



QUIFER ACTUATORS SL.

CONSTRUCCIÓN DE ACTUADORES, REDUCTORES
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DUCTILE IRON

INSTALLATION, SAFETY & MAINTENANCE INSTRUCTIONS

1- SPECIAL HAZARDOUS AREAS

The Rack & Pinion pneumatic actuators manufactured by QUIFER ACTUATORS S.L. are designed to be used in the following potential explosive zones: Zone 1 & 2 for gases and Zone 21 & 22 for dust.

  II 2GD C T6 / IP-67 T85°C Ta: -20 / +60°C

2- GENERAL SAFETY PRECAUTIONS.

The QUIFER Rack and Pinion Pneumatic Actuators are specifically designed to operate quarter-turn valves, such as Ball, Butterfly and Plug valves. As such they should be:

- Used as specified.
- Regularly maintained to remain in good working order.
- Not be modified without first consulting Quifer or an Authorised Quifer agent.

BEWARE; METAL SURFACES ARE EXCELLENT HEAT CONDUCTORS.

Protect HANDS and EXPOSED SKIN whenever handling ACTUATOR OR ACCESSORIES in extreme temperature environments.

BEWARE AT ALL TIMES; KEEP FINGERS CLEAR OF ALL MOVING PARTS.

3- ACTUATOR DESIGNATION

The actuators are designated as follows:

K-xxx ⇒ Double Acting Actuators

KM-xxx -yy ⇒ Single Acting Actuators

xxx Designates actuator size.

yy Denotes the number of springs.

4- GENERAL DATA

Interface for positioner or signal transmitters dimensions in accordance with: **VDI/VDE-3845**

Valve connection flange according to: **ISO-5211**

Solenoid valve interface: **DIN228/1**

Working pressure: 1 - 8 Bar Double Acting Actuators
3 - 8 Bar Single Acting Actuators.

Medium: Air or non-corrosive gas.

Working temperature: -20°C to 60°C.

Travel stop adjustment: 0°±2,5° to 90°±2,5°

5- INSTALLATION

BEWARE; NEVER WORK ON AN ACTUATOR WITH MAINS AIR CONNECTED.

BEWARE AT ALL TIMES; KEEP FINGERS CLEAR OF ALL MOVING PARTS

A) Determine valve direction of rotation.

B) Determine correct operating quadrant for mounting bracket according to direction of rotation and whether valve is Normally Open (N/O) or Normally Closed (N/C).

C) Attach bracket/actuator/valve assembly as follows:

- 1) Rotate valve stem to correct operating position (N/O or N/C).
- 2) Attach mounting bracket to valve. Do not fully tighten the bolts at this time.
- 3) Insert coupling onto valve stem making that sure that the coupling is correctly engaged.
- 4) Mount actuator onto the valve ensuring the coupling insert engages properly into drive sleeve of the actuator drive shaft.
- 5) Secure bracket to valve using correctly sized fasteners (nuts & bolts) and tighten them fully.
- 6) At this point CHECK that both actuator and valve are in the correct operation mode (N/O or N/C).
- 7) If the actuator is not mounted correctly, remove the actuator and repeat the mounting procedure.

6- MAINTENANCE

All actuators are supplied with sufficient lubrication for their normal working life. However if required, a recommended lubricant is OPTIMOL LONGTIME 2 grease.

Depending upon the actuator operating conditions: e.g. extended duty; contaminated operating medium (air/gas) or any other abnormal operating conditions. Regular inspection and replacement of internal seals is recommended. Spare Parts Kits are available and can be easily obtained by contacting QUIFER ACTUATORS SL.

Spare Parts Kits are identical for both double and single acting versions.

Springs are supplied as complete sets with preloading inserts.

7- STORAGE

For those applications where the actuator is not put into immediate service (or is used in an intermediate function) it is recommended that the actuator is cycled, under air pressure, at least once every 3 months. When it is not possible to cycle with air the actuator should be manually turned through 2 – 3 strokes. Indoor storage, wherever possible, is recommended. Care should be taken to plug the cylinder ports to keep them free from the ingress of foreign particles and/or moisture. Actuators should not be stored in an aggressive atmosphere, which could be harmful to the elastomeric seals.

8- DISASSEMBLY AND ASSEMBLY INSTRUCTIONS

8.1.- Disassembly

BEWARE AT ALL TIMES; THE ACTUATOR MUST BE ISOLATED FROM BOTH MAINS AIR AND ELECTRICALLY BEFORE STARTING ANY MAINTENANCE OPERATION.

- 1- Remove all control accessories, such as solenoid valves, positioners, and limit switches Etc, from the actuator.

- 2- Remove both end caps (5) removing all end cap bolts (15).
- 3- Remove pistons (2) by rotating the drive shaft (3) clockwise.
- 4- Release the drive shaft (3) by removing the retaining ring (7) and thrust washer (6).

The actuator is now completely disassembled and maintenance can begin.

8.2.- Assembly

- 1- Replace all bearings (4,9) and seals (8,10,15,18), ensuring that all components are clean and greased.
- 2- Before assembling components, ensure the drive shaft, piston teeth and springs (if spring-return actuator) are well greased.
- 3- Before assembly, ensure cylinder valve ports are free of dirt and grease by blowing through with an air gun. Hold actuator with valve ports facing towards you and the Drive Shaft location hole uppermost.
- 4- Lower the drive shaft (3) into the body (1), and fix it by installing the thrust washer (6) and the retaining ring (7) into place.

- 5- Rotate the drive shaft (3) clockwise until the 4mm drive shaft top groove is at 45° to the bottom right. At this point assemble both pistons (2) by pushing them simultaneously into the body (1).
- 6- **Check that the 4 mm drive shaft top groove is at right angles to the piston bore.** If it is not, then the piston rack (2) is out of position with the drive shaft, repeat the process until the groove **is at right angles (90°)** to the piston bore.
- 7- Install the Springs (13) (only requires in spring return actuators)
- 8- Fit end caps (5) and end cap bolts (14).

Now the actuator is completely assembled. But will require adjustment of the travel stops when it is mounted to the process valve. (Covered in Section 8)

At this point check the actuator does not leak and rotates through 90°.

