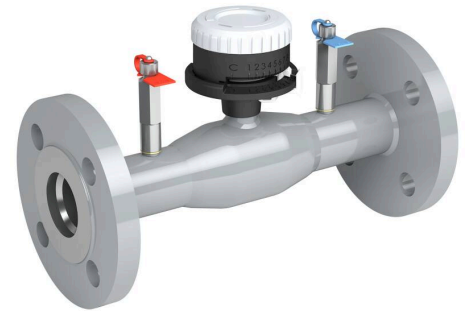




# X-balancing valves, stainless steel, reduced bore

243X series, X-series, flange / flange, DN 15-50, reduced bore

Body	DN 15-50 Stainless steel, AISI316L (1.4404)
Ball	DN 15-50 Stainless steel, AISI316L (1.4404), flowtube composite
Ball seal	DN 15-50 PTFE+GF
Stem	DN 15-50 Stainless steel, AISI316L (1.4404)
Stem seal	DN 15-50 FPM/NBR
Measuring block	DN 15-50 Self-sealing, stainless steel, X8CrNiS18-9 (1.4305)
Operation	DN 15-50 with precision control knob
Flanges	EN 1092-1 Available PN 10, 16, 25, 40



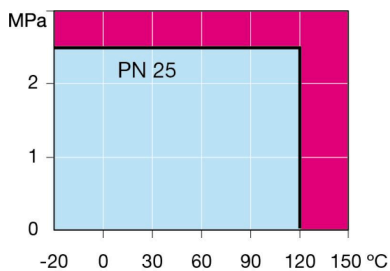
## Operation conditions

-20 ° – +120 °C

Below -20 °C contact manufacturer

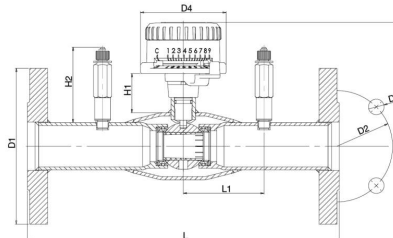
Lowest allowed ambient temperature -40 °C

Leakage rate A (EN 12266-1)



Not for steam

DN 15-50



DN	PN	Product no.	D1	D2	D3	D4	H	H1	H2	L	L1	kg
15	25	243015X	95.0	65.0	14.0	77.0	101	38.5	68	250	73	1.9
20	25	243020X	105.0	75.0	14.0	77.0	105	38	68	250	73	2.5
25	25	243025X	115.0	85.0	14.0	77.0	107	37	68	240	73	3.0
32	25	243032X	140.0	100.0	18.0	77.0	111	35	68	280	73	4.8
40	25	243040X	150.0	110.0	18.0	77.0	116	35	68	270	73	5.6
50	25	243050X	165.0	125.0	18.0	77.0	123	39	68	310	73	7.7

Vexve's balancing valves can be found e.g. from libraries of TA-SCOPE and SmartBalancing measuring devices.



# Balancing valves, stainless steel, reduced bore

243 series, flange / flange, DN 65-150, reduced bore

Body	DN 65-150 Stainless steel, X2CrNiMo17-12-2 (1.4404)
Ball	DN 65-150 Stainless steel, X2CrNiMo17-12-2 (1.4404)
Ball seal	DN 65-150 PTFE+GF
Stem	DN 65-150 Stainless steel, X2CrNiMo17-12-2 (1.4404)
Stem seal	DN 65-150 FPM/NBR
Measuring block	DN 65-150 Type Oras, stainless steel, X2CrNiMo17-12-2 (1.4404)
Operation	DN 65-150 With zinc-plated steel handle
Flanges	EN 1092-1 Available PN 10, 16, 25, 40



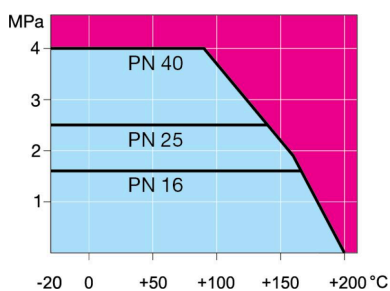
## Operation conditions

-20 °C – +200 °C

Below -20 °C contact manufacturer

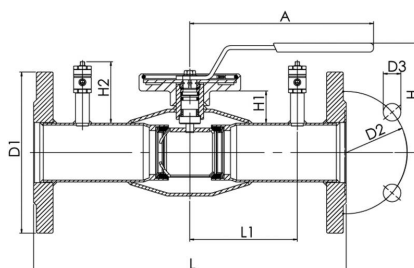
Lowest allowed ambient temperature -40 °C

Leakage rate A (EN 12266-1)



Not for steam

DN 65-150



DN	PN	Product no.	A	D1	D2	D3	H	H1	H2	L	L1	kg
65	16	243065	280	185.0	145.0	18.0	160	58	82	310	110	10.1
80	16	243080	280	200.0	160.0	18.0	173	64	82	310	110	12.0
100	16	243100	280	220.0	180.0	18.0	173	52	82	350	122.5	15.9
125	16	243125	400	250.0	210.0	18.0	221	68	82	355	137.5	25.6
150	16	243150	600	285.0	240.0	22.0	240	74	82	370	150	30.0

Vexve's balancing valves can be found e.g. from libraries of TA-SCOPE and SmartBalancing measuring devices.

# Balancing valves, stainless steel, reduced bore

243 series, flange / flange, DN 200-250, reduced bore



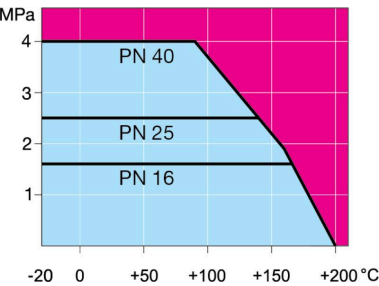
Body	DN 200-250 Stainless steel, X2CrNiMo17-12-2 (1.4404)
Ball	DN 200-250 Stainless steel, X2CrNiMo17-12-2 (1.4404)
Ball seal	DN 200-250 PTFE+GF
Stem	DN 200-250 Stainless steel, X2CrNiMo17-12-2 (1.4404)
Stem seal	DN 200-250 FPM/NBR
Measuring block	DN 200-250 Type Oras, stainless steel, X2CrNiMo17-12-2 (1.4404)
Operation	DN 200-250 Valve is equipped with manual gear
Flanges	EN 1092-1 Available PN 10, 16, 25, 40



## Operation conditions

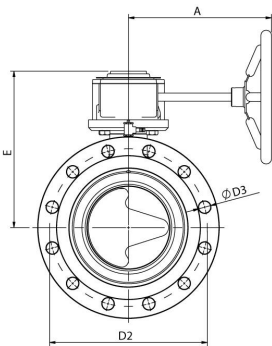
-20 °C – +200 °C  
Below -20 °C contact manufacturer  
Lowest allowed ambient temperature -40 °C

Leakage rate A (EN 12266-1)

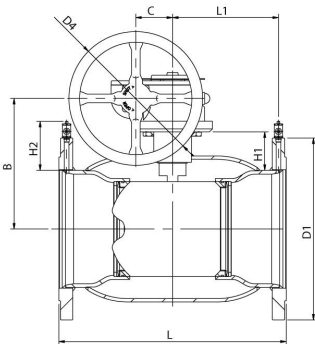


Not for steam

DN 200-300



DN 200-300

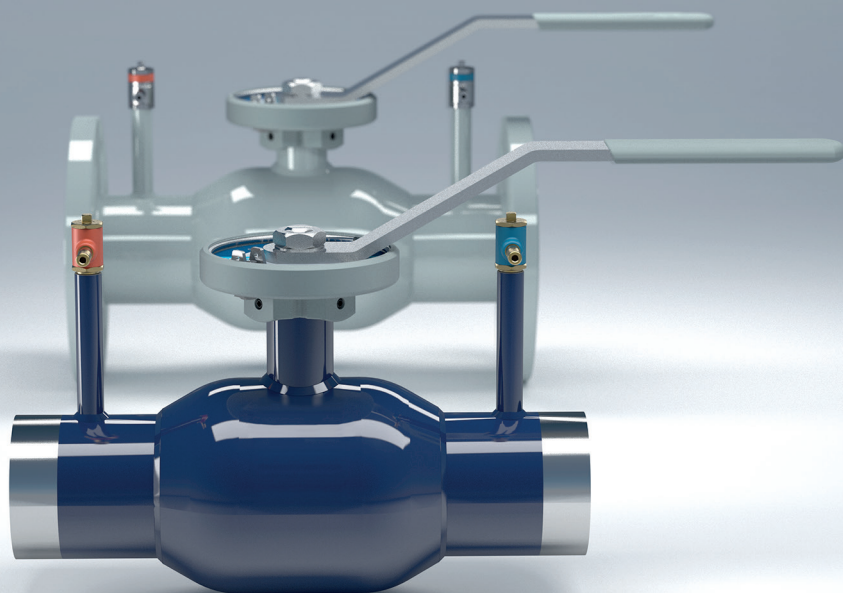


DN	PN	Product no.	A	B	C	D1	D2	D3	D4	E	H	H1	H2	L	L1	kg
200	16	243200	268	244	69	340.0	295.0	22.0	250.0	293		72	92	425	198	56.7
250	16	243250	301	294	97	405.0	355.0	26.0	300.0	345		88	97	550	259	103.9

Vexve's balancing valves can be found e.g. from libraries of TA-SCOPE and SmartBalancing measuring devices.



Balancing valves,  
steel and stainless steel  
installation, operation and maintenance manual



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#### NOTE:

This manual must be read and its instructions must be followed when installing, operating and/or performing maintenance on the valve as well as its manual gear or actuator.

These instructions are of general nature and do not cover all possible operating scenarios. For more specific guidance on the installation, operation and maintenance of the valve or its suitability for an intended use, please contact the manufacturer.

Vexve reserves the right to make alterations to these instructions.

Vexve is not responsible for damages caused by incorrect transportation, handling, installation, operation or maintenance. Furthermore, Vexve is not responsible for damage caused by foreign objects or impurities.

## Warranty

Warranty according to Vexve's "General terms and conditions of sale".

The warranty covers manufacturing and material faults. The warranty does not apply to damages caused by inappropriate installation, operation, maintenance, or storage ie. these instructions must be followed for the warranty to apply. Vexve requires that any faulty products under warranty are to be returned to the factory for inspection. Only after the product has been found faulty, Vexve can grant compensation.

Please refer to Vexve's "General terms and conditions of sale" for detailed warranty clauses. The document is available from the manufacturer

## Warnings and symbols

Ignoring the warnings and symbols may lead to serious injury or equipment damage. Persons authorized to use the equipment must be familiar with the warnings and instructions.

Appropriate transportation, storage and installation as well as careful commissioning are essential to ensure faultless and stable operation.

The following symbols are used in this manual to draw attention to actions essential to ensure the proper use and safety of the device.



#### Meaning of the symbol: NOTE

The NOTE symbol is used for actions and functions that are essential for the proper use of the device. Ignoring this symbol may have harmful consequences.



#### Meaning of the symbol: WARNING

The WARNING symbol is used for actions and functions that, if carried out incorrectly, may lead to injury or equipment damage.



# 1. General

Vexve's fully welded balancing valves are suitable for shut-off and balancing purposes in heating and cooling systems (HVAC/R).

Steel balancing valve (color blue) is designed for clean mediums such as oxygen-free water or glycol.

Stainless steel balancing valve (color grey) is designed for clean mediums. Vexve's stainless

steel balancing valve is suitable also many industry systems where medium is for instance process water, ethanol, methanol, glycol or freezium.

Vexve's balancing valves can be used within the following pressure-temperature range. Please note that the maximum allowable working pressure depends on the operating temperature.

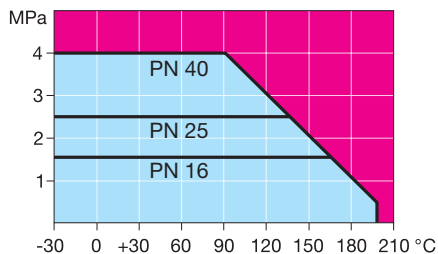
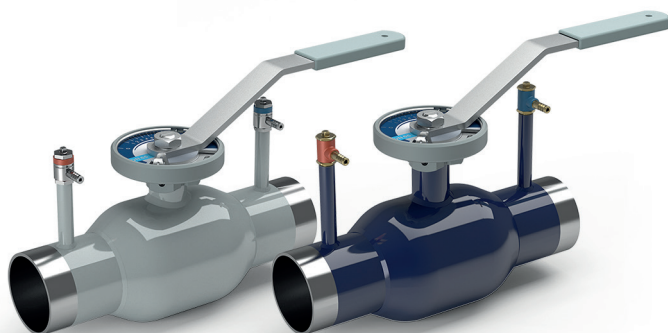


Chart 1.  
Pressure-temperature chart.



## NOTE:

When intending to use the valve for other media or applications please contact Vexve to ensure its suitability.

Parts lists for Vexve's balancing valves are presented in Appendices 7.1 and 7.2

For detailed technical information including dimensions and weights, torques, Kv-values etc please refer to [www.vexve.com](http://www.vexve.com).



## 2. Valve identification

The identification plate locates at the valve body. It has the following information:

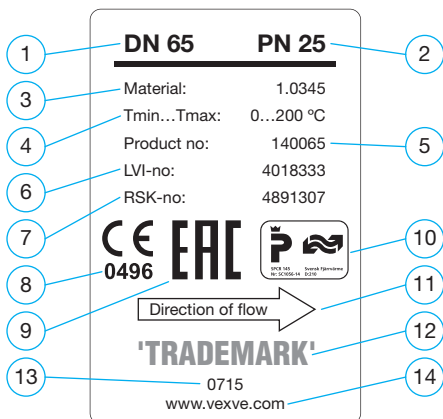


Figure 1. Identification plate.

1. Valve DN size
2. Pressure class
3. Valve Body Material
4. Maximum Allowable Temperature
5. Product number
6. Identification code for Finnish HVAC products
7. Identification code for Swedish HVAC products
8. CE-mark and the number of the notified body
9. Eurasian conformity valve certification
10. Swedish valve certification
11. Direction of flow
12. Trademark
13. Manufacturing date
14. Manufacturer's Website





### 3. Unloading and storage

Check that the contents of the delivery is as ordered. Check that the valve and related equipment have not been damaged during transportation.

Store the valve carefully before installation, preferably in a well-ventilated, dry place, on a shelf or a wooden grid to protect it from rising damp.

Protect bare metal surfaces, shaft parts, and flange surfaces with anti-corrosive agent before storage.

The valve must be transported to the installation site in a sturdy package. Do not remove the flow port protectors before installation. Protect the valve from sand, dust, and other impurities.

Use lifting ropes when lifting the large size valves. It is forbidden to lift the valve by its actuator or stem (see Figure 2).



**NOTE:**

**Take the weight of the valve into account when handling it.**

When delivered, the valve is in the open position. During storage, the valve must also be in the open position.

The maximum storage time is two years.

#### **Packaging:**

Vexve's products are protected during transportation with special packaging. The packaging consists of environmentally friendly materials that are easy to sort and recycle.

Recycling the packaging materials at designated waste collection points is recommended.

The following packaging materials are used: wood, cardboard, paper, and polyethylene sheets.

#### **Recycling and disposal**

Nearly all parts of the valve are made of recyclable materials. The material type is marked on most parts. Separate recycling and disposal instructions are available from the manufacturer. The valve can also be returned to the manufacturer for recycling and disposal against a fee.



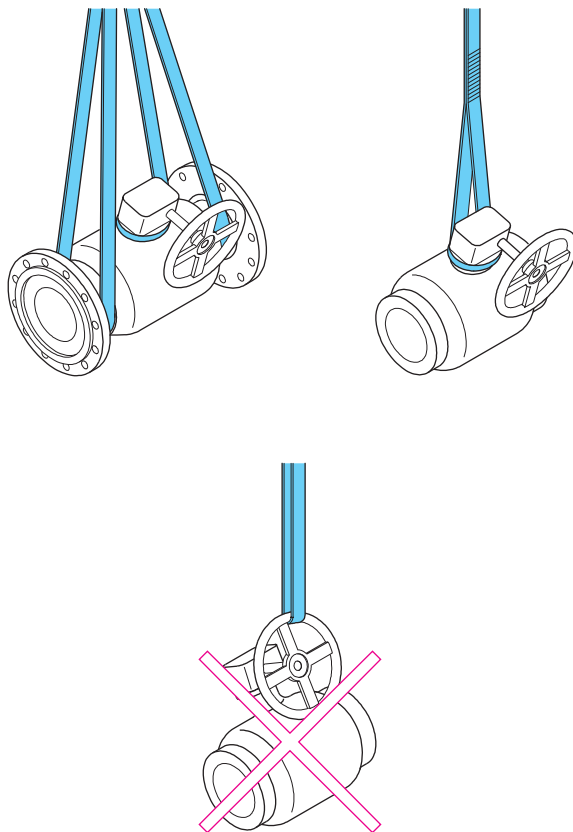


Figure 2. Lifting the valve.



## 4. Valve installation



### WARNING:

Incorrect installation may result in serious personal injury and it may damage or cause malfunction of the equipment. These instructions must therefore be followed carefully when installing the valve.

These general instructions do not cover all possible operating scenarios. For more specific guidance on the use of the valve or its suitability for an intended use, please contact the manufacturer.

- Do not remove the flow port protectors before installation. Keep the valve protected from sand, dust, and other impurities.
- If the valve was delivered with the actuator installed, avoid removing the actuator during installation.
- Incorrect re-installation or adjustment of the actuator will result in a high risk of damage and leakage.
- Exercise extreme caution when testing the valve before installation in the pipeline.
- The valve or valve assembly must not be lifted from the actuator. Dropping or incorrect lifting of the valve can result in personal injury or equipment damage.
- Use one of the allowed lifting methods shown in Figure 2.



### NOTE:

The valve must be used only in applications for which it is intended.

Prior to installation:

- Remove the flow port protectors and check that the inside of the valve is clean.



### WARNING:

The pipeline and valve shall be carefully cleaned prior to installation as any welding debris or other impurities can damage the valve.



Following minimum installation distances should be followed:

In the picture D = pipeline diameter

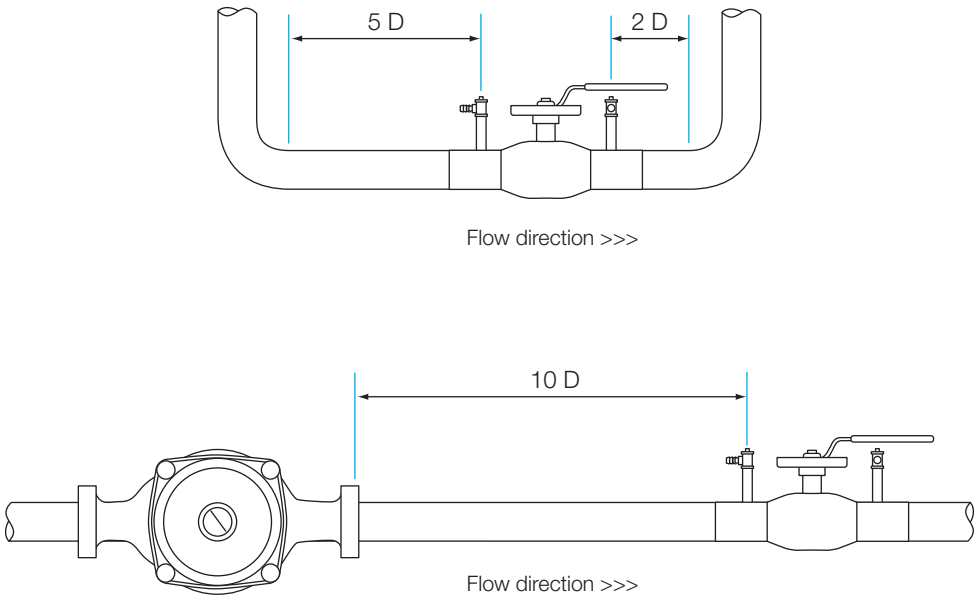


Figure 3. Minimum installation distances



## 4.1 Installation of valve with weld connections

### 4.1.1 Balancing valves < DN300

It is recommended to use the electric welding (TIG, MIG).

Valve size DN 125 and bigger must be welded to the pipeline by using electric welding.

#### Welding

Do not overheat the valve. Use cooling during the welding. Use wet fabric to protect the valve seat from excess heat during the welding. The welder should have the proper qualification to do this kind of welding procedures.

The valve must first be bridged to the pipeline using spot welding, with 4–8 seams alternately on opposite sides of the valve.

During welding the ground must be connected to the pipe of the valve body or the pipeline. Ground cable should be connected to the pipe on the same side as the welding seam. Otherwise the current may damage the valve seal. Never connect the ground to the valve neck, top flange, handle or actuator.

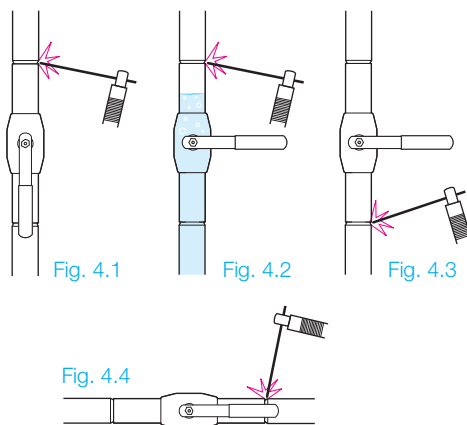
#### When valve is installed in a horizontal position:

When welding the valve, it must be in the open position in order to protect the surface of the ball from welding contamination (See Figure 4.4).

#### When valve is installed in a vertical position:

When making the upper seam welding, the valve must be open in order to protect the surface of the ball from welding contamination (See Figure 4.1).

When making the lower welding seam the valve must be closed to avoid the overheating of the valve (See Figure 4.3).



**Figure 4.1. Vertical position.**

*When welding the upper seam the valve must be in open position.*

**Figure 4.2. Vertical position.**

*When welding the upper seam and lower side of the valve is pressurized the valve must be in closed position. Also cover the seal and ball with a water cushion of minimum 40 mm.*

**Figure 4.3. Vertical position.**

*When welding the lower seam the valve must be in closed position.*

**Figure 4.4. Horizontal position.**

*The valve must be in open position.*

Cool down the valve (after welding) before normal operation. The valve may not be opened or/and closed after the welding before it has cooled down.



## 4.1.2 Balancing valves DN300



### NOTE:

Electric welding must be used to weld the valve in place.

- A valve may be welded only by an authorized mechanic, following valid norms and standards.
- The valve must remain open during installation and welding to ensure that welding residue does not damage the seal surfaces.
- The ends of the pipes must be parallel to the valve and correctly aligned.
- The length of the valve must be the same as the distance between the pipe ends, taking into consideration the welding gaps.
- The inner diameter of the pipes must be the same as the inner diameter of the ends of the valve.
- Recommended installation position for the valve is with the shaft in the vertical or horizontal position.

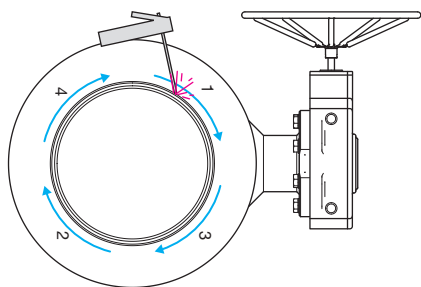


Figure 5. Welding the seams.



### NOTE:

The recommended installation position for the valve is with the shaft in the vertical or horizontal position.

- The valve must first be bridged to the pipeline using spot welding, with 4–8 seams alternately on opposite sides of the valve.
- Then the seams between the bridges are welded as shown in Figures 5. and 6. Welding order: 1-2-3-4.
- Any lid welding must be carried minimum at 200 mm from the valve seam.
- During welding the ground must be connected to the pipe of the valve body or the pipeline. Never connect the ground to the valve neck, top flange or actuator.

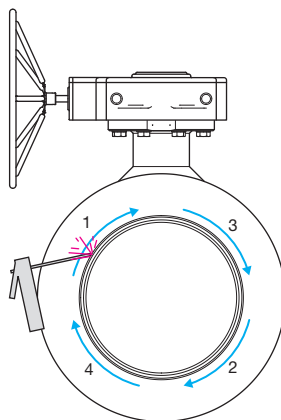


Figure 6. Welding the seams.



## 4.2 Installation of valve with flanges

- Valve may be installed only by an authorized mechanic, following valid norms and standards.
  - The valve must remain open during installation to ensure that any residue or dirt does not damage the sealing faces
  - The sealing faces of the pipe flanges must be parallel to the valve sealing faces and correctly aligned.
  - The length of the valve must be the same as the distance between the flanges in the pipe line, taking into consideration the gasket.
  - The flanges in the pipeline must be compatible with valve flanges. For detailed information please refer to the standard EN1092-1.
- The bolts and nuts used on installation must be selected to match operating conditions at installation location. Bolts and nuts must also fulfill requirements of the pressure, temperature, flange material and gasket. For detailed information please refer to the standards EN 1515-1, EN1515-2 and 1515-4.
  - The gasket used on installation must be selected to match operating conditions, temperature, pressure and medium. Gasket dimensions must be compatible with sealing faces of the flanges. For detailed information please refer to the standard EN1514.
  - Recommended installation position for the valve is with the shaft in the vertical or horizontal position.

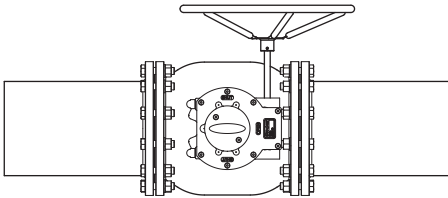


Figure 7. Horizontal installation.

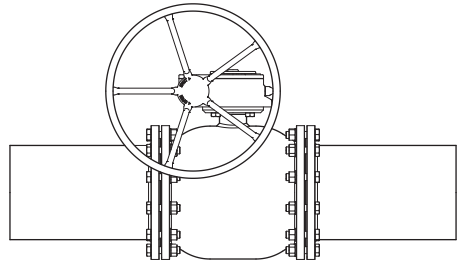


Figure 8. Vertical installation.



## 4.3 Installation at the end of pipeline



### NOTE:

Do not use the valve at the end of the pipeline – a blank flange must always be installed after the valve (see Figure 9. and 10.).

When the valve is installed at the end of the pipeline, there is a risk of corrosion-causing oxygen-rich water or air collecting on the empty rear side of the valve. To prevent corrosion, the space after the valve must be filled with oxygen-free water.

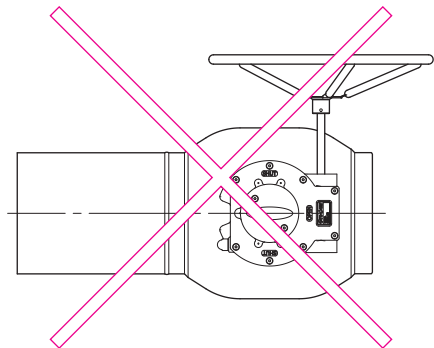


Figure 9. Do not use the valve at the end of the pipeline.

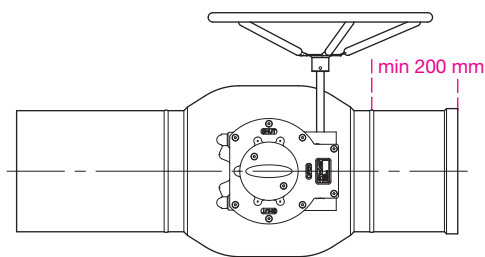


Figure 10. Blank flange.

Min. 200 mm pipe must be installed between the valve and the blank flange.



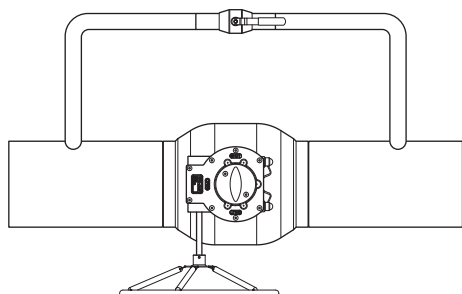
### NOTE:

If the valve is located near to the blind flange at the end of the pipeline, valve must be in the fully open position to prevent a closed space from forming between the valve and blind flange. If water in the closed space expands (for example due to temperature), it may damage the valve.





## 4.4 Before commissioning



To avoid pressure shocks and to reduce the forces caused by opening the valve under pressure, it is recommended to use a by-pass valve in connection with ball valves of size DN150 and larger (see Figure 11).

Figure 11. By-pass valve.

## 4.5 Commissioning and Pressure testing

Exceeding of permitted values marked on the valve may damage the valve and, in the worst case, cause uncontrolled venting of the pressure. This leads to equipment damage and possibly also to personal injuries. The largest allowable testing pressure is  $1,1 \times P_N$ , when the valve is closed. During the pipeline pressure testing ( $1,5 \times P_N$ ), the valve must be open.

## 4.6 Defining the pre-set value

Pre-set value of a valve can be defined by desired  $K_v$ -value of the valve.

- If the desired  $K_v$ -value is known, the suitable valve size and pre-set value can be checked from the table 1.
- If the desired  $K_v$ -value is not known, suitable valve size and pre-set value can be determined with the help of  $K_v$ -curves (available from the manufacturer) in case the desired flow rate and pressure drop across the valve are known



Set value	DN 15/20	DN25	DN 32	DN 40	DN 50	DN 65	DN 80	DN 100	DN 125	DN 150	DN 200	DN 250	DN 300
1,0	-	-	0,39	0,60	1,26	2,52	3,42	6,48	6,84	13,68	19,7	35,0	54,5
1,5	-	0,35	0,57	1,01	1,80	3,64	5,37	9,47	13,32	20,16	20,2	51,2	80,0
2,0	0,14	0,49	0,83	1,48	2,70	4,75	7,31	12,46	18,00	26,64	38,4	66,5	105,0
2,5	0,28	0,99	1,08	2,02	3,55	6,34	10,23	16,28	24,30	35,46	51,1	90,0	142,0
3,0	0,42	1,36	1,44	2,70	4,39	7,92	13,14	20,09	30,60	44,28	63,8	110,0	176,0
3,5	0,61	1,66	1,80	3,24	5,61	9,78	16,11	24,45	37,80	55,08	79,3	140,0	220,0
4,0	0,80	2,00	2,30	3,96	6,84	11,63	19,08	28,84	45,00	65,88	95,0	165,0	260,0
4,5	1,02	2,40	2,74	4,86	8,34	14,15	23,31	35,82	55,26	84,06	121,0	215,0	336,0
5,0	1,24	3,00	3,42	5,98	9,83	16,67	27,54	42,84	65,52	102,24	147,0	260,0	408,0
5,5	1,64	3,50	4,21	7,18	11,94	20,94	33,21	51,84	81,72	127,08	183,0	325,0	510,0
6,0	2,04	4,50	5,11	8,57	14,04	25,20	38,88	60,84	97,92	151,92	219,0	380,0	600,0
6,5	2,64	5,10	5,97	10,15	16,92	29,52	46,26	75,42	121,86	196,56	282,0	500,0	785,0
7,0	3,24	6,70	7,27	12,31	19,80	33,84	53,64	90,00	145,80	241,20	325,0	576,0	950,0
7,5	3,84	7,30	8,64	14,40	23,40	39,78	64,62	113,40	177,30	289,80	417,0	740,0	1156,0
8,0	4,45	9,30	10,08	17,64	27,00	45,72	75,60	136,80	208,80	338,40	486,0	866,0	1353,0
8,5	5,04	10,00	11,52	20,88	30,60	53,46	91,80	169,20	251,30	399,80	576,0	1020,0	1594,0
9,0	5,83	12,65	13,14	22,57	34,20	61,20	108,00	216,00	293,80	460,80	660,0	1170,0	1840,0

Table 1. Kv-values for Vexve's balancing valves

## 4.7 Setting the pre-set value

See figure 12

### Valves ≤ DN150

1. Set the desired pre-set value (1)
2. Open the locking screw of the limiter (2)
3. Move the limiter against the edge of the scale plate (3)
4. Tighten the locking screw of the limiter (2)

### Valves ≥ DN200

1. Set the desired pre-set value (1)

## 4.8 Measuring the flow rate through the valve

Flow rate through the valve can be measured by using special flow measuring devices. These devices measure the pressure drop across the valve and calculate the flow rate based on the pressure drop measurements. For more detailed information on measuring the flow rate, please refer to user manuals of flow meters. For more information on suitable flow meters, please contact Vexve.

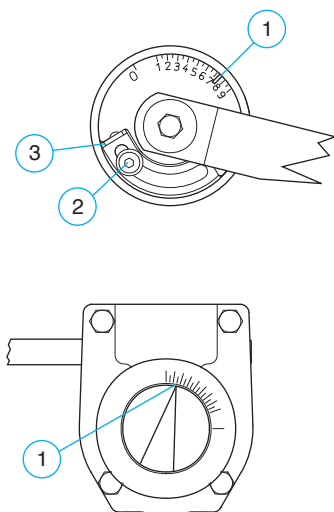


Figure 12.  
Setting the pre-set value.



## 5. Gear and actuator disassembly and installation



### NOTE:

Avoid removing the actuator/gear from the valve. The actuator/gear has been calibrated at the factory to ensure that the valve is tight. If the actuator/gear is removed, it may have to be re-calibrated.

Vexve accepts responsibility only for actuators/gears installed by Vexve.

Refer to the separate adjustment instructions, available from the manufacturer.



### WARNING:

The manual gear or actuator may not be removed or dismantled if the valve is pressurized! It is recommended to use the special actuator removal tools!

Incorrect disconnection may cause serious personal injuries as well as malfunction and damage to the equipment. Extreme caution must be exercised during the disconnection!

Do not use too high torques to operate the valve. Too high torques can damage the valve or the actuator/gear!

### 5.1 Disassembly and reinstallation of ProGear/Rotork manual gear

Part numbers mentioned in this chapter refer to the figure 13.

#### Disassembly:

1. Turn the valve to the open position before removing the gear. Valve opens when you turn the hand wheel of the gear counterclockwise
2. Turn the hand wheel slightly towards the close position (clockwise) to release forces between the valve and the gear in order to make it easier to remove the gear. To do this, turn the hand wheel only that much that it rotates easily
3. Remove the bolts (2) of the position indicator plate and remove the position indicator plate (3). Mark the position of the valve stem to the bush of the gear (1) in order to make it easier to reinstall the gear back into the right position
4. Remove the attachment bolts of the gear and then remove the gear

#### Reinstallation:

5. When reinstalling the manual gear back to valve, check that the gear is in the right position
  - If the gear is installed back to its original position there is no need to adjust the gear settings
  - If the gear is turned 180 degrees from its original position, you must carefully check that the valve closes and opens correctly. If the mechanical limits (parts 4-7) are not correct you must adjust the gear as described in the chapter "5.2 Adjustment of manual gear"
6. Install the gear back to the valve and tighten the attachment bolts
7. Check that the valve opens and closes correctly. If the mechanical limits (parts 4-7) are not correct you must adjust the gear as described in the chapter "5.2 Adjustment of manual gear"



## 5.2 Adjustment of ProGear/Rotork manual gear

Part numbers mentioned in this chapter refer to the figure 13.

1. Remove the plastic dust caps (4) from the top of the mechanical limits. Open the locking nuts (5) and loosen the adjusting screws (6 & 7)
2. Turn the valve to the open position. Valve opens when you turn the hand wheel of the gear counterclockwise. Valve is in the open position when the flow port of the valve ball is concentric with the seat of the ball
3. Tighten the OPEN position adjusting screw (7) until it stops turning. Fix it with the locking nut (5) and put the dust cup in its place (4)
4. Turn the valve 90 degrees to the closed position. Valve closes when you turn the hand wheel of the gear clockwise
5. Tighten the CLOSE position adjusting screw (6) until it stops turning. Fix it with the locking nut (5) and put the dust cup in its place (4)
6. Check that the valve opens and closes correctly

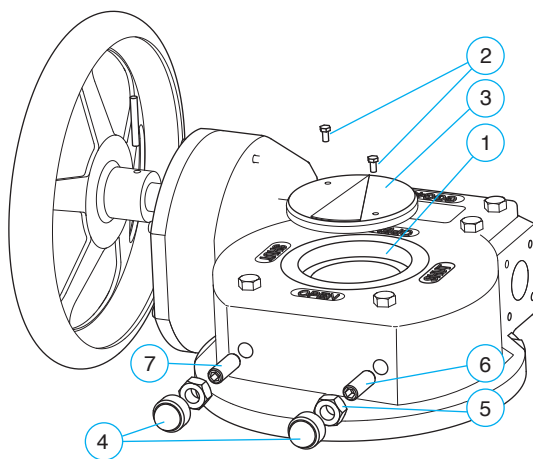


Figure 13. Manual gear.



## 5.3 Disassembly and reinstallation of AUMA electric actuator

Part numbers mentioned in this chapter refer to the figure 14.

### Disassembly:

1. Before removing the actuator, turn the valve to the open position either electrically or manually by rotating the hand wheel (3) of the motor unit (2) counterclockwise
2. Turn off the power supply of the actuator
3. Turn the hand wheel (3) of the motor unit (2) slightly towards the close position (clockwise) to release forces between the valve and the actuator in order to make it easier to remove the actuator. To do this, turn the hand wheel (3) only that much that it rotates easily
4. Remove the bolts (4) of the position indicator plate. Remove the position indicator plate (5), the retaining ring (6) and the cover plate (7)
5. Before removing the actuator, mark the position and the place of the bushing (8) in relation to the actuator and the valve
6. Remove the attachment bolts of the actuator and remove the actuator. The bushing (8) will stay at the valve stem

### Reinstallation:

7. When reinstalling the actuator back to the valve, check that the actuator is in the right position
  - If the actuator is installed back to its original position there is no need to adjust the actuator settings
  - If the actuator is turned 180 degrees from its original position, you must carefully check that the valve closes and opens correctly. If the actuator limits are not correct you must adjust the actuator as described in the chapter 5.4 "Adjustment of the mechanical limits of AUMA electric actuator"
8. Install the actuator back to the valve and tighten the attachment bolts of the actuator
9. Check that the valve opens and closes correctly. If the actuator limits are not correct you must adjust the actuator as described in the chapter 5.4 "Adjustment of the mechanical limits of AUMA electric actuator"



## 5.4 Adjustment of the mechanical limits of AUMA electric actuator

Part numbers mentioned in this chapter refer to the figure 14.

If the actuator is already installed to the valve, you can skip the points 1-8

1. Vexve's ball valves are delivered from the factory in the open position. If the valve has been operated so that it is in some other position, turn the valve to the open position. Remove the device (handle/ actuator) that you used to operate the valve
2. Check that the valve stem is intact and clean. Check also that the key of the valve stem is properly in its groove
3. Put the bushing (8) on the valve stem and set it to the right depth. Check that the overlap between the valve stem and the bushing is long enough. Usually a proper gap between the bushing and the actuator flange of the valve is about 10 mm
4. Tighten the locking screw (9) with an Allen key
5. Turn the actuator to the open position
6. Install the actuator on the valve in the preferred position. The gear unit (1) must fit the bushing (8) easily and you must not force it in its place
7. Grease the attachment screws of the actuator. Put all the washers and the attachment screws first loosely in their places and finally tighten them up
8. (If the motor unit (2) is not installed to the gear unit (1), install it now. Put all the washers and the attachment screws first loosely in their places and finally tighten them up)
9. Turn the hand wheel (3) a couple of revolutions clockwise. Remove the attachment screws (10) of the limiting bush (11)
10. (Set the position and torque limit of the motor unit (or control unit if included) according to separate AUMA's instructions)
11. Turn the valve to the open position
12. Turn the limiting bush counterclockwise until it stops turning. Then turn it backwards (clockwise) app. 1/8 turn
13. Pull the limiting bush out and put it back in its place so that the holes of it will match the holes of the gear unit. Fasten the limiting bush (11) tightly with the attachment screws (10).
14. Check that the actuator works properly



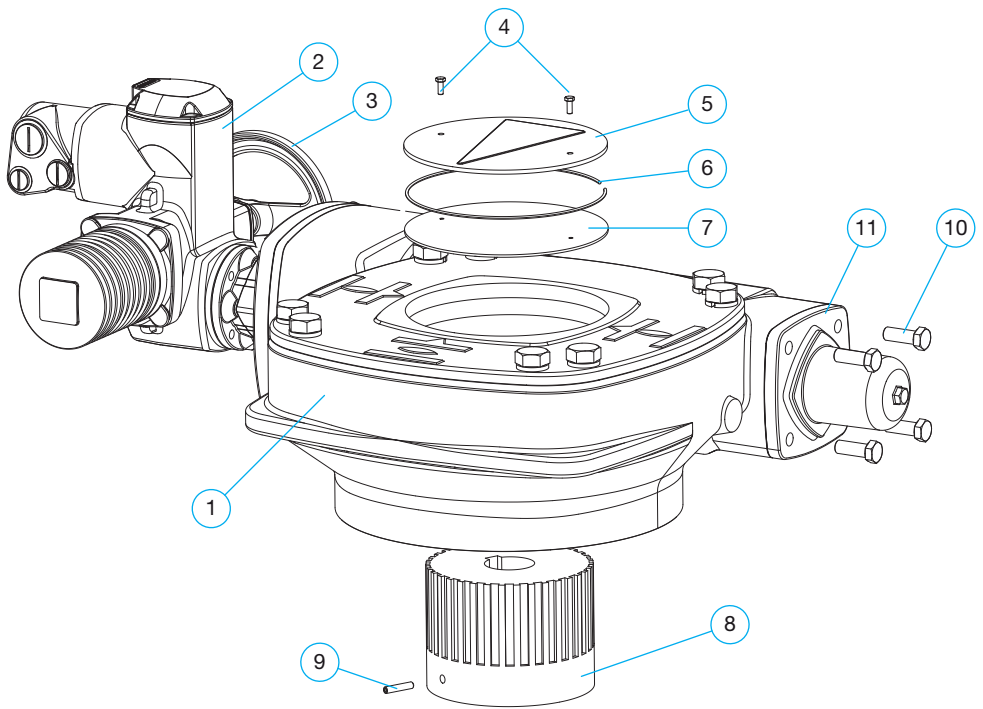


Figure 14. Electric actuator.

## 5.5 Assembly/disassembly of pneumatic actuator

Please refer to the separate installation/adjustment instructions, available from the manufacturer.



## 6. Maintenance

Vexve's ball valves are virtually maintenance-free.

Correct choice of valve as well as careful installation, commissioning, and use significantly reduce any need for maintenance.



**WARNING:**

When the valve is installed in the line, its surface temperature may be dangerously high.  
Protect yourself against burns.

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We recommend checking the following periodically:

Check that the valve is free from surface damage and shaft leaks, and carefully repair any damage.

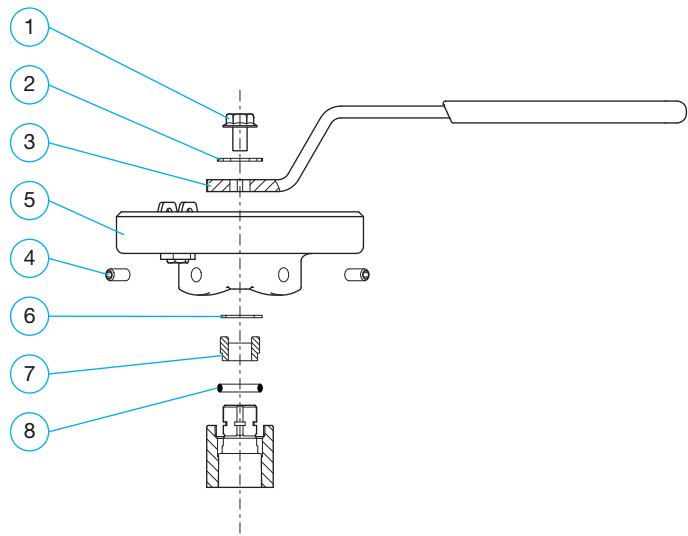
To ensure long-term operational reliability, even when seldom used (around ten times a year or less), we recommend the following:

Approximately six months after commissioning and then once a year, inspect the valve for shaft leaks, check the manual gear / actuator, and ensure the tightness of the screws between valves.





# 6.1 Replacing the O-ring seal of stem in balancing valves DN10-50

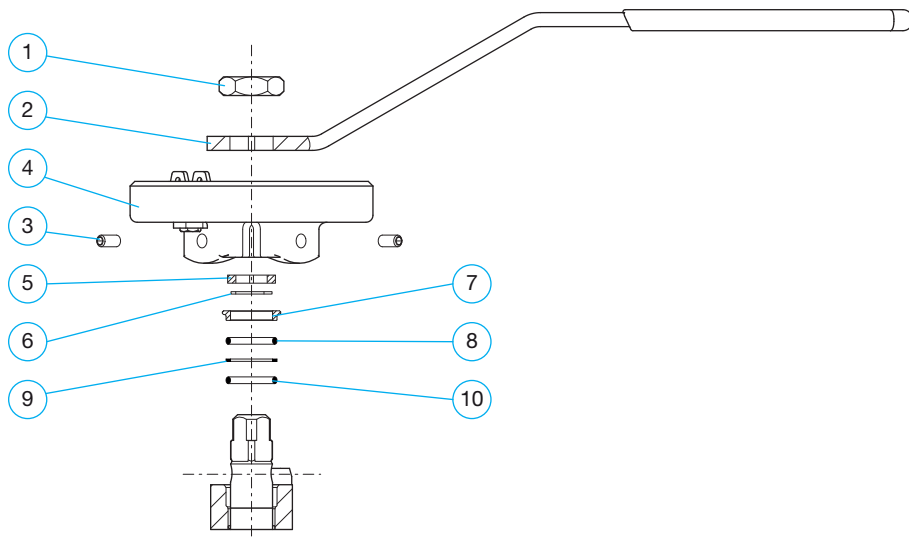


- Remove the hex screw (1), the washer (2) and the handle (3)
  - Remove the two set screws (4) and remove the display plate flange (5)
  - Remove the retaining ring (6)
- Remove the block stop (7)
  - Remove the damaged o-ring (8)
  - put the new o-ring (8) in its place by pressing it evenly downwards from its upper edge
  - assemble removed parts in reverse order

	Part	Steel						Stainless steel					
		DN15	DN20	DN25	DN32	DN40	DN50	DN15	DN20	DN25	DN32	DN40	DN50
1	Hex screw	298162	298162	298162	298162	298163	298163	299162	299162	299162	299162	299163	299163
2	Washer	-	-	-	-	298236	298236	-	-	-	-	298936	298936
3	Handle	930001	930001	930003	930003	930005	930005	940076	940076	940077	940077	940078	940078
4	Set screw	001005	001005	001005	001005	001004	001004	001006	001006	001006	001006	001007	001007
5	Display plate flange	940429	940429	940430	940430	930579	930579	940429	940429	940430	940430	930579	930579
6	Retaining ring	299411	299411	299413	299413	299415	299415	289111	289111	289113	289113	289115	289115
7	Block stop	298190	298190	298192	298192	298194	298194	298190	298190	298192	298192	298194	298194
8	O-ring	298261	298261	298263	298263	298264	298264	298260	298260	298264	298264	298271	298271



## 6.2 Replacing the O-ring seal of stem in balancing valves DN65-150

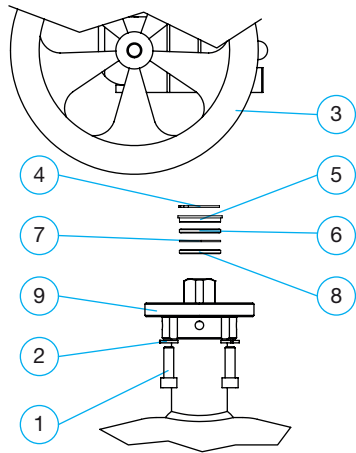


- remove the hex nut (1) and the handle (2)
- remove the two set screws (3) and remove the display plate flange (4)
- remove the retaining ring (6)
- remove the bush (7)
- remove the upper o-ring (8), the distance plate (9) and the lower o-ring (10)
- put the new lower o-ring (10), the distance plate (9) and the new upper o-ring (8) in their places.
- Install the o-rings by pressing them evenly downwards from the upper edge
- assemble the rest of the removed parts in reverse order

	Part	Steel					Stainless steel				
		DN65	DN80	DN100	DN125	DN150	DN65	DN80	DN100	DN125	DN150
1	Hex nut	288570	288570	288570	-	-	288570	288570	288570	-	-
2	Handle	930031	930031	930030	930178	930177	930167	930167	930168	930334	930358
3	Set screw	001004	001004	001004	001004	001004	001007	001007	001007	001007	001007
4	Display plate flange	930921	930921	930923	930924	930924	930921	930921	930923	930924	930924
5	Block stop	298196	298196	298198	298200	298200	298196	298196	298198	298200	298200
6	Retaining ring	299419	299419	299421	299422	299422	299419	299419	299421	299423	299423
7	Bush	29943740	29943740	299439	299450	299450	299434	299434	299438	299450	299450
8	O-ring upper	298267	298267	298267	288270	288270	298285	298285	298288	298290	298290
9	Distance plate	299327	299327	299329	299330	299330	299327	299327	299329	299330	299330
10	O-ring lower	298267	298267	298267	288270	288270	298268	298268	288269	288271	288271



### 6.3 Replacing the O-ring seal of stem in balancing valves with actuators DN65-150



**NOTE!**

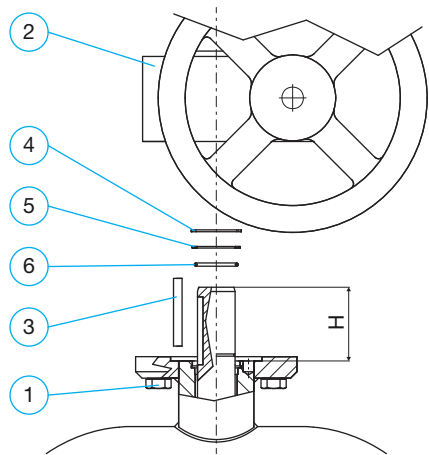
Clean the stem hole of the actuator before reinstalling the actuator. Actuator must fit the stem easily so that it won't press the stem downwards.

- remove the hex screws (1), the washers (2), the actuator (3), the retaining ring (4) and the bush (5)
- remove the upper o-ring (6), the distance plate (7) and the lower o-ring (8)
- put the new lower o-ring (8), the distance plate (7) and the new upper o-ring (6) in their places. Install the o-rings by pressing them evenly downwards from the upper edge
- assemble the rest of the removed parts in reverse order

	Part	Steel					Stainless steel				
		DN65	DN80	DN100	DN125	DN150	DN65	DN80	DN100	DN125	DN150
1	Hex screw	288961	288961	288961	001034	001034	288961	288961	288961	001034	001034
2	Washer	289453	289453	289453	-	-	289453	289453	289453	-	-
3	Actuator	x	x	x	x	x	x	x	x	x	x
4	Retaining ring	299419	299419	294421	299422	299422	299419	299419	299421	299423	299423
5	Bush	29943740	29943740	299439	299450	299450	299434	299434	299438	299450	299450
6	O-ring upper	298267	298267	288267	288270	288270	298285	298285	288269	298290	298290
7	Distance plate	299327	299327	299329	299330	299330	299327	299327	299329	299330	299330
8	O-ring lower	298267	298267	288267	288270	288270	298268	298268	288269	288271	288271
9	Flange	298824	298824	298826	930299	930229	298824	298824	298826	930299	930299



# 6.4 Replacing the O-ring seal of stem in balancing valves DN200-300



## NOTE!

When reassembling, be sure to put the retaining ring (4) properly into its groove in the stem and make sure that the stem is in the right position >> Check the height H from the table below.

Make sure that the gap in the retaining ring (4) is not located in the same place with the key (3). Clean the stem hole of the actuator before reinstalling the actuator (2). Actuator must fit the stem easily so that it won't press the stem downwards.

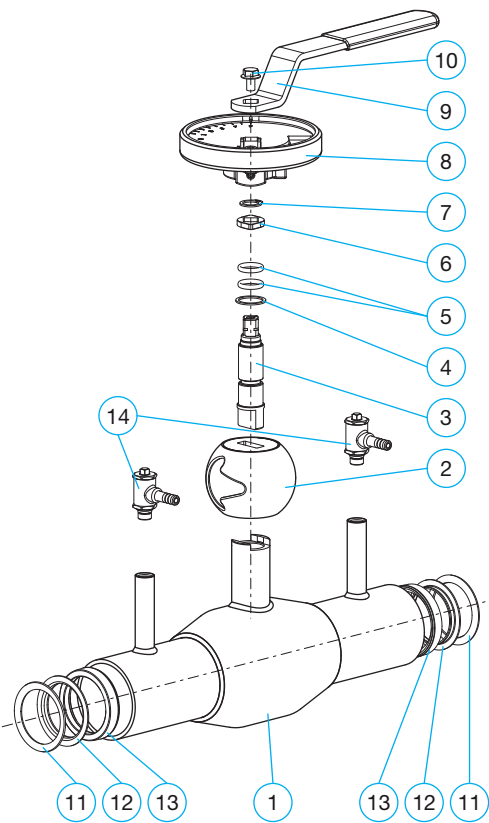
- remove the hex screws (1) and the actuator (2)
- remove the key (3), the retaining ring (4) and the top distance plate (5)
- remove the damaged o-ring (6)
- put the new o-ring (6) in its place by pressing it evenly downwards from its upper edge
- assemble the rest of the removed parts in reverse order

	Part	Steel			Stainless steel	
		DN200	DN250	DN300	DN200	DN250
1	Hex screw	001031	001032	981166	001031	001032
2	Actuator	x	x	x	x	x
3	Key	040002	040001	040005	040002	040001
4	Retaining ring	080010	009006	009008	080012	080012
5	Top distance plate	940068	940037	940164	940218	940217
6	O-ring	010017	010018	010024	010086	010081
H	Height [mm]	68	84	94	68	84



# 7. Appendices

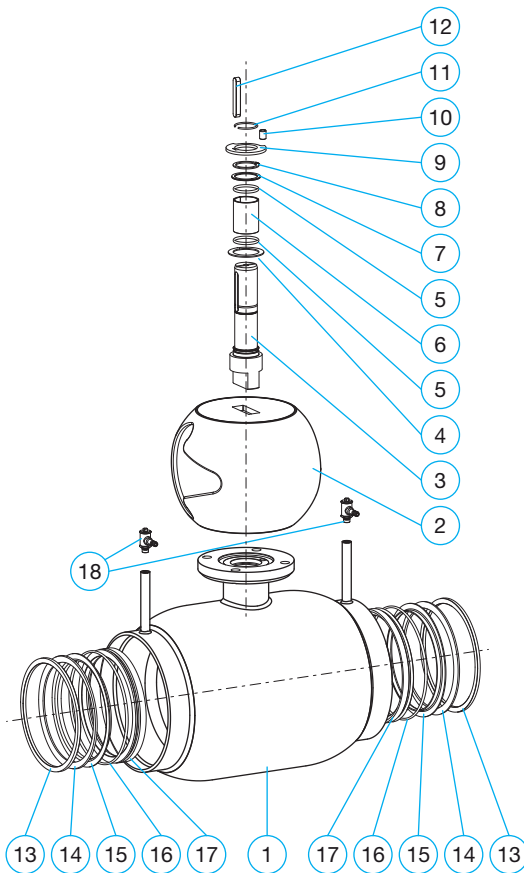
## 7.1 Parts list for balancing valves < DN200



Part number		qty
1	Valve body	1
2	Control ball	1
3	Stem	1
4	Sliding plate	1
5	O-ring	2
6	Block stop	1
7	Retaining ring	1
8	Display flange	1
9	Handle	1
10	Hex flange bolt	1
11	Spring plate	2
12	Support plate	2
13	Ball seal	2
14	Measuring block	2



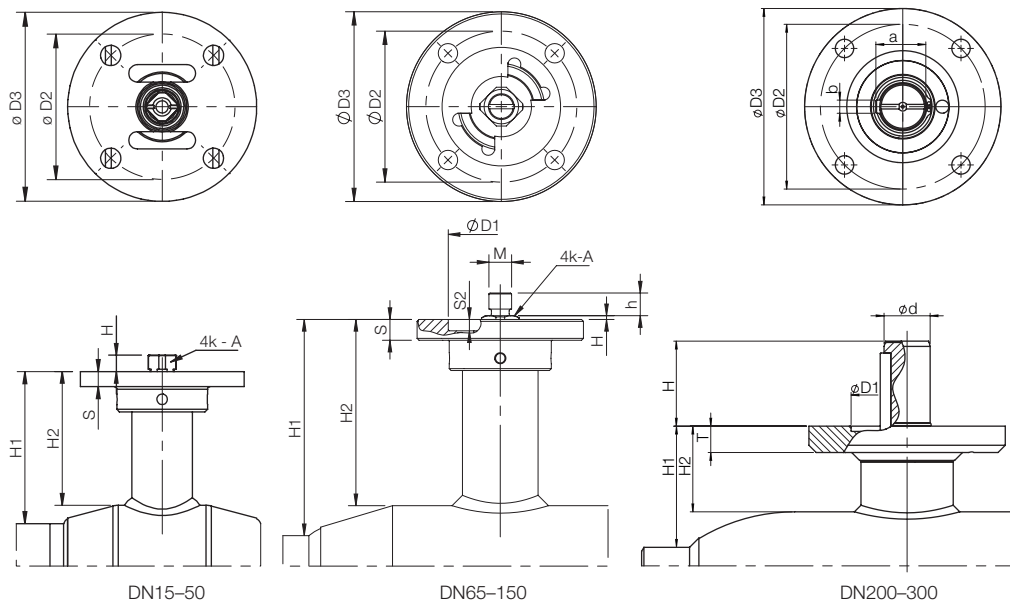
## 7.2 Parts list for balancing valves $\geq$ DN200



Part number		qty
1	Valve body	1
2	Control ball	1
3	Stem	1
4	Sliding plate	1
5	O-ring	2
6	Sliding bearing	1
7	Top distance plate	1
8	Retaining ring	1
9	Block stop	1
10	Dowel pin	1
11	Retaining ring	1
12	Key	1
13	Retaining ring	2
14	Spring plate	2
15	Support plate	2
16	O-ring	2
17	Ball seal	2
18	Measuring block	2



## 7.3 Coupling dimensions, balancing valves steel DN15–300 with actuators



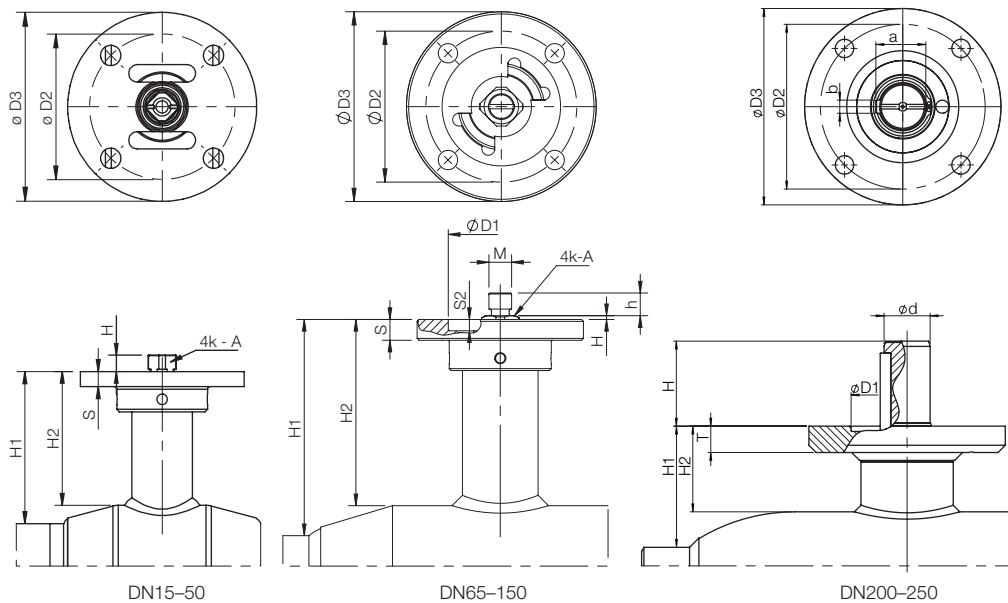
DN	H	h	S	S2	A	M	Ød	T	H1	H2	a	b	D1	D2	D3	Bolts	Key	Flange ISO5211
15	6,5		6		7				61	50				50	64	4xM6		F05
20	6,5		6		7				58	50				50	64	4xM6		F05
25	6,5		6		9				60	53				50	65	4xM6		F05
32	6,5		6		9				60	50				50	65	4xM6		F05
40	7,8		8		11				68	58				70	100	4xM8		F07
50	7,8		8		11				69	55				70	100	4xM8		F07
Toler.					-0.1													

65	8,9	13	11	2	14	M12			69	56			55	70	88	4xM8		F07
80	8,9	13	11	2	14	M12			75	59			55	70	88	4xM8		F07
100	3,5	12	11	6	16	M12			114	99			55	70	88	4xM8		F07
125	22		11	4	20				112	93			70	102	125	4xM10		F10
150	22		11	4	20				121	96			70	102	125	4xM10		F10
Toler.					-0.1													

200	65						35	20	92	65	38	10	85	125	149	4xM12	A-10x8 - 63	F12
250	79						40	20	108	67	43	12	100	140	179	4xM16	A-12x8 - 80	F14
300	88						50	20	133	67	53.5	14	130	165	209	4xM20	A-14x9 - 90	F16



## 7.4 Coupling dimensions, balancing valves stainless steel DN15–250 with actuators



DN	H	h	S	S2	A	M	$\varnothing d$	T	H1	H2	a	b	D1	D2	D3	Bolts	Key	Flange ISO5211
15	7		6	7					30	20				50	64	4xM6		F05
20	7		6	7					27	20				50	64	4xM6		F05
25	6,5		6	9					34	27				50	65	4xM6		F05
32	4		6	9					35	26				50	65	4xM6		F05
40	7,5		8	11					40	29				70	100	4xM8		F07
50	7,5		8	11					40	26				70	100	4xM8		F07
Toler.					-0.1													

65	7,2	13	11	2	14	M12			58	39			55	70	88	4xM8		F07
80	7,2	13	11	2	14	M12			64	43			55	70	88	4xM8		F07
100	3,5	13	11	6	16	M12			68	47			55	70	88	4xM8		F07
125	20		11	4	20				80	60			70	102	125	4xM10		F10
150	20		11	4	20				85	60			70	102	125	4xM10		F10
Toler.					-0.1													

200	65						35	20	92	65	38	10	85	125	149	4xM12	A-10x8 - 63	F12
250	79						40	20	108	67	43	12	100	140	179	4xM16	A-12x8 - 80	F14

