

GQ 70000 (Combination Foot valve) Assembly Procedure

Purpose:

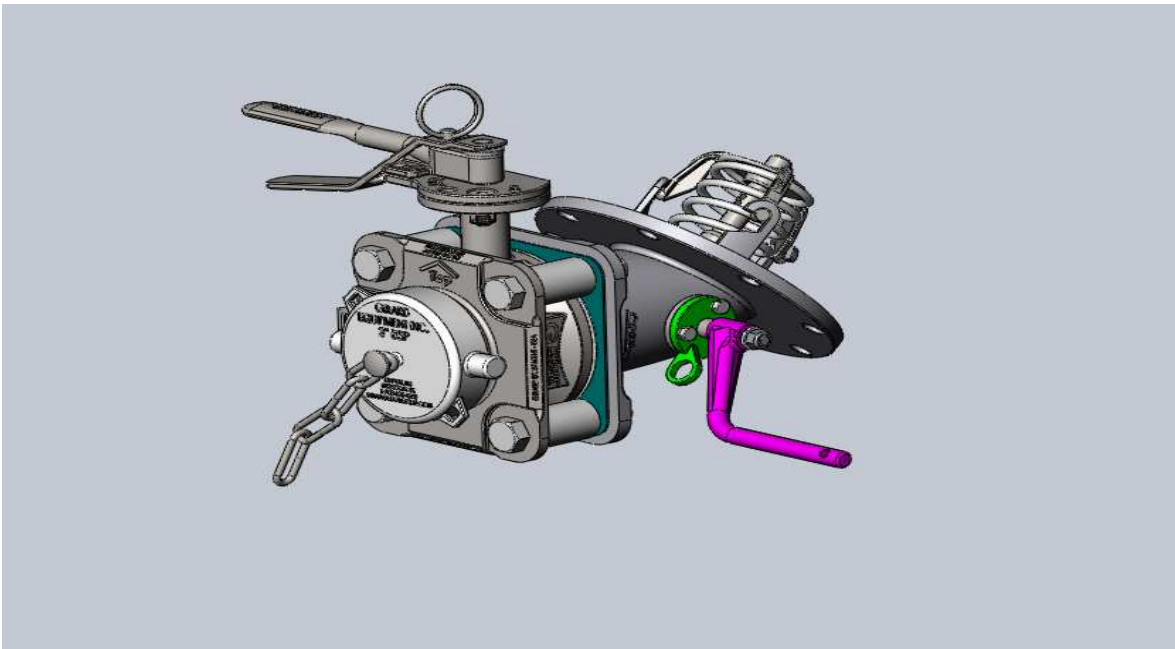
The purpose of this manual is to describe the assembly procedure for the GQ70000

Responsibilities:

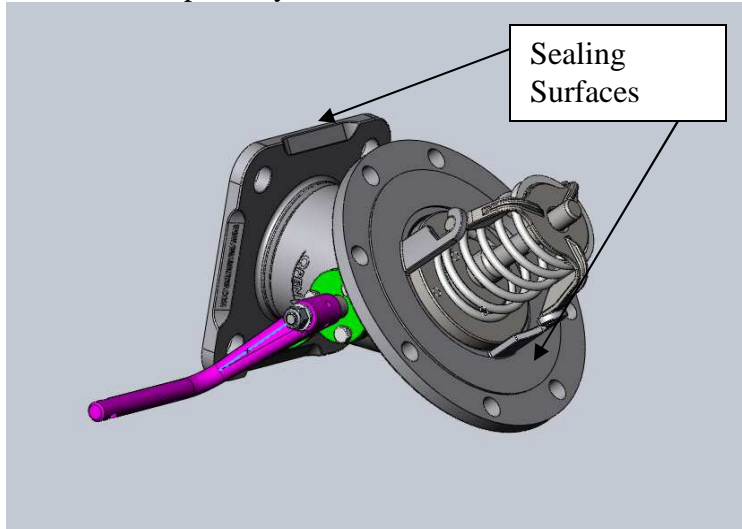
It is the responsibility of all employees performing the assembly of the GQ70000 Combination Foot valve to read and understand this procedure before starting work.

Equipment:

- 13 mm Open Ended Wrench
- 15/16 in Open Ended Wrench
- ½ in Ratchet
- 8, 24, and 27 mm Sockets
- 2.5, 5, and 8 mm Hex Key
- Stainless Steel Wire Brush
- Foam Cleaning Solution
- WD-40
- Never Seize
- 2 Sided Rubber Mallet

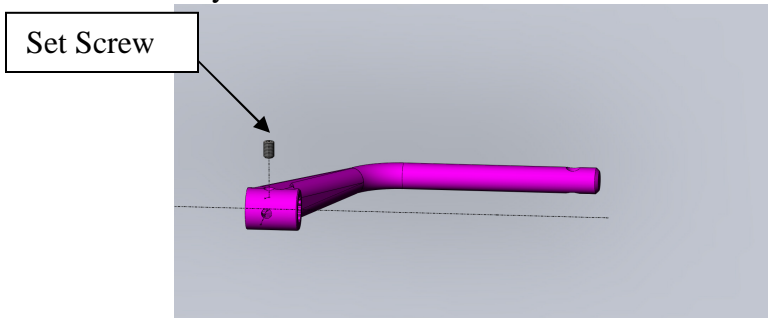


1: Inspect all sealing surfaces on **10**(45 Deg Bottom Outlet Valve Assembly GQ60000) for defects or porosity.



2: Clean top and bottom flanges on **10**(45 Deg Bottom Outlet Valve Assembly GQ60000) with Foam Cleaning Solution and Stainless Steel Wire Brush.

3: Screw set screw into **10**(45 Deg Bottom Outlet Valve Assembly GQ60000) handle half way.

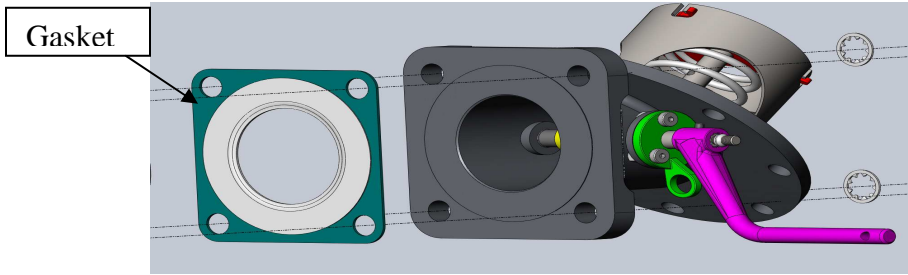


4: Slide handle onto shaft on **10**(45 Deg Bottom Outlet Valve Assembly GQ60000).

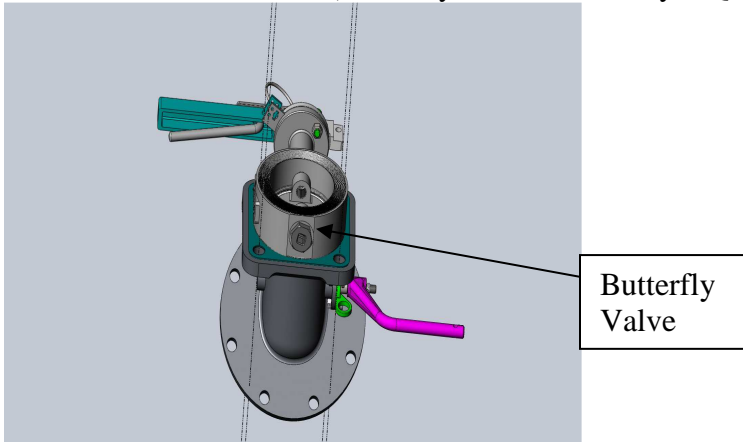
5: Using a 5 mm Hex Key ensure that the three screws on **10**'s(45 Deg Bottom Outlet Valve Assembly GQ60000) shaft are tight.

6: Open and close **10**(45 Deg Bottom Outlet Valve Assembly GQ60000) five times to ensure cam is not sticking.

7: Place **7**(Gasket GQ70030) on to of **10**(45 Deg Bottom Outlet Valve Assembly GQ60000) so that the solid color side of **7**(Gasket GQ70030) is facing up.

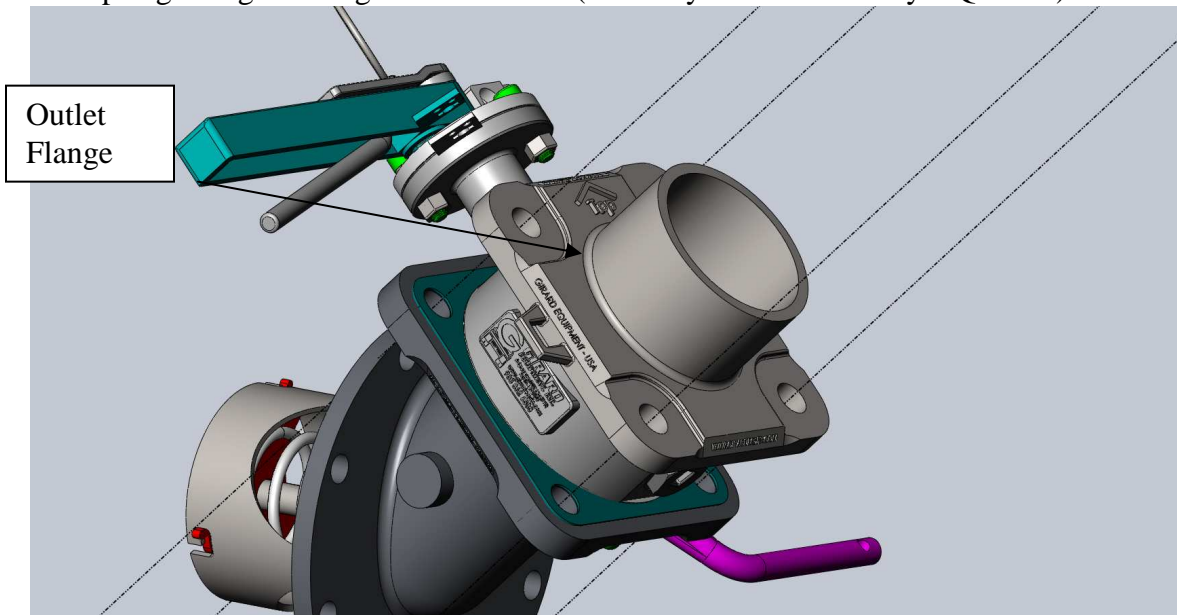


8: Place **9**(Butterfly Valve Assembly GQ50400) onto **7**(Gasket GQ70030) so that the handles on **9**(Butterfly Valve Assembly GQ50400) and **10** are facing away from each other and the handle on **9**(Butterfly Valve Assembly GQ50400) is facing away from you.



9: Place **7**(Gasket GQ70030) on to **9**(Butterfly Valve Assembly GQ50400) so that the solid color side of **7** is facing down.

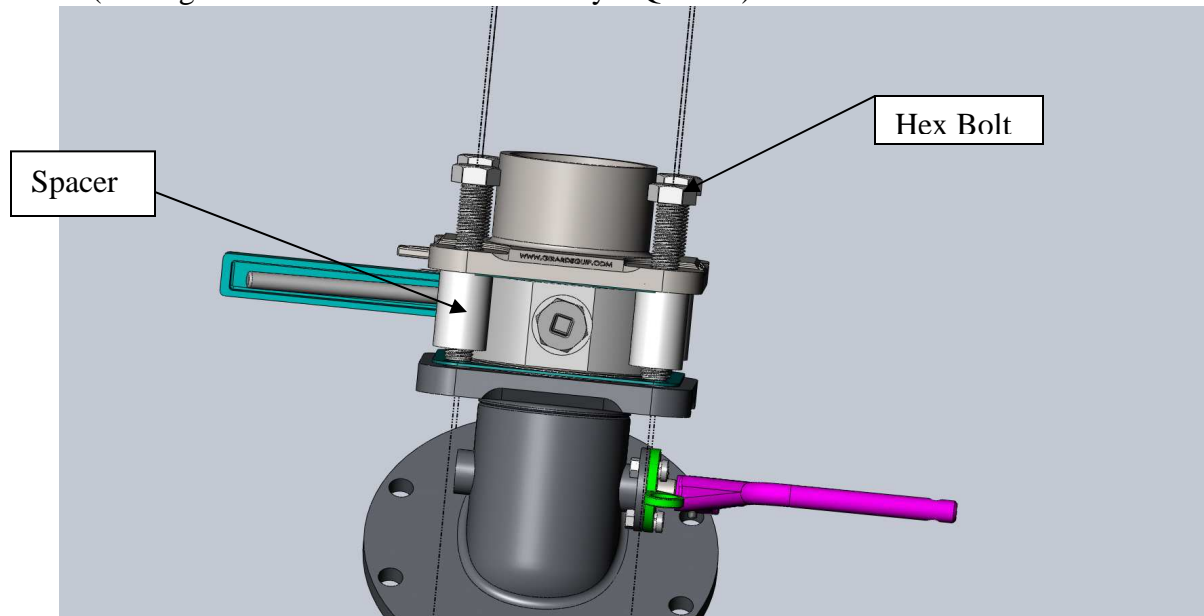
10: Place **6**(Outlet Flange GQ70040) onto **9**(Butterfly Valve Assembly GQ50400) so that the top engraving is facing the handle on **9**(Butterfly Valve Assembly GQ50400).



11: Place four **8**(Spacer GQ70020) in between **6**(Outlet Flange GQ70040) and **10**(45 Deg Bottom Outlet Valve Assembly GQ60000) as shown in the diagram.

12: Slide one **5**(16mm Washer) onto each **1**(Hex Bolt).

13: Insert **1**(Hex Bolt) into holes in **6**(Outlet Flange GQ70040),**8**(Spacer GQ70020), and **10**(45 Deg Bottom Outlet Valve Assembly GQ60000).



14: Dab Never Seize onto threaded end of **1**(Hex Bolt).

15: Slide **11**(Star Washer) on to threaded ends of **1**(Hex Bolt).

16: While holding **11**(Star Washer) finger tighten **12**(Jam Nut 93935A360).

17: Cross tighten **1**(Hex Bolt) and **12**(Jam Nut 93935A360) while ensuring **9**(Butterfly Valve Assembly GQ50400) is properly aligned with **6**(Outlet Flange GQ70040).

18: Tighten all nuts and bolts on **9**(Butterfly Valve Assembly GQ50400).

19: Slide one 10mm washer and two 8mm washer onto **10**(45 Deg Bottom Outlet Valve Assembly GQ60000) shaft.

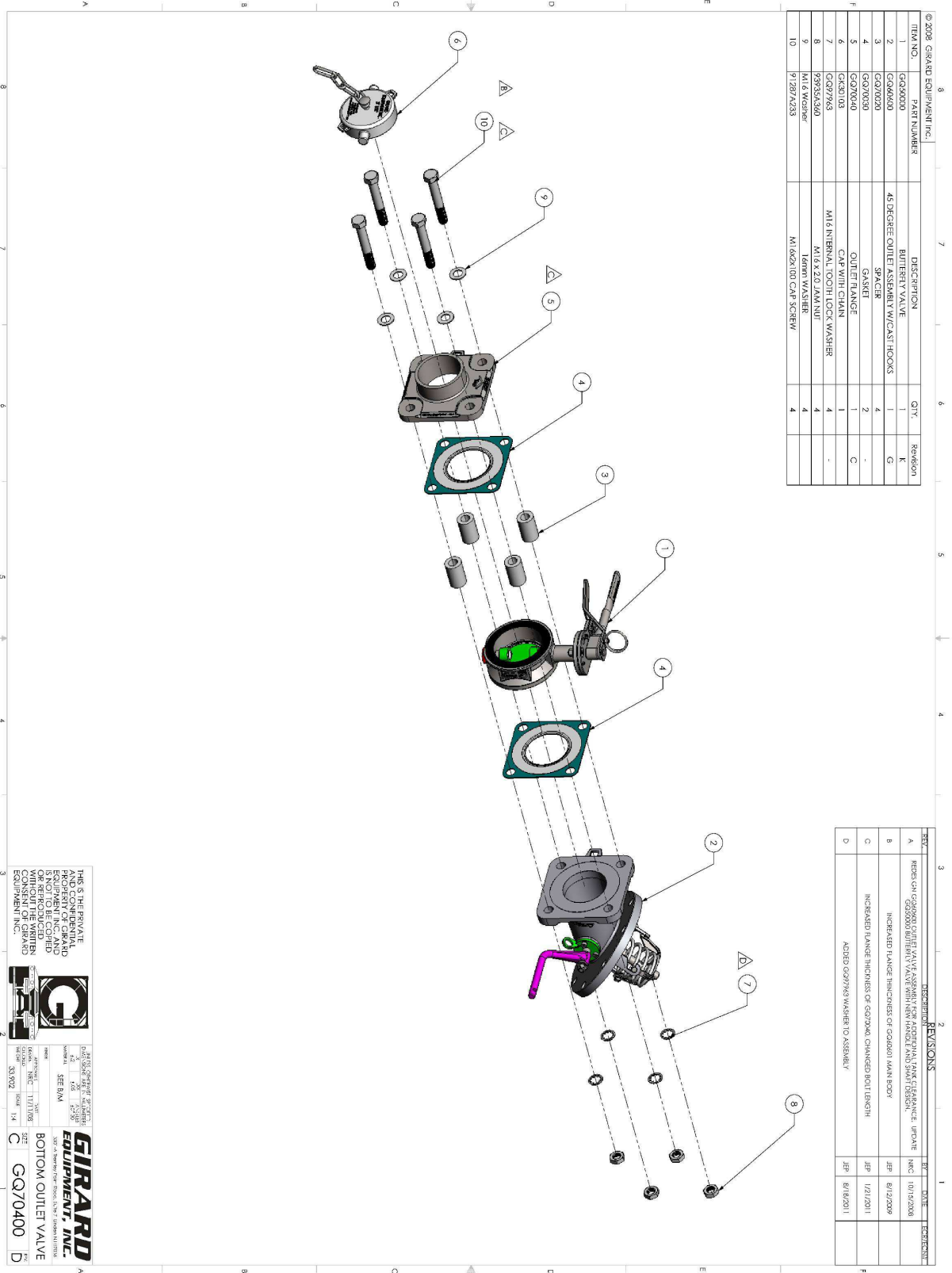
20: Finger Tighten lock nut onto **10**(45 Deg Bottom Outlet Valve Assembly GQ60000) **shaft**.

21: Pass on for testing.


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ITEM NO.	PART NUMBER	DESCRIPTION	QTY.	Revision
1	GQ20000	BUTTERFLY VALVE	1	K
2	GQ40000	45 DEGREE OUTLET ASSEMBLY W/CAST HOOPS	1	G
3	GQ27000	SPACER	4	-
4	GQ20000	GASKET	2	C
5	GQ20000	OUTLET FLANGE	1	-
6	GK30103	CAP WITH CHAIN	1	-
7	GQ27963	M16 INTERNAL TOOTH LOCK WASHER	4	-
8	9939VA340	M16 X 2.0 JAM NUT	4	-
9	M16 WASHER	16mm WASHER	4	-
10	91287A233	M16X2100 CAP SCREW	4	-

REV.	DESCRIPTION	BY	DATE	EXPLANATION
A	REDESIGN GQ20000 OUTLET VALVE ASSEMBLY FOR ADDITIONAL TANK CLEARANCE. UPDATE GQ20000 BUTTERFLY VALVE WITH NEW HANDLE AND SHAFT DESIGN.	JEP	10/19/2008	
B	INCREASED FLANGE THICKNESS OF GQ20000 MAIN BODY	JEP	8/17/2009	
C	INCREASED FLANGE THICKNESS OF GQ20000. CHANGED BOLT LENGTH	JEP	1/21/2011	
D	ADDED GQ27963 HARDER TO ASSEMBLY	JEP	8/18/2011	



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REV. C
QTY: 1
DATE: 1/21/2011
BY: JEP
DESCRIPTION: BOTTOM OUTLET VALVE