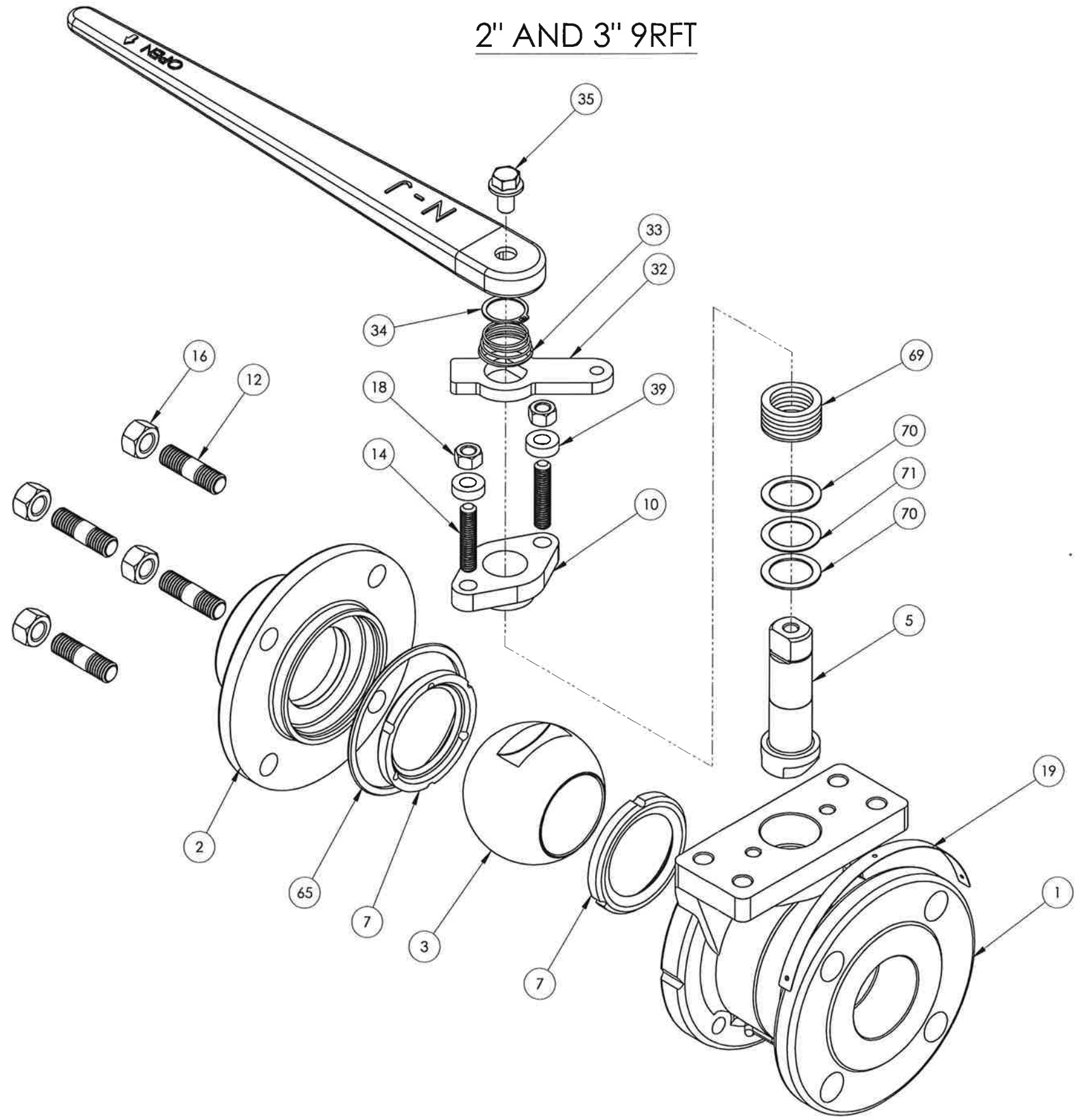




# 2" AND 3" 9RFT



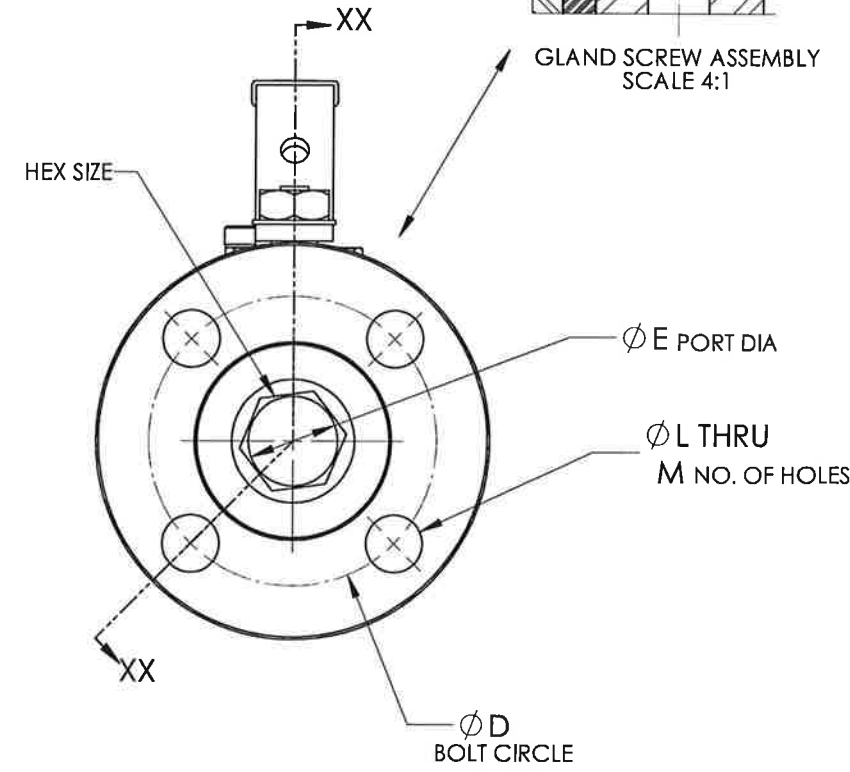
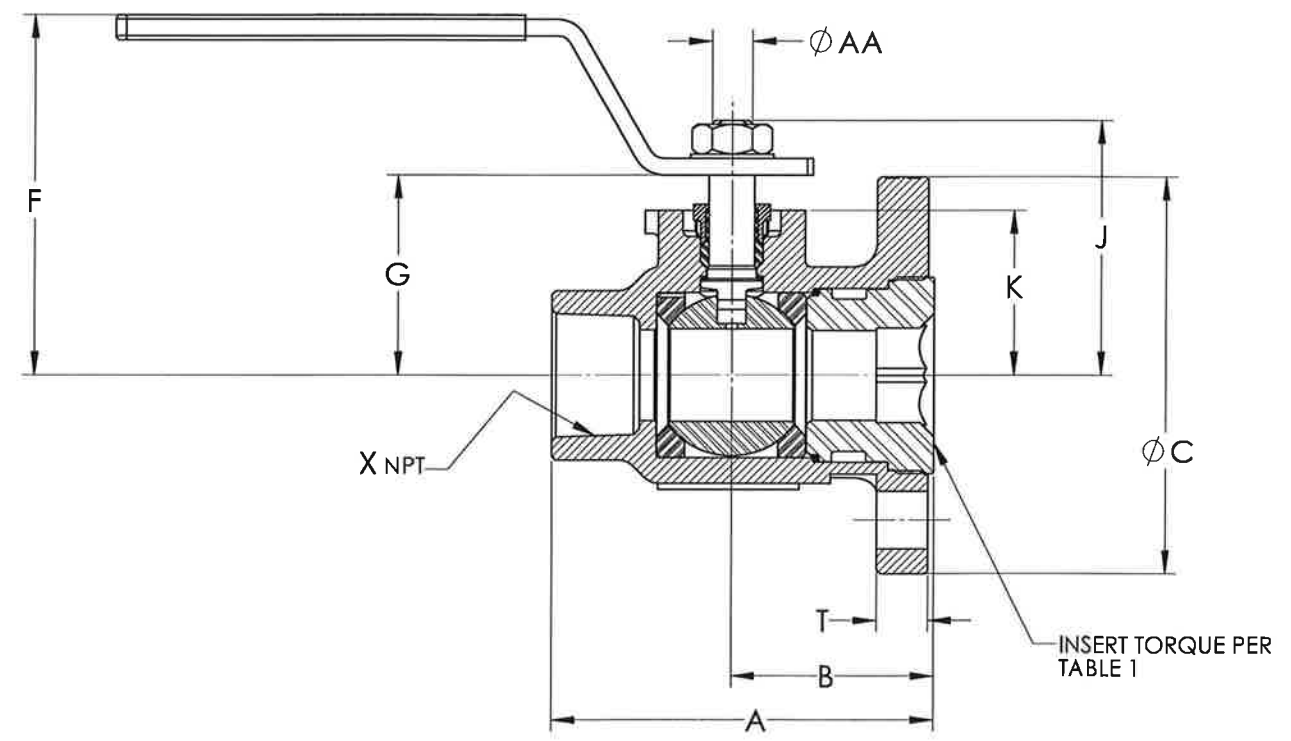
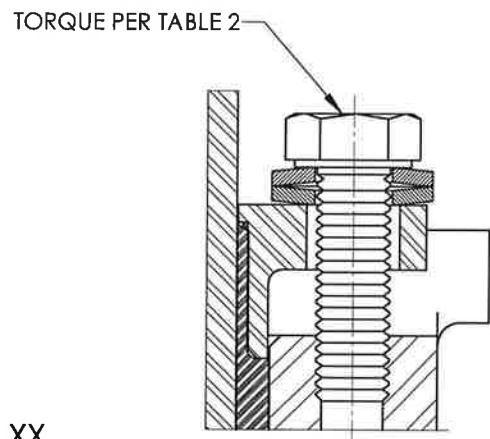
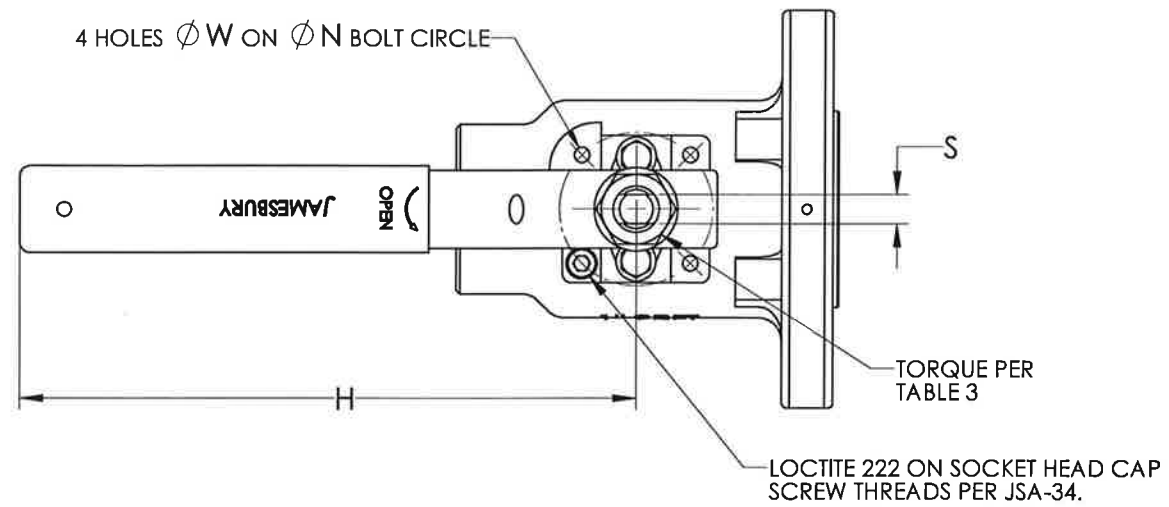
ITEM NO.	PART NAME	QTY.
1	BODY	1
2	BODY CAP	1
3	BALL	1
5	STEM	1
7	SEAT	2
10	COMPRESSION PLATE	1
12	BODY STUD	*
14	BONNET STUD	2
16	BODY STUD NUT	*
18	BONNET STUD NUT	2
19	IDENTIFICATION TAG	1
32	INDICATOR STOP	1
33	SPRING	1
34	RETAINING RING	1
35	HANDLE SCREW	1
36	GROUNDING SPRING	1
39	STOP BUSHING	1
65	BODY GASKET	1
69	PACKING	1
70	STEM BEARING	2
71	SECONDARY STEM SEAL	1

\* SEE BODY JOINT STUD AND NUT TABLE FOR QUANTITIES (SHT. 1)

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	<small>TITLE:</small> ASSEMBLY 1", 2", 3" 9RFT RAILROAD VALVE		<small>DRWN</small> BA <small>DATE</small> 8/29/01 <small>APPVD</small> PJD <small>REV</small>
	<b>METSO AUTOMATION USA, INC.</b> <small>SHIREWSBURY, MASSACHUSETTS</small>		<small>SIZE</small> D <small>DWG NO.</small> 5428

NOMINAL DIMENSIONS = INCHES

VALVE SIZE	A	B	C	D	E	F	G	H	J	K	L	M	N	P	R	S	T	U	V	W	X	AA	HEX SIZE	ISO BONNET
1"	4.07	2.19	4.25	3.12	1.00	3.90	2.16	6.50	2.75	1.78	0.62	4	1.65	N/A	N/A	0.31	0.63	N/A	N/A	M5	1NPT	0.50	1.00	F04



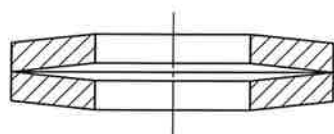
SECTION XX-XX

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	<small>TITLE</small> ASSEMBLY 1", 2", 3" 9RFT RAILROAD VALVE	<small>DRAWN</small> BA	<small>DATE</small> 8/29/01	<small>REV</small> B
	<small>APPROVED BY</small> PJD	<small>DATE</small> 8/29/01	<small>SIZE</small> D	<small>DWG NO.</small> 5428
	METSO AUTOMATION USA, INC. SHREWSBURY, MASSACHUSETTS		<small>SHEET</small> 3	<small>OF</small> 4

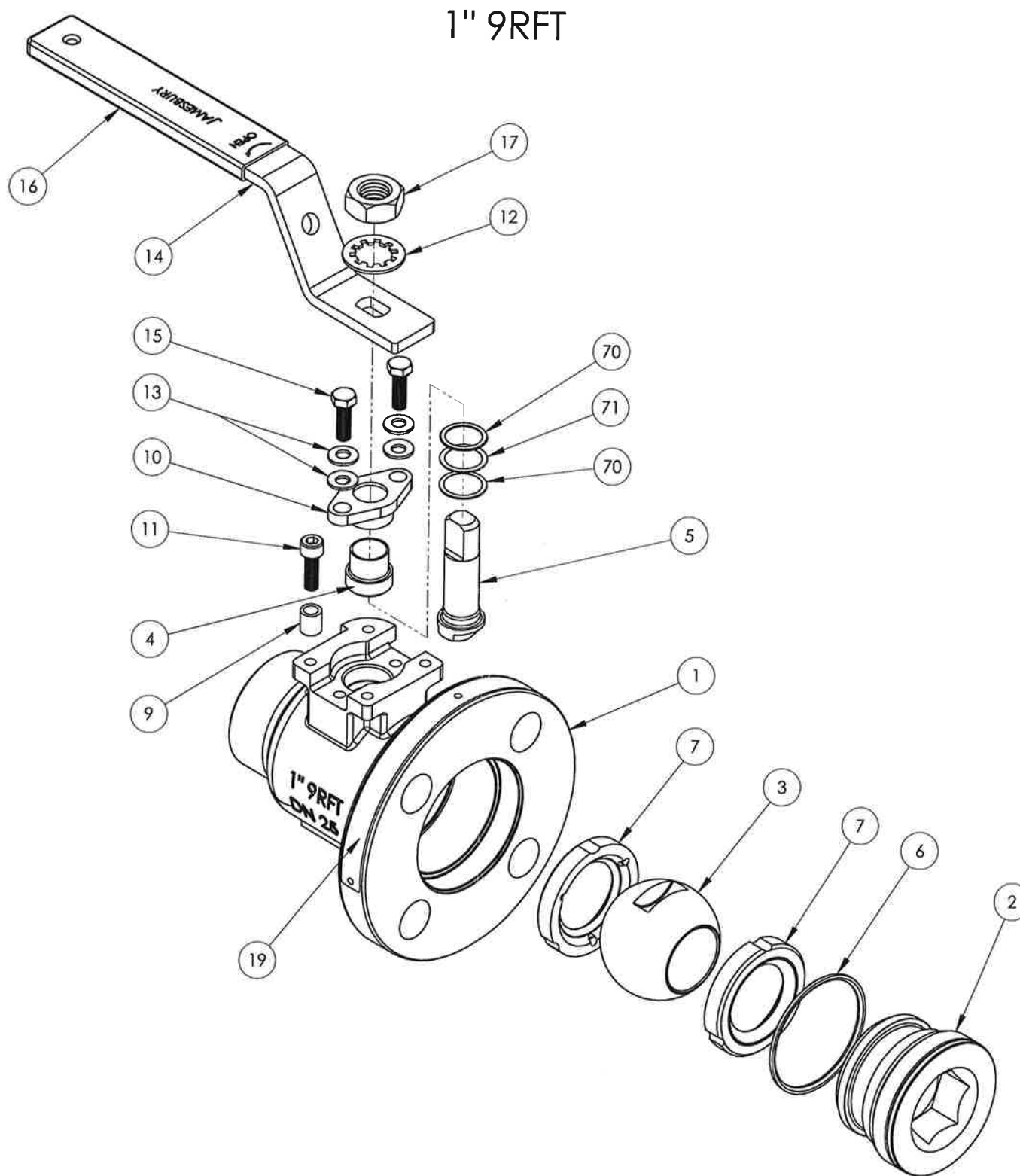
TABLE 1 INSERT TORQUE	
VALVE SIZE	TORQUE LB-FT (±10%)
1"	200

TABLE 2 HEX HEAD CAP SCREW TORQUE	
VALVE SIZE	TORQUE LB-IN.
1"	20

TABLE 3 HANDLE NUT TORQUE	
VALVE SIZE	TORQUE LB-FT
1"	20-25



PROPER DISC SPRING ORIENTATION



ITEM NO.	DESCRIPTION	QTY.
1	BODY	1
2	INSERT	1
3	BALL	1
4	STEM SEAL	1
5	STEM	1
6	BODY SEAL	1
7	SEAT	2
9	STOP SPACER	1
10	COMPRESSION PLATE	1
11	SOCKET HEAD CAP SCREW	1
12	SHAKEPROOF WASHER	1
13	DISC SPRING	4
14	LEVER HANDLE	1
15	HEX HEAD CAP SCREW	2
16	LEVER HANDLE VINYL COATING	1
17	HANDLE NUT	1
19	IDENTIFICATION TAG	1
70	STEM BEARING	2
71	SECONDARY STEM SEAL	1

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UNLESS OTHERWISE NOTED DIMENSIONING, TOLERANCING, & DRAWING INTERPRETATION IS IN ACCORDANCE WITH ASME Y14.5M

ANGLES = 45° FINISH = 250 REMOVE SHARP EDGES AND CORNERS TO 02-03 RADIUS OR CHAMFER, DIMENSIONS IN INCHES

SPECIFICATIONS TO BE USED IN CONNECTION WITH THIS DRAWING: JSA-1, JSA-10, JSA-17, JSA-80, JSA-34, JST-02, JMA-9B

DO NOT SCALE DRAWING

SCALE: 1:1

TITLE: ASSEMBLY 1", 2", 3" 9RFT RAILROAD VALVE

DATE: 8/29/01

APPROVED: PJD

DATE: 8/29/01

SIZE: D DWG NO: 5428

REV: B