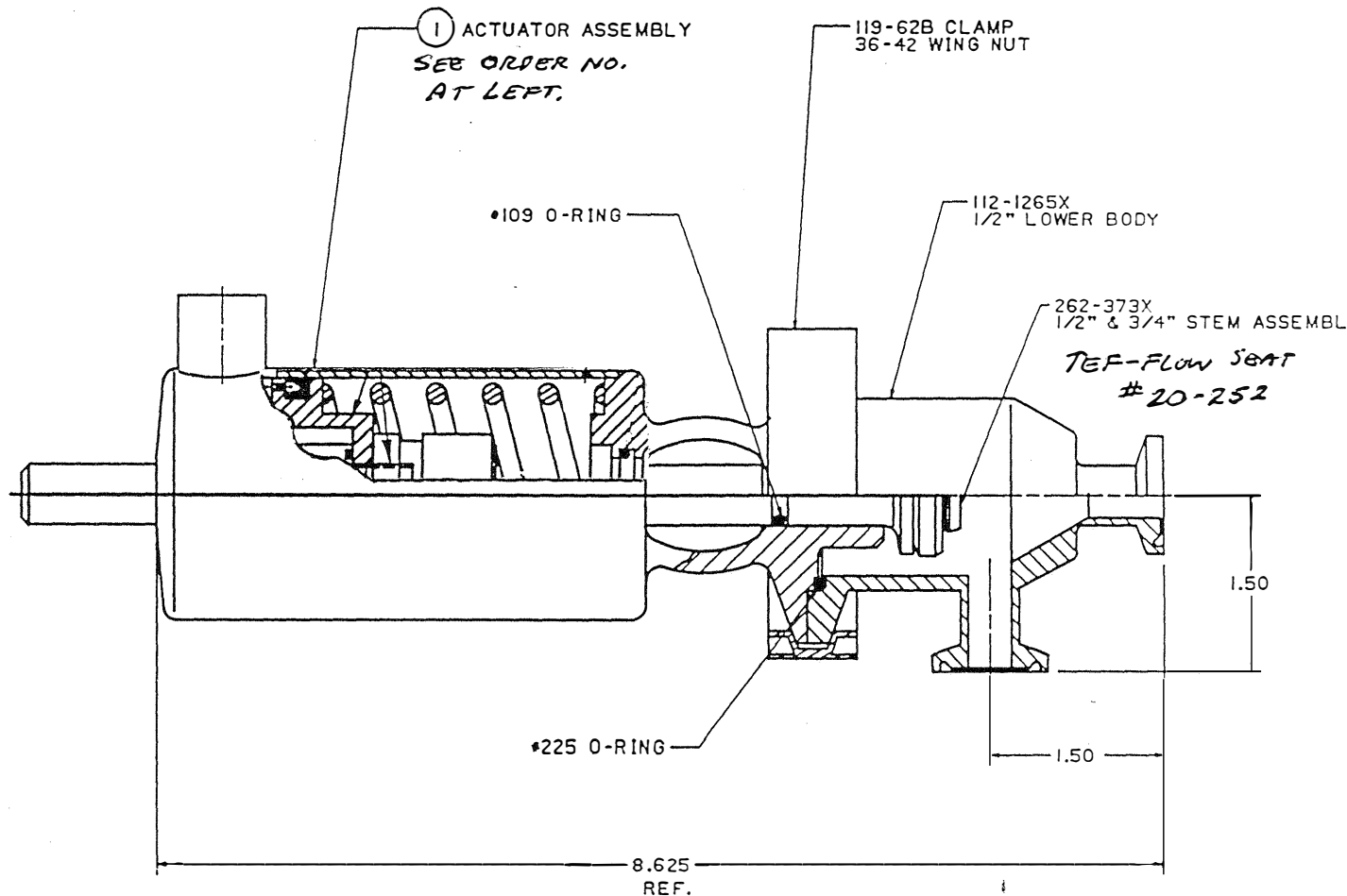
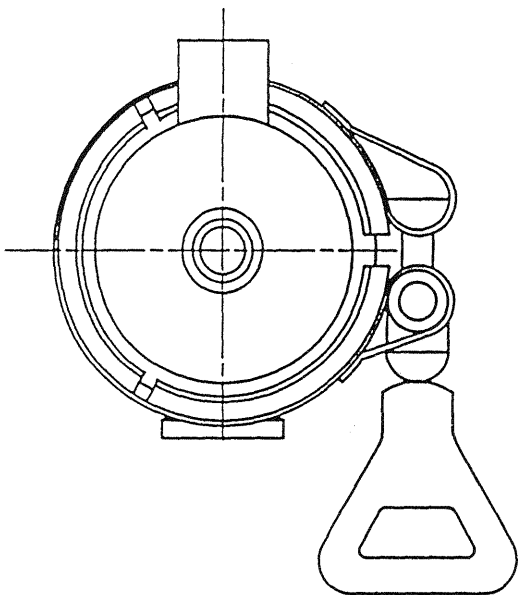
MATERIAL —

DRAWN SB	APPV'D	OWG. SIZE	REV LEVEL
DATE 6/19/01	DATE	B	0

Unless otherwise specified, dimensions are in inches and tolerances are as follows: Angles: ±1° Inside Radius: .031
Finish: 125Ra Remove sharp edges and burrs
Decimals: XX= ±.015 XXX= ±.005 Fractions: ±.015

SHEET 1 OF 1

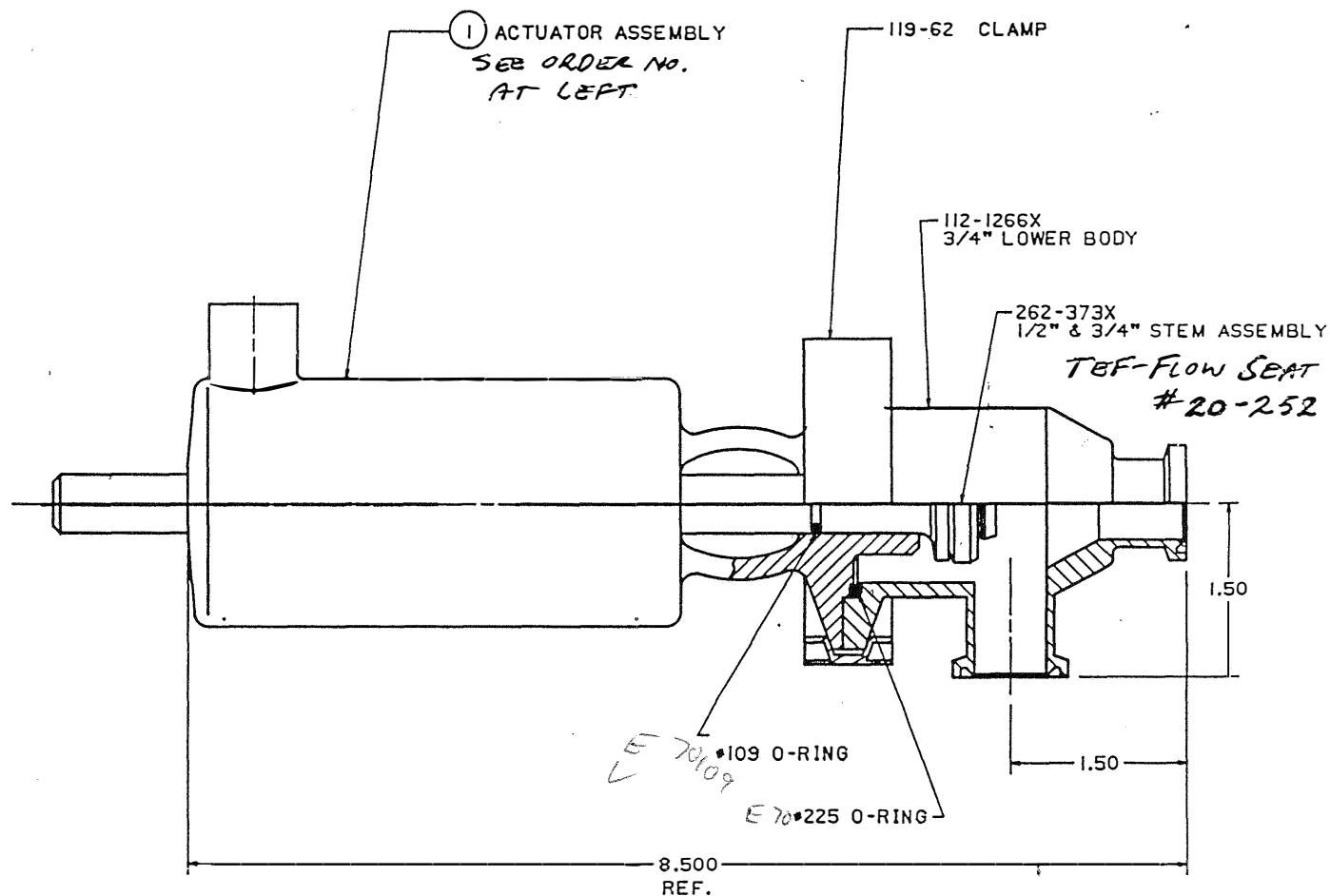
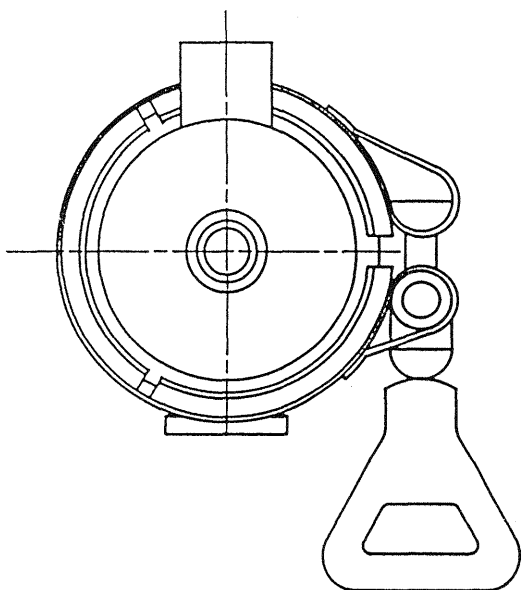
AIR TO LOWER	256-96L
AIR TO RAISE	256-96R
AIR TO AIR	256-96A



*Buna	*Viton	*Silicone	*EPDM
N70109	V70109	S70109	E70109
N70225	V70225	S70225	E70225

SCALE				FULL				THIS DOCUMENT CONTAINS PROPRIETARY INFORMATION AND IS THE PROPERTY OF SUPERIOR STAINLESS. AND IS NOT TO BE DISCLOSED, REPRODUCED IN WHOLE OR IN PART, OR USED FOR MANUFACTURE BY ANYONE OTHER THAN SUPERIOR STAINLESS WITHOUT ITS WRITTEN CONSENT. THIS DOCUMENT IS SUBJECT TO ACTIVITY TO SUPERIOR STAINLESS WHEN RELEASED.			
MATERIAL				316L SS							
1/2" K67 WITH TEF-FLOW SEAT											
DR. DISRUD				CK. RICHARDSON		AP. DA.		DATE 5-18-8			
O E.G. 7/16/80				RELEASED FOR PRODUCTION				DRAWING NO.			
LET. CHANGE ORDER				DATE		DESCRIPTION		312-1265			
UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES AND TOLERANCES ARE AS FOLLOWS: FINISH: 32 RMS (REMOVE SHARP EDGES AND BURRS) FRACTIONS: +/- .015 ANGLES: +/- 1/2 DEG. RADII: .015 DECIMALS: XX* +/- .031 XXX* +/- .015 XXXX* +/- .005											
SUPERIOR STAINLESS				INFORMATIONAL							

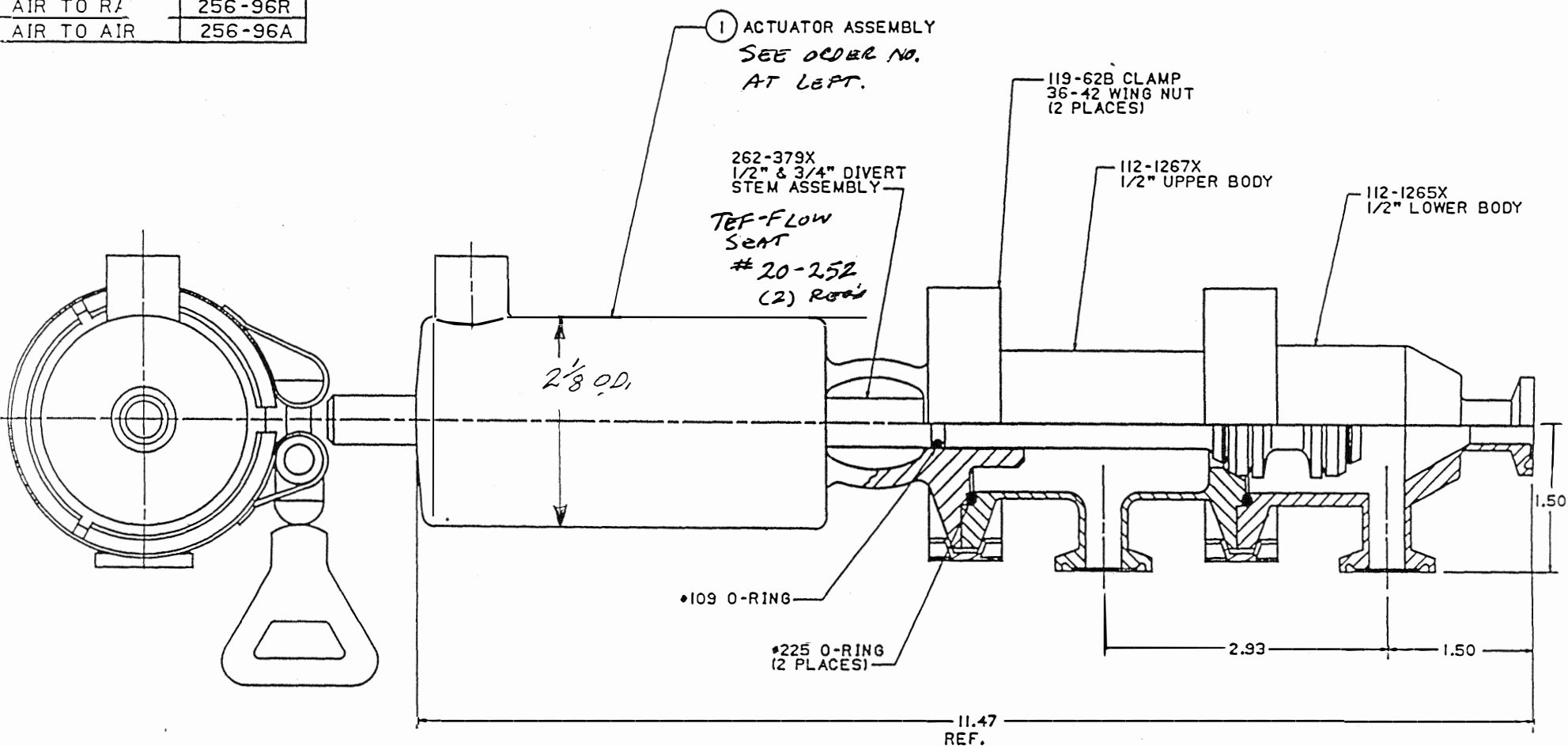
TYPE	I
AIR TO LOWER	256-96L
AIR TO RAISE	256-96R
AIR TO AIR	256-96A



*Buna	*Viton	*Silicone	*EPDM
N70109	V70109	S70109	E70109
N70225	V70225	S70225	E70225

SCALE		FULL	
MATERIAL		316L SS	
3/4" K67 WITH TEF-FLOW SEAT			
0 E.G. 7/16/79 RELEASED FOR PRODUCTION		DATE 7-18-82	
DESCRIPTION		DRAWING NO.	
UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES AND TOLERANCES ARE AS FOLLOWS: FINISH: 32 RMS (REMOVE SHARP EDGES AND BURRS) FRACTIONS: +/- .015 ANGLES: +/- 1/2 DEG. RADII: .015 DECIMALS: X +/- .031 XX +/- .015 XXX +/- .005		SUPERIOR STAINLESS AUSCA INDUSTRIAL	
		312-1266	

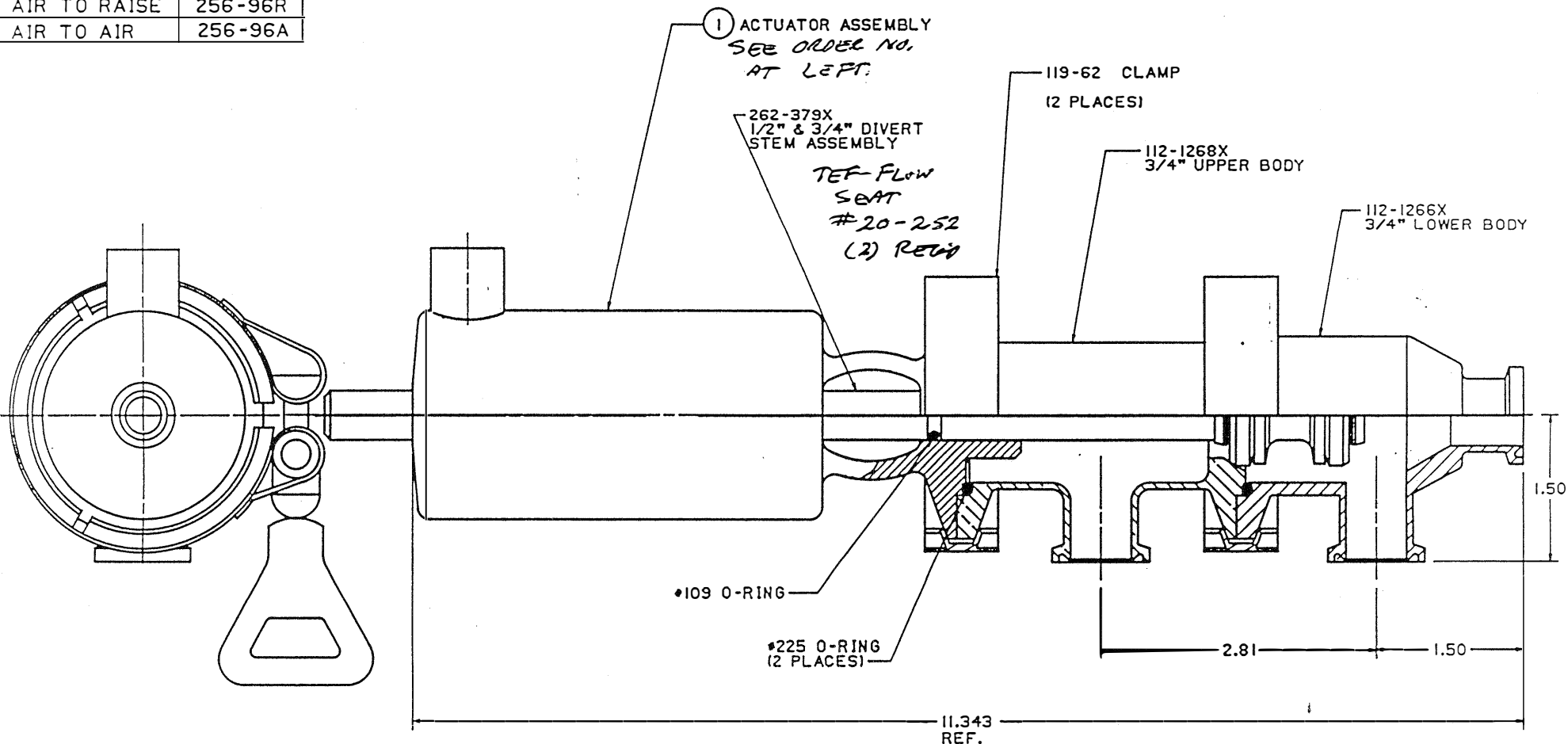
AIR TO LO	256-96L
AIR TO R/	256-96R
AIR TO AIR	256-96A



<u>*Buna</u>	<u>*Viton</u>	<u>*Silicone</u>	<u>*EPDM</u>
N70109	V70109	S70109	E70109
N70225	V70225	S70225	E70225

SCALE		FULL	
MATERIAL		316L SS	
1/2" K67-7 WITH TEF-FLOW SEAT			
0	E.G. 7/10/80	RELEASED FOR PRODUCTION	
DATE	DESCRIPTION	DR. RICHARDSON	CK. RICHARDSON
DATE	DESCRIPTION	AP. DA.	DATE 11-2-89
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES AND TOLERANCES ARE AS FOLLOWS: FINISH: 32 RMS (REMOVE SHARP EDGES AND BURRS) FRACTIONS: +/- .015 ANGLES: +/- 1/4 DEG. ROUNDS: .015 DECIMALS: XX +/- .031 XXX +/- .015 XXXX +/- .005		 SUPERTOR STAINLESS AUSTENITIC STAINLESS STEEL	
		DRAWING NO. 312-1267	

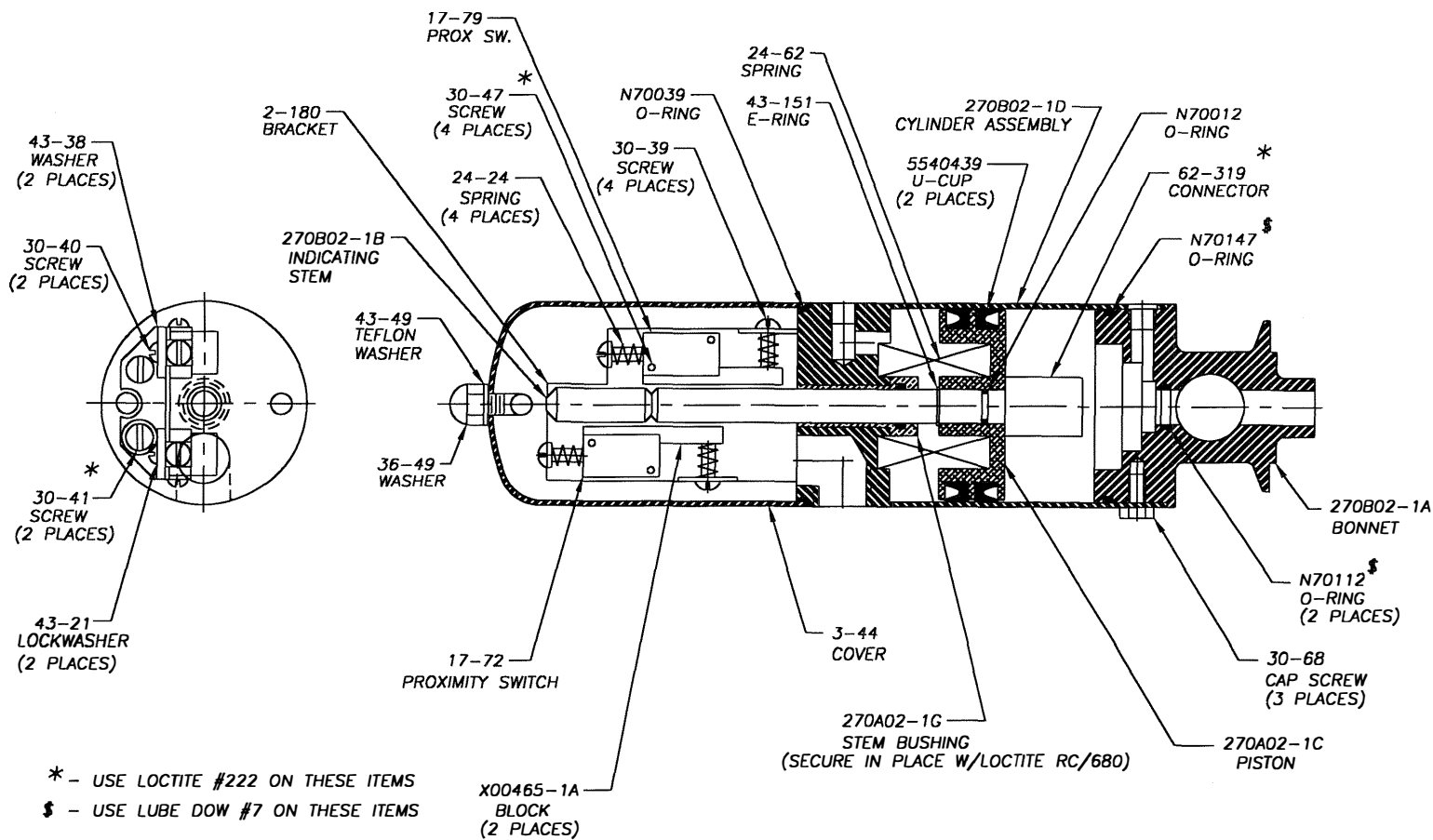
TYPE	I
AIR TO LOWER	256-96L
AIR TO RAISE	256-96R
AIR TO AIR	256-96A



<u>*Buna</u>	<u>*Viton</u>	<u>*Silicone</u>	<u>*EPDM</u>
N70109	V70109	S70109	E70109
N70225	V70225	S70225	E70225

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MATERIAL 316L SS			
3/4" K67-7 WITH TEF-FLOW SEAT			
O E.G. 7/16/80 RELEASED FOR PRODUCTION		DR. DISRUD CK. RICHARDSON AP. DA. DATE 5-19-89	
LET ORDER	DATE	DESCRIPTION	
UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES AND TOLERANCES ARE AS FOLLOWS: FINISH: 32 RMS (REMOVE SHARP EDGES AND BURRS) FRACTIONS: +/- .015 ANGLES: +/- 1/2 DEG. RADIUS: .015 DECIMALS: X +/- .031 XX +/- .015 XXX +/- .005		 SUPERIOR STAINLESS ALSCA CERTIFIED SPECIAL	
		DRAWING NO. 312-1268	

DRAWING AT FULL SCALE, LOT AT 1.1250=1!!!



NOTE:

RUN WIRES OF 17-72 & 17-79 SWITCHES OUT OF 1/2" N.P.T. OPENING.

CAD DRAWING
DO NOT SCALE OR MANUALLY CHANGE

PART NUMBER
X07070-1

Information contained herein is confidential and must not be copied or disclosed in any form without the written authorization of Waukesha Cherry-Burrell.

TITLE
ACTUATOR 1/2" AR W/2 PROX

10/31/00		SB	RELEASE
ECO NO.	DATE	BY	DESCRIPTION
Unless otherwise specified, dimensions are in inches and tolerances are as follows: Angles: ±1° Inside Radius: .031 Finish: 125Ra Remove sharp edges and burrs Decimals: XX= ±.015 XXX= ±.005 Fractions: ±.015			

MATERIAL	DRAWN	SB	APP'D	DATE	DWG. SIZE	REV. LEVEL
	DATE 10/31/00				C	0