

Installation Instructions

Complete Bellows Valve Upperworks

"BN" Series Air Actuated Valves

(Normally Closed model)

1. Relieve system pressure to valve.
2. While holding down the **air actuator**, unscrew **bonnet nut** and remove **valve upper assembly** from body.
3. Place new **upper assembly** on valve body.
4. Do not pressurize the air actuator.
5. Push down on top of **air actuator** until stem tip seats in body. While holding down **air actuator**, thread **bonnet nut** onto **body** by hand until snug. Tighten bonnet nut to **500 in • lbs. (56 N • m)**.

Note: During tightening, hold the valve body and air actuator stationary to prevent rotation and damage to the bead seal.

6. Test **valve** and **air actuator** to ensure proper operation and seal integrity.

For assemblies with Vespel Stem Tip:

Preseating Stem Tip

1. Thread a #10-32 cap screw into the top of the cap until it contacts the top of the stem.
2. Tighten the screw to a maximum of 15 in • lbs. (1.7 N • m) torque.
3. Remove the screw from the cap.
4. Test the valve and pneumatic actuator to ensure proper operation and seal integrity.

Swagelok

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"BK" Series Air Actuated Valves

(Normally Closed model)

1. Relieve system pressure to valve.
2. While holding down the **air actuator**, unscrew **bonnet nut** and remove **valve upper assembly** from body.
3. Remove **metal o-ring** or **gasket** from body and discard.
4. Place new **metal o-ring** or **gasket** into the recess on top of body.

NOTE: Use a new metal o-ring or gasket each time the valve is reassembled.

5. Place new **upper assembly** on valve body.
6. Push down on top of air actuator until stem tip seats in body. While holding down air actuator, thread bonnet nut onto body by hand until snug. Tighten bonnet nut to the appropriate torque.

Hold the valve body and air actuator stationary to prevent rotation and damage to the body seal.

Stainless Steel / Alloy 400	Brass
300 in • lbs. (34 N • m)	200 in • lbs. (23 N • m)

Note: These torque values are for the standard TFE coated metal o-rings. For torque values on other o-ring materials and gaskets, see the installation instructions for Gasket and Metal O-Ring for Bellows Valves (MS-CRD-0008).

7. Test **valve** and **air actuator** to ensure proper operation and seal integrity.