INSTRUCTIONS and PARTS LIST
for

Oxweld
Trade-Mark

V-11-R
SINGLE OXYGEN SHUTOFF VALVE

The V-11-R is a plunger stem, cam lever-operated, quick-acting on-off valve. It controls oxygen flow at any point in the supply line.

I. OPERATING INSTRUCTIONS

The instructions contained in this booklet are for experienced operators. They assume that the operator knows the general principles of operation and safe practices to be followed in operating oxy-acetylene equipment. If you are not sure that you understand these principles fully, we urge you to read OXWELD’S “Safety Rule Booklet” in addition to these instructions. You can obtain a copy of the “Safety Rule Booklet” from your supervisor or from the OXWELD service engineer.

A. To Connect
There are two standard pipe threaded holes, located one on each end of the valve body. This makes it easy to connect pipe nipples or hose connection adaptors to the valve.

1. Mount the valve assembly in the desired position with the two hex head cap screws supplied with the valve.

2. Connect the oxygen supply line to the inlet connection.

3. Connect the service line or oxygen hose to the outlet connection.

4. Test for leaks around all connections with soapy water solution (use Ivory soap only).
II. MAINTENANCE INSTRUCTIONS

For all repairs and replacements other than those mentioned below, send the valve to the Oxweld Railroad Service Company, 3626 S. Jasper Place, Chicago, Illinois. The specific repair information shown on the drawing is provided for experienced and qualified persons engaged in the repair of oxy-acetylene apparatus. Improperly repaired apparatus may be hazardous. OXWELD offers economical repair service through its repair station.

A. Leakage Through the Valve

If leakage occurs through the valve when the operating lever is in an "OFF" position, it may be due to dirt present on the valve seat or a worn-out seat.

To correct either of these conditions:

1. Remove the two fillister head screws which secure the cam body to the valve body.
2. Remove the cam body (16A75) and the push rod (50Z32).
3. With a suitable wrench, remove the valve stem clamping screw (38A65).
4. Grip the valve stem extension (41A86) with a suitable wrench and unscrew the slotted head valve stem (41A89).
5. Remove the valve stem and rubber valve seat (47A29).
6. Examine the rubber valve seat and if dirt particles are found present, wipe off the faces of the valve seat with a clean cloth.
7. If the valve seat is worn or distorted, replace it with a new valve seat.

8. If the valve stem (41A89) is marred or bent replace it with a new valve stem.
9. Reassemble in reverse order, check for leakage with a soapy solution (use Ivory soap only).

B. Leakage Around the Valve Stem

If leakage occurs around the valve stem, at the top of the valve, tighten the clamping ring (37A43). If leakage persists, the packing bushing must be replaced. To replace the valve packing bushing, the valve stem clamping screw assembly must be entirely disassembled as outlined in Section A, then disassemble the valve stem extension as follows:

1. With a spanner type screwdriver, remove the clamping ring (37A43) which secures the packing bushing (57A22) in place.
2. Remove the valve stem extension (41A86) from the valve stem clamping screw (38A65).
3. Remove the packing bushing from the valve stem extension and replace with a new bushing.
4. Reassemble in reverse order, check for leakage with a soapy solution (use Ivory soap only).

FLOW CAPACITY OXYGEN

<table>
<thead>
<tr>
<th>Pressure Drop Through Valve (lb. per sq. in.)</th>
<th>Capacity (cu. ft. per hr.) At Inlet Pressure of (lb. per sq. in.)</th>
</tr>
</thead>
<tbody>
<tr>
<td>25</td>
<td>350  550  700</td>
</tr>
<tr>
<td>50</td>
<td>550  850  1,100</td>
</tr>
<tr>
<td>100</td>
<td>800  1,100  1,600</td>
</tr>
</tbody>
</table>

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Replacement Parts List

<table>
<thead>
<tr>
<th>PART NO.</th>
<th>DESCRIPTION</th>
</tr>
</thead>
<tbody>
<tr>
<td>16A75</td>
<td>Cam Body</td>
</tr>
<tr>
<td>35A28</td>
<td>Lock Pin</td>
</tr>
<tr>
<td>37A42</td>
<td>Slip Ring</td>
</tr>
<tr>
<td>37A43</td>
<td>Clamping Ring for Packing Bushing</td>
</tr>
<tr>
<td>38A65</td>
<td>Valve Stem Clamping Screw</td>
</tr>
<tr>
<td>40A39</td>
<td>Spring</td>
</tr>
<tr>
<td>41A86</td>
<td>Valve Stem Extension</td>
</tr>
<tr>
<td>41A89</td>
<td>Valve Stem</td>
</tr>
<tr>
<td>47A29</td>
<td>Valve Seat</td>
</tr>
<tr>
<td>57A22</td>
<td>Valve Packing Bushing and Ferrule Assembly</td>
</tr>
</tbody>
</table>

Includes:
- 57A18 Packing Bushing
- 73A93 Ferrule
- 24Y22 Handle Assembly
- 50Z32 Push Rod
- S-F-B-248 1/4-in.-20 x 1/2-in. Fillister Head Brass Machine Screw (2 used)

PARTS NOT ILLUSTRATED

- 03Z54 Oxygen Hose Connection (2 used)
- S-HH-258 1/4-in.-20 x 2-1/4-in. Hex Head Machine Screw (2 used)