

ACV-4

POWDER-PINCH VALVE

 **CAUTION**

These INSTRUCTIONS are for experienced operators. If you are not fully familiar with the principles of operation and safe practices for oxy-fuel gas equipment, we urge you to read our booklet "Precautions and Safe Practices for Gas Welding, Cutting and Heating" Form 2035. Do NOT permit untrained persons to install, operate, or maintain this equipment. Do NOT attempt to install or operate this equipment until you have read and fully understand these instructions. If you do not fully understand these instructions, contact your supplier for further information.

INSTALLATION

The ACV-4 Powder-Pinch Valve provides ON-OFF powder control and is designed for use with a variety of manual and mechanized cutting torches. It can also be used in place of the powder valves on powder cutting attachments in installations where it is desirable to have the valve conveniently located away from the torch. The ACV-4 powder valve can be operated manually, or can be remotely controlled by air pressure. In the latter method, a length of 1/4-in. air line pipe is screwed into the powder valve in place of the 1/4-in. pipe plug located in the body, or plug is replaced with an adaptor (10Z30) and a suitable length of hose fitted with nuts (36Z40) is used to connect the valve to the air line. The powder valve lever is left in the open position, and operation is controlled through the air line valve. By this method, a single air line valve can also be used for simultaneous remote control operation of two or more powder valves.

A. To Connect

Oxweld C-60 and C-100 Torch

The threads on the inlet and outlet connections of the ACV-4 (16X36) are 5/8-18. Two suitable lengths of hose fitted with nuts (38Z40) are required to connect the valve to the powder adaptor and to the powder dispenser.

Other Oxweld Manual and Mechanized Torches

If the ACV-4 is to be used in place of the valve on an existing powder cutting attachment, simply replace the old valve with the new.

MAINTENANCE

A. To Disassemble the Valve Stem Assembly

1. Remove the valve lever. The pin (38Z34) can be pushed out after the clip (81W53) is removed.
2. Remove the cam-riding washer (53Z61) by pulling it over the top of the stem.
3. Loosen the retaining nut (21750) with a wrench; then unscrew it by hand. The complete valve stem assembly will come out as one unit.
4. Replace any corroded, damaged or worn parts.

B. To Replace Rubber Passage Tube

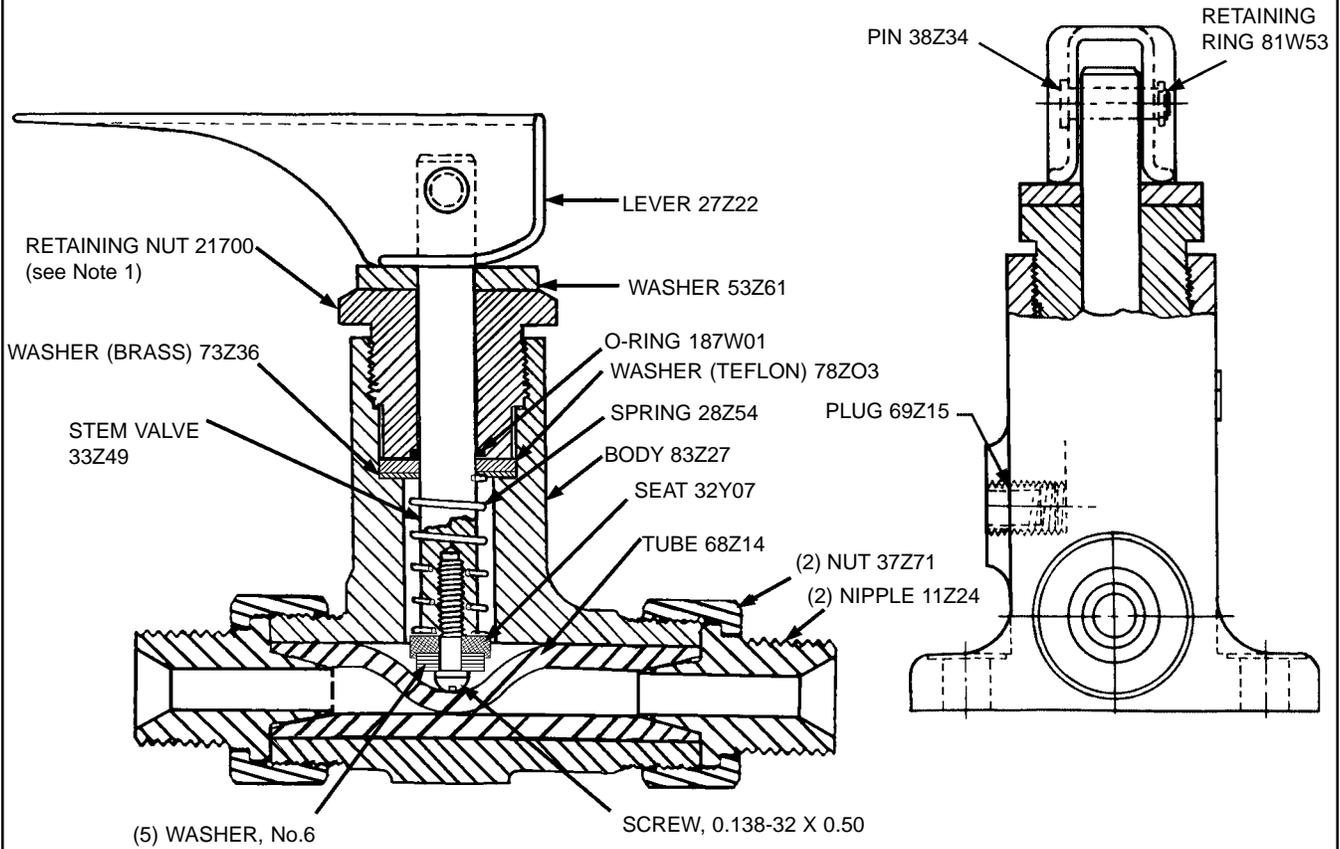
1. Loosen the retaining ring (21700) and screw it out about two turns, then raise the lever to the open position.
2. Unscrew the nuts (32Z71) which lock the nipples in place.
3. Remove the nipples (11Z24).
4. Remove the hose and replace with a piece of similar hose of the same length.

**Be sure this information reaches the operator.
You can get extra copies through your supplier.**



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Note: 1. Assemble Retaining Nut P/N 21700 with 15 in./lbs. torque.
 2. Lightly lubricate O-Rings with silicone grease P/N 17672 (1 oz. tube).



ACV Powder Pinch Valve Part No. 16X36



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