

ONYX VALVE COMPANY

Model CER CML-750 ACTUATOR

Installation & Maintenance

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Model CER with Rotork CML-750 ACTUATOR

Installation & Maintenance

OPERATION:

The Onyx series CER is an electric operated pinch valve. It will fail in last position on loss of electric power. The Rotork electric actuator has a linear output that directly opens and closes the pinch valve. Positive opening tabs molded into the sleeve attached to the pinch bar insure complete opening.

TESTING:

All Onyx pinch valves are tested to customer specifications before shipment. Unless otherwise specified, all valves are shipped assembled with all actuator limit switches, torque switches, and positioners fully adjusted and calibrated.

STORAGE

Correct storage extends valve life. The rubber sleeve in the valve is perishable. Ideal storage conditions are 50°F and 60% relative humidity.

1. Keep valves and spare sleeves as cool as possible. They can be stored in an unheated area but allow maximum ventilation in storage areas subject to high ambient summer temperatures. Truck trailers and storage sheds become incredibly hot during summer months. Avoid such locations.
2. Avoid sunlight. Ultra-violet light accelerates the deterioration of rubber. Leave the valve in its box. If not feasible to box the valve, cover the sleeve with black plastic.
3. Avoid ozone. DO NOT STORE valve near active electrical equipment. For long term storage, coat the face and inside the sleeve with silicone spray or liquid.

DESIGN CRITERIA

The **maximum process temperature** that the valve can tolerate is based on the elastomer used to fabricate the sleeve.

Poly Isoprene	Chloroprene	EPDM Ethylene Propylene	Nitrile	Butyl	Fluorocarbon
PGR Pure Gum Rubber	Neoprene	Nordel	Buna-N	Butyl	Viton
-30°→+180° F -34°→+82° C	-20°→+220° F -29°→+104° C	-40°→+300° F -40°→+150° C	-30°→220° F -34°→104° C	-30°→+225° F -34°→+106° C	-15°→+375° F -26°→+190° C

The **maximum safe process pressure** that the valve sleeve and housing can tolerate is based on valve size and flange rating. For Onyx model CER – Rotork CML valves with 150# flanges maximum process pressure:

Size	½ -2	2½ & 3
P _{max} psi	100	75

Notes:

1. Higher pressure ratings are available on special order.
2. This is the maximum safe pressure that the valve body can safely handle. The actuator is sized to close against the line pressure stipulated on the customer's PO and in most cases is significantly lower than max rated housing pressure shown here. Check name tag on the valve for maximum operating pressure based on actuator available thrust.

INSTALLATION:

1. **Inspection:** Inspect the valve before installation. Report any shipping damage before installation. DO NOT INSTALL A VALVE KNOWN TO HAVE BEEN DAMAGED IN SHIPMENT. Check inside the valve to make sure no foreign objects are present.

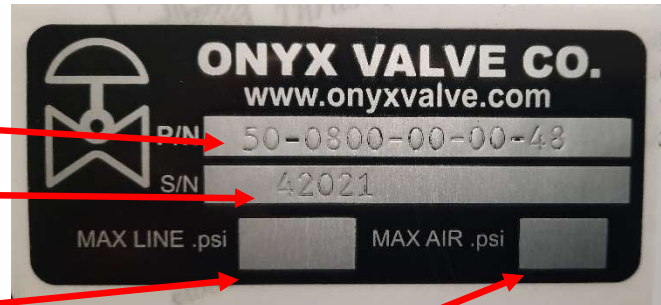
2. **Identification:**

Part#. Use this number when ordering spare/replacement parts.

Serial#

This is the pressure that the valve was tested at the factory prior to shipping.

This is the maximum compressed air pressure feeding the actuator.



3. **Safety:**

- a) Consider the possibility of leakage. Pinch valves handle abrasive fluids; it is reasonable to expect the rubber sleeve to eventually wear out and leak. Precautions should be taken where liquids may spray out or drip down onto electrical equipment or plant personnel or combustible fluid may drain into a dangerous area.
- b) After shutting down: Pinch valves can hold pressure in a system for a considerable length of time. Means should be provided to safely relieve pressure and drain lines.

4. **Flanges:**

- a. Onyx pinch valves are designed to work with standard ANSI 150# (or 300#) flanges.
- b. No gasket is required; the sleeve face *is* the gasket.
- c. Make sure the inside edges of mating flanges are filed or ground smooth. Any sharp edges on the inside corner of mating flanges will cut the rubber sleeve causing premature failure.
- d. Valve flanges have through holes and are designed to have an ANSI hex (not heavy hex) nut behind the flange. Flange bolts must be inserted from the mating flange side.
- e. Use **flat face flanges**. Do NOT use raised face flanges. Raised face flanges cut into the rubber sleeve damaging it.
- f. Flange bolts must be installed through the mating flanges. Flange bolts can **not** be inserted from the valve side of the flange assembly.



Bolt valve into pipeline. Snug up the bolts gently in a crisscross pattern. It may be necessary to re tighten bolts later after the rubber has taken set.

BOLT TORQ in FT-LB			
VALVE SIZE	NO OF BOLTS	PINCH VALVE & DUCKBILL	
		*INTIAL TIGHTENING	*RE- TIGHTENING
1	4	30	50
1.5			
2			
2.5		35	55
3		45	65

* Allow at least one hour between the initial and re-tightening.

INSTALL SUFFICIENT PIPE SUPPORTS TO ISOLATE VALVE BODY FROM EXCESSIVE FORCES.



Electrical connections:

a. Safety:

Warning! High voltages may be present inside the electric actuator.

Turn off all power before proceeding with wiring.

All wiring must be performed by a qualified electrician in accordance with local and national electrical codes.

Failure to heed this warning could result in injury, death, and/or damage to equipment.

- a. Wiring: Connect power and control wiring to appropriate terminals inside the actuator wiring compartment.
- b. Refer to wiring diagram supplied with valve actuator for correct wiring sequence.
- c. Refer to instruction manual supplied with actuator for details of operation related to the electric actuator.



Warning!

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5. Startup.

- a. Every Onyx electric actuated valve is tested at final assembly.
 - i. The valve is flanged and pressurized to max working pressure stated on Order Acknowledgement + 10%.
 - ii. Electric actuator is powered up.
 - iii. **Limit switches are set here at the factory. Don't monkey with them.**
 - iv. Torque limits are set here at the factory.
 - v. Positioners and position re-transmitters are calibrated here at the factory and should not require any adjustment in the field.
 - vi. Actuator is operated for 15 minutes. Amp draw and temperature rise are checked in ensure that they are within specified limits.
 - vii. Valve should be plug & Play. You should only have to connect electric power and command signals and valve should be ready to operate.
- b. When you start an electric actuated valve – especially electric valves in modulating service – you should monitor valve operation for the first few hours to ensure that you are not exceeding the actuator's rated duty cycle.

6. Duty Cycle

Electric actuation eliminates the costs associated with air compressors and the danger of frozen air lines. However, electric actuators have specific limitations which must be observed during start up, tuning, and operation.

The Rotork CML-750 is a continuous duty rated actuator so it can run at a very demanding duty cycle, none the less it is advisable to tune the control loop so that the actuator has a rest interval between every jog up and down and to make sure that the valve isn't "dithering".

Depriving the actuator of a rest interval will shorten motor life. **What can go wrong** tuning the control loop with an electric actuator:

- a. **Too much gain:** Inside your SCADDA system is a unique PID module dedicated to controlling every modulating valve in the plant. This PID module has to be "tuned" to match each individual valve's response characteristic. To do this, the programmer in charge of the SCADDA system adjusts the gain in the PID module. The natural tendency is to crank up the gain (also known as reducing dead band) in the PID module. This improves accuracy. **BUT: increasing the gain forces the electric actuator to cycle more frequently.**
- b. **The valve port is oversized.** In this situation, the valve seems to control the flow well enough, but even at maximum flow it never goes more than 20% open. When the valve operates close to the seat the high velocity accelerates sleeve wear, requiring more frequent sleeve replacement. The sweet spot is 15% to 90% open. **Operating too close to the seat (< 20% Open) will shorten sleeve life substantially.**

MAINTENANCE

1. Visually inspect valve periodically.
2. Lubricate valve once a year. Coat stem (#7) where it passes through the yoke adapter (#12) with grease. If valve is in a dusty environment, grease may cause dust to stick to the stem; use light oil.

Lubrication Schedule:

- i. At start up: Construction activities can create a lot of abrasive dust so it's a good idea clean and oil the stem at start up.
- ii. Once a year: Clean and oil the stem.



SLEEVE REPLACEMENT

WARNING: Before attempting to disassemble the valve housing the stem must be in the retracted position. Failure to retract the stem could result in equipment damage and/or serious personal injury.

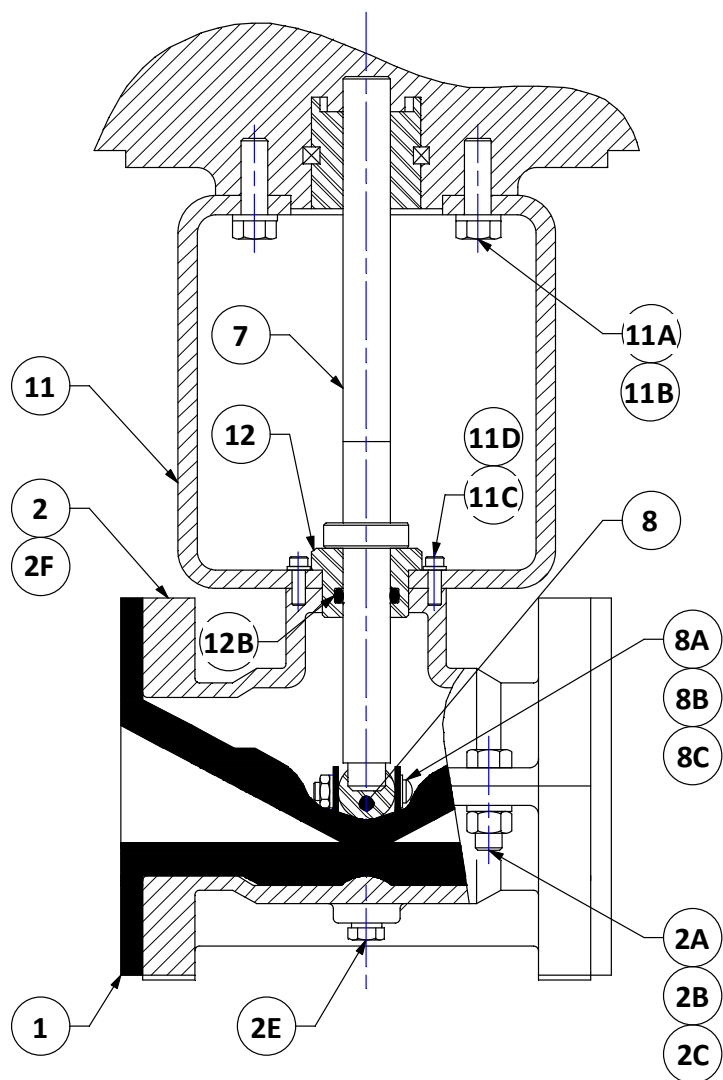
1. Relieve process pressure and drain process line.
2. Disconnect electric lines. Label and record connections so the valve can be reconnected in the same manner.
3. Remove valve from process line.
4. Disassemble valve bonnet assembly (#2) by removing bolts, nuts, and washers (#2A, 2B, 2C).
5. Separate upper and lower bonnet halves (#2).
6. Turn the manual hand wheel override of electric actuator clock wise to push the sleeve clear of the upper bonnet. If the valve is equipped with POF tabs, drive the pinch bar out far enough to access the POF hardware.

7. If sleeve (#1) is provided with positive opening tabs (integrally molded tabs bolted to the pinch bar), follow steps 'a' through 'e' below. If no positive opening tabs are provided, proceed directly to step 10.
- a) Remove bolts, nuts and washers that secure the positive opening tabs to the pinch bar (8A, 8B, 8C). The sleeve (#1) is now free from the pinch bar (#8). Discard old sleeve. Prepare new sleeve for installation.
 - b) Punch holes through the positive opening tabs using a gasket or pliers type punch. The diameter of the holes in tabs should be approximately equal to hole diameter in pinch bar.
 - c) Positive opening tab holes must be in proper alignment with respect to the flange face holes, or there will be hell to pay when you reinstall the valve. It is very difficult to twist the rubber sleeve to align these holes later.
 - d) Replace tab bolts, nuts and washers (#8A, 8B & 8C). Use flat washers on every hole. If you replace bolts (#8A), cut or grind flush with nut (#8C) so bolts do not puncture sleeve in closed position.
 - e) Trim the tabs even with the top surface of the pinch bar.



8. Apply a coat of silicone valve sealant to the mating flanges of the bonnet assembly.
9. Coat the stem (#7) where it passes through the yoke adapter with a light application of grease or machine oil.
10. Reinsert the adapter (#12) into the upper bonnet (#2) and reattach to yoke (#11) using the spud nut (#12A).
11. Pull bonnet halves together with clamps or by temporarily inserting threaded rods in diagonally opposite holes and drawing bonnet into bolting range by gradually turning nuts down the threaded rods. Replace bonnet hardware (#2A, 2B & 2C).
12. Reinstall valve in process line.
13. Reconnect electric lines.

ITEM	NOMENCLATURE
1	SLEEVE
2	BONNET ASSEMBLY
2A	BOLT, BONNET
2B	LK. WASHER, BONNET
2C	NUT, BONNET
2E	PLUG, BONNET
2F	SEALANT, BONNET
7	STEM, VALVE
8	PINCH BAR
8A	BOLT, POF
8B	WASHER, POF
8C	NUT, POF
11	YOKE
11A	BOLT, YOKE - ACTUATOR
11B	LK. WASHER, YOKE - ACTUATOR
11C	BOLT, YOKE - BONNET
11D	LK. WASHER, YOKE - BONNET
12	YOKE ADAPTER
12B	"O"-RING, YOKE ADAPTER O.D.



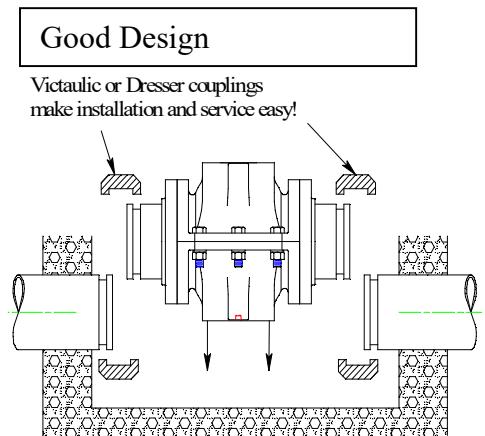
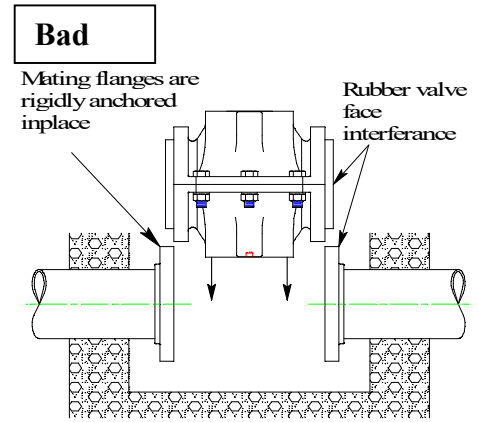
7. Installation Design considerations:

- a. If the valve is at the end of a pipe run, install a flange ring on the discharge end of the valve to seal the properly.
- b. Design the installation so the valve can be removed and reinstalled later.

Pinch valve sleeves wear out and have to be replaced. The rubber sleeve is molded longer than the housing to provide enough compression in the rubber to prevent leaks. If mating pipe flanges are rigidly anchored in concrete or welded in place, you might be able to remove the valve from the line but there will be hell to pay when you attempt to reinstall it. The protruding rubber faces of the sleeve will thwart any attempt to get the valve back into place.

- c. Using a Victaulic or Dresser coupling will facilitate removal and make it easy to reinstall the valve later.

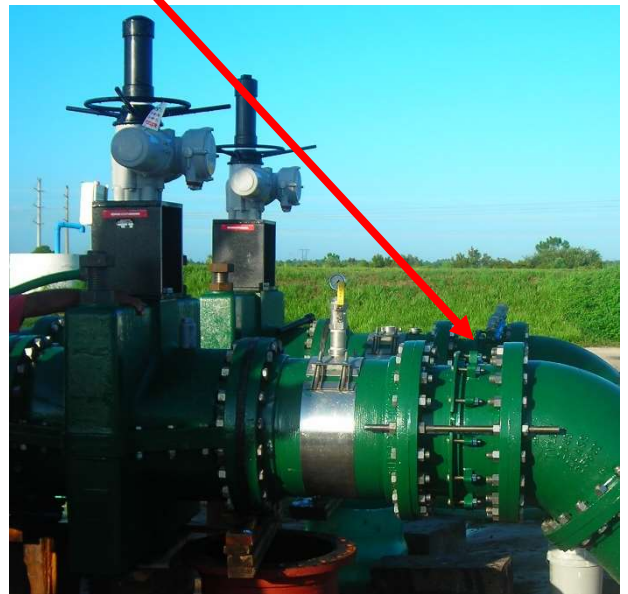
By using split couplings, the mating flanges can be attached to the valve first and tightened prior to installation. Then the entire assembly can be dropped into place and secured with the split couplings.



Victaulic couplings.



Dresser coupling



- d. On valves **for modulating service**: Allow at least 2-pipe diameters straight run into throttling valves as a minimum.

Good ↓



Better ↓



- e. Valves for **On/Off service** can be connected directly to adjacent pipe fittings without straight run in or out.



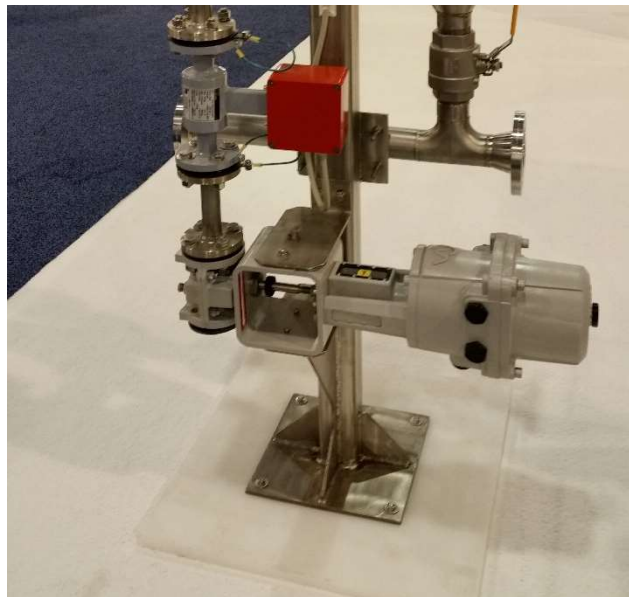
Orientation:

- f. Orientation: There are 4-ways to install a pinch valve. 1 and 2 are good. #3 is bad.

1. Valve upright in **horizontal pipe**. Always good. Works with liquid and dry bulk applications.



2. Valve installed in vertical pipe. Works well with both liquid and dry material.

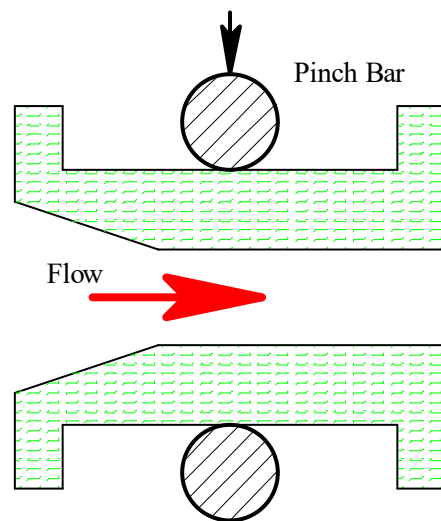


3. **BAD:** Trouble brewing. Valve at an intermediate angle between vertical and horizontal. Don't do this.



Most pinch valves can be installed with flow in either direction.

The exception: modulating valves with Trumpet Mouth (Taper-Inlet-Only) design. In this case there will be a Flow Arrow on the valve showing correct flow direction. The correct flow direction is always from the tapered end towards the non-tapered end.



Trouble Shooting:

Symptom:	Diagnosis	How to fix:
Process fluid is leaking out from around the stem and guide rods.	Sleeve is ruptured	Replace sleeve.
Process fluid is leaking through valve when it's supposed to be fully closed. Limit switch shows valve is in full closed position.	Wire draw failure through sleeve.	Replace sleeve.
Leaking through valve seat when valve is supposed to be fully closed. Limit switch shows valve is not in full closed position.	Either there is a foreign object stuck inside the valve or the actuator limit switch or the actuator torque setting is not correct	Refer to Actuator I&M.

ONYX VALVE COMPANY

WARRANTY

The following statement of our Warranty and Claims Policy is intended to assist our customers in understanding the terms of our warranty, the circumstances under which we will honor claims, and the procedure for making claims.

1 Warranty on Products Manufactured by Us.

We warrant Products manufactured by us to be free from defects in material and workmanship for a period of one year from the date of shipment from our factory or warehouse.

Our liability under this warranty or in connection with any other claim relating to our Products is limited to the repair, or at our option, the replacement or refund of the purchase price of any products or parts or components which are returned to us freight prepaid which are defective in material or workmanship. Products or parts or components that are repaired or replaced by us will be returned to our customer freight collect.

With regards to rubber components, Onyx Valve does not guarantee resistance to erosion, abrasion or other sources of failure, nor does Onyx Valve guarantee a minimum length of service or that the product shall be fit for any particular service.

2. Products of Other Manufacturers.

We make no warranty with regard to any products not manufactured by us. The only warranty that attaches to such Products is that warranty, if any, of the manufacturer of such Products. Our Customer Service Department should be consulted if our customers have questions as to whether particular products are covered by our warranty or are separately warranted by their manufacturers.

3 Limitation of Liability.

The only warranty that we make to our customers is that summarized above.

WE DO NOT MAKE ANY OTHER EXPRESS WARRANTIES OR ANY IMPLIED WARRANTIES, INCLUDING ANY IMPLIED WARRANTY OF MERCHANTABILITY OR OF FITNESS FOR A PARTICULAR PURPOSE OR USE.

In addition, we do not assume and we expressly disclaim any liability for (i) any special, indirect, incidental, or consequential damages which anyone may suffer as the result of the sale, delivery, servicing, use, or loss of use, of any Product, or (ii) any charges or expenses of any nature that are incurred without our express written consent.

Our total liability under our warranty or in connection with any claim involving any Product is expressly limited to the purchase price of the Product in respect of which damages are claimed.

Failure of purchaser to give prompt written notice of any alleged defect under this guarantee forthwith upon its discovery, or use, and possession thereof after an attempt has been made and completed to remedy defects therein, or failure to return product or part for replacement as herein provided, or failure to install and operate said products and parts according to instructions furnished by Onyx Valve, or failure to pay entire contract price when due, shall be a waiver by purchaser of all rights under these representations. All orders accepted shall be deemed accepted subject to this warranty which shall be exclusive of any other or previous warranty, and shall be the only effective guarantee or warranty binding on Onyx Valve.

4. What Is Not Covered By Our Warranty; Types of Damages and Claims For Which We Are Not Responsible.

The following are examples of the kinds of defects which are not covered by our warranty: defects which are caused by improper installation, improper or abnormal use or operation, or improper storage or handling; defects caused by our customer's failure to perform normal preventive maintenance; defects caused by the use of replacement parts not manufactured or supplied by us; defects caused by repairs by persons not authorized by us; defects caused by modifications or alterations made by our customer, and any damage to our Product occurring while it is in our customer's possession. Since these are examples and not a complete list, we suggest that our customers contact our Customer Service Department if they have any questions concerning the scope of our warranty.

Additional costs incurred by our customers because of delays in delivery are consequential damages for which we are not responsible.

Risk of loss or damage to our Products passes to our customer when we tender our Products to the carrier. Although we cannot process transit damage claims with any carrier on a customer's behalf, we will provide reasonable assistance to our customers when such claims arise.

5. Consultations with Customers.

When so requested, our engineers and other personnel may consult with our customers concerning our Products. While our employees offer their best judgment on any question, the ultimate responsibility for selecting that Product which will perform the functions and applications desired by the customer rests with the customer. As noted above, we make no warranty, express or implied, as to the fitness of any Product for any particular purpose or use.

6. How to Make a Claim.

Within the limits of the terms and conditions set forth on our quotation and acknowledgment forms and in this Warranty and Claims Policy, we will honor reasonable and justified claims when adequate evidence is provided to show that our Product was defective.

Whenever a customer has a claim concerning a Product, the customer should contact the Customer Service Department. CUSTOMERS SHOULD NOT RETURN ANY PRODUCTS OR PARTS OR COMPONENTS TO US WITHOUT FIRST CONTACTING US.

When contacting us, customers should have the following information available:

1. Customer name, location, purchase order number and date of purchase.
2. Serial number.
3. Product/Model number.
4. Equipment installation date.
5. Equipment failure date.
6. Application or service of unit.
7. Details of claim.

We shall have the option of requiring the return of the defective product to our factory, with transportation charges prepaid, to establish the claim and our liability shall be limited to the repair or replacement of the defective product, F.O.B. our factory. Onyx Valve Co will not assume costs incurred to remove or install defective products nor shall we incur back charges or liquidated damages as a result of warranty work.

We will notify the customer whether it will be necessary to return the Product or part or component to us. If so, we will issue the customer an "AUTHORIZED RETURN GOODS NUMBER" that must be attached to the Product or part or component before returning it. All items returned to us must be returned freight prepaid.

If we determine that the Product or part or component is defective and that the defect is covered by our warranty, we will, as explained above, correct the defect or refund the purchase price.

Customers should promptly inspect all Products upon delivery. Customers must make claims for shortages within 20 days after the date of shipment from our factory or warehouse. We suggest that shortages be noted on the bill of lading or packing list, which should then be sent to our Customer Service Department for verification.

All other claims must be submitted within 60 days after the date of shipment from our factory or warehouse, or in the case of an alleged breach of warranty, within 60 days after the date within the warranty period on which the defect is or should have been discovered.

Claims may not be deducted from payments made to us unless we have so agreed in writing in advance.

Questions?

Contact Onyx Valve Company

Phone: 1-856-829-2888 extension 112

Fax: 1-856-829-3080

Email: david@onyxvalve.com