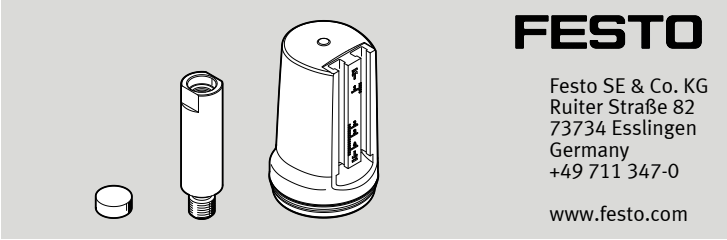


SAMH-F12-MK
Position indicator



Assembly instructions

8128632
2020-08
[8128634]



Translation of the original instructions

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1 Applicable documents

Documents	Product	Contents
Instructions	Angle seat valve VZXA	Operating
Addendum document	Angle seat valve VZXA	Operating conditions
Safety data sheet	Adhesive from the original manufacturer	e.g. LOCTITE 270

Tab. 1

2 Safety

2.1 Safety instructions

- Before carrying out any work on the product, switch off the compressed air supply and secure it against being switched back on.
- Observe the safety data sheet for the adhesive from the original manufacturer.
- The magnet [1] is fragile and strongly magnetic.
 - Handle the magnet carefully.
 - Store the magnet at least 20 cm away from magnetisable objects.

2.2 Intended use

Installation of a position indicator on an angle seat valve VZXA.

3 Product Range Overview

3.1 Scope of delivery

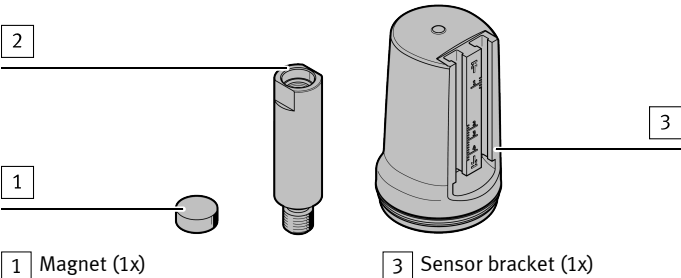


Fig. 1

3.2 Not in scope of delivery

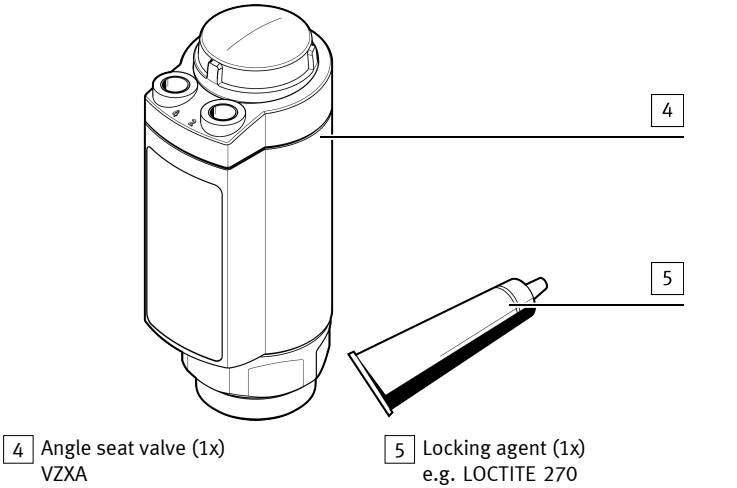


Fig. 2

4 Assembly

A distinction is made between the following control functions of the angle seat valve [4]:

- Double acting (D/A)
- Normally closed (N/C)
- Normally open (N/O)

4.1 Preparation

4.1.1 For angle seat valves with D/A and N/C control function

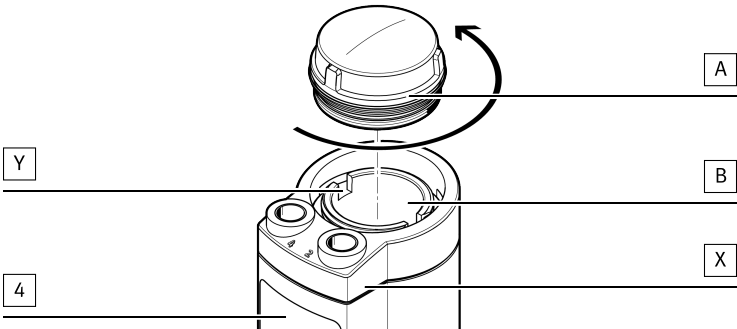


Fig. 3

- Clamp the angle seat valve [4] in a vice on the edges [X] of the spine.
- Remove the sight cap [A].
- If the connector [B] was unscrewed together with the inspection cap [A], detach it from the inspection cap [A].
 - Do not damage the thread of the connector [B].
 - Screw the connector [B] back into the angle seat valve [4].
- Use an auxiliary tool to engage into the slots [Y].
Auxiliary tool: 5 mm thick, 35 mm wide
- Tighten connector [B]. Tightening torque: 20 Nm ± 10 %

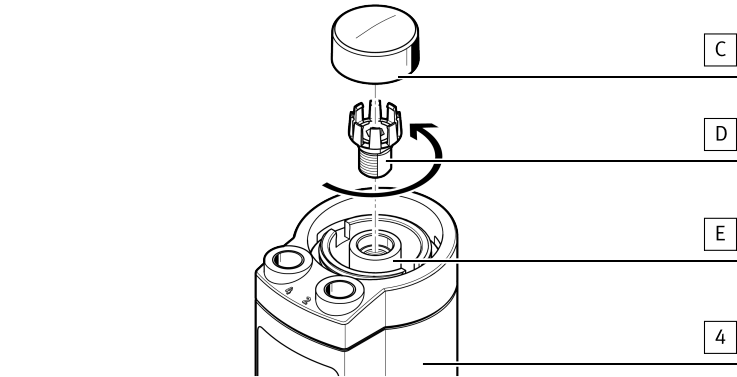
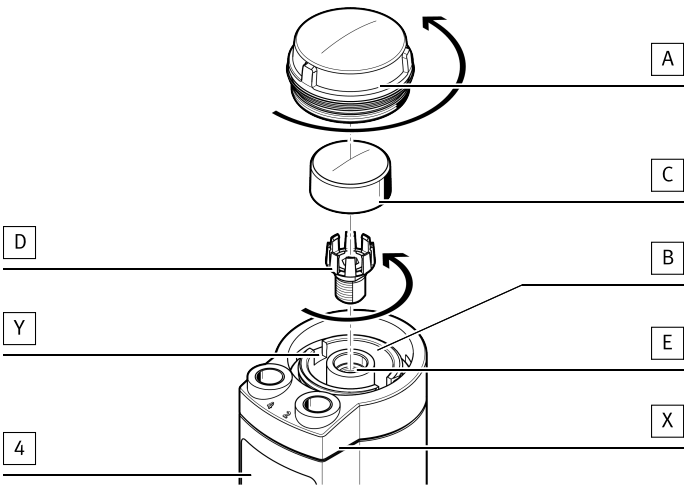


Fig. 4

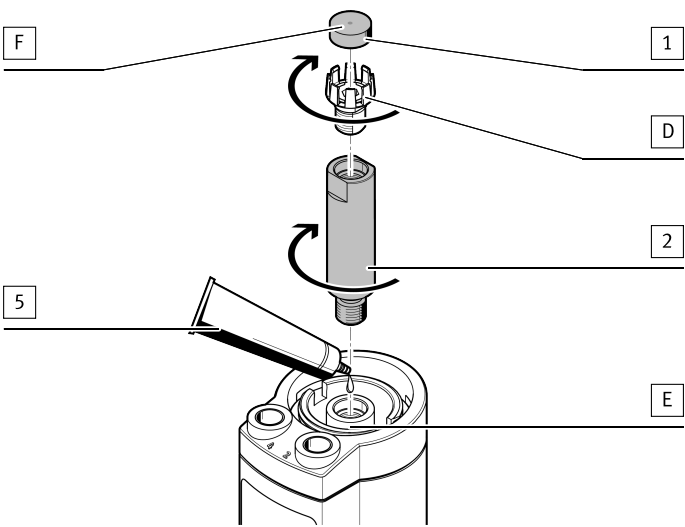
- Pressurise the angle seat valve [4] with compressed air at port 2.
☞ The piston rod [E] travels to the top end position.
- Pull off display part [C].
- Unscrew the retaining bracket [D] from the piston rod [E]. Hexagon: 5 mm
- If necessary, remove objects from the angle seat valve [4]. Clean coarse contamination. Objects: e.g. thread abrasion

4.1.2 For angle seat valves with N/O control function

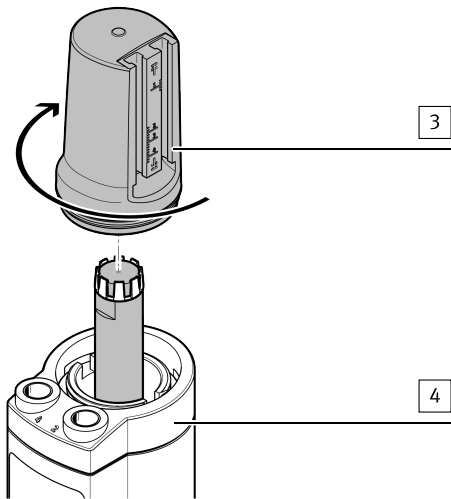


- Fig. 5
1. Clamp the angle seat valve [4] in a vice on the edges [X] of the spine.
 2. Remove the sight cap [A].
 3. Pull off display part [C].
 4. Unscrew the retaining bracket [D] from the piston rod [E]. Hexagon: 5 mm
 5. If the connector [B] was unscrewed together with the inspection cap [A], detach it from the inspection cap [A].
 - Do not damage the thread of the connector [B].
 - Screw the connector [B] back into the angle seat valve [4].
 6. Pressurise the angle seat valve [4] with compressed air at port 2.
 - ☞ The piston rod [E] travels to the lower end position.
 7. Use an auxiliary tool to engage into the slots [Y].
Auxiliary tool: 5 mm thick, 35 mm wide
 8. Tighten connector [B]. Tightening torque: 20 Nm ± 10 %
 9. If necessary, remove objects from the angle seat valve [4]. Clean coarse contamination. Objects: e.g. thread abrasion

4.2 Assembly



- Fig. 6
1. Check that the rod [2] can be screwed easily into the piston rod [E].
 2. Degrease rod [2].
 3. Apply the screw locking agent [5] to the female thread of the piston rod [E].
Do not contaminate the seal of the piston rod [E] with the screw locking agent [5].
 4. Screw the rod [2] into the piston rod [E] to the stop. Spanner size: ≈ 13
☞ Rod [2] is flush with the piston rod [E].
 5. Screw the retaining bracket [D] into the rod [2].
 - Hexagon: 5 mm
 - Tightening torque: 1.1 Nm ± 10%
 6. Orient solenoid [1] with the red marking [F] upwards.
 7. Press the magnet [1] into the retaining bracket [D].



- Fig. 7
1. Screw hood [3] into the angle seat valve [4] to the stop.
 2. Turn hood [3] another 5°.

5 Switching points of the sensors

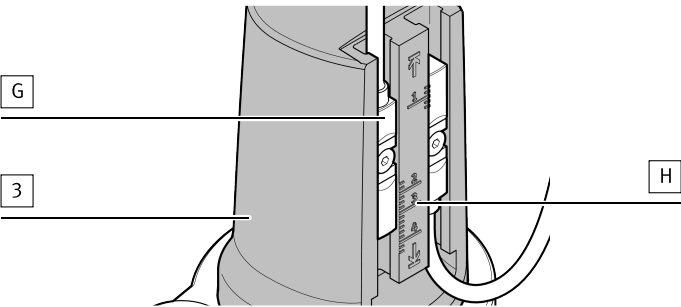


Fig. 8

The exact switching points vary slightly depending on the sensors [G] and the tolerances of the drives.

The following table explains the markings [H] on the hood [3]:

Marking	Meaning	Drive
↑	Direction of upper end position	all drives
1	upper end position (valve fully open)	all drives
2	lower end position (valve fully closed)	K-46
3		K-75
4		M-90
↓	Direction towards lower end position	all drives

Tab. 2 Markings on the hood

The markings [H] mark the position of the centre of the magnet [1]. The activated sensors must be precisely positioned at the drive position for precise position sensing.