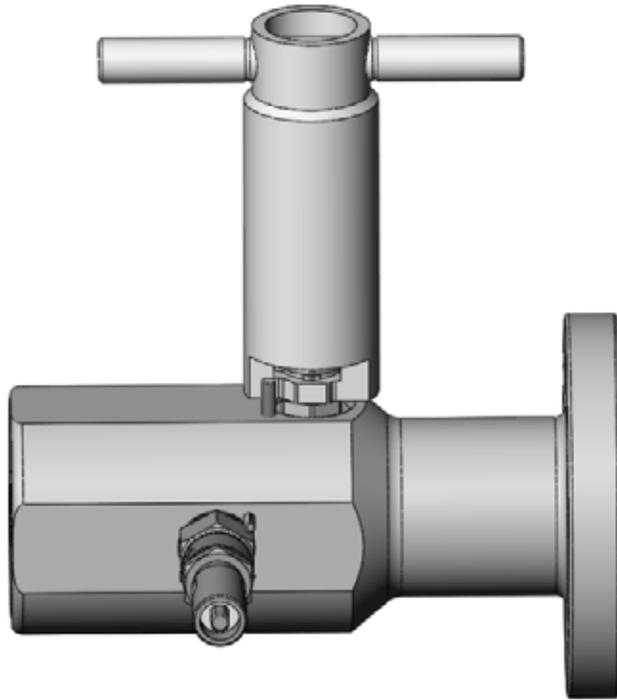


VB04 Series (14 mm Bore) Process Interface Valves Extended Handle Replacement Instructions

Swagelok®



Kit Contents



Lock washer



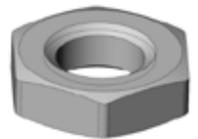
Handle body



Handle



Retaining rings (2)



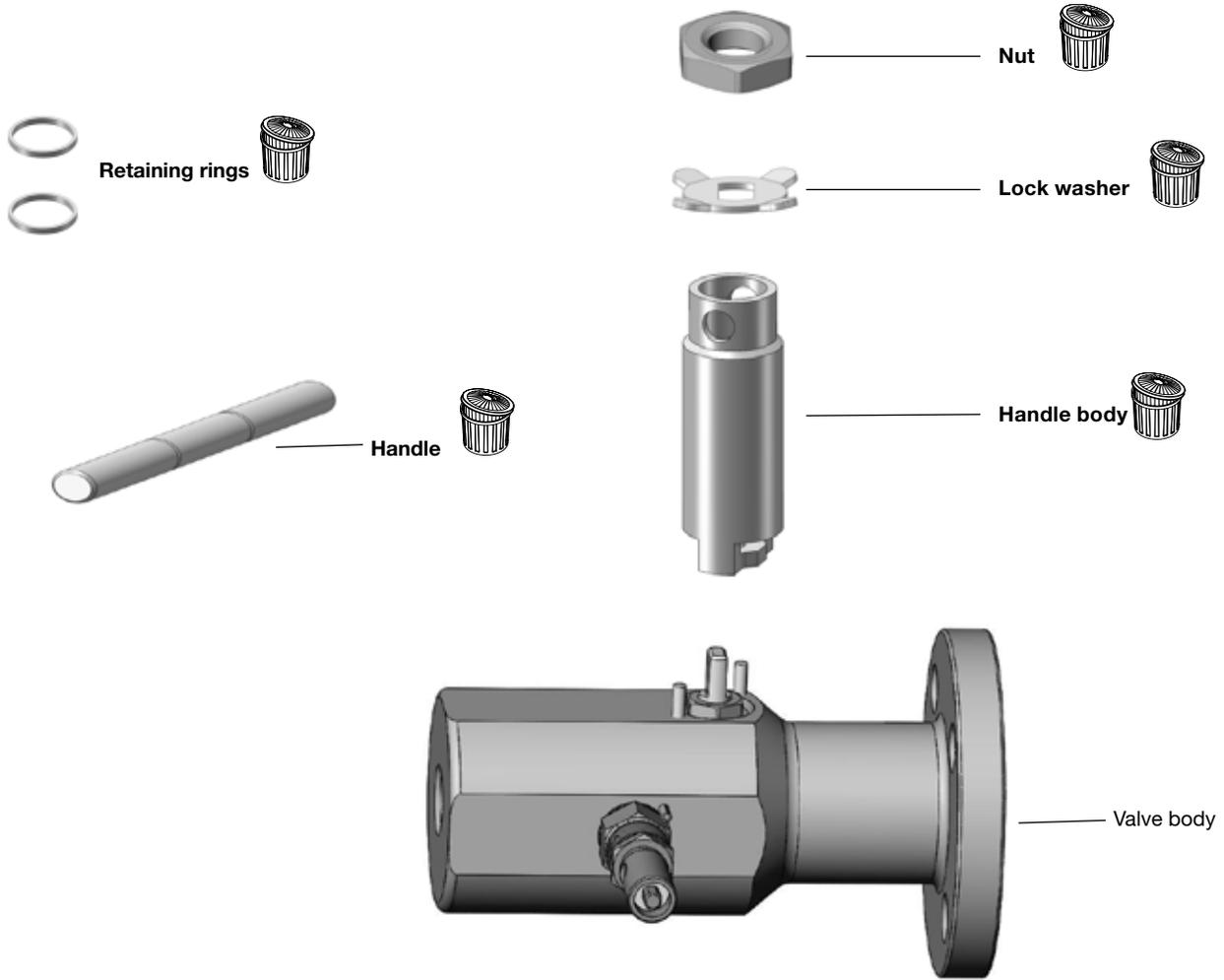
Nut

Symbols



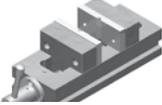
Discard

Exploded View



***Bold indicates kit component.**

Tools Required

| Tool | Size | Component |
|---|-----------------------------------|-----------------|
|  Vise | — | Body |
|  Torque wrench | Capable of 110 in.*lbs (12.4 N*m) | Nuts |
|  Socket | 17 mm | Nuts |
|  Pliers | — | Retaining rings |
|  Thread-locking fluid | — | Stem |
|  Punch and hammer | — | Lock washer |

⚠ WARNING

Before removing valve from system, to avoid personal injury, you must

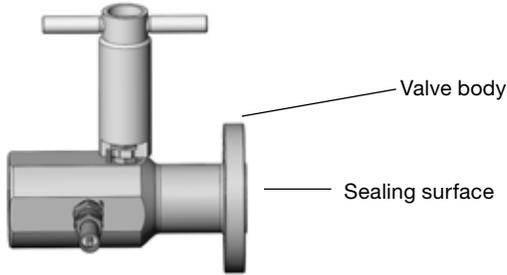
- Depressurize the system
- Cycle the valve
- Purge the system to remove any residual system media left in the valve

Disassembly

1. Secure the **valve body** in a vise.

NOTICE

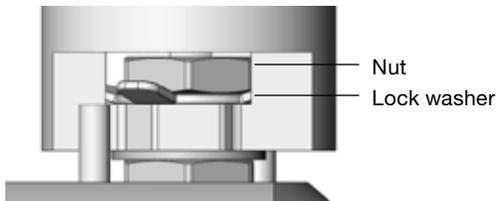
Be careful not to damage the sealing surfaces. Leakage could result.



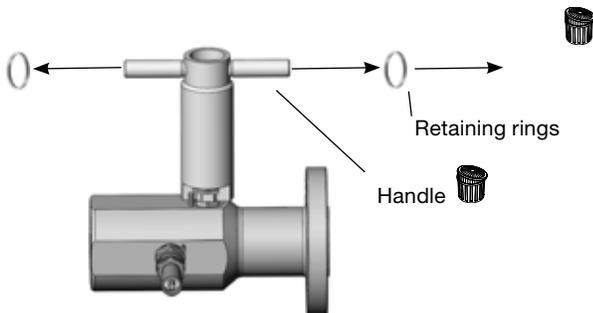
2. Actuate the valve to the closed position.
3. Carefully bend the **lock washer** tabs away from the **nut** using a punch and hammer.

NOTICE

Excessive force may damage the valve. Leakage could result.



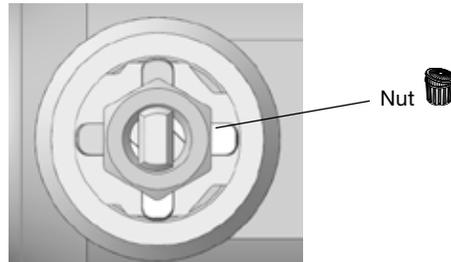
4. Using pliers remove the **retaining rings** and **handle**.



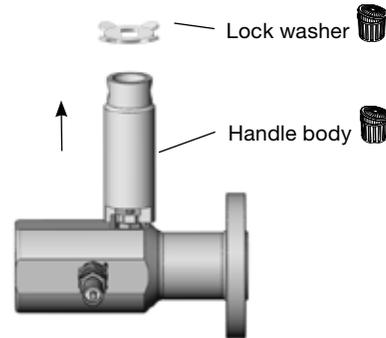
5. Remove the top **nut** using a wrench with a socket.

NOTICE

Keep the valve in closed position and do not let the stem or handle body rotate during removal. Unexpected flow could result.



6. Remove the **handle body** and **lock washer**.

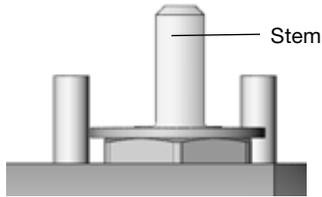


NOTICE

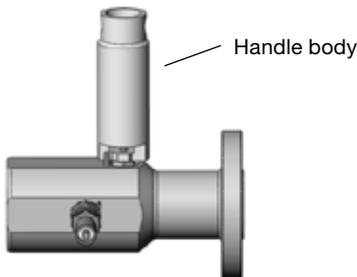
Be careful not to loosen the bottom nut in order to keep the stem components in place. Leakage could result through the stem bore if not in place.

Reassembly

1. Torque the bottom nut using a torque wrench and socket to 5 to 6 in·lb (0.5 to 0.6 N·m) in case the nut has loosened during disassembly.
2. Apply a thin coat of thread-locking fluid to the **stem** threads.



3. Place the **handle body** over the stem.



4. Install the lock washer by lifting the handle body so the bottom is flush with top of the stem. Slide the lock washer through the lower gap in the handle body and then over the top of the stem.
5. Install the top nut.
6. Torque the top nut using a torque wrench and socket to 90 to 110 in·lbs (10.1 to 12.4 N·m).

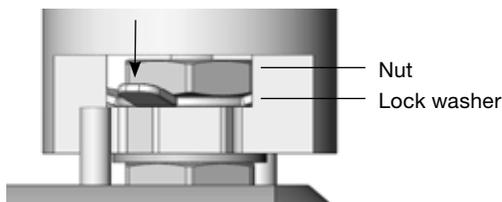
NOTICE

Keep the valve in a closed position and do not let the stem or handle body rotate during assembly. Unexpected flow could result.

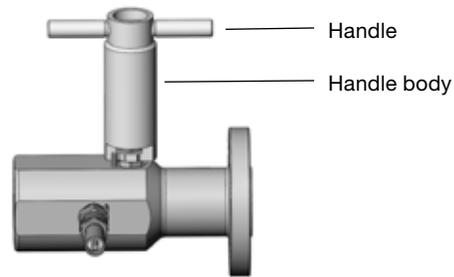
7. Bend the **lock washer** tabs against the **nut** using a punch and hammer.

NOTICE

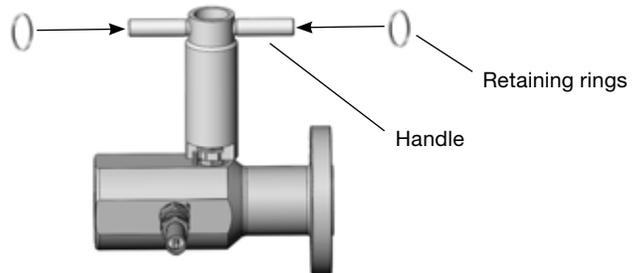
Excessive force may damage the valve. Leakage could result.



8. Assemble the **handle** into the **handle body**.



9. Install the **retaining rings** in the grooves on each side of the **handle**.



10. Test each valve for proper operation and leak-tight integrity.

NOTICE

Allow thread-locking fluid 24 hours to cure before installing the valve. Failure to do so could result in leakage.

For additional information, see www.swagelok.com.