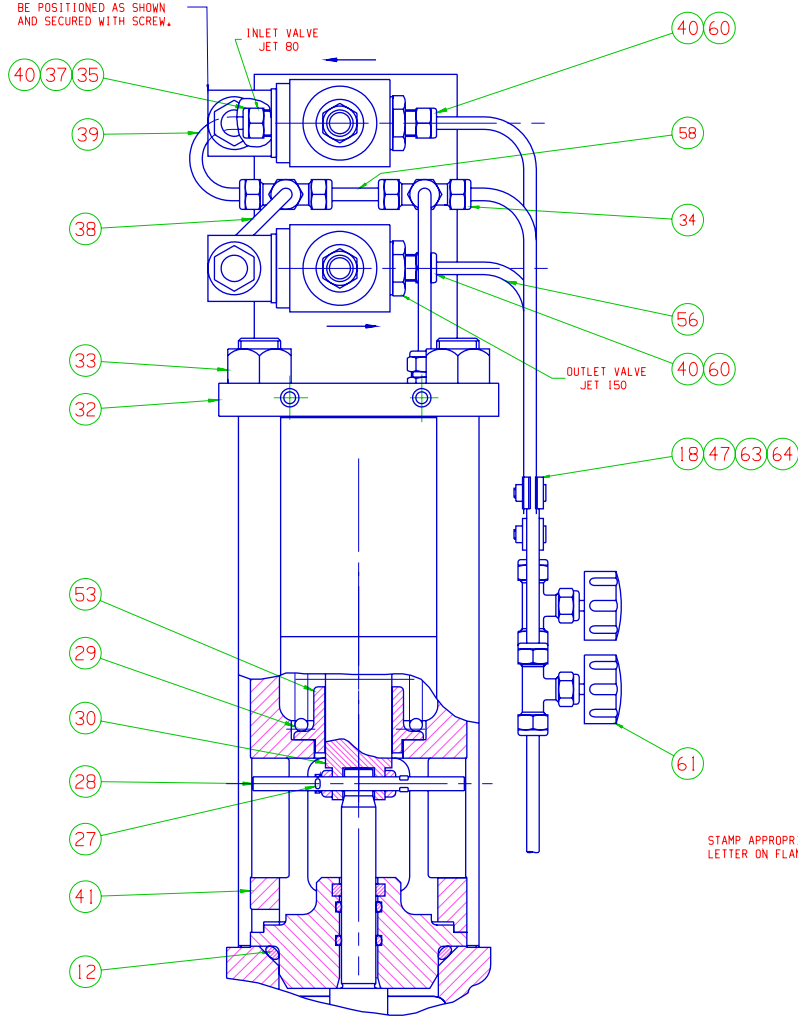


NOTE SOLENOID PLUGS TO BE POSITIONED AS SHOWN AND SECURED WITH SCREW.



BEFORE ASSEMBLING PISTON IN CYLINDER, GREASE BORE AND CUP USING ITEM 50

STAMP APPROPRIATE "LID & SPINDLE" LETTER ON FLANGE*

SEE NOTE 2

FOR THROTTLE CONTROL VALVES (SEE TABLE) THE CORE SHOULD BE SET TO THE DIMENSION SHOWN.

39.0±0.5

51 62 72
SEE NOTE 5

31 16
SEE NOTE 4

71 SEE NOTE 5

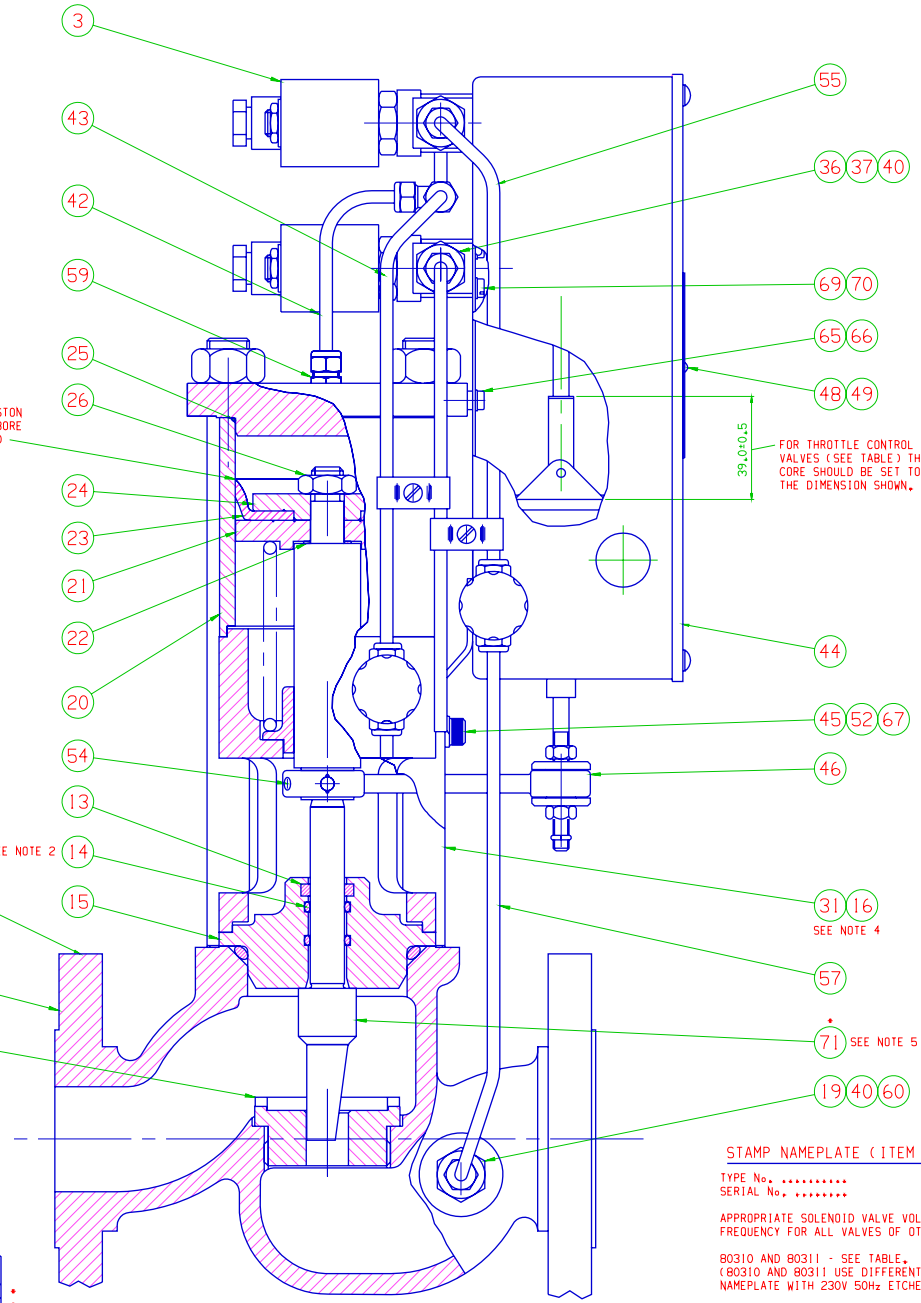
STAMP NAMEPLATE (ITEM 48) WITH:-
TYPE No.
SERIAL No.
APPROPRIATE SOLENOID VALVE VOLTAGE AND FREQUENCY FOR ALL VALVES OF OTHER THAN TYPES:-
80310 AND 80311 - SEE TABLE.
(80310 AND 80311 USE DIFFERENT NAMEPLATE WITH 230V 50Hz ETCHED ON).

NOTES.

- ASSEMBLE VALVE SEAT (ITEM 72) INTO BODY (ITEM 11) ACCORDING TO ASSEMBLY PROCEDURE B1471.
- GREASE (ITEM 50) TO BE USED ON ASSEMBLY OF ITEM 14 AND SPREAD EVENLY AROUND SPINDLE BORE BETWEEN "O" RINGS AFTER ASSEMBLY. LUBRICATE ITEM 13 AT TOP OF ITEM 15 USING SILICONE OIL (ITEM 71).
- USE COMPRESSION RING KEY ON ASSEMBLY.
- SECURELY TIGHTEN TAG (ITEM 16) TO ONE OF THE STUDS (ITEM 31) WHERE SHOWN.
- IMPORTANT: ITEM 71 (WHEN FITTED) MUST BE OF THE TYPE WITH A REDUCED DIAMETER AT THE CROSS HOLE. GREASE SPINDLE WITH ITEM 50 BEFORE ASSEMBLY TO ITEM 15.
- FOR HIGH LEVEL SHUT DOWN ASSEMBLY SEE B1698.
- APPLY TAPE (ITEM 19) TO THREAD OF ITEM 60 BEFORE ASSEMBLY.
- TEST TO TS80409.

| TYPE No. | BODY SIZE | CONTROL TYPE | VOLTAGE | SOLENOID COIL |
|----------|-----------|--------------|---------|---------------|
| 80310 | 1 1/2" | THROTTLE | 230 | 50Hz |
| 80311 | 40mm | THROTTLE | 230 | 50Hz |
| 80436 | 40mm | THROTTLE | 230 | 60Hz |
| 80653 | 40mm | THROTTLE | 110 | 50Hz |
| 80657 | 40mm | THROTTLE | 110 | 60Hz |

* NOTE: WHEN VALVES ARE ASSEMBLED WITHOUT SEAT AND LID, NO PRESSURE TEST IS CARRIED OUT AND STAMPING ON FLANGE IS OMITTED.



| | | | | | | | |
|--|--------|-------------|------|--|--------------|-----------------------------|---|
| A1 DRAWING ON CAD | | | | SOLARTRON MOBREY | | PROJECTION | ALL UNSPECIFIED FEATURES TO COMPLY WITH COMPANY STANDARD 201C |
| ALL DIMENSIONS TO BE WITHIN THE FOLLOWING TOLERANCES UNLESS OTHERWISE SPECIFIED ±: | | | | | | | |
| 1 DECIMAL PLACE OF METRIC ±0.4 | | | | | | | |
| 2 DECIMAL PLACES OF METRIC ±0.25 | | | | | | | |
| 7 | 5/6/03 | ST1817 | SLC | PRINT MAY NOT BE TO SCALE STATED, IF IN DOUBT ABOUT DIMENSIONS THEN ASK. | | TITLE | |
| ISS | DATE | CHANGE NOTE | NAME | FINISH | FINISH SPEC. | SCALE | 80310/80311/80436/80653/80657 |
| MATERIALS - SEE PLS. MAT'L SPEC. | | | | SCALE | | 1/1 | |
| | | | | | | DRAWN DATE CHECKED DRG. NO. | |
| | | | | | | NFDW 15.1.89 RH 81699 | |
| | | | | | | MODULATING VALVE | |

SCANNED BY: ALVIN C. MARCOS
 DATE: 11/15/2024