

MPV MANUAL PINCH-TUBE ABRASIVE METERING VALVE

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WARNING

Do not proceed with these instructions until you have READ the orange cover of this MANUAL and YOU UNDERSTAND its contents. *

These WARNINGS are included for the health and safety of the operator and those in the immediate vicinity.

***If you are using a Clemco Distributor Maintenance and Part Guide, refer to the orange warnings insert preceding the Index before continuing with the enclosed instructions.**

Electronic files include a Preface containing the same important information as the orange cover.

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WARNING

- Employers are responsible for identifying all job site hazards, educating and training all persons who will operate and maintain these products, and ensuring that all blast operators and their assistants understand the warnings and information contained in these instructions relating to safe and proper operation and maintenance of this equipment.
- Serious injury or death can result from failure to comply with all Occupational Safety and Health Administration (OSHA) regulations and all manufacturer's instructions.
- This equipment is not intended for use in any area considered hazardous per National Electric Code NFPA 70 2011, Article 500.
- Read this document and follow all instructions before using this equipment.

OSHA regulations relating to abrasive blasting are contained in the Code of Federal Regulations, Title 29 (29 CFR 1910 General Industry; 1915 Maritime; 1926 Construction). The most pertinent include: 1910.94 Ventilation, 1910.95 Occupational Noise Exposure, 1910.132 Personal Protective Equipment, 1910.133 Eye and Face Protection, 1910.134 Respiratory Protection, 1910.135 Head Protection, 1910.244 (b) Remote Controls. Consult www.osha.gov for complete information.

NOTICE TO PURCHASERS AND USERS OF OUR PRODUCTS AND THIS INFORMATIONAL MATERIAL

Clemco proudly provides products for the abrasive blast industry and is confident that industry professionals will use their knowledge and expertise for the safe and efficient use of these products.

The products described in this material, and the information relating to these products, are intended for knowledgeable, experienced users.

No representation is intended or made as to: the suitability of the products described here for any purpose or application, or to the efficiency, production rate, or useful life of these products. All estimates regarding production rates or finishes are the responsibility of the user and must be derived solely from the user's experience and expertise, not from information contained in this material.

It is possible that the products described in this material may be combined with other products by the user for purposes determined solely by the user. No representations are intended or made as to the suitability of or engineering balance of or compliance with regulations or standard practice of any such combination of products or components the user may employ.

Abrasive blast equipment is only one component of an abrasive blasting job. Other products, such as air compressors, air filters and receivers, abrasives, scaffolding, hydraulic work platforms or booms, equipment for lighting, painting, ventilating, dehumidifying, parts handling, or specialized respirators or other equipment, even if offered by Clemco, may have been manufactured or supplied by others. The information Clemco provides is intended to support the products Clemco manufactures. Users must contact each manufacturer and supplier of products used in the blast job for warnings, information, training, and instruction relating to the proper and safe use of their equipment.

GENERAL INSTRUCTIONS

This material describes some, but not all, of the major requirements for safe and productive use of blast machines, remote controls, respirator systems, and related accessories. All equipment and accessories must be installed, tested, operated and maintained only by trained, knowledgeable, experienced users.

The blast operator and all workers in the vicinity must be properly protected from all job site hazards including those hazards generated by blasting.

Work environments involving abrasive blasting present numerous hazards. Hazards relate to the blast process from many sources that include, but are not limited to, dust generated by blasting or from material present on the surface being blasted. The hazards from toxic materials may include, but are not limited to, silica, cyanide, arsenic, or other toxins in the abrasives or in the coatings, such as lead or heavy metals. Other hazards from toxins include, but are not limited to, fumes from coating application, carbon monoxide from engine exhaust, contaminated water, chemicals or asbestos. In addition, physical hazards that may be present include, but are not limited to, uneven work surfaces, poor visibility, excessive noise, and electricity. Employers must identify all job site hazards and protect workers in accordance with OSHA regulations.

Never modify Clemco equipment or components or substitute parts from other manufacturers for any Clemco components or parts. Any unauthorized modification or substitution of supplied-air respirator parts violates OSHA regulations and voids the NIOSH approval.

IMPORTANT

Contact Clemco for free booklets:

Blast Off 2 – Guide to Safe, Productive, and Efficient Abrasive Blasting, and Abrasive Blasting Safety Practices – Guide to Safe Abrasive Blasting.

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OPERATIONAL INSTRUCTIONS

OPERATOR SAFETY EQUIPMENT

WARNING

- OSHA regulation 1910.134 requires appropriate respiratory protection for blast operators and workers in the vicinity of blasting. These workers must wear properly-fitted, properly-maintained, NIOSH-approved, respiratory protection that is suitable for the job site hazards. Blast respirators are to be worn only in atmospheres not immediately dangerous to life or health from which wearers can escape without use of the respirator.
- The employer must develop and implement a written respiratory protection program with required worksite- specific procedures and elements for required respirator use. The employer must provide effective training to employees who are required to use respirators. The training must be comprehensive, understandable, and recur annually, and more often if necessary.
- NEVER use abrasives containing more than one percent crystalline silica. Fatal diseases, such as silicosis, asbestosis, lead or other poisoning, can result from inhalation of toxic dusts, which include, but are not limited to, crystalline silica, asbestos, and lead paint. Refer to NIOSH Alert 92-102; and OSHA CPL 03-00-007: “National Emphasis Program – Crystalline Silica”, in which OSHA describes policies and procedures for implementing a national emphasis program to identify and reduce or eliminate health hazards from exposure to crystalline silica. Numerous topics associated with the hazards of crystalline silica in silica blasting sand can be found on [http:// osha.gov/](http://osha.gov/). Clemco urges users of silica blasting sand to visit this website, and read and heed the information it contains.
- Always make sure the breathing air supply (respirator hose) is not connected to plant lines that supply gases that include, but are not limited to, oxygen, nitrogen, acetylene, or other non-breathable gas. Never modify or change respirator air line connections without first testing the content of the line for safe breathing air. Failure to test the line may result in death to the respirator user.

- Breathing air quality must be at least Grade D, as defined by the Compressed Gas Association specification G-7.1, per OSHA Regulation 29 CFR 1910.134. When compressed air is the breathing air source, a Clemco CPF (suitable sorbent bed filter) should be used. Respirator hose connecting the respirator to the filter must be NIOSH approved. Non- approved hose can cause illness from chemicals employed to manufacture the hose.

- All workers must always wear NIOSH-approved respirators when any dust is present. Exposure to dust can occur when handling or loading abrasive, blasting, cleaning up abrasive, or working in the vicinity of blasting. Before removing the respirator, test the air with a monitoring device to ensure it is safe to breathe.

- Clemco respirators DO NOT remove or protect against carbon monoxide or any other toxic gas. Monitoring devices must be used in conjunction with the respirator to ensure safe breathing air. Always locate compressors and ambient air pumps where contaminated air will not enter the air intake.

- Always use Clemco lenses with Clemco respirators; installing non-approved lenses voids the NIOSH approval. Respirator lenses are designed to protect the wearer from rebounding abrasive; they do not protect against flying objects, heavy high-speed materials, glare, liquids, or radiation.

INDUSTRY ORGANIZATIONS

For additional information, consult:

Occupational Safety and Health Administration (OSHA) - www.osha.gov

Compressed Gas Association (CGA) - www.cganet.com

The Society for Protective Coatings (SSPC) - www.sspc.org

National Association of Corrosion Engineers (NACE) - www.nace.org

American Society for Testing and Materials (ASTM) - www.astm.org

National Institute of Occupational Safety and Health (NIOSH) - www.niosh.gov

American National Standards Institute (ANSI) - www.ansi.org

PREFACE

BLAST MACHINES AND REMOTE CONTROLS

⚠ WARNING

OSHA regulation 1910.169 describes the necessity of pressure relief valves on compressed air equipment. Do not operate blast machines with air compressors that are not equipped with properly functioning pressure relief valves.

OSHA regulation 1910.244(b) requires the use of remote controls on blast machines.

Serious injury or death can result from many sources, among them:

- Involuntary activation of the remote controls. Never modify or substitute remote control parts; parts are not compatible among different manufacturers. Welding hose is not suitable for remote control hose. Its ID and material composition make it unsafe for remote control use.
- Exceeding the maximum working pressure. Clemco blast machines are built to ASME-code and carry a 'U' or 'UM' stamp, and National Board/serial number. Every machine is marked with its maximum working pressure. Never exceed the maximum working pressure limits of the blast machine.
- Uncontrolled blast stream. High-velocity abrasive particles will inflict serious injury. Always point the blast nozzle in the direction of the blast surface only. Keep unprotected workers out of the blast area.
- Welding on the blast machine. Never weld on the blast machine; welding voids the National Board approval and may affect the dimensional integrity of the vessel.
- Moving the blast machine. Never manually move a blast machine containing abrasive, any machine containing abrasive must be moved with appropriate mechanical lifting equipment.

HOSES, COUPLINGS, AND NOZZLE HOLDERS

- The inside diameter (ID) of air hoses, fittings, and connections should be at least four times larger than the nozzle orifice size. Blast hose ID should be three to four times the size of the nozzle orifice. Example: a #6 nozzle (3/8" diameter orifice) calls for 1-1/2" ID blast hose and 1-1/2" ID or larger compressor hose. All hose runs should be kept as short as possible and run in as straight a line as possible to reduce pressure loss.
- To install, squarely cut the end of the hose so that it fits snugly against the coupling or hose end shoulder. Always use the screws recommended by the manufacturer ensuring that they do not penetrate the inner wall. Make sure the couplings tightly fit the hose. Install cotter pins at every connection or use couplings with built-in lock-springs to prevent disengagement. Install safety cables at all connections to prevent whipping if hoses disengage or blow out.

MAINTENANCE AND REPAIR

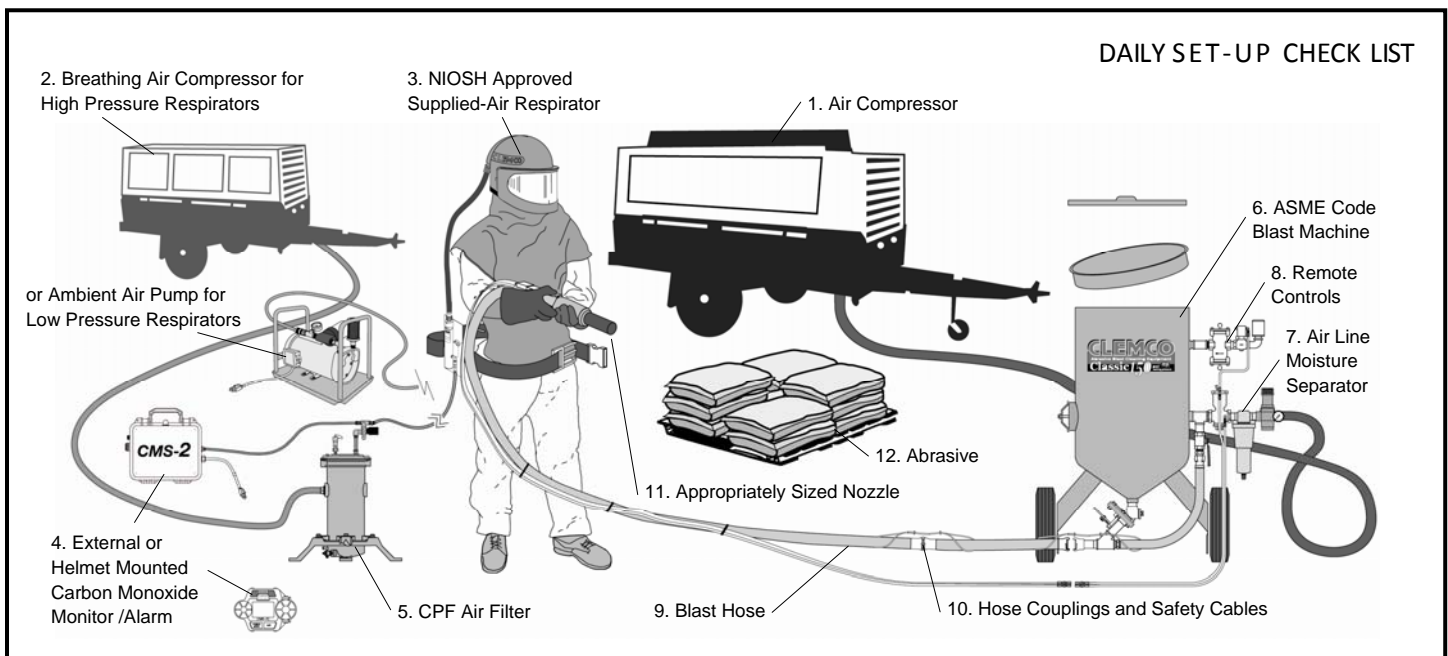
- Completely read and follow all service instructions and recommended maintenance intervals. Always shut off compressor and depressurize blast machine before performing any maintenance. At every service interval, clean all filters, screens, and alarm systems. If spring-loaded abrasive valves are used, always cage spring before disassembly.

WARRANTY

The following is in lieu of all warranties, express, implied or statutory, and in no event shall seller or its agents, successors, nominees or assignees, or either, be liable for special or consequential damage arising out of a breach of warranty. This warranty does not apply to any damage or defect resulting from negligent or improper assembly or use of any item by the buyer or its agent or from alteration or attempted repair by any person other than an authorized agent of seller. All used, repaired, modified, or altered items are purchased "as is" and with all faults. In no event shall seller be liable for consequential or incidental damages. The sole and exclusive remedy of buyer for breach of warranty by seller shall be repair or replacement of defective parts or, at seller's option, refund of purchase price, as set forth below

1. Seller makes no warranty with respect to products used other than in accordance hereunder.
 2. On products seller manufactures, seller warrants that all products are to be free from defects in workmanship and materials for a period of one year from date of shipment to buyer, but no warranty is made that the products are fit for a particular purpose.
 3. On products which seller buys and resells pursuant to this order, seller warrants that the products shall carry the then standard warranties of the manufacturers thereof, a copy of which shall be made available to the customer upon request.
 4. The use of any sample or model in connection with this order is for illustrative purposes only and is not to be construed as a warranty that the product will conform to the sample or model.
 5. Seller makes no warranty that the products are delivered free of the rightful claim of any third party by way of patent infringement or the like.
 6. This warranty is conditioned upon seller's receipt within ten (10) days after buyer's discovery of a defect, of a written notice stating in what specific material respects the product failed to meet this warranty. If such notice is timely given, seller will, at its option, either modify the product or part to correct the defect, replace the product or part with complying products or parts, or refund the amount paid for the defective product, any one of which will constitute the sole liability of the seller and a full settlement of all claims. No allowance will be made for alterations or repairs made by other than those authorized by seller without prior written consent of seller. Buyer shall afford seller prompt and reasonable opportunity to inspect the products for which any claim is made as above stated.
- Except as expressly set forth above, all warranties, express, implied or statutory, including implied warranty of merchantability, are hereby disclaimed.

PREFACE



DAILY SET-UP CHECK LIST

Make sure all blast operators are properly trained and suitably attired with a blast suit, safety boots, leather gloves, respiratory and hearing protection. Every day before start up, check all equipment components, including piping, fittings, and hoses, and valves, for leaks, tightness, and wear. Repair or replace as needed. Use the following checklist.

- 1. PROPERLY-MAINTAINED AIR COMPRESSOR** sized to provide sufficient volume (cfm) at given pressure for nozzle and other tools. ADD 50% volume (cfm) reserve to allow for nozzle wear. Use large compressor outlet and air hose (at least 4 times the nozzle orifice diameter). For oil-lubricated compressors, the employer shall use a high-temperature or carbon monoxide alarm, or both, to monitor carbon monoxide levels. If only high-temperature alarms are used, the air supply shall be monitored at intervals sufficient to prevent carbon monoxide in the breathing air from exceeding 10 ppm. Follow the manufacturer's checklist and maintenance instructions.
- 2. BREATHING-AIR COMPRESSOR** (or oil-less ambient air pump) capable of providing Grade D quality air, located in a dust free area. Read # 1 above.
- 3. CLEAN, PROPERLY-MAINTAINED NIOSH-APPROVED SUPPLIED-AIR RESPIRATOR** worn by blast operators, and other workers exposed to blast dust. Make sure all respirator components are in place — all lenses, inner collar, and cape. Thoroughly inspect all components for wear. The NIOSH approval (approval number is listed in the owner's manual) is for a complete assembly from point of attachment on the CPF (sorbet bed) filter to the complete respirator. Substitution of any part voids the NIOSH approval.
- 4. CARBON MONOXIDE MONITOR/ALARM** installed at the CPF filter or inside the supplied-air respirator for monitoring for the presence of deadly CO gas and warning the operator(s) when the CO level reaches an unacceptable level. When an ambient air pump is used for breathing air, a CO monitor provides a measure of safety. Read # 1 above.
- 5. BREATHING-AIR FILTER (OSHA-REQUIRED sorbet bed filter)** for removal of moisture and particulate matter in the compressed air breathing-air supply. Monitor the condition of the cartridge and replace when odor is detected or at 3 month intervals, whichever comes sooner. The breathing air filter does NOT detect or remove carbon monoxide (CO). Always install a CO monitor/alarm.
- 6. BLAST MACHINE** (bearing U or UM stamp, National Board Number, and Maximum Working Pressure) sized to hold a 30-minute abrasive supply. Examine pop-up valve for alignment. Check piping, fittings, screens, valves for tightness, leaks, and wear. Always ground the machine to eliminate hazard of static shock. Install a blast machine screen to keep out foreign objects. Use a blast machine cover if left outdoors overnight. Never exceed the maximum working pressure of the vessel.
- 7. AIR LINE FILTER** (moisture separator) installed as close as possible to the blast machine inlet and sized to match the size of the inlet piping or larger air supply line. Clean filter and drain often. Damp abrasive causes operational problems.
- 8. REMOTE CONTROLS** are required by OSHA and must be in perfect operating condition. Test and check all components to ensure all parts are present and fully functional. Use genuine replacement parts. NEVER mix parts from different manufacturers. Never use welding hose for remote control hose.
- 9. BLAST HOSE** should have an inside diameter sized to suit the blast nozzle. The ID should be three to four times the size of the nozzle orifice diameter. Blast hose should be arranged in as straight a line as possible from the blast machine to the work area, avoiding sharp bends.
- 10. COUPLINGS AND NOZZLE HOLDERS** should fit snugly on the hose and be installed with manufacturer recommended screws. Coupling lugs must snap firmly into locking position. Gasket must always be used to form a positive seal, and cotter pins must be installed. Replace gasket when wear, softness or distortion is detected. Check nozzle holder for thread wear; replace at any sign of wear. Install safety cables at all connections.
- 11. NOZZLE** orifice size should be checked and nozzle replaced when worn 1/16" from original size. (No. 5 nozzle has 5/16" orifice diameter; replace when it measures 3/8"). Threads should be inspected daily for wear and nozzle should be replaced when wear is detected. Always use a nozzle washer.
- 12. ABRASIVE** must be a material specifically manufactured for blasting. It should be properly sized for the job. Check material safety data sheet for free-silica, cyanide, arsenic, lead and other toxins and avoid use when these toxic, harmful substances are present.
- SURFACE TO BE BLASTED** should be examined for hazardous substances. Take appropriate protective measures as required by OSHA to ensure the blast operator, other workers in the vicinity, and any bystanders are properly protected.

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1.0 INTRODUCTION

1.1 Scope of Manual

1.1.1 These instructions cover operation, service, and replacement parts for the Clemco manual pinch-tube abrasive metering valves.

1.1.2 These instructions contain important safety information. All operators and personnel involved with the abrasive blast process must read and understand the contents of these instructions, including the orange cover. It is equally important that the operator is trained and qualified to safely operate the blast machine and remote controls, and all other equipment used with the blast machine.

1.1.3 All personnel involved with the abrasive blasting process must be made aware of the hazards associated with abrasive blasting. The Clemco booklet "Abrasive Blasting Safety Practices" is included with every blast machine, and contains important safety information about abrasive blasting that may not be included in equipment operation manuals. To order additional copies, visit www.clemcoindustries.com or email info@clemcoindustries.com.

1.2 Safety Alerts

1.2.1 Clemco uses safety alert signal words, based on ANSI Z535.4-2011, to alert the user of a potentially hazardous situation that may be encountered while operating this equipment. ANSI's definitions of the signal words are as follows:



This is the safety alert symbol. It is used to alert you to potential physical injury hazards. Obey all safety messages that follow this symbol to avoid possible injury or death.

NOTICE

Notice indicates information that is considered important, but not hazard-related, if not avoided, could result in property damage.

CAUTION

Caution indicates a hazardous situation that, if not avoided, could result in minor or moderate injury.

WARNING

Warning indicates a hazardous situation that, if not avoided, could result in death or serious injury.

DANGER

Danger indicates a hazardous situation that, if not avoided, will result in death or serious injury.

1.3 **Description and Application:** The manual pinch tube metering valve features the same construction and pinch tube metering design as the PVR pinch tube remote valves, which can be used with all types of abrasives including metallic abrasives. Components are shown in Figure 1.

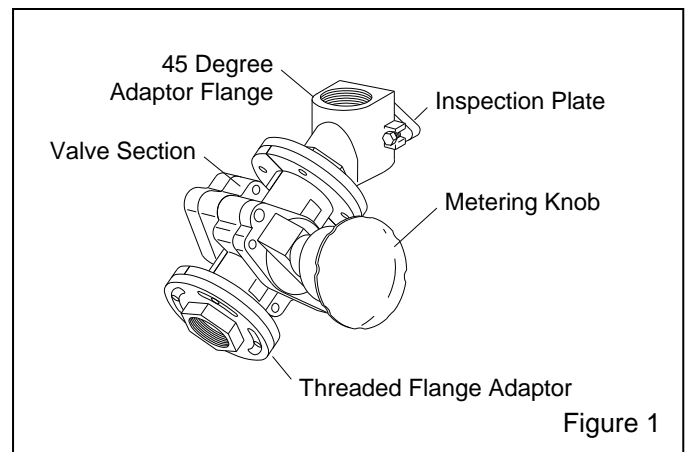


Figure 1

2.0 INSTALLATION

2.1 Empty abrasive from the blast machine.

WARNING

Failure to observe the following before performing any maintenance could cause serious injury from the sudden release of trapped compressed air.

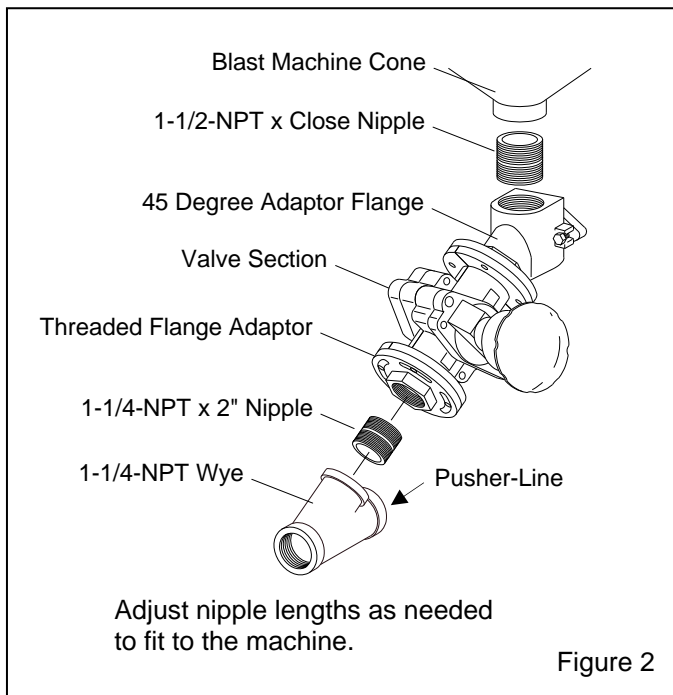
- Depressurize the blast machine.
- Lockout and tagout the compressed air supply.
- Bleed the air supply line to the blast machine.

2.2 Disconnect the pusher-line at the metering valve and remove the existing valve from the blast machine.

Note: Use pipe sealant on all male pipe threads. Use new pipe fittings to connect the valve to the blast machine and to connect the CF coupling to the wye. Use a schedule 80 nipple to connect the 45 degree adaptor flange to the bottom of the blast machine.

2.3 It is recommended that the wye be attached to the flange adaptor on a bench, using a vise and pipe wrench, before attaching the valve to the blast machine. Attach the flange to the branch of a 1-1/4-NPT wye, using a 1-1/4-NPT x 2" nipple. Align the wye in line with the pusher-line, as shown in Figure 2.

2.4 Use a 1-1/2 x close, schedule 80 nipple to connect the 45 degree adaptor flange to the outlet at the bottom of the blast machine as shown in Figure 2. Position the clean-out toward the air inlet side of the machine. NOTE: If interference prohibits the installation of an assembled valve, remove the four fasteners securing the 45 degree adaptor flange to the valve section, and if necessary the threaded flange adaptor from the valve section, as shown in Figure 3, then reattach the valve section when the adaptor(s) is installed.



2.5 Reattach the pusher-line to the back side of the wye.

2.6 Use a new pipe nipple to attach the CF coupling to the wye.

2.7 Assemble all hose connections, apply air to the system and check for leaks.

3.0 ADJUST ABRASIVE FLOW

3.1 Adjust abrasive flow by turning the knob on the metering valve. The valve is shipped in the open position. The valve is closed when the knob has been turned fully clockwise. Begin with the knob set 1-1/2 turns from fully closed. To increase abrasive flow, the machine tender turns the knob no more than 1/4 turn counterclockwise while the operator is blasting. Allow 10 to 15 seconds for the flow to stabilize before readjusting. Continue making adjustments as described until the ideal flow is attained.

3.2 Optimum abrasive flow depends on the type and size of abrasive and blasting pressure, and is best determined by experience. Use as little abrasive as possible while maintaining the maximum cleaning rate. The air/abrasive mixture should be mainly air. As a rule, the stream of abrasive coming out of the nozzle should barely discolor the air when seen against a contrasting background.

4.0 SERVICE

4.1 Removing Obstructions

4.1.1 An inspection plate is provided for removing obstructions.

4.1.2 If the nature of the obstruction permits emptying the machine of abrasive, follow the instructions in the blast machine manual.

4.1.3 Turn off the compressed air supply. Lockout and tagout the air supply, and bleed the air supply line to the blast machine and make sure the pop-up valve is open.

⚠ WARNING

Do not remove the inspection plate or disassemble the valve while the machine is under pressure. Failure to fully depressurize the blast machine before performing any service could cause serious injury from the sudden release of trapped compressed air and abrasive.

4.1.4 Remove the inspection plate wing nuts and remove the inspection plate.

4.1.5 Check the valve for blockage, by inserting a finger into the opening, and feel for an obstruction or foreign object.

4.1.6 Make sure the inspection plate o-ring is in good condition and in place before reattaching the inspection plate.

4.1.7 Make sure all inspection plates and hoses are secure before restarting the machine.

4.2 Replacing the Pinch Tube

4.2.1 Periodically inspect the pinch valve. Replace the tube if air leaks from the hole at the base of the control knob, or when it is difficult to maintain consistent abrasive flow.

4.2.2 Empty the machine of abrasive, observe the warning following Paragraph 4.1.3, and depressurize the blast machine. If emptying the machine is not practical, remove the inspection plate and block the abrasive flow with a rag or similar object. Be sure to remove the rag and replace the inspection plate when service is completed.

4.2.3 Open the metering valve by turning the metering knob fully counterclockwise.

4.2.4 Remove the center valve section, by removing the eight flange bolts and sliding the center valve section out from between the flanges, as shown in Figure 3.

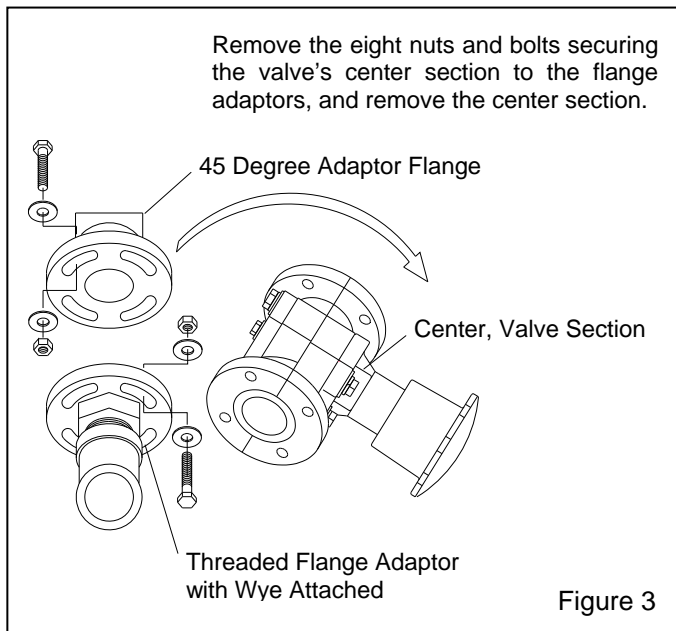


Figure 3

4.2.5 Separate the two body halves, as shown in Figure 4, by removing the two 3/8" x 4" bolts.

4.2.6 Discard the old pinch tube and replace with a new tube. Make sure the tube flanges are seated in the recesses in the body halves.

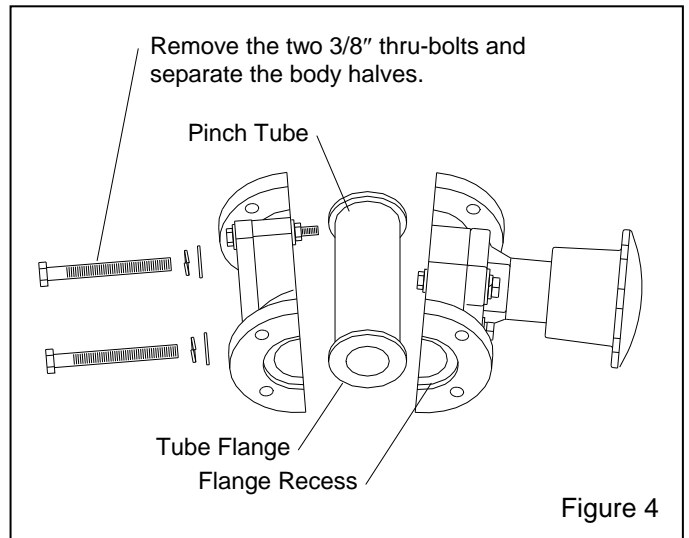


Figure 4

4.2.7 With the new pinch tube in place, reassemble the body halves and attach the valve's center section to the adaptor flanges.

4.2.8 Return the machine to operation and adjust abrasive flow.

5.0 TROUBLESHOOTING

5.1 No abrasive flow

5.1.1 Metering valve closed. Closed is when the metering knob is fully clockwise.

5.1.2 Machine empty. Check abrasive level.

5.1.3 Foreign material jamming the valve, refer to Section 4.1.

5.1.4 Obstruction in media valve. Clear as follows:

5.1.4.1 Fully open the valve, full open is when the knob is turned fully counterclockwise. While blasting, close the choke valve to force out small obstructions or wet abrasive.

⚠ WARNING

To avoid serious injury from the release of trapped compressed air, depressurize the blast machine, lockout and tagout the compressed air supply before continuing.

5.1.4.2 For larger obstructions, shut the machine down to examine the metering valve. Remove the inspection plate and clear obstruction.

5.2 Abrasive flow decreases shortly after blasting starts.

5.2.1 Abrasive bridging in the blast machine. This is usually caused by using very fine abrasive, reusing worn out abrasive, or by moist air.

5.3 Abrasive Bridging

5.3.1 Frequent bridging or blockage in the blast machine and metering valve can be caused by damp abrasive. Blast media becomes damp by blasting parts that are slightly oily (when using recycled abrasive), from moisture in the compressed air line, or from absorption.

5.3.2 To avoid contaminating recyclable abrasive by the workpiece, all parts should be clean and dry. If parts are oily or greasy, degrease and dry them prior to blasting.

5.3.3 Moist compressed air: Moisture in the air supply may be due to a faulty compressor that overheats, or pumps oil or moisture into the air line; an air line that is too long permitting moisture to condense on the inside; and from high humidity. Drain filters and receiver tank regularly. If the problem persists, a dryer or aftercooler may be required in the air supply line.

5.3.4 Absorption: Some abrasive tends to absorb moisture from the air, especially fine-mesh media in high humidity areas. Empty media from the blast machine at the end of the work day, and store media in an area protected from damp environment.

5.0 REPLACEMENT PARTS

5.1 Optional Accessories, not shown

- (-) Nipple, 1-1/4-NPT x 2" 01718
- (-) Nipple, 1-1/2-NPT x close, schedule 80 01791
- (-) Wye, 1-1/4-NPT standard 01818

5.2 Pinch Tube Metering Valve Assembly, Figure 5

Item	Description	Stock No.
(-)	MPV Manual Pinch Tube Metering Valve	04321
1.	Metering knob assembly	05072
2.	Inspection plate	02440
3.	O-ring, 1-3/4" OD	01990
4.	Body, pinch valve, 2 required	05677
5.	Flanged adaptor, 45 degree	05672
6.	Flanged adaptor	05673
7.	Cover plate	05674
8.	Pinch tube, 1" ID	04635
9.	Nut, 5/16-NC wing	03213
10.	Cap screw, 5/16-NC x 1"	03152

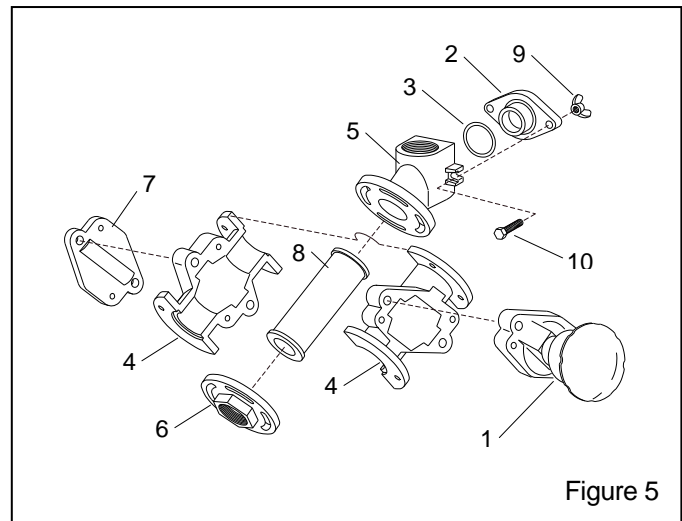


Figure 5