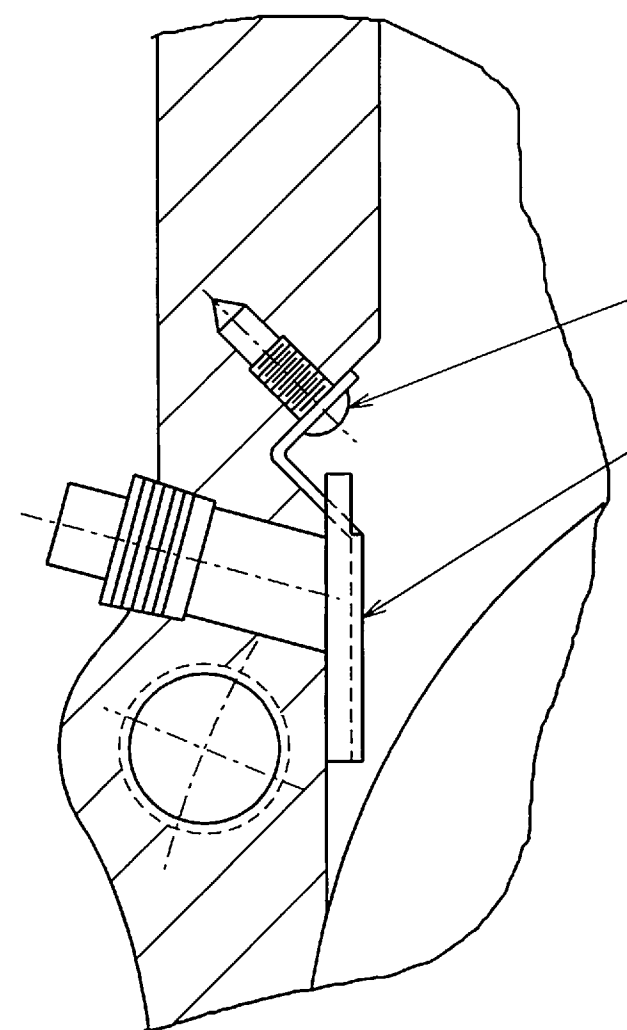


5-1918-38-

	VALVE TYPE	BLADE MATERIAL	BODY PART NUMBER	BLADE PART NUMBER	PACKING ARRANGEMENT	INCLUDES PARTS MARKED
	1 BRANCHLINE	304 SS	5-191808-2	3-190570-0-1	#1 SEE DETAIL-5 FOR PART NUMBER AND QUANTITY	<input type="checkbox"/>
	2 BRANCHLINE	316 SS	5-191808-2	3-190570		
	3 CROSSOVER	304 SS	5-191808-3	3-191803-5-1		
	4 CROSSOVER	316 SS	5-191808-3	3-191803-5		
F.P.O.	5 BIN ISOLATION	304 SS	5-191808-2	3-190570-0-1	#2 SEE DETAIL-5 FOR PART NUMBER AND QUANTITY	<input checked="" type="checkbox"/>
	6 BRANCHLINE	304 SS	5-191808-2	3-190570-0-1		<input type="checkbox"/>
	7 BRANCHLINE	316 SS	5-191808-2	3-190570		
	8 CROSSOVER	304 SS	5-191808-3	3-191803-5-1		
	9 CROSSOVER	316 SS	5-191808-3	3-191803-5		



DETAIL 4

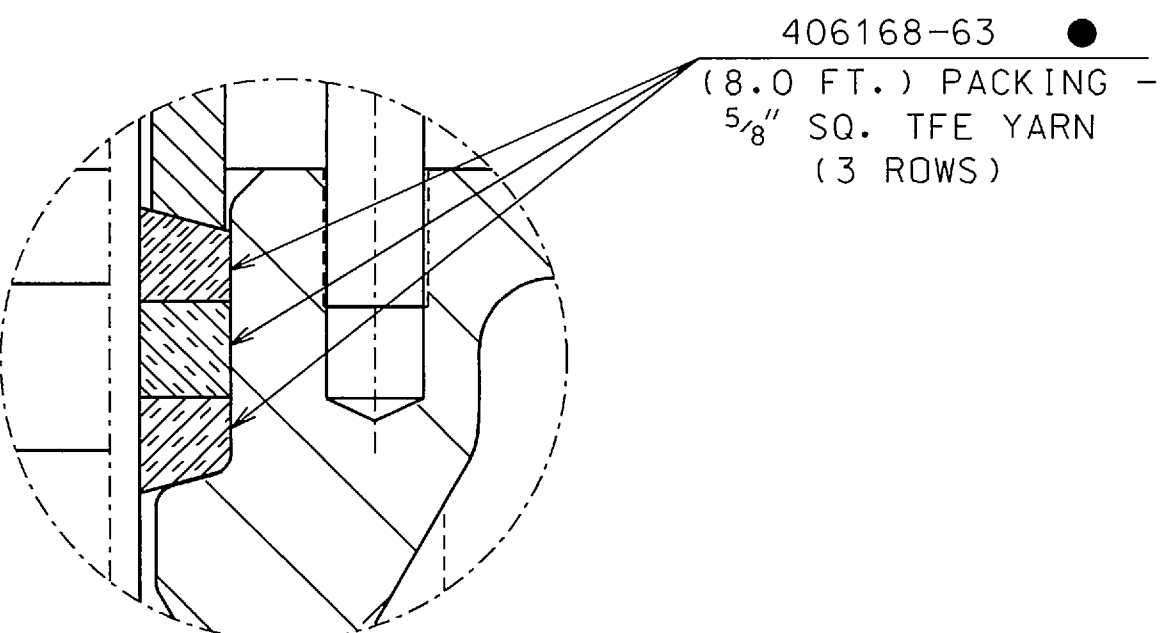
PURGE AIR DEFLECTOR
INSTALLATION
(TYPICAL BOTH SIDES OF BODY)

NOTE 4

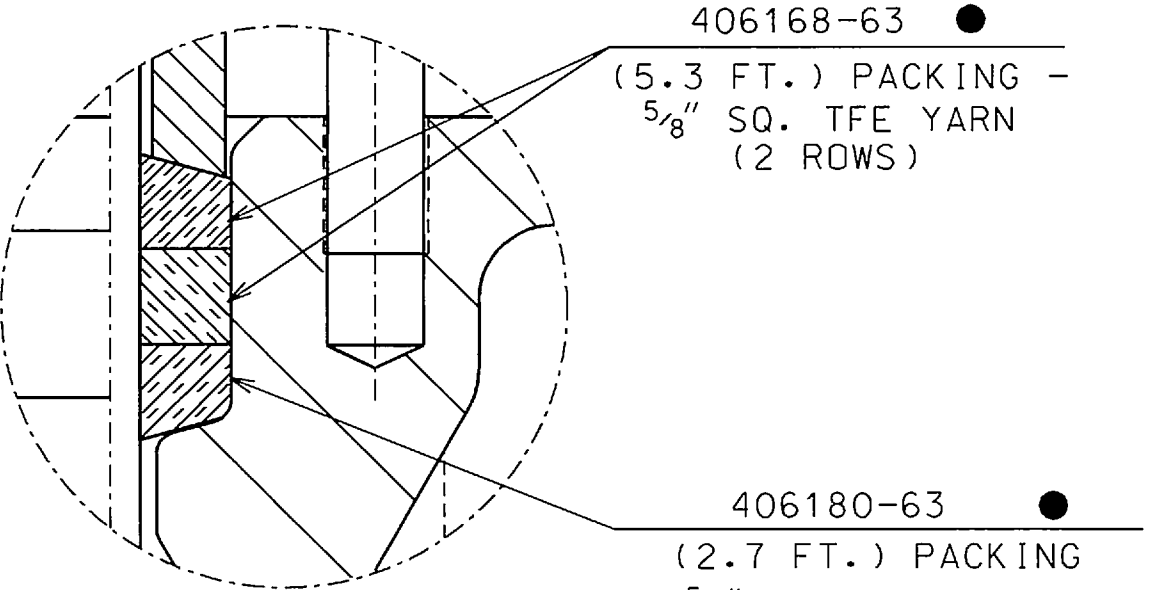
46192-0250-0038
(2) SCREW-BTHC 1/4"-20
UNC X 3/8" LG
1-191835-1

(2) DEFLECTOR-PURGE AIR

NOTE 1



ARRANGEMENT #1



ARRANGEMENT #2

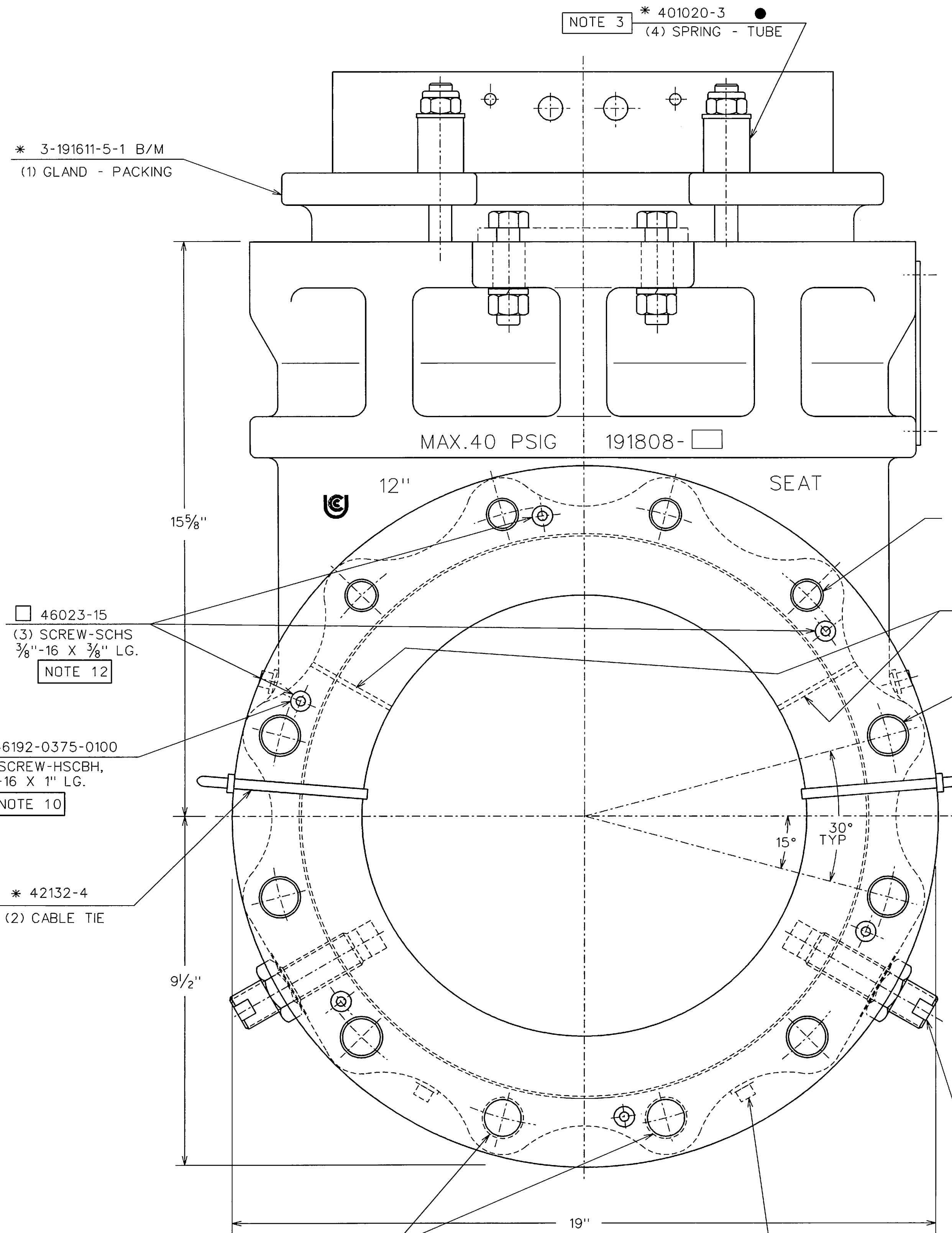
DETAIL 5

PACKING ARRANGEMENT

* 46188-0625-0250
(4) SCREW-HHC, 5/8-11
X 2 1/2" LG., CS/ZINC
* 46301-625-1
(4) NUT-HEX, 5/8"-11
CS/ZINC
* 46289-625-1
(4) WASHER-LOCK, 5/8"
CS/ZINC

* SK-460417-7
(4) STUD- 5/8"-11
* 460395-5
(4) NUT-LOCK, NYLON
INSERT, 5/8"-11
* 46255-14-1
(4) WASHER-PLAIN, SAE
5/8", CS/ZINC

NOTE 4



NOTE 11
(1) NAMEPLATE-CAUTION
46022-2
(2) SCREW-DRIVE TYPE
"U" #6 X 3/8" LG.

(4) 7/8"-9 UNC TAPPED 5/8" DEEP HOLES
IN BODY SPACED AS SHOWN ON A 17" B.C.
STRADDLING CENTERLINES
TYP. BOTH SIDES

NOTE 13

FOR BIN ISOLATION VALVES ONLY
(6) 1" DIA. THRU HOLES
SPACED AS SHOWN
ON A 17" B.C.
STRADDLING CENTERLINES
FOR ALL OTHERS:
(8) 1" DIA. THRU HOLES
SPACED AS SHOWN
ON A 17" B.C.
STRADDLING CENTERLINES

* 1-191834
(1) PLATE-SEAT
RETENTION
NOTE 9

* 462020-08-1200-3
(2) STUD - FULLY
THREADED 1/8"-9X12" LG.
NOTE 7

(2) WEDGE PINS, (2) JAM NUTS
AND (2) TAPPED HOLES ARE
NOT SUPPLIED ON CROSSOVER
VALVES.

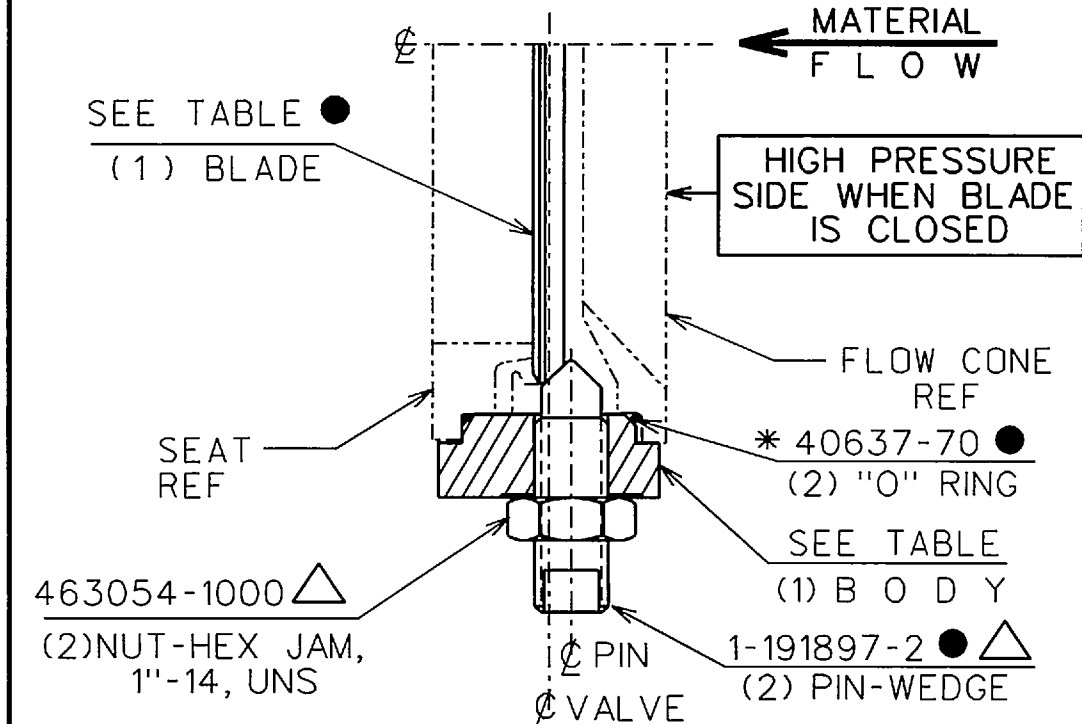
* 17732-3
(4) PLUG-PIPE, 3/8" NPT
NOTE 8

FOR BIN ISOLATION VALVES ONLY
(2) 1/8"-9 UNC TAPPED HOLES IN
3/8" THK. SEAT RETENTION PLATE
SPACED AS SHOWN ON A 17" B.C.
STRADDLING CENTERLINE.

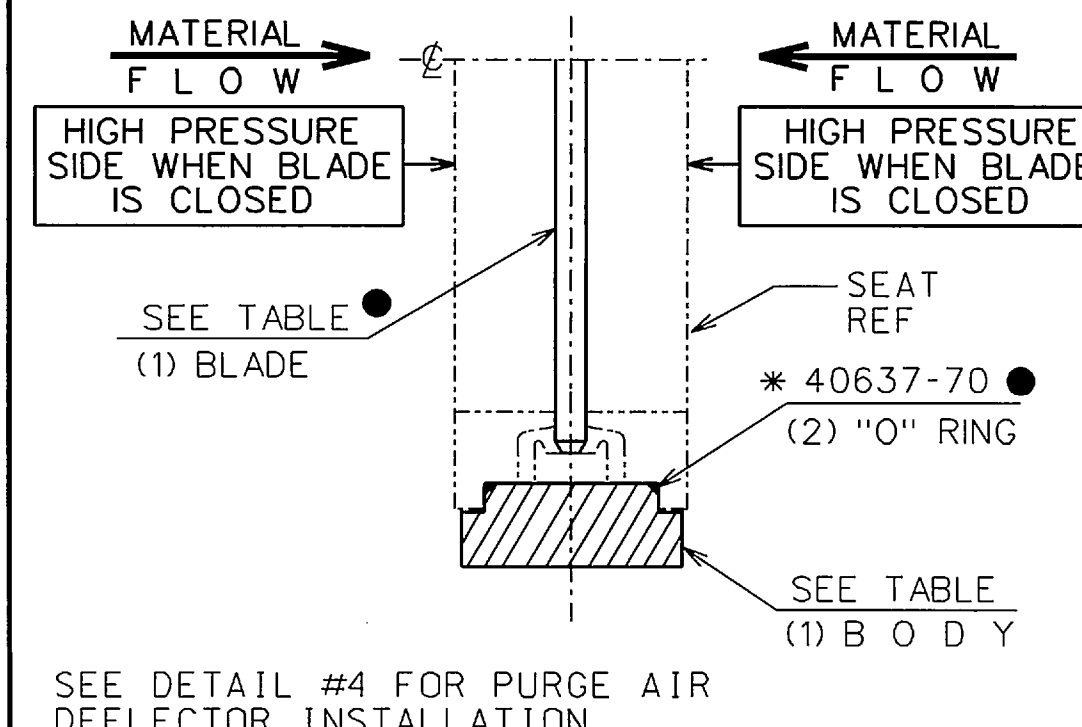
INSTALLED WIDTH
FOR BIN ISOLATION
INSTALLATION

SEE DETAIL # 3
ABOVE FOR CORRECT
ASSEMBLY CONFIGURATION

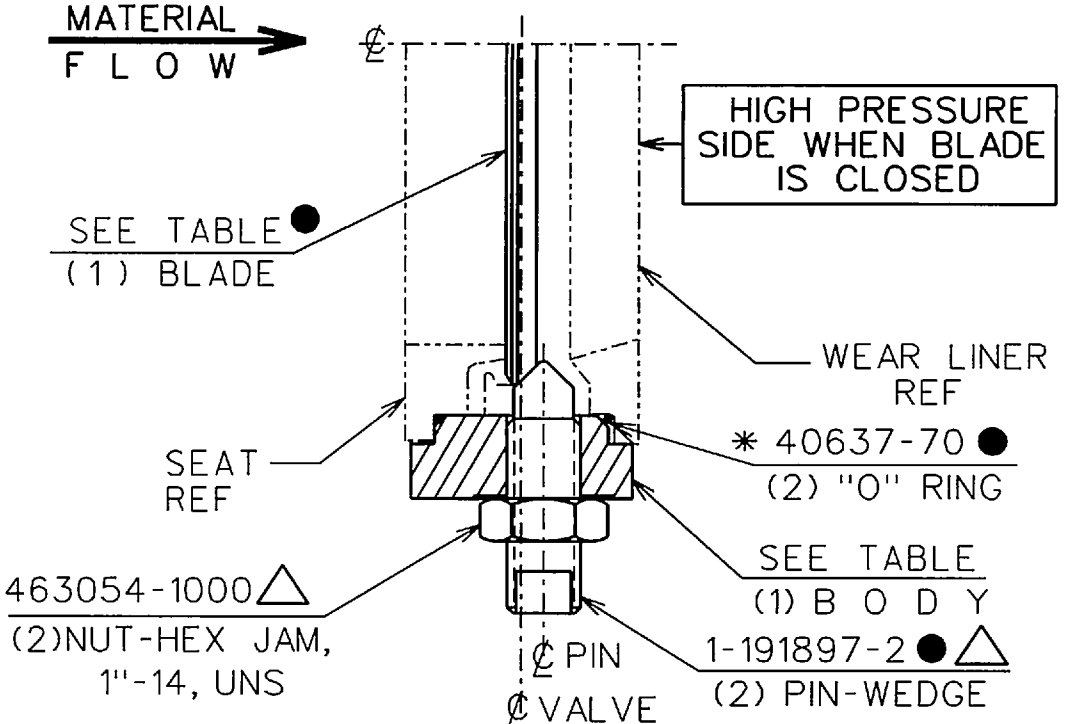
INSTALLED WIDTH
FOR BRANCHLINE/
CROSSOVER INSTALLATION



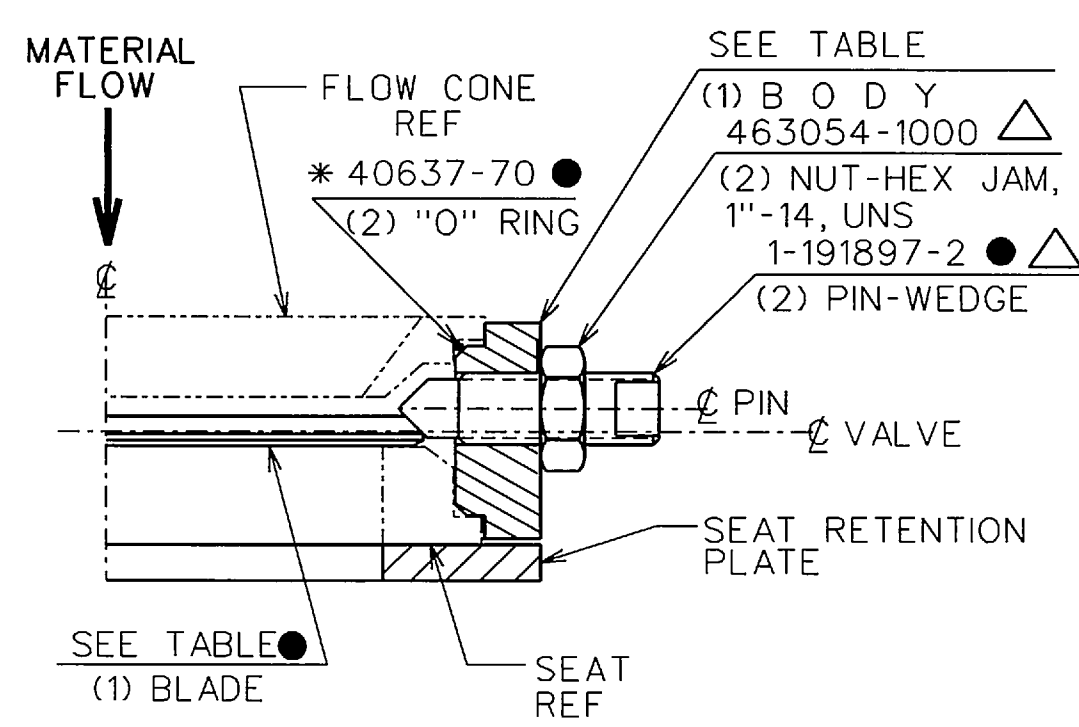
BRANCHLINE VALVE WITH FLOW CONE



CROSSOVER VALVE



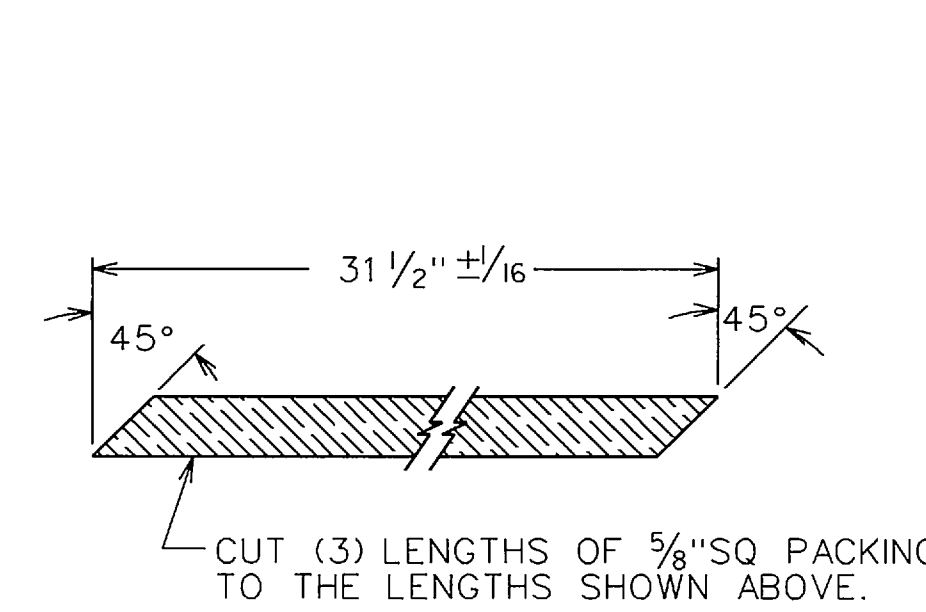
BRANCHLINE VALVE WITH WEAR LINER



BIN ISOLATION VALVE

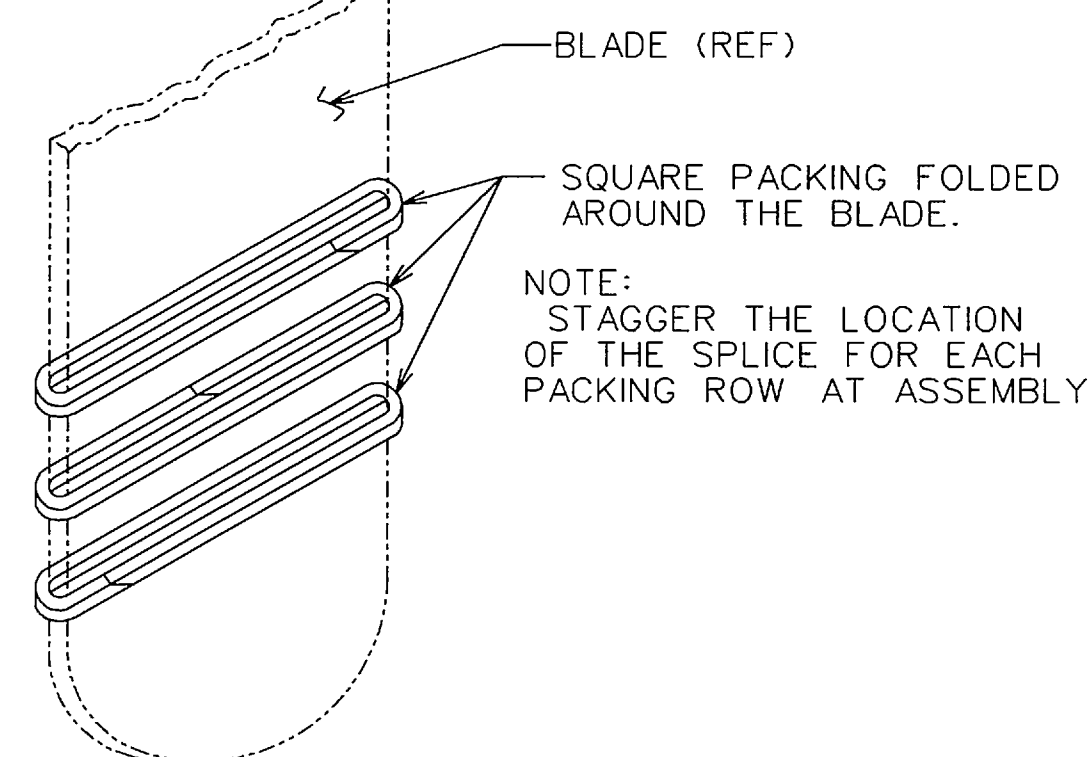
(VALVE ASSEMBLY/INSTALLATION CONFIGURATION)

DETAIL 3



DETAIL 1

NOTE 2A



DETAIL 2

NOTE 2B

MANUFACTURING NOTES:


- 1 - IF NECESSARY BEND DEFLECTOR LEG SO THAT IT SITS FIRMLY AGAINST THE BODY WALL.
- 2 - A) PACKING MUST BE CUT TO A LENGTH OF 31 1/2" AS SHOWN IN DETAIL "1". DO NOT CUT TO A SHORTER LENGTH BECAUSE DOING SO WILL EFFECT THE VALVE SEAT.
B) INSTALL PACKING SO THAT THE CUT ENDS ARE JOINED AS SHOWN IN DETAIL "2". JOINTS OF PACKING MUST BE STAGGERED ON OPPOSITE SIDES OF THE BLADE AS SHOWN. TAMP DOWN EACH PACKING LENGTH AS IT IS INSTALLED.
- 3 - TIGHTEN LOCKNUTS EVENLY ON TUBE SPRING UNTIL ZERO LEAKAGE IS OBTAINED, AT TIME OF ASSEMBLY, WITH ACTUATOR.
- 4 - APPLY THREAD LOCKING COMPOUND (45528*) TO THREADS WHICH THREAD INTO BODY.
- 5 -
- 6 - ASTERISK (*) INDICATES ITEMS SUPPLIED ON COMMON PARTS BILL OF MATERIAL 1918-38.
- 7 - FLANGE STUDS ARE NOT ASSEMBLED. SEE SHIPPING INSTRUCTION #91072 FOR PACKAGING METHOD.
- 8 - APPLY RTV SILICONE SEALANT (45507-8*) TO PLUG THREADS WHICH THREAD INTO THE BODY.
- 9 - APPLY A 1/4" DIA. BEAD OF RTV SILICONE SEALANT P/N 45507-8 ON THE FLAT SIDE OF THE SEAT WHICH WILL CONTACT THE SEAT RETENTION PLATE. THE DIAMETER OF SEALANT BEAD IS TO BE APPROXIMATELY 13".
- 10 - APPLY RTV SILICONE SEALANT P/N 45507-8 TO THREADS OF CAPSCREWS BEFORE INSTALLING AND TORQUE TO 30 FT. LBS.
- 11 - DRILL (2) HOLES, DRILL SIZE #31 (.120") THRU NAMEPLATE AND 3/8" DEEP INTO BODY IN LOCATIONS SHOWN.
- 12 - APPLY RTV SILICONE SEALANT (45507-8*) TO THREADS OF SET SCREWS PRIOR TO SCREWING INTO BODY.
- 13 - AT FINAL ASSEMBLY USE A PAINTSTICK MARKER TO DRAW "MATCH MARKS" AT APPROXIMATELY 10 AND 2 O'CLOCK POSITIONS, ACROSS THE FACE OF FLANGE. DOUBLE MATCH MARKS ON SEAT SIDE, SINGLE MATCH MARKS ON CONE SIDE.

MAINTENANCE NOTES:

- 14 - • INDICATES ITEMS RECOMMENDED FOR SPARE PARTS.
- 15 - SEE DRAWING 2-1918-27 FOR REPAIR KITS.

SHIPPING NOTES:

- 16 - FULLY ASSEMBLED. USE SHIPPING BAG 47000-5* AND SHIPPING HARDWARE (2) 46294-450*.
(2) 46301-500* & (4) 46255-11* AS INDICATED IN SHIPPING INSTRUCTION #91072 & 5-1918-3.

L	K	ECN	751722	TOLERANCES		VALVE - KNIFE GATE 12" 40D, BASIC
K	ECN 800040 3/11/08 LGM			UNLESS OTHERWISE SPECIFIED: ALL TAPPED HOLES AND REEL HOLE LOCATIONS TO BE .005" FRACTIONAL DIMENSIONS ± 1/16" METRIC DIMENSIONS ± 1.0 MM ALL ANGLES ± 1°		
J	ECN 762217 06/25/07 PLM	S	Est. Wt.	kg.		
H	ECN 760951 6/4/04 CRH	S	155 lbs.			
G	ECN 754990 2/12/04 JWD	S				
F	ECN 758922 5/27/03 JR	S	General fabrication specification 98001 is a part of this drawing.			
E	ECN 754980 4/5/03 JWD	S	 UNITED CONVEYOR CORPORATION 2180 NORMAN DRIVE WEST MANKATO, ILLINOIS 60805			
D	ECN 754940 03/10/00 JMH	M	THE EQUIPMENT AND DESIGN SHOWN ON THIS DRAWING ARE THE EXCLUSIVE PROPERTY OF THE UNITED CONVEYOR CORPORATION.			
C	ECN 754931 11/02/98 JMH	M	THIS DRAWING OWNED BY UNITED CONVEYOR CORPORATION, IS CONDITIONALLY LOANED BY RECEIVING IT. THE RECIPIENT AGREES NOT TO REPRODUCE OR COPY IT, IN WHOLE OR IN PART, OR TO FURNISH INFORMATION FROM IT TO OTHERS, OR TO MAKE ANY USE OF IT THAT IS, OR MAY BE, INJURIOUS TO UNITED CONVEYOR CORPORATION AND TO RETURN IT UPON REQUEST.			
B	ECN 754911 03-07-97 RAE	M	DRAWN - CR DATE 02/25/98 SCALE N O N E			
A	ECN 751722 1-25-96 CR	M	CHECKED - DCT 02/21/98 APPROVED - RJB 03/13/98 DRAWING NUMBER APPROVED - DEC 03/18/98 5-1918-38 APPROVED			
REVISIONS		MEMO				