

# Assembly Instructions

## Quadax Series Butterfly Valves

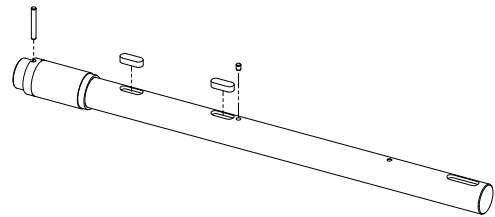
Version May 2011

This assembly instructions are only a draft to remind the order of assembly of a standard valve. Any special special versions, options or special applications cause a different assembly than for the standard valve. Only trained and authorized personnel is allowed to assemble a Quadax butterfly valve, otherwise co-ax ag will refuse any liability.

---

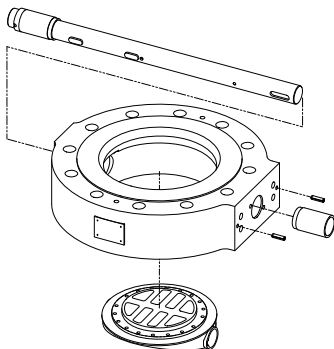
### Pre-assemble shaft

- Mount pin
- Mount keys
- Mount bushing
- Mount retaining ring
- Insert holding pin



---

### Assemble disc

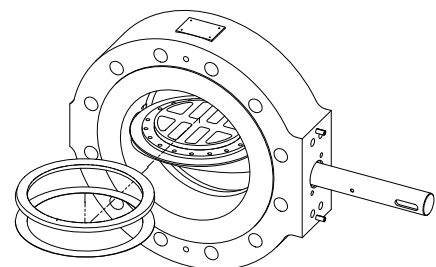


- Key way in disc must be on the type plate side
- Insert disc in body
- Install preassembled shaft in body, leading in through the shaft hole of the disc
- Install upper bushing
- Push shaft in until stop
- Insert pins on the upper part of the body

---

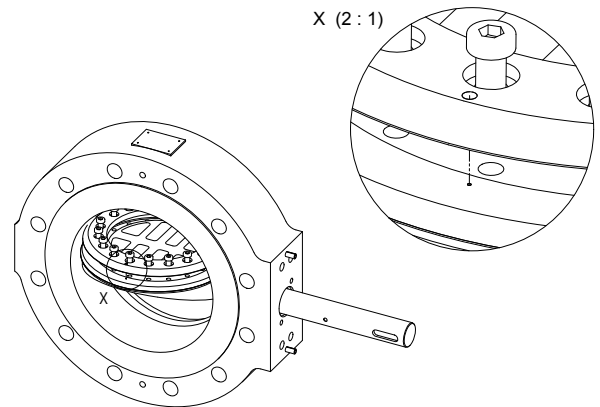
### Assemble lamel

- Place lamination seal on disc
- Place lamel on lamination seal

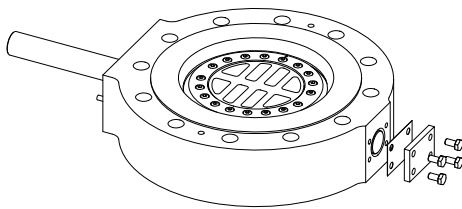


### Clamping ring assembly

- Adjust lamination on both sides so that the marking on the lamel, the disc and the clamping ring match (see detail x in the magnification)
- Place the clamping ring on the lamination
- Insert clamping ring screws and lightly tighten by hand with lowest torque
- Slightly close the valve and allow the lamination to find the right position
- Slightly tighten clamping ring screws



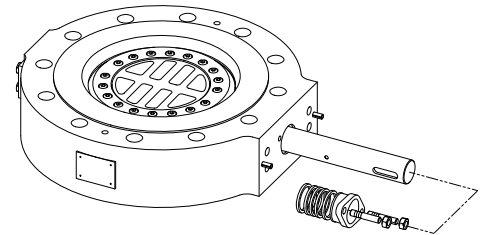
### Lid assembly



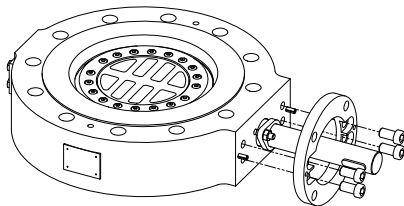
- Place the cover gasket on the cover plate
- Fasten cover plate to body with screws
- Tighten screws with specified torque

### Assemble stuffing box packing

- Insert graphite wound
- Use three massive graphite rings
- Insert graphite ring
- Insert stuffing box follower
- Insert studs into body
- Alternatively Belleville springs below nuts
- Tighten nuts with specified torque



### Assemble assembly ring



- Place assembly ring onto pins
- Install screws and tighten with specified torque

### Tighten clamping ring screws

- Mount actuator and close valve at low torque
- Cross clamping ring screws and tighten slightly
- Open valve
- Tighten clamping screw at torque spec.
- Close valve
- Tighten clamping screws