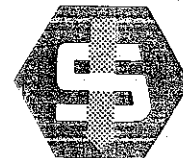


Mounting Instructions :



While mounting our SEITZ-ROTEX Solenoid Valves, please remember that:

1. These Valves are suitable for the control of :
(a) Air, (b) Gases and (c) Liquid-flow ONLY.
2. HEMP-FILAMENTS, 'JUTE', or EVEN TEFLON-RIBBONS are normally not required, as the part connections of our Valves are ACCURATELY THREADED. By chance, if any of these or any other tightening mediums get into the operational area inside the Valves, possible choking of the Valves should not be ruled out.
3. With the installation of our Valves, you receive steady and controlled flow of the Air, Gases, Liquids to UTMOST Cleanliness, and PAINSTAKING care are observed during the manufacture of parts and assembly of these Valves.
4. Hence, this additional advantage should not be neutralised by allowing dirty Air, Gases or Fluids to get into the Valves.
5. Please clean all pipes and tube fitting THOROUGHLY with suitable means, as even when brand new pipes are fitted, their greasy or unclean interior are quite covered with dirt and dusts.
6. Any foreign material like Dirt and Dust can affect the Valves, when brought to operation.
7. Hence, it is strongly recommended that the connections/pipes should be rinsed with degreasing or by any grease-dissolving liquids or agents, before being connected to our Valves.

(11)

SEITZ-ROTEX

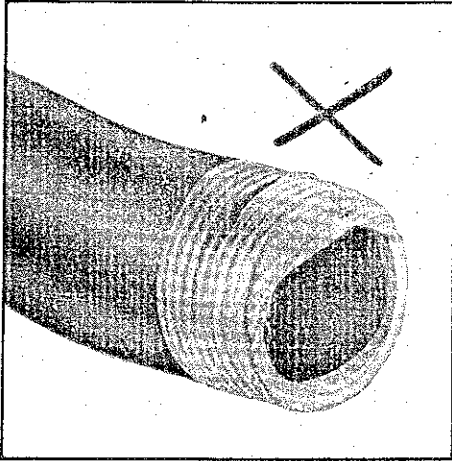


Fig. 1.

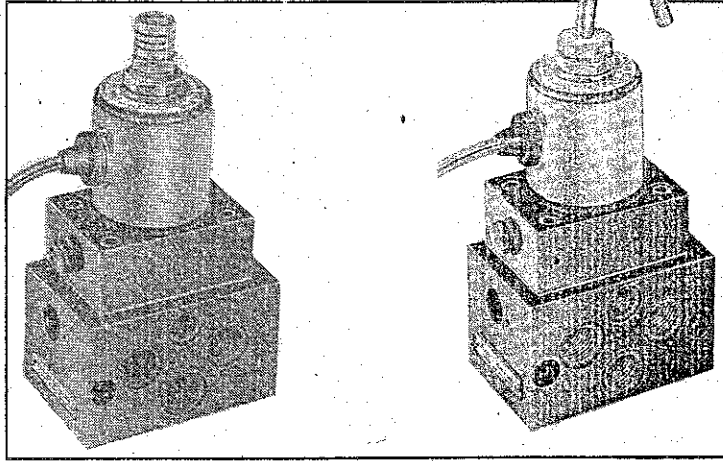


Fig. 4.

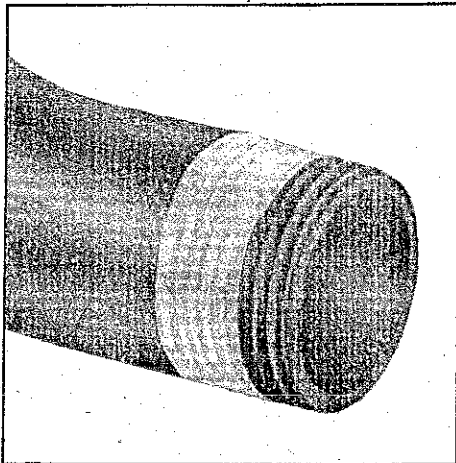


Fig. 2.

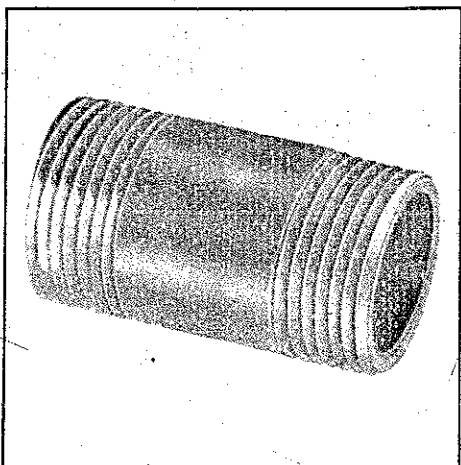


Fig. 3.

8. While the Valves are tightened in with pipe connections, the tightening material like TEFLON-RIBBONS when used-happen to overlap as shown in Fig. 1. The Teflon Ribbon cuts while tightening, will be carried away into the Valves, where such refuse might cause a "Break-down", Hence, it is recommended, not to cover first two thread-pitches, Fig. 2. Make sure that the threaded length is not longer than STANDARD LENGTH, Fig. 3, for, tubing and piping with too much thread may touch the interior parts of the Valves when screwed and tightened-in. It is also important not to use our Valves to pull together two tubes cut too short. It is advised to make new tubings, for, the Valves will respond this with longer life. Please try to bring the tube to the Valves in a curve. In case of stress due to change in Temperature, this arrangement will have no ill-effect on our Valves. Also please do not use these Valves as a MOUNTING-BASE for Cables or Tube/Pipe Clamps. We wish to impress upon you that, no additional holes are to be drilled on our Valves, for, your EACH VALVE is made by us SPECIALLY FOR YOU, and if you drill holes on these Valves, you will perhaps reach to their interior, sooner than you presume.

9. If dirt is expected in the surrounding area, please do not mount our Valves there, for the EXHAUST-PORT of the PILOT Ports need protection against it. Small Mufflers or Screwed-in-Angle-Tubes are very suitable to this purpose, Fig. 4, and UPSIDE DOWN MOUNTING of the Valves are also suggested.

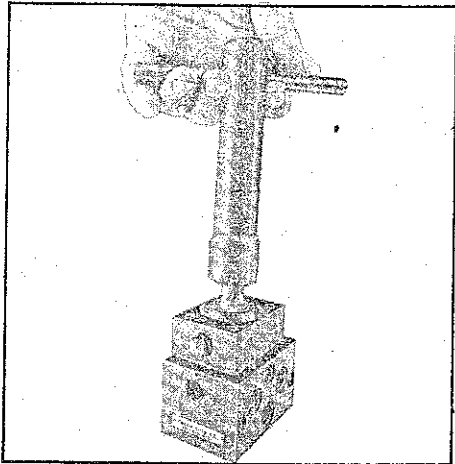


Fig. 5.

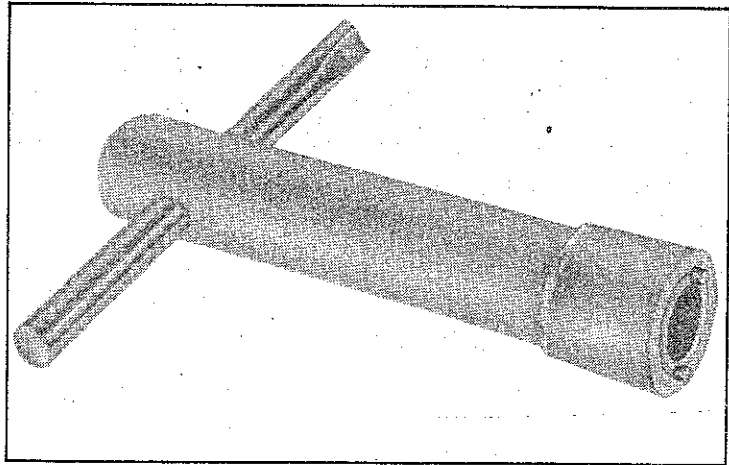


Fig. 6

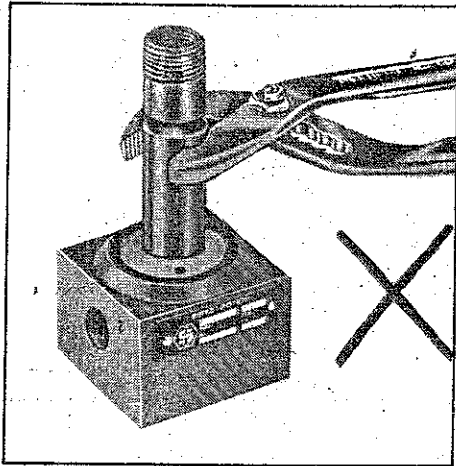


Fig. 7

10. Our Valves are well-packed before they leave our plant and only open the coverings when ready for mounting/installing, to prevent dirt and dust getting in. Avoid impacts against the relatively sensitive Pilot Parts. These things may occur during transportation or mishandling. It is necessary to avoid a Twisted Guide Tube of the Valve, to avoid a break-down.

11. It is suggested to study sectional view or spare parts list before a Valve is dismantled and to understand better the working principles of the Valves. It is also suggested to leave the servicing part of the job to US, but even then, if you wish to dismantle Valves, please remove the Solenoid Coil first. It is most suitably fastened by a Nut, SW19 or SW22 to the upper part of the Valve. The Nut goes tight to avoid its loosening by itself, and therefore, it should be opened/tightened with Spanners only Please refer to Fig. 5.

Before the Solenoid Coil is separated from the Guide Tube, please see that the coil is not energised. In order to remove the Guide-tube, please use the special set Pin Spanner, (Fig. 6).

Our authorised Sales Representatives can get it for you.

TOOL-No. 4-100 183 for Solenoid Coil, Size 1, Construction.
TOOL-No. 4-102 384 for Solenoid Coil, Size 2, Construction.

12. Please do not try or remove the Guide Tube with pliers (Fig. 7) and if you do so, you are risking to squeeze the tube and then the plunger will get jammed as the movable plunger is guided by the tube.

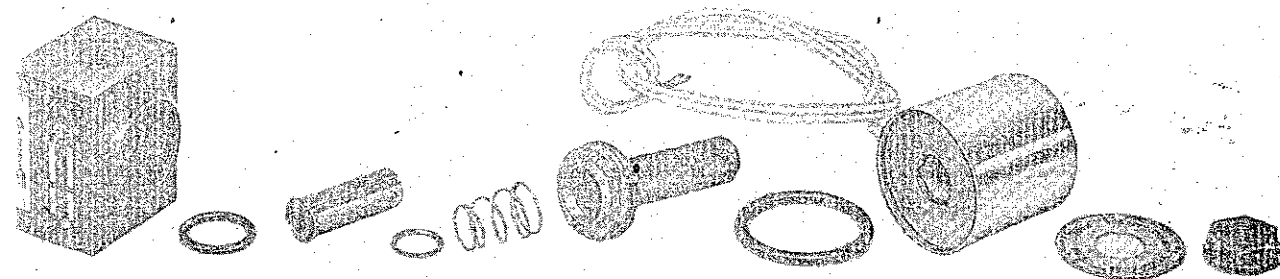


Fig- 8

If you have to dismantle the Valve, please fix the Valve Housing into a benchvice with a soft 'protection' over it. When the Guide Tube has been screwed out, you have got access to the plunger space, where the delicate Guide Orifice can be seen. Now you can remove the whole pilot part which consists of.

(1) Guide-Tube (2) Movable plunger which has a Plug on either side (3) A conical plunger Spring and (4) Supporting Ring. It is worth remembering to use the Spare Parts List when dismantling and re-assembling our Valves. You will find a small supporting Ring having a slope edge on it's inward side. This slope edge has to be kept to the Supporting Ring, which is situated at the lower end of the movable plunger. If the Supporting Ring is not fixed correctly, the requisite length span of the Spring will be reduced, resulting the plunger not be able to move the whole way to close the Orifice in the Guide Tube. The proper way of Fixing the spring is to place the narrower side on the plunger and should well support itself on the Supporting Ring. Therefore, it is to be remembered that a wrong assembly causes jamming of the plunger, for the narrow spring coil slips into the chamfer of the Guide-Tube causing a wedging effect leading to the said jamming of the plunger.

In the Production Schedule of SEITZ-ROTEX, there are many types of SEITZ-ROTEX Valves. Pilot operated Valves, once assembled, cannot be dismantled further, without spoiling some of their parts. They consists of a complete pilot part added to one or the other Valve-Housing. Internal or External PILOT Operated Valves have an extensive interior in addition to the Pilot part. An experienced Technician, however, will be able to cope-up with the requirements when using the corresponding sectional sheet or spare parts list.

Another very important thing to be remembered is, not to place the dismantled Valve parts on any dirty Workbench or place of work, but place them on a clean paper or cloth, surely in same sequence in which you have dismantled them, as shown in Fig. 8. It may save your time and unpleasent breakdown incidents, if you strictly follow the above Mounting Instructions.

(A)