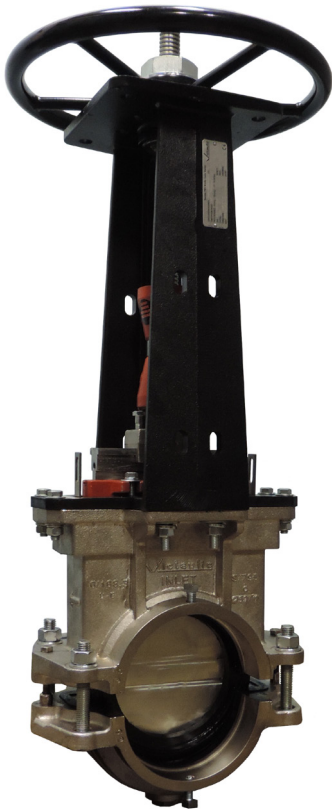


Series 795 Installation-Ready™ Knife Gate Valve



HANDWHEEL OPERATOR



PNEUMATIC OPERATOR



HYDRAULIC OPERATOR

⚠ WARNING



- Read and understand all instructions before attempting to install, remove, adjust, or maintain any Victaulic piping products.
- Depressurize and drain the piping system before attempting to install, remove, adjust, or maintain any Victaulic piping products.
- Wear safety glasses, hardhat, foot protection, and hearing protection.

Failure to follow instructions and warnings could cause system failure, resulting in death or serious personal injury and property damage.

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HAZARD IDENTIFICATION



Definitions for identifying the various hazard levels are provided below. When you see this symbol, be alert to the possibility of personal injury. Carefully read and fully understand the message that follows.

DANGER

- The use of the word “DANGER” identifies an immediate hazard with a likelihood of death or serious personal injury if instructions, including recommended precautions, are not followed.

WARNING

- The use of the word “WARNING” identifies the presence of hazards or unsafe practices that could result in death or serious personal injury if instructions, including recommended precautions, are not followed.

CAUTION

- The use of the word “CAUTION” identifies possible hazards or unsafe practices that could result in personal injury and product or property damage if instructions, including recommended precautions, are not followed.

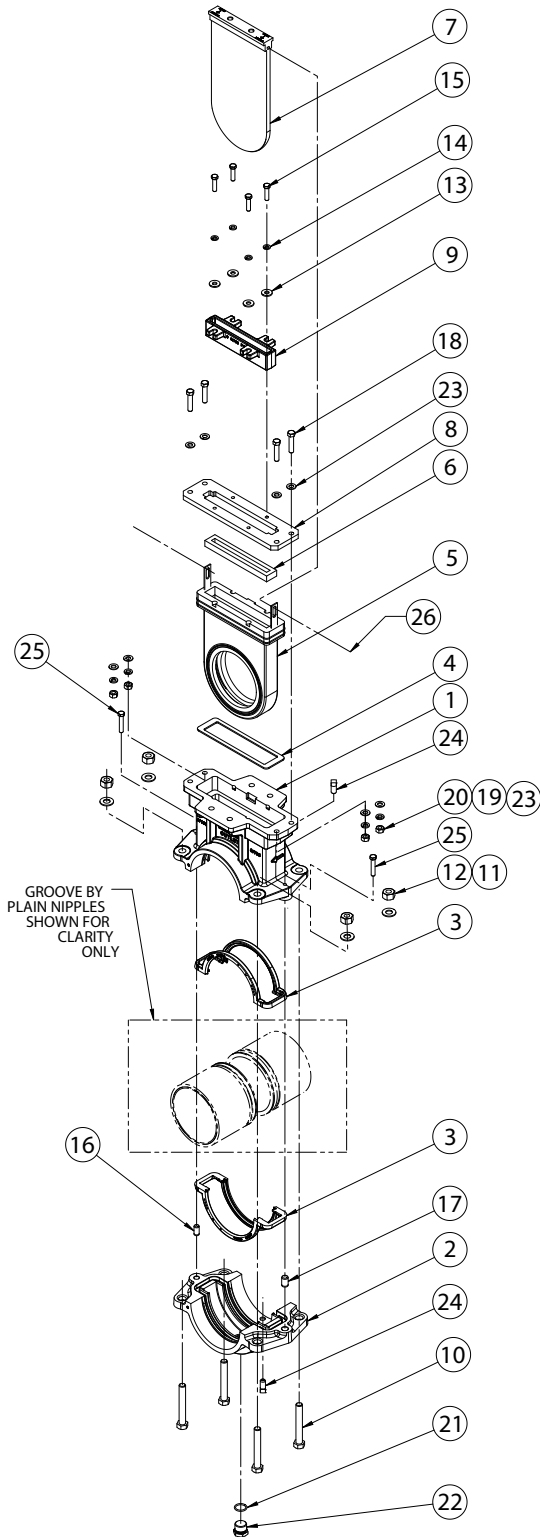
NOTICE

- The use of the word “NOTICE” identifies special instructions that are important but not related to hazards.

KNIFE GATE VALVE COMPONENTS

NOTICE

- Drawings and/or pictures in this manual may be exaggerated for clarity.
- Dimensions listed are for reference only. Refer to Victaulic submittal 08.25 for complete dimensional information.
- The product, along with these installation and maintenance instructions, contains trademarks, copyrights, and/or patented features that are the exclusive property of Victaulic.



BILL OF MATERIALS

Item	Qty.	Description
1	1	Upper Body
2	1	Lower Body
3	2	Pipe Gasket
4	1	Seat Gasket
5	1	Seat
6	1	Knife Seal
7	1	Knife
8	1	Retaining Plate
9	1	Packing Gland
10	4	Full Thread Hex Bolt †
11	4	Washer †
12	4	Heavy Hex Nut †
13	4	Washer
14	4	Helical Spring-Lock Washer
15	4	Hex Cap Screw
16	1	Dowel Pin
17	1	Dowel Pin
18	4	Hex Bolt
19	4	Helical Spring-Lock Washer
20	4	Hex Nut
21	1	O-Ring
22	1	Plug
23	8	Washer
24	2	Square Head Set Screw
25	2	Spacer Bolt
26	2	Hex Cap Screw*

NOTES:

† Items 10, 11, and 12 comprise the assembly hardware.

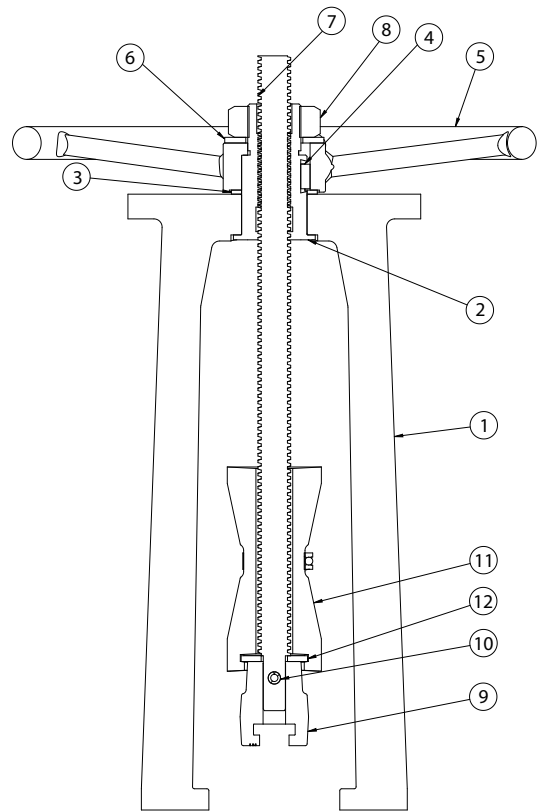
* Item 26 is required when servicing the valve.

Victaulic offers a kit to replace the entire seat cartridge. Refer to Section II in this manual for complete removal and replacement instructions.

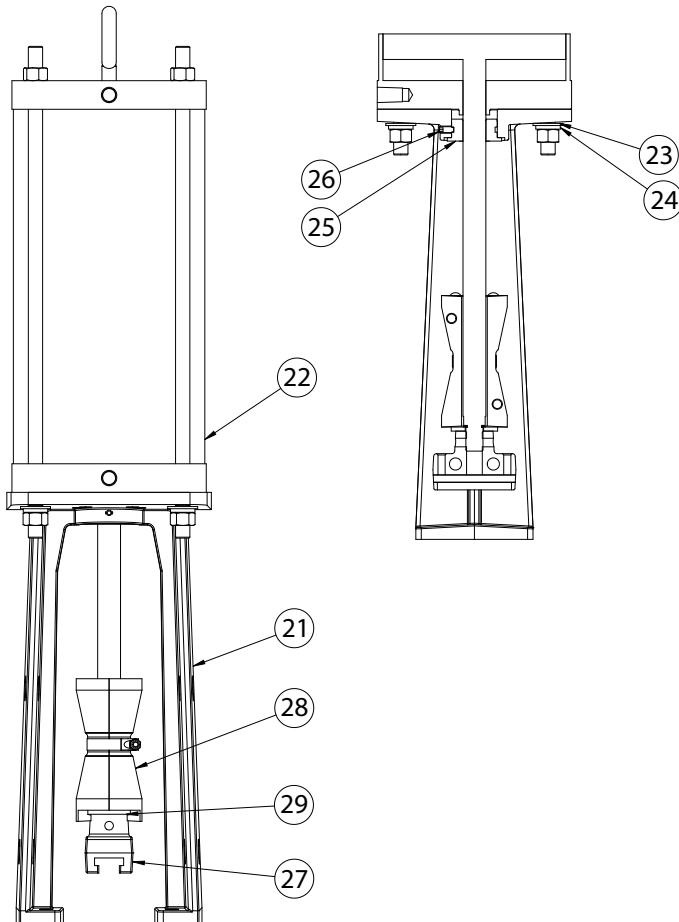
HANDWHEEL OPERATOR COMPONENTS

BILL OF MATERIALS

Item	Qty.	Description
1	1	Yoke
2	1	Drive Nut
3	1	Spacer
4	1	Parallel Key
5	1	Handwheel
6	1	Washer
7	1	Stem
8	1	Hex Jam Nut
9	1	Gate Connector
10	1	Slotted Spring Pin
11	1	Limit Stop Assembly
12	1	Washer



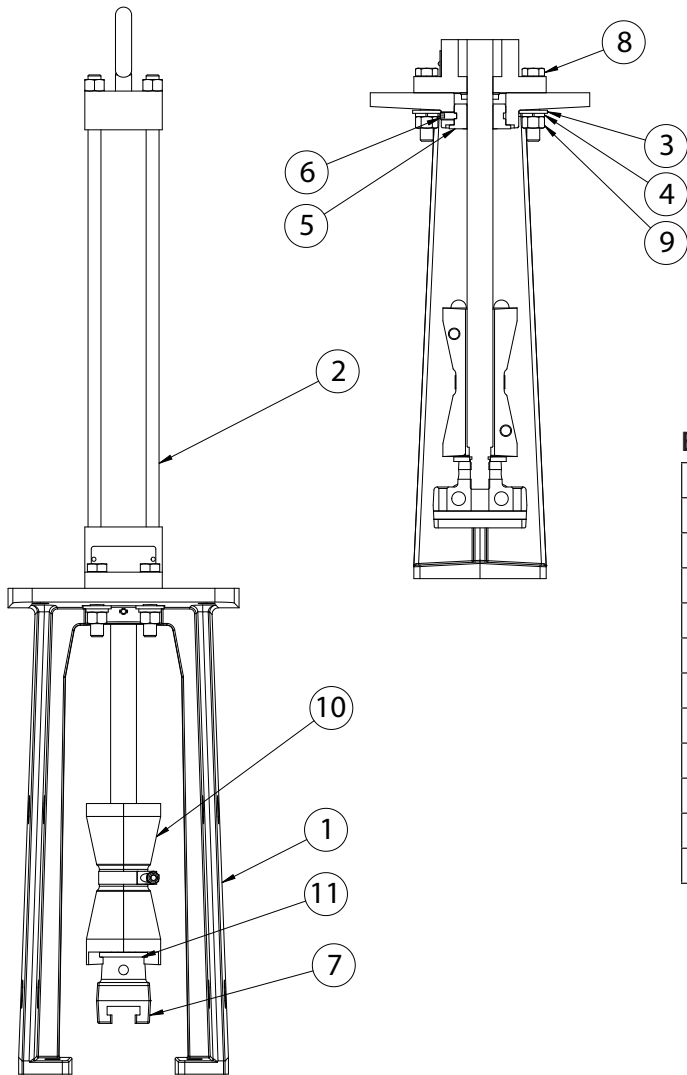
PNEUMATIC OPERATOR COMPONENTS



BILL OF MATERIALS

Item	Qty.	Description
21	1	Yoke
22	1	Pneumatic Cylinder
23	4	Washer
24	4	Helical Spring-Lock Washer
25	1	Bushing
26	1	Socket Set Screw
27	1	Gate Connector
28	1	Limit Stop Assembly
29	1	Washer

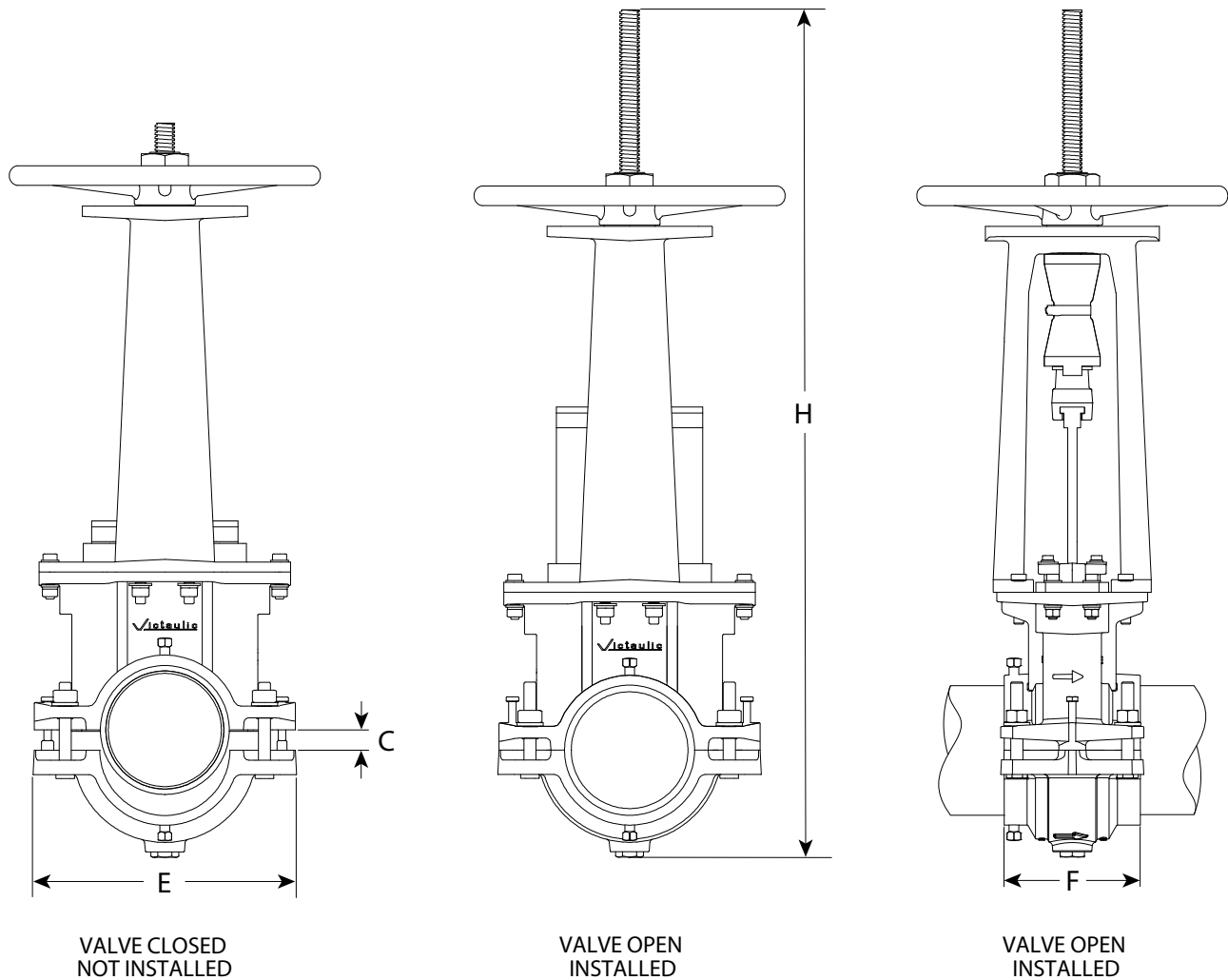
HYDRAULIC OPERATOR COMPONENTS



BILL OF MATERIALS

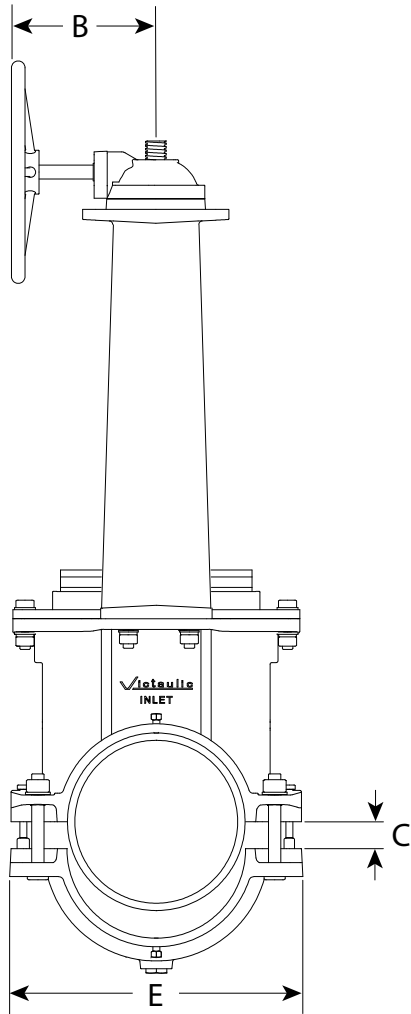
Item	Qty.	Description
1	1	Yoke
2	1	Hydraulic Cylinder
3	4	Washer
4	4	Helical Spring-Lock Washer
5	1	Bushing
6	1	Socket Set Screw
7	1	Gate Connector
8	4	Hex Cap Screw
9	4	Hex Nut
10	1	Limit Stop Assembly
11	1	Washer

DIMENSIONS – WITH HANDWHEEL OPERATOR

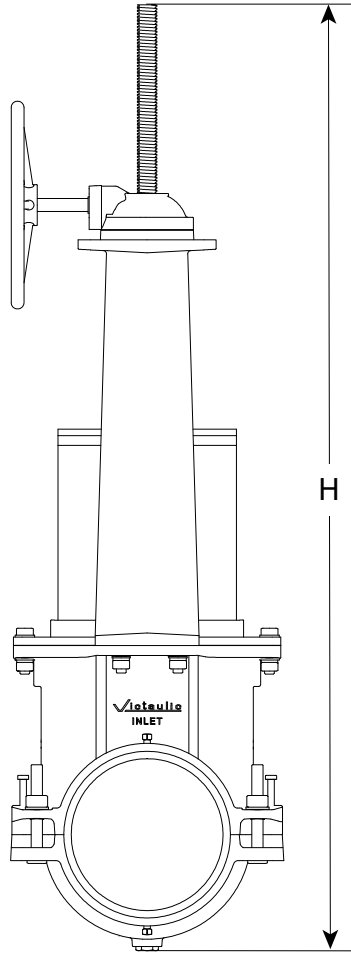


Nominal Size in DN	Dimensions – inches/millimeters				Weight lbs kg
	C	E	F	H	
3 DN80	0.88 22.4	10.25 260.4	6.75 171.5	32.25 819.2	113.00 51.3
4 DN100	0.88 22.4	11.25 285.8	6.75 171.5	34.75 882.7	122.00 55.3
6 DN150	1.13 28.7	13.75 349.3	7.00 177.8	43.75 1111.3	166.00 75.3
8 DN200	1.63 41.4	15.50 393.7	7.00 177.8	53.25 1352.6	237.00 107.5

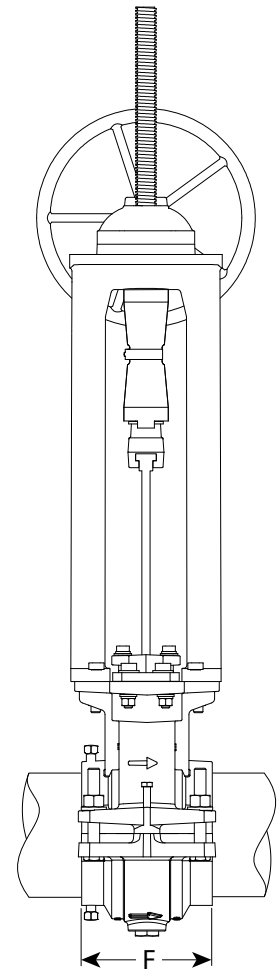
DIMENSIONS – WITH BEVEL GEAR OPERATOR



VALVE CLOSED
NOT INSTALLED



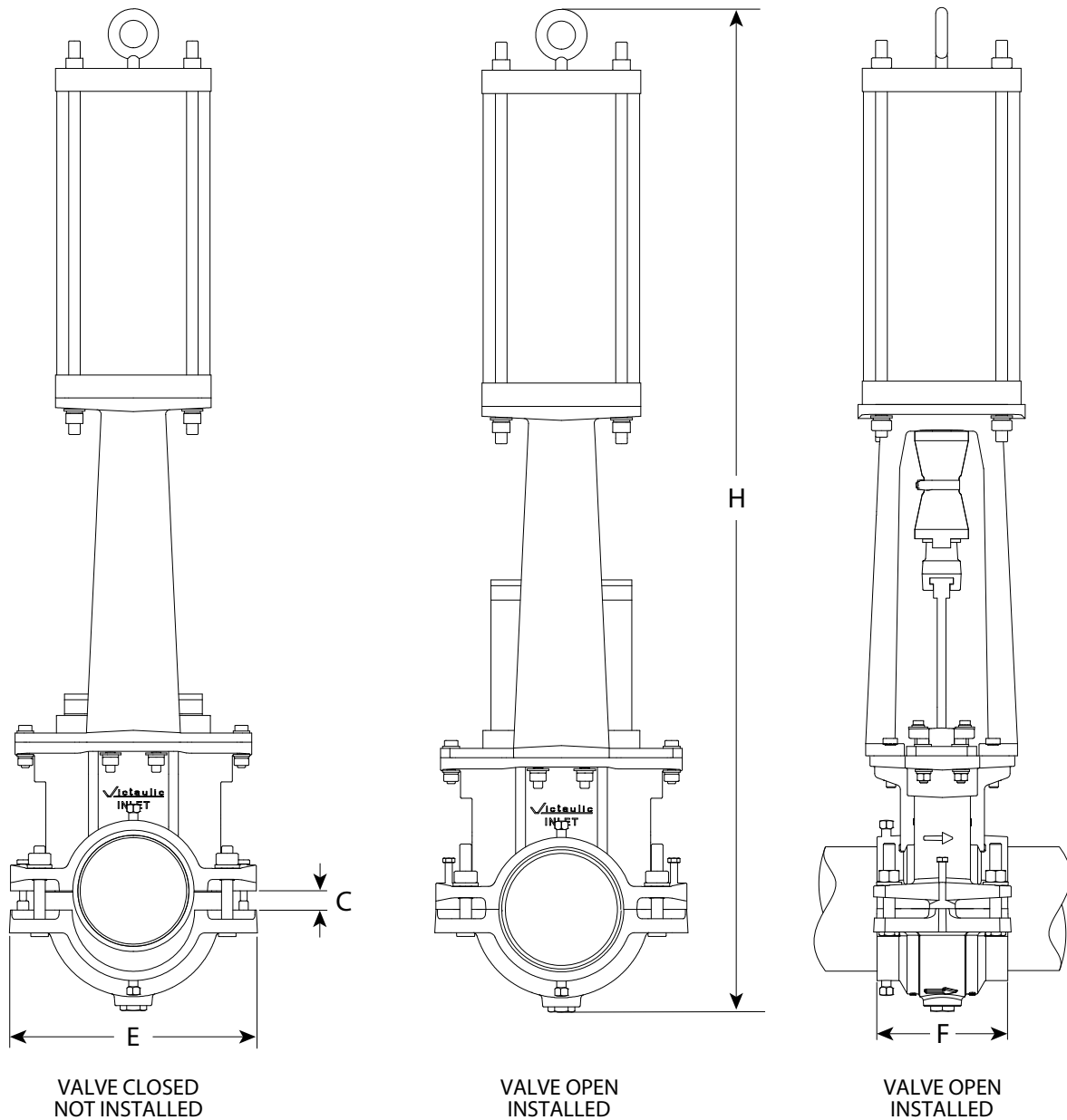
VALVE OPEN
INSTALLED



VALVE OPEN
INSTALLED

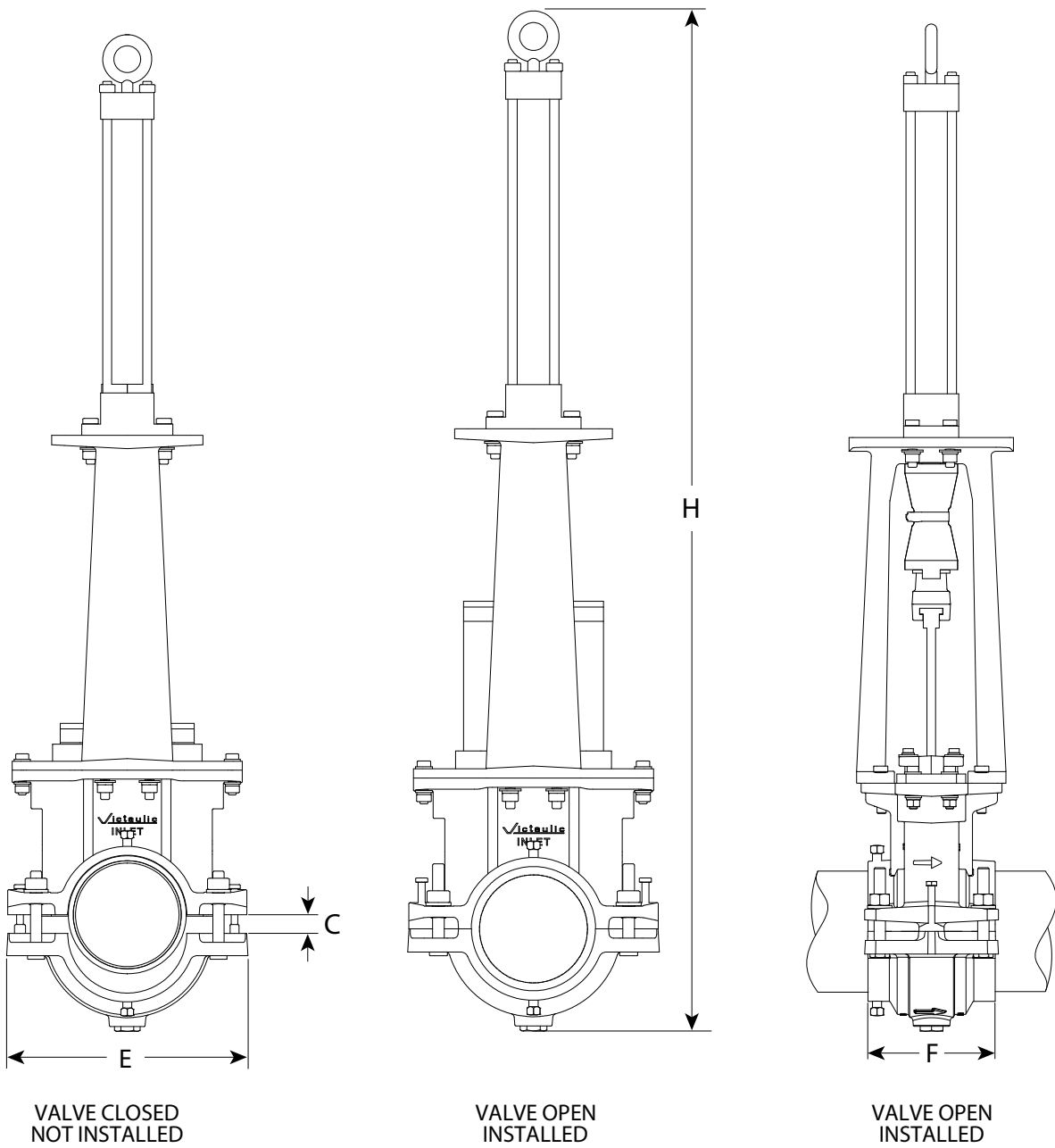
Nominal Size in DN	Dimensions – inches/millimeters					Weight lbs kg
	B	C	E	F	H	
10	11.22	1.75	19.00	7.50	68.50	465.00
DN250	284.9	44.5	482.6	190.5	1739.9	210.9
12	11.22	2.00	21.00	7.50	73.00	497.00
DN300	284.9	50.8	533.4	190.5	1854.2	225.4

DIMENSIONS – WITH PNEUMATIC OPERATOR



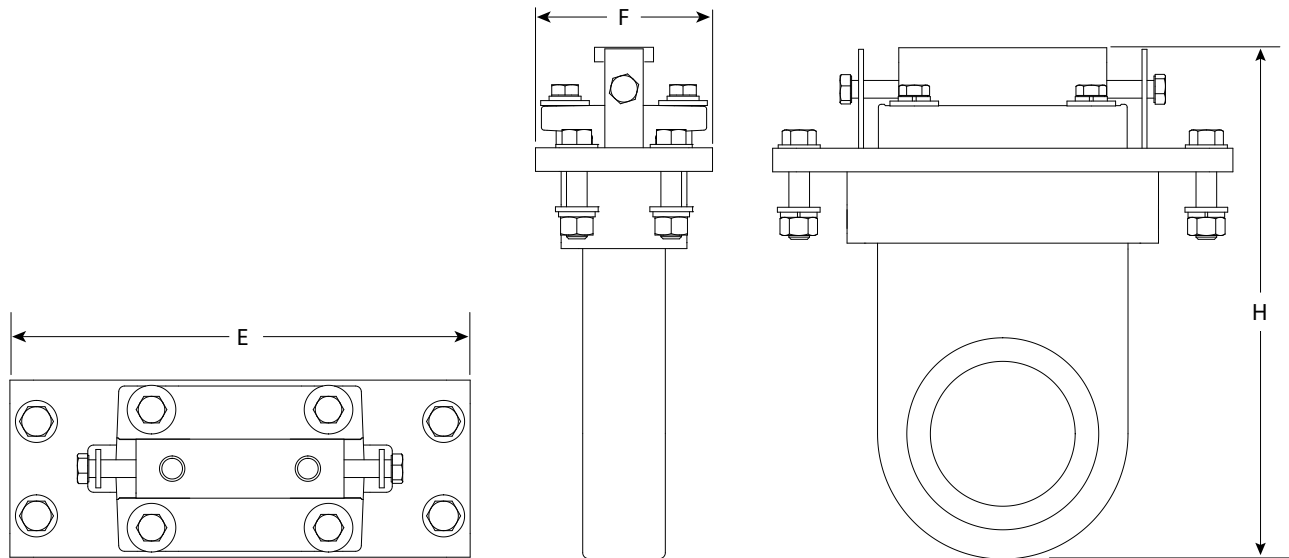
Nominal Size in DN	Dimensions – inches/millimeters				Weight lbs kg
	C	E	F	H	
3	0.88	10.25	6.75	42.00	126.00
DN80	22.4	260.4	171.5	1066.8	57.2
4	0.88	11.25	6.75	44.50	133.00
DN100	22.4	285.8	171.5	1130.3	60.3
6	1.13	13.75	7.00	53.75	215.00
DN150	28.7	349.3	177.8	1365.3	97.5
8	1.63	15.50	7.00	55.75	348.00
DN200	41.4	393.7	177.8	1416.1	157.9
10	1.75	19.00	7.50	79.50	550.00
DN250	44.5	482.6	190.5	2019.3	249.5
12	2.00	21.00	7.50	86.50	586.00
DN300	50.8	533.4	190.5	2197.1	265.8

DIMENSIONS – WITH HYDRAULIC OPERATOR



Nominal Size in DN	Dimensions – inches/millimeters				Weight lbs kg
	C	E	F	H	
3	0.88	10.25	6.75	43.88	115.00
DN80	22.4	260.4	171.5	1114.6	52.2
4	0.88	11.25	6.75	46.50	125.00
DN100	22.4	285.8	171.5	1181.1	56.7
6	1.13	13.75	7.00	55.00	172.00
DN150	28.7	349.3	177.8	1397.0	78.0
8	1.63	15.50	7.00	66.50	259.00
DN200	41.4	393.7	177.8	1689.1	117.5
10	1.75	19.00	7.50	80.25	462.00
DN250	44.5	482.6	190.5	2038.4	209.6
12	2.00	21.00	7.50	89.50	525.00
DN300	50.8	533.4	190.5	2273.3	238.1

DIMENSIONS – SEAT CARTRIDGE



Nominal Size in DN	Dimensions – inches/millimeters			Weight lbs kg
	E	F	H	
3 DN80	9.88 251.0	3.88 98.6	10.88 276.4	16.30 7.4
4 DN100	10.75 273.1	3.88 98.6	12.13 308.1	19.70 8.9
6 DN150	13.00 330.2	3.88 98.6	15.00 381.0	28.90 13.1
8 DN200	15.50 397.3	3.88 98.6	18.25 463.6	40.70 18.5
10 DN250	19.00 482.6	5.00 127.0	23.00 584.2	82.00 37.2
12 DN300	20.63 524.0	5.00 127.0	25.50 647.7	100.60 45.6

IMPORTANT INFORMATION

- Series 795 Installation-Ready™ Knife Gate Valves are designed for installation with Schedule 40 or Schedule 80 grooved-end carbon steel pipe. Welding of pipe ends to the valve is not permitted. Refer to the Victaulic I-100 Field Installation Handbook for pipe preparation requirements.
- The Series 795 is rated for a maximum working pressure of 150 psi/10 Bar.
- The Series 795 is not intended for throttling service. This valve is designed for shutoff applications only.
- The Series 795 is not intended for use in air services.
- The Series 795 can be installed either horizontally or vertically. **NOTE:** Additional restraints or supports shall be considered when the valve is installed horizontally, especially when a pneumatic, electric, or hydraulic actuator is used.
- The Series 795 and connecting piping must be supported properly to prevent the joints from being subjected to bending loads, shear loads, or any other external loads.
- DO NOT use the Series 795 as a jack for pipe alignment or support.
- DO NOT climb on or stand on the Series 795 or other piping system components.

RECOMMENDED SPARE PARTS AND TOOLS

CAUTION

- Ensure that all spare seals and gaskets are compatible with the line media.

Failure to follow this instruction will cause gasket degradation, resulting in joint leakage and property damage.

- Spare Seat Cartridge
- Ratchet Wrenches
- Crescent Wrenches
- Pipe Wrenches
- Victaulic Lubricant or Silicone Lubricant
- Water-Stabilized Calcium Grease Containing Graphite and Molybdenum Disulfide
- Anti-Seize Compound

MANUAL OPERATION

For Series 795 Installation-Ready™ Knife Gate Valves installed with a handwheel operator, the following table contains the approximate number of complete rotations required during standard operation (i.e. going from fully closed to fully open) or during maintenance to remove the seat cartridge.

Valve Size inches DN	Thrust Load lbs N	Approximate Number of Handwheel Rotations for Standard Operation	Approximate Number of Handwheel Rotations for Maintenance	Maximum Torque Required ft-lbs N•m	Rim Pull Effort lb N
3 DN80	1500 6672	20	45	11 14	16 70
4 DN100	2100 9341	25	55	15 20	22 99
6 DN150	3000 13,344	35	70	22 29	33 145
8 DN200	4600 20,461	45	90	33 44	49 217
10* DN250	7000 31,136	44	88	72 98	43 189
12* DN300	7200 32,026	52	100	73 99	43 192

* These sizes come standard with a bevel gear operator.

PNEUMATIC OPERATION

Pneumatic cylinders are designed to be operated with a minimum of 80 psi/6 Bar air pressure. Contact Victaulic if your system air pressure is less than 80 psi/6 Bar. Additional information will be required to determine appropriate specifications for your system.

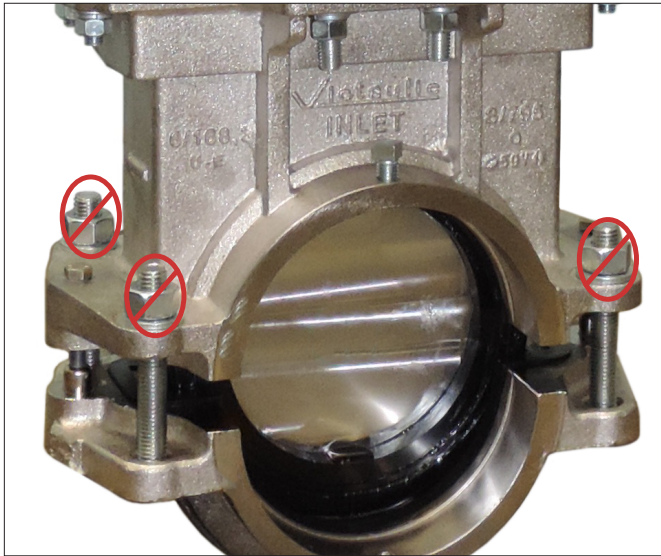
HYDRAULIC OPERATION

Hydraulic cylinders are designed to be operated with a minimum of 1500 psi/103 Bar hydraulic pressure. Contact Victaulic if your system hydraulic pressure is less than 1500 psi/103 Bar. Additional information will be required to determine appropriate specifications for your system.

SECTION I

- **Installing the Valve Into the Piping System**

INSTALLING THE VALVE INTO THE PIPING SYSTEM



1. DO NOT REMOVE THE ASSEMBLY HARDWARE: Series 795 Installation-Ready™ Knife Gate Valves are designed so that the installer does not need to remove the assembly hardware for installation. This design facilitates installation by allowing the installer to directly insert a grooved pipe end into each opening of the valve.



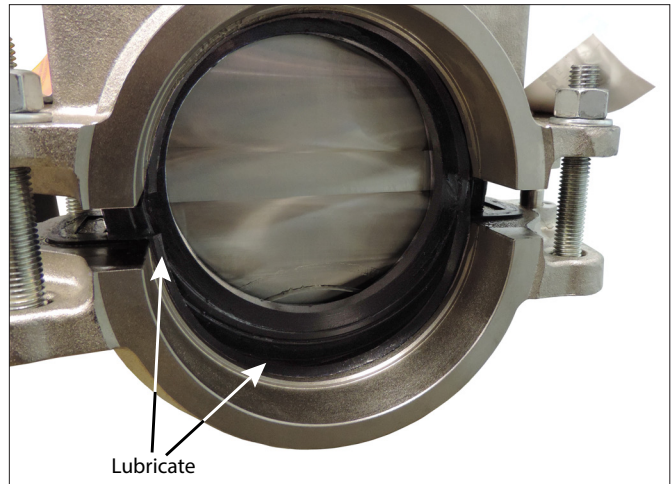
2. INSPECT PIPE ENDS: The outside surface of the pipe, between the groove and the pipe end, must be smooth and free from indentations, projections, weld seams, and roll marks to ensure a leak-tight seal. All oil, grease, loose paint, dirt, and cutting particles must be removed. The pipe OD, groove dimensions, and maximum allowable flare diameter must be within the tolerances published in current Victaulic grooving specifications. **NOTE:** Maximum allowable pipe ovality shall comply with the requirements of ASTM A-999 and API 5L. Greater variations between the major and minor pipe diameters will result in difficult assembly.

3. INSPECT PIPE GASKETS: Check the pipe gaskets to ensure that they are suitable for the intended service. The color code identifies the gasket grade. Refer to Victaulic publication 05.01 in the G-100 General Catalog for the color code chart.

CAUTION

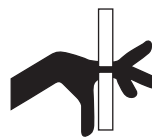
- A compatible lubricant must be used to prevent the pipe gaskets from pinching/tearing during installation.
- Pipe gaskets are designed for one-time use only. **DO NOT** attempt to reuse pipe gaskets.

Failure to follow these instructions will cause gasket degradation, resulting in joint leakage and property damage.



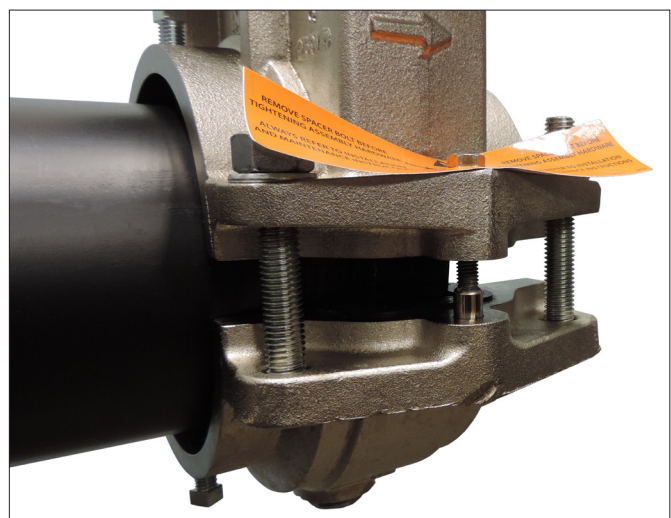
4. LUBRICATE PIPE GASKETS: Apply a thin coat of Victaulic Lubricant or silicone lubricant only to the sealing lips of the pipe gaskets' interior. **NOTE:** The exterior surface of the pipe gaskets is supplied with a factory-applied lubricant. It is not necessary to remove the pipe gaskets from the valve to apply additional lubricant to the exterior surface.

CAUTION

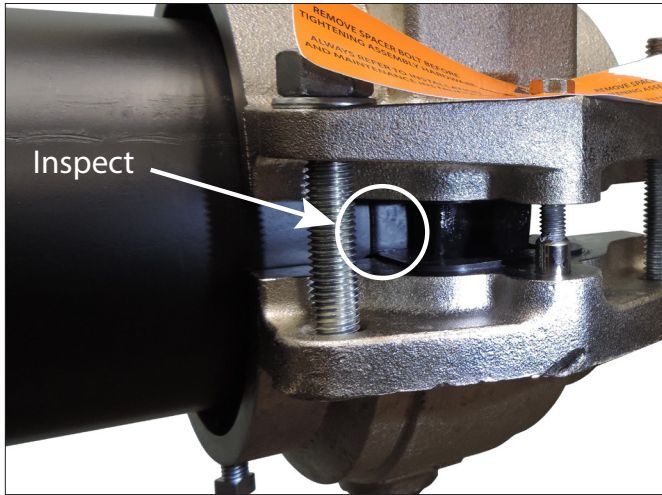


- Keep hands away from the pipe ends and the openings of the valve when attempting to insert grooved pipe ends into the valve.

Failure to follow this instruction could result in personal injury.



5a. ASSEMBLE JOINT: Assemble the joint by inserting a grooved pipe end into each opening of the valve.



5b. INSPECT KEYS: Each grooved pipe end must be inserted into the valve until contact with the seat occurs, as shown above. A visual check is required to ensure that the valve body's keys align with the grooves in the pipe ends.



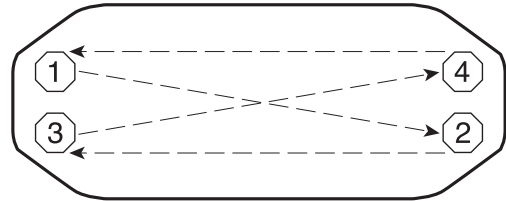
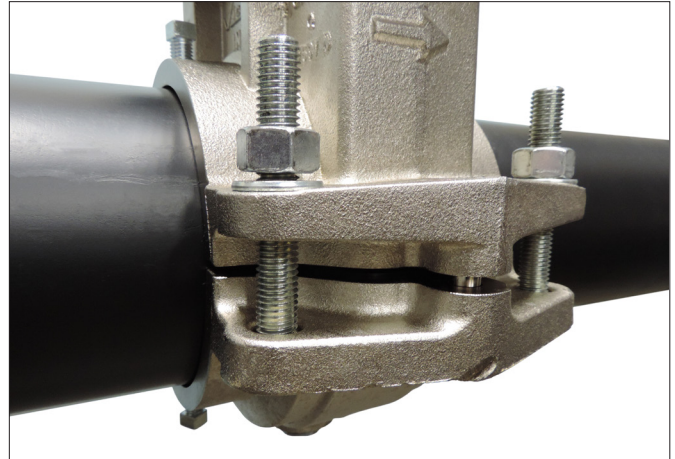
5c. REMOVE ONLY THE SPACER BOLTS: There is one spacer bolt on each bolt pad to maintain spacing between the bolt pads during shipping. These bolts are not intended to remain in the installed product. Remove only the spacer bolts and the attached warning tags before tightening the four nuts in step 6.

CAUTION

- Spacer bolts are designed to keep the valve's housings at the proper spacing during installation of the pipe ends.
- These spacer bolts must be removed prior to tightening the hex nuts to bring the bolt pads into metal-to-metal contact. The bolts will prevent proper tightening of the valve housings.

Failure to follow these instructions will cause damage to the valve components. This may result in joint leakage or property damage, and could void the product warranty.

NOTE: Do not discard the spacer bolts. Label and store them in an easily accessed location. If the valve must be removed from the system, the spacer bolts should be reinstalled to maintain spacing (dimension "C", as defined in the dimension tables found on pages 7–10) between the bolt pads during storage or shipping.



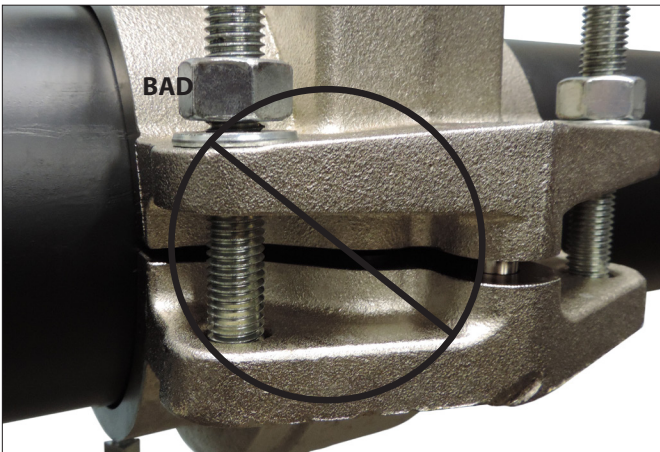
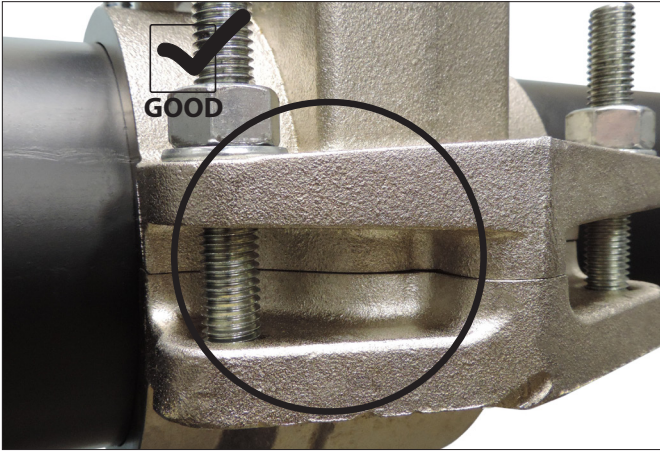
6. TIGHTEN NUTS: Tighten the hex nuts evenly by alternating sides in a crossing pattern (as shown in the sequence above) until metal-to-metal contact occurs at the bolt pads. Ensure that the valve body's keys engage the grooves completely during tightening.

NOTE: It is important to tighten the hex nuts evenly by alternating sides to prevent pinching of the pipe gaskets. An impact wrench or standard socket wrench with a deep-well socket can be used to bring the bolt pads into metal-to-metal contact. Refer to the "Series 795 Helpful Information" and "Impact Wrench Usage Guidelines" sections.

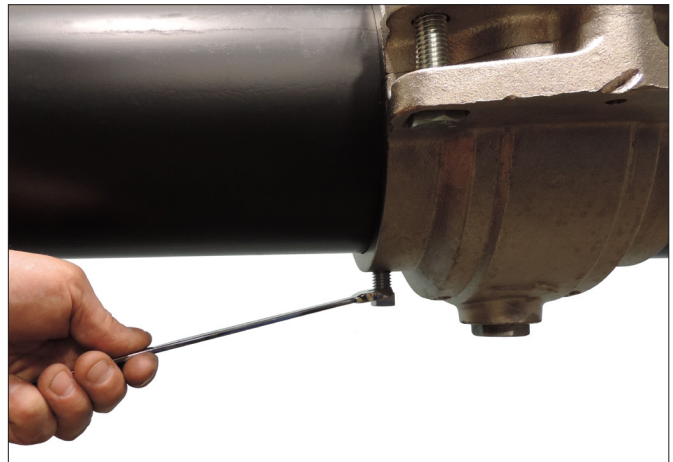
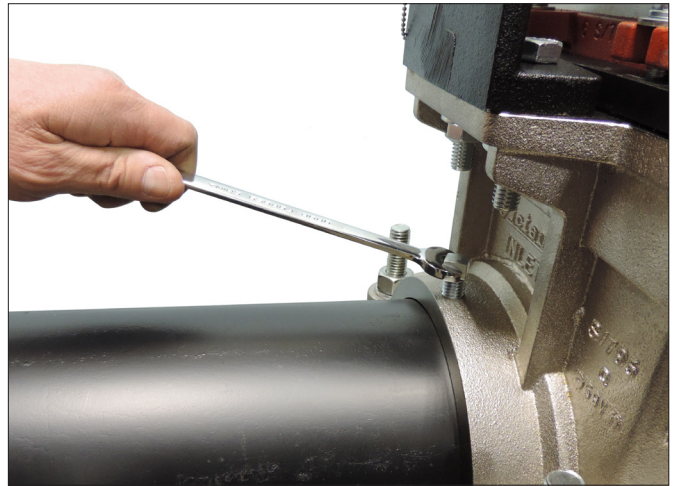
WARNING

- Visual inspection of each joint is critical.
- Improperly assembled joints must be corrected before the system is placed into service.

Failure to follow these instructions could cause joint failure, resulting in serious personal injury and/or property damage.

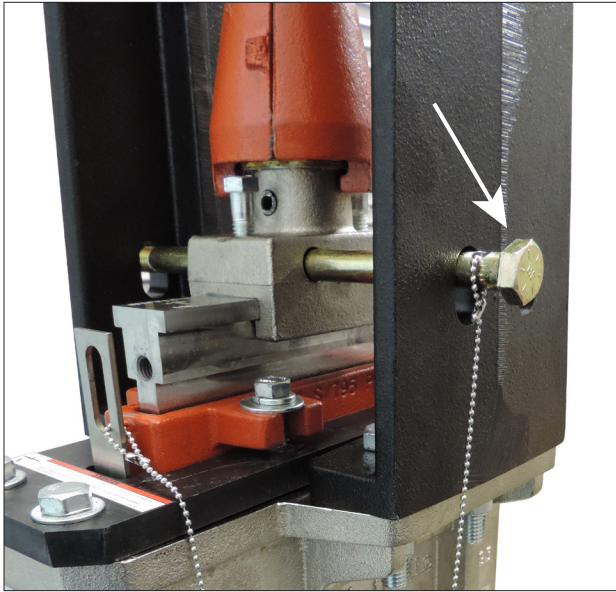


7. INSPECT PADS: Visually inspect the bolt pads at each joint to ensure that metal-to-metal contact is achieved across the entire bolt pad section.



8. TIGHTEN ANTI-ROTATION SCREWS: Tighten the two anti-rotation screws evenly by alternating sides until they reach 40 ft-lbs.

NOTICE



An optional locking pin is provided to assist with Lockout/Tagout procedures during installation and maintenance. Ensure that the pin is removed before attempting to place the valve into service.

IMPACT WRENCH USAGE GUIDELINES

⚠ WARNING

- It is important to tighten the nuts evenly by alternating sides until metal-to-metal contact occurs at the bolt pads.
- **DO NOT** continue to tighten the nuts after the visual installation guidelines for the product are achieved.

Failure to follow these instructions could cause gasket pinching and product damage, resulting in joint failure, serious personal injury, and property damage.

Due to the speed of assembly when using an impact wrench, the installer should take extra care to ensure that nuts are tightened evenly by alternating sides until proper assembly is complete. Always refer to the specific product installation instructions for complete installation requirements.

Impact wrenches do not provide the installer with direct “wrench feel” or torque to judge nut tightness. Since some impact wrenches are capable of high output, it is important to develop a familiarity with the impact wrench to avoid damaging or fracturing the bolts or the bolt pads during installation. **DO NOT continue to tighten the nuts after the visual installation guidelines are achieved.**

If the battery is drained or if the impact wrench is under-powered, a new impact wrench or a new battery pack must be used to ensure that the visual installation guidelines for the product are achieved.

Perform trial assemblies with the impact wrench and check the assemblies with socket or torque wrenches to help determine the capability of the impact wrench. Using the same method, periodically check additional nuts throughout the system installation.

For safe and proper use of impact wrenches, always refer to the impact wrench manufacturer’s operating instructions. In addition, verify that proper impact grade sockets are being used for product installation.

⚠ WARNING

Failure to follow instructions for tightening product hardware could result in:

- Bolt fractures
- Damaged or broken bolt pads or product fractures
- Joint leakage

Series 795 Helpful Information

Valve Size	Spacer Bolt Size	Spacer Bolt Socket	Coupling Nut Size	Coupling Nut Deep-Well Socket
3	3/8" - 16 UNC x 2"	9/16"	1/2" - 13 Heavy Hex	7/8"
4	3/8" - 16 UNC x 2"	9/16"	1/2" - 13 Heavy Hex	7/8"
6	3/8" - 16 UNC x 3"	9/16"	5/8" - 11 Heavy Hex	1 1/16"
8	3/8" - 16 UNC x 3"	9/16"	5/8" - 11 Heavy Hex	1 1/16"
10	1/2" - 13 UNC x 3.5"	3/4"	7/8" - 9 Heavy Hex	1 7/16"
12	1/2" - 13 UNC x 3.5"	3/4"	7/8" - 9 Heavy Hex	1 7/16"

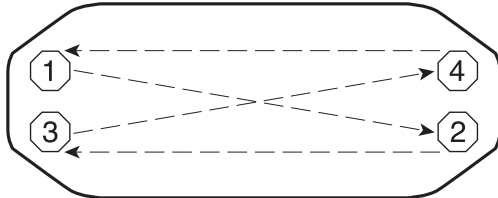
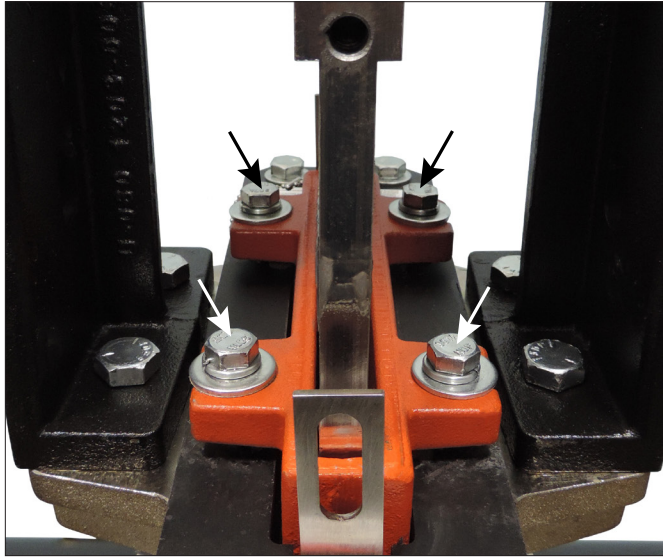
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SECTION II

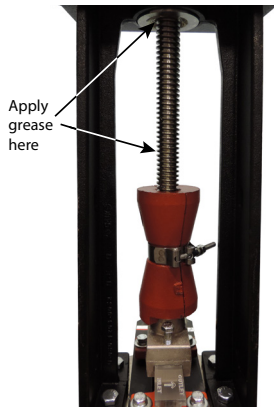
- **Maintenance**
- **Removing the Seat Cartridge**
- **Installing the Seat Cartridge**

MAINTENANCE

Maintenance should be performed on the Series 795 on a regularly scheduled basis, as established by job site requirements, or when leakage occurs.



If leakage occurs at the packing, tighten the hex cap screws evenly in $\frac{1}{4}$ turns by alternating sides (as shown in the sequence above) until leakage stops. If leakage persists, perform the instructions that follow to remove and replace the seat cartridge.



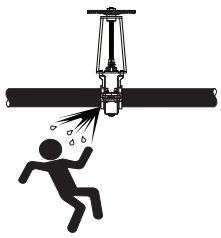
For handwheel, bevel gear, or electrically operated valves, Victaulic recommends greasing the threaded stem and drive nut on a quarterly basis, depending on the number of cycles. If the valve is cycled on a daily basis, increase the frequency of lubricating the threaded stem to ensure proper handwheel operation.

Apply a water-stabilized calcium grease containing graphite and molybdenum disulfide to the entire threaded stem and drive nut. Operate the handwheel to raise and lower the threaded stem to ensure that grease is distributed evenly. **NOTE:** If the valve is in a critical shutoff service and cannot be cycled, insert the locking pin (referenced on page 17) through the yoke (page 5, item 1) into the gate connector (page 5, item 9). Disconnect the threaded stem (page 5, item 7) from the gate connector by removing the slotted spring pin (page 5, item 10). Cycle the threaded stem independent of the gate connector, then replace the slotted spring pin and remove the lockout bolt.

For pneumatically or hydraulically operated valves, refer to the manufacturer's maintenance instructions.

REMOVING THE EXISTING SEAT CARTRIDGE

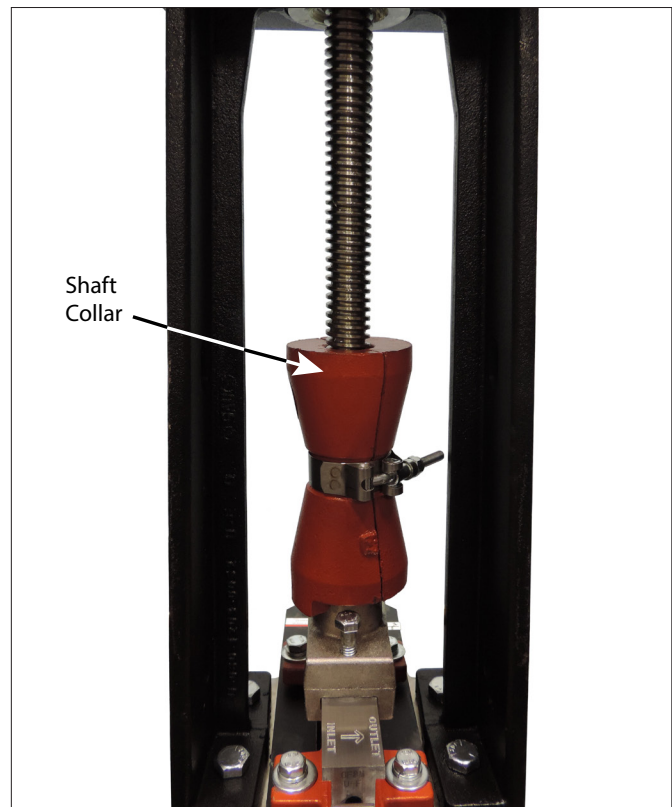
⚠ DANGER



- Depressurize and drain the piping system completely before attempting to remove the seat cartridge.

Failure to follow this instruction could result in death or serious personal injury and property damage.

1. DEPRESSURIZE AND DRAIN SYSTEM: Depressurize and drain the piping system completely before attempting to remove the seat cartridge.



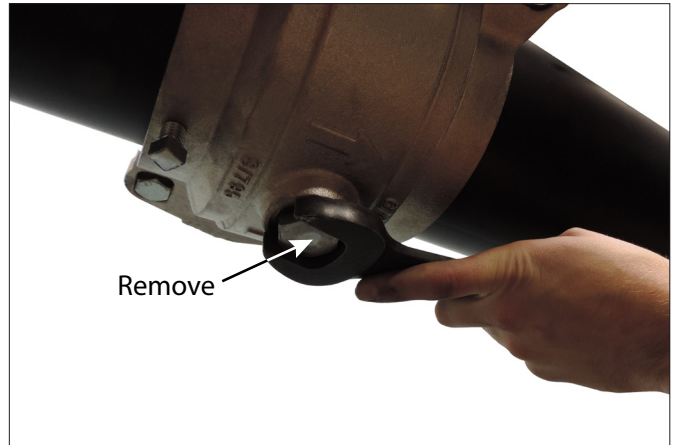
2a. REMOVE SHAFT COLLAR: Remove the shaft collar in order to raise the stem completely.



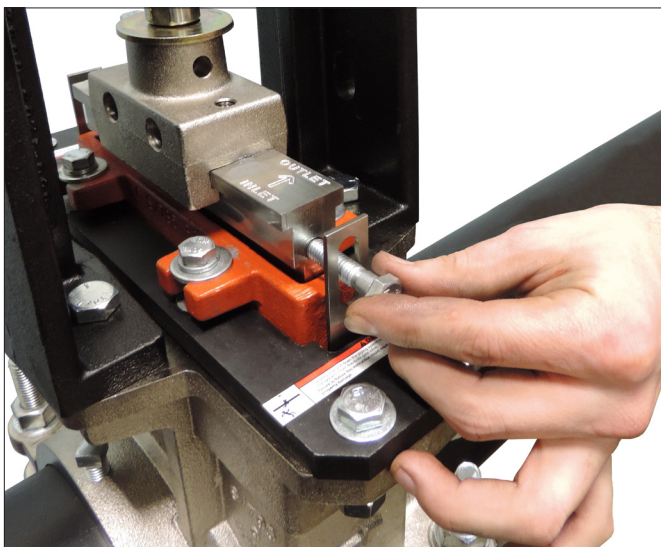
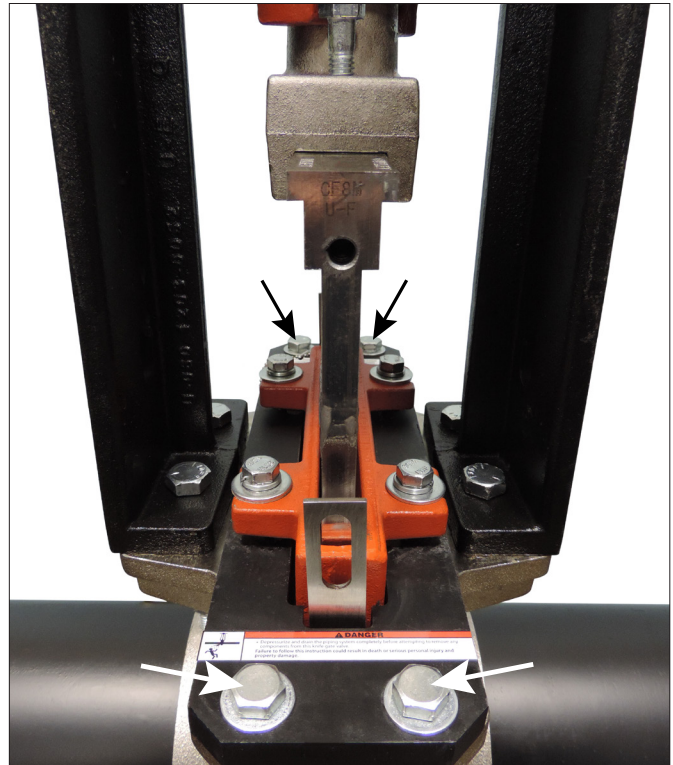
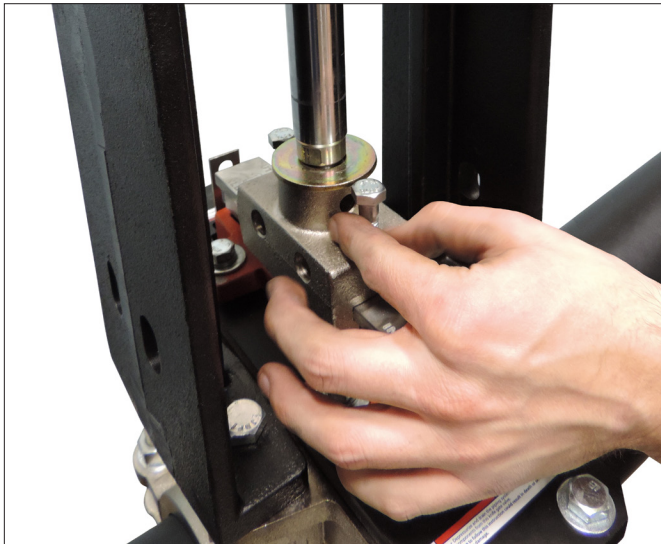
2b. Using a $\frac{7}{16}$ " deep-well socket wrench, remove the nut on the T-bolt clamp and pull the clamp apart.



2c. Remove the T-bolt clamp and split the two halves of the shaft collar to remove.



3. REMOVE PLUG: Using a $1\frac{1}{4}$ " wrench (for the 3 to 8" valves) or a $1\frac{1}{2}$ " wrench (for the 10 to 12" valves), remove the plug from the bottom of the valve body.



4. REMOVE AND RELOCATE GATE CONNECTOR SCREWS: Remove the two hex cap screws from the gate connector, then relocate them through the tab on each side of the seat and into the side of the knife, as shown above. Tighten the two hex cap screws securely. This is necessary to attach the seat to the knife during removal in later steps.

Valve Size	Retaining Plate Bolt Size	Retaining Plate Sockets
3–8"	7/16"	5/8" Bolt 1 1/16" Nut
10–12"	3/4"	1 1/8" Bolt 1 1/4" Nut

5. REMOVE RETAINING SCREWS: Remove the four hex cap screws and nuts from the retaining plate, as shown above.

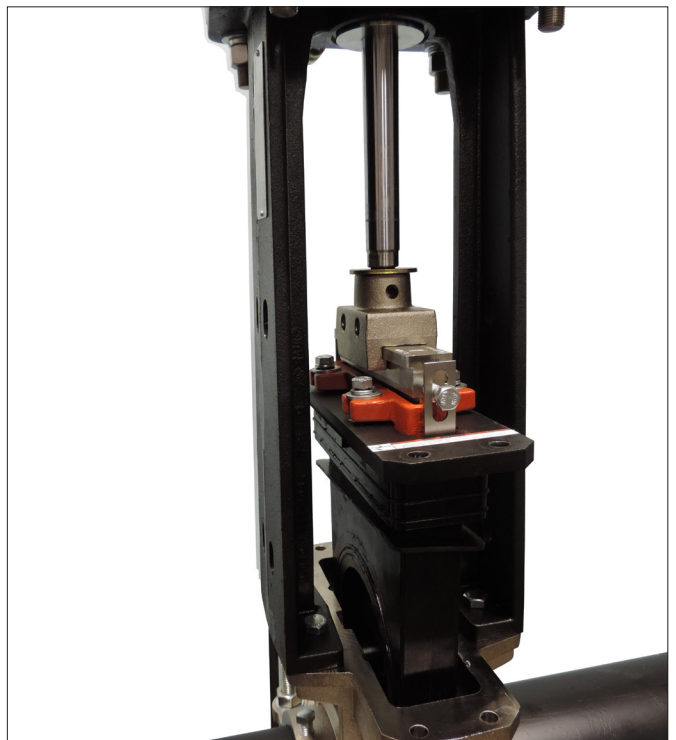
NOTE: Do NOT remove the packing screws. Doing so will damage the seat.



6a. OPEN VALVE: For handwheel operated valves, begin operating the handwheel in the “open” direction (counterclockwise) to draw the seat out from the valve body.

NOTICE

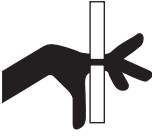
- Support the seat cartridge during actuation to prevent lateral movement. Though the valve is operable in any configuration, angled placement may allow an unsupported seat cartridge to slide out of the gate connector prematurely.

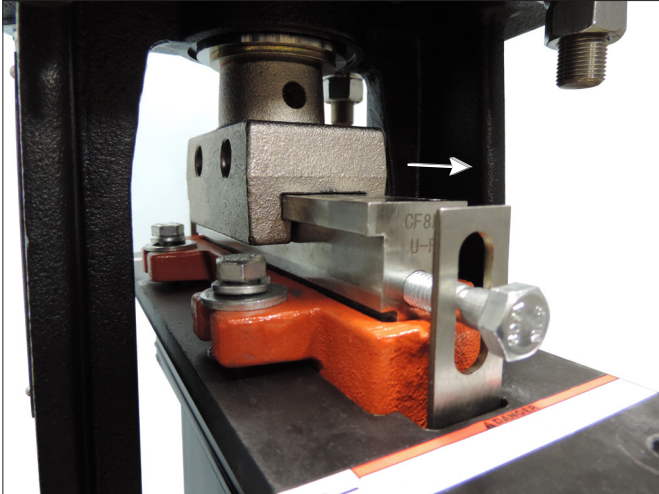


6b. For pneumatically or hydraulically operated valves, actuate the valve open and draw the seat out from the valve body.

NOTICE

- Support the seat cartridge during actuation to prevent lateral movement. Though the valve is operable in any configuration, angled placement may allow an unsupported seat cartridge to slide out of the gate connector prematurely.

⚠ CAUTION	
	<ul style="list-style-type: none"> • Keep hands away from the edges of the knife seat while lifting it from the valve body. <p>Failure to follow this instruction could result in personal injury.</p>



8. CLEAN VALVE: Ensure that the seat cavity and drain plug are free from debris by flushing the cavity with water. Wipe clean the sealing faces with a rag or brush.

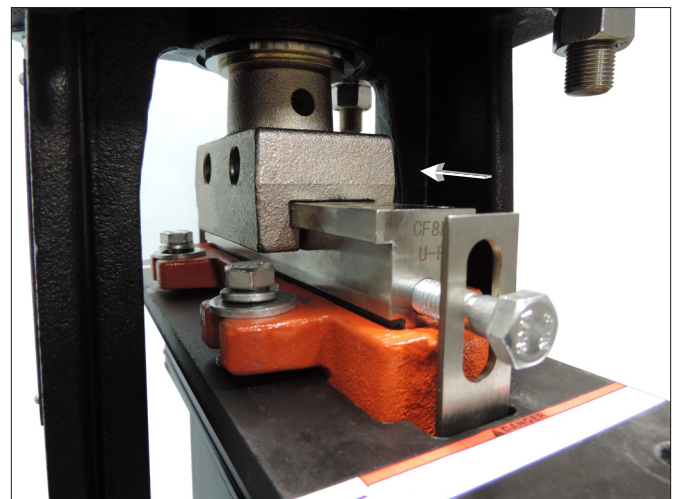
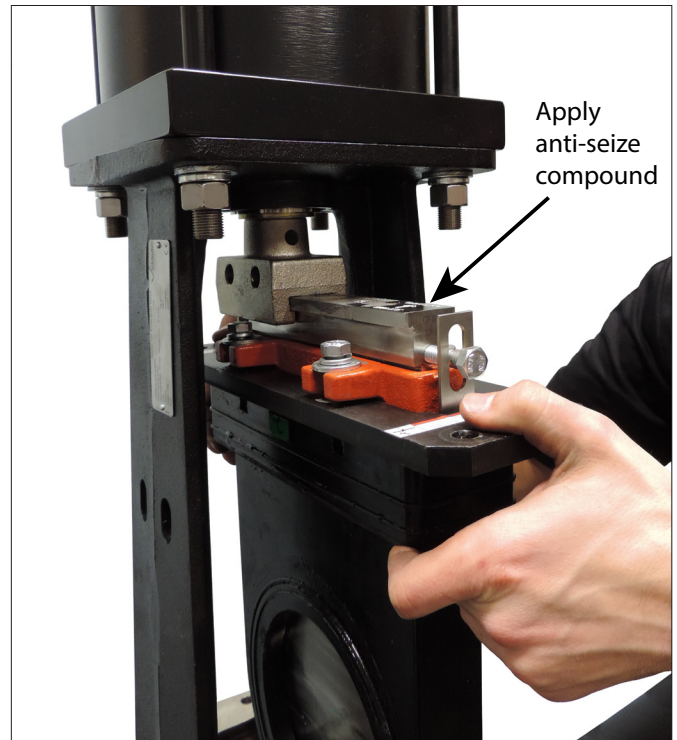
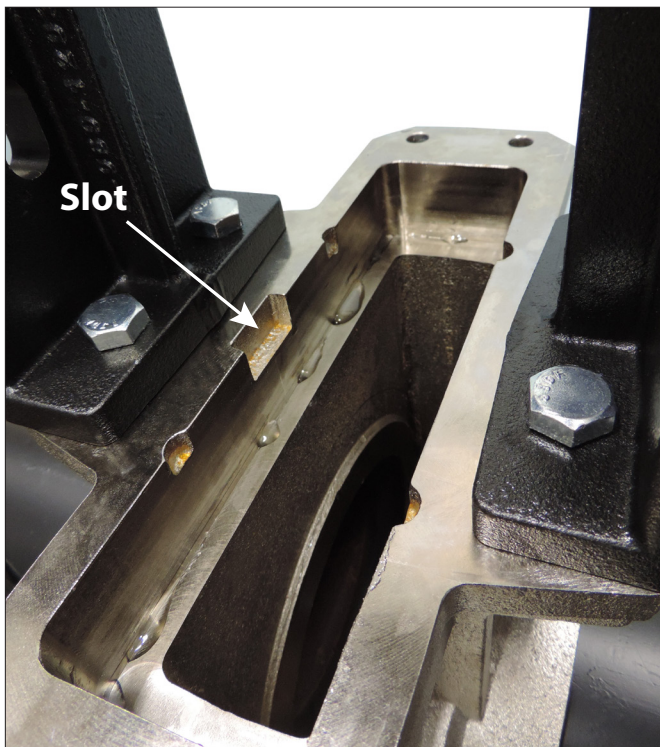
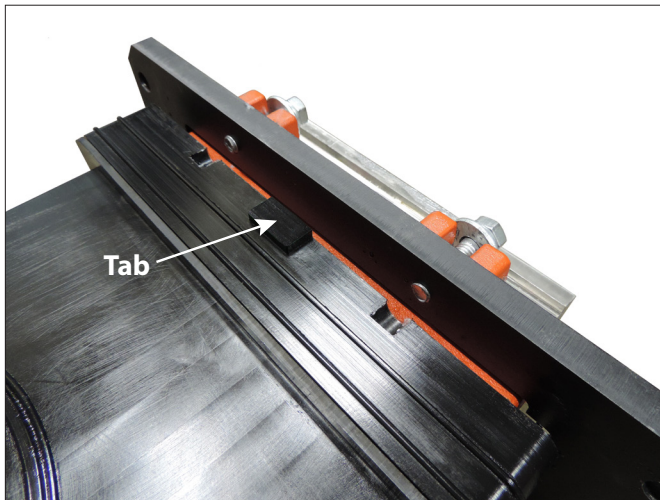
Inspect the cavity to ensure that particles have been removed. All foreign matter should be cleared away before replacing the seat cartridge.

NOTICE
<ul style="list-style-type: none"> • Victaulic recommends having a spare replacement seat cartridge available to prevent maintenance delays.

7. REMOVE CARTRIDGE: When the seat has cleared the opening of the valve body, slide the seat cartridge out from the slot in the gate connector, as shown above. For clearance measurements, reference the E dimension in the table on page 11.

NOTE: When removing the seat cartridge, be prepared to support its weight with both hands. Refer to the table on page 11 for specific weights before attempting to remove the seat cartridge. Larger sizes may require the use of mechanical lifting equipment.

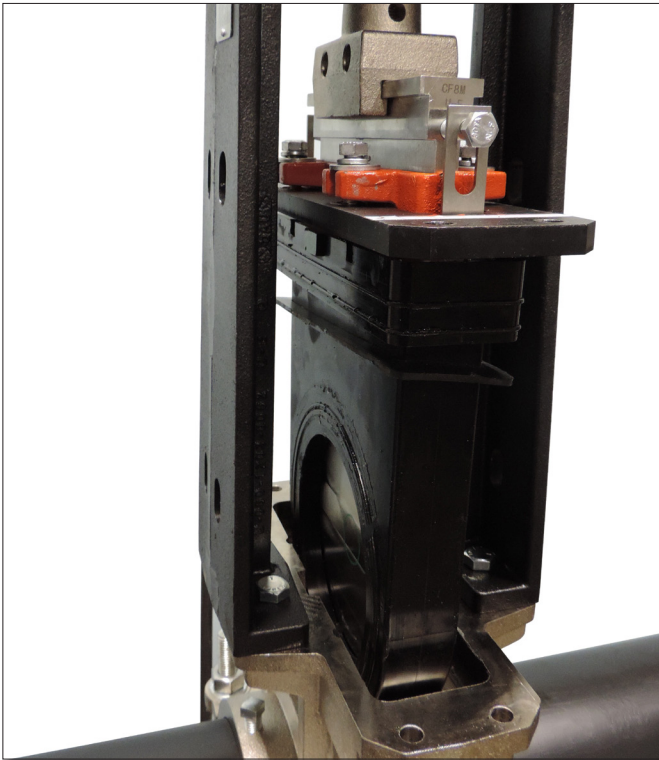
INSTALLING THE REPLACEMENT SEAT CARTRIDGE



2. INSERT CARTRIDGE: Slide the replacement seat cartridge into the slot in the gate connector, as shown above.

1a. PREPARE CARTRIDGE SURFACES: Apply a thin coat of Victaulic Lubricant or silicone lubricant to all surfaces of both sides of the new seat cartridge. **NOTE:** The seat contains a tab that must be installed facing the slot in the valve body, as shown above.

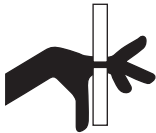
1b. Add a thin coat of anti-seize compound to the top of the knife, as shown to the right, to aid with installation and with future removal of the cartridge.



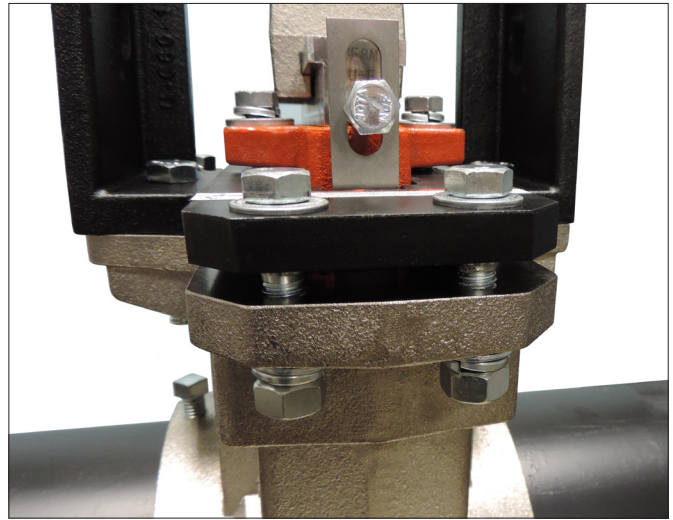
3a. CLOSE VALVE: For handwheel operated valves, begin operating the handwheel slowly in the “closed” direction (clockwise) to bring the seat toward the valve body. Ensure that the tab of the seat is facing the slot in the valve body, as shown in step 1. To prevent damage to the surfaces of the seat, do not attempt to operate the handwheel at an increased rate, or by using a drill or impact gun.

3b. For pneumatically and hydraulically operated valves, actuate the valve closed to bring the seat toward the valve body.

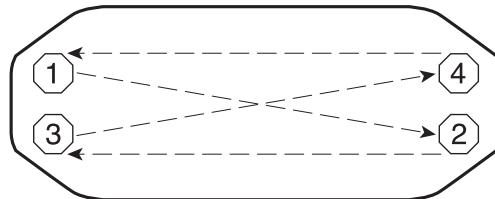
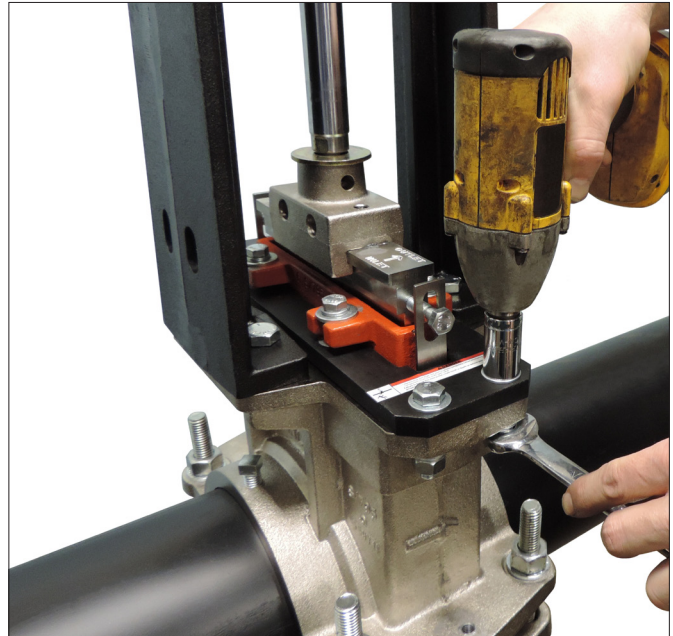
CAUTION



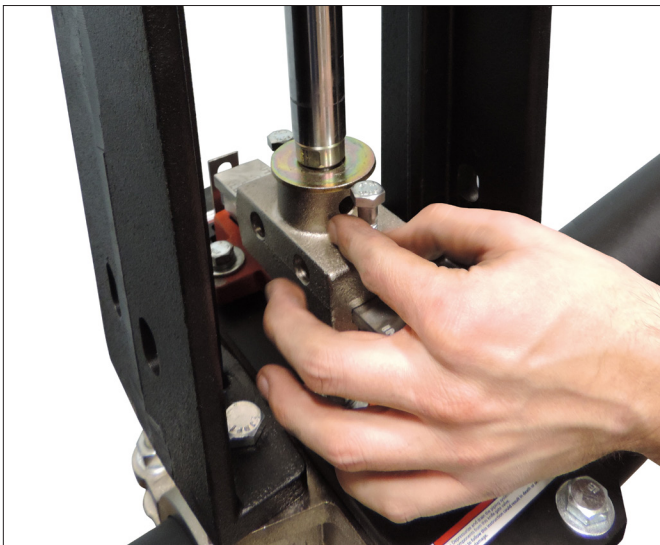
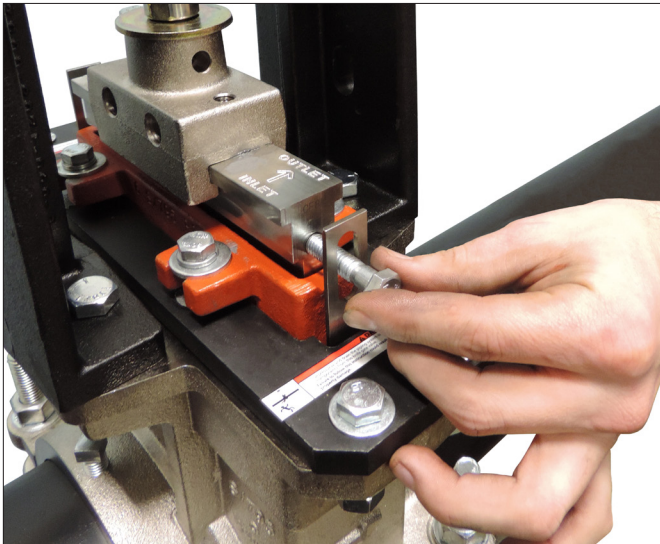
- Keep hands away from the edges of the knife seat while replacing it into the valve body.
 - Keep hands away from the seat cartridge and yoke while actuating the valve.
- Failure to follow this instruction could result in personal injury.



4. REPLACE RETAINING SCREWS: When the retaining plate is 1 inch/25 mm or less from the valve body, insert the four hex cap screws and flat washers through the retaining plate and into the valve body, as shown above.



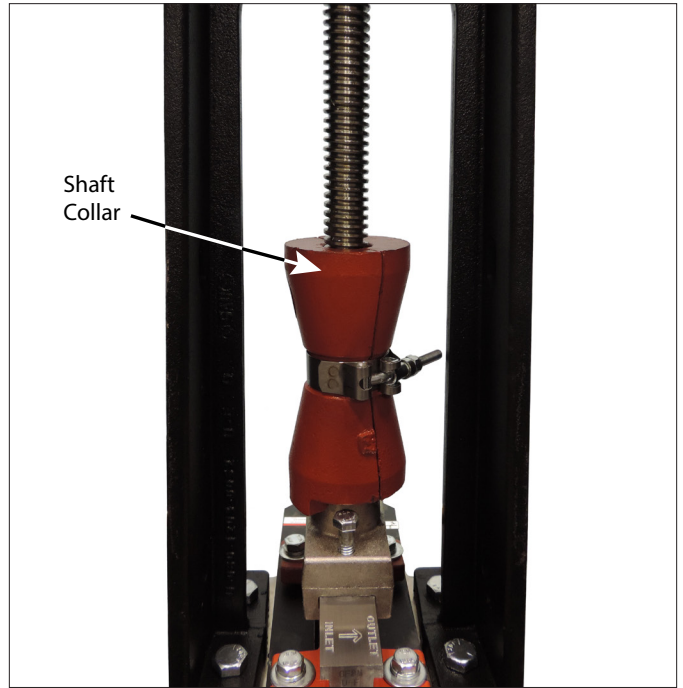
5. TIGHTEN RETAINING SCREWS: Tighten the four hex cap screws evenly by alternating sides (as shown in the sequence above) until the lock washers are fully compressed. There should be metal-to-metal contact between the plate and the housing.



6. REMOVE AND RELOCATE STEM CONNECTOR SCREWS: Remove the two hex cap screws from the knife and relocate them to the gate connector, as shown above. Ensure that the hex cap screw is threaded down so that the head is below the washer (page 5, item 12).



7. REPLACE PLUG: Replace the plug in the bottom of the valve body.

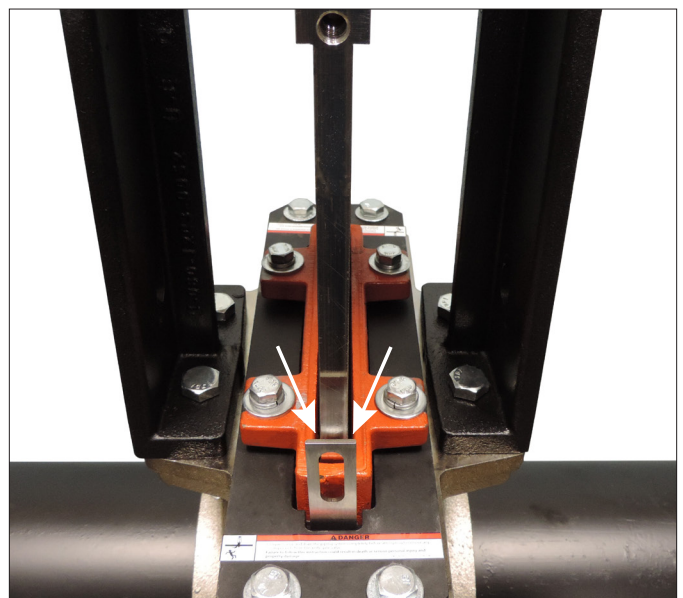


8. REPLACE SHAFT COLLAR: Replace the shaft collar on the stem by reversing the procedure for removal. Do not overtighten the T-bolt clamp.

⚠ CAUTION

- **DO NOT** attempt to place the valve back in service without replacing the shaft collar.

Failure to follow these instructions will cause damage to the valve components. This may result in joint leakage or property damage, and could void the product warranty.



9. INSPECT GAP: Operate the handwheel (or the pneumatic or hydraulic operator) to raise the knife out of the valve body. Ensure that the gap on both sides of the knife is equal, as shown above. The hex cap screws of the packing gland can be adjusted, if necessary, to achieve an equal gap on both sides of the knife. Refer to the "Maintenance" section to review adjusting the hex cap screws.

Series 795 Installation-Ready™ Knife Gate Valve

For complete contact information, visit victaulic.com

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