

PRODUCT DEVELOPMENT DOCUMENT CONTROL

DOCUMENT#: BVG110 & BVG110P HANDLE & NOTCH PLATE RETROFIT	Eng. Mgr. Approval: Lonnie Horne
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BVG 110 & BVG110P HANDLE & NOTCH PLATE RETROFIT



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Installation instructions for handle & notch plate upgrade

1. On existing cars, open the bottom discharge cover and swing the cover away from the opening. This will aid in adjusting the gate.



2. Remove the existing shaft/handle assembly by unbolting the valve from the shaft and slide out of gate. Install the new shaft and valve into the gate the opposite way you remove the old shaft. A properly installed shaft and valve will have the handle bolt hole horizontal at the end of the shaft when the valve is closed (remember that the valve opens from right to left). Next, remove the notch plate from the gate.



3. Attach the modified back plate to the existing notch plate using (4) 1/2"x1-1/4" bolts, lock washers, and nuts.

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4. Apply the retro notch plate by inserting over the valve shaft and locate the notch plate against the backing plate on the gate, rotate the notch plate to the correct rotation of the butterfly valve.

Reattach the handle with the nut and bolt. Apply shims to the three points at the butterfly valve. One .060" shim should be placed at the apex of the valve and two shims that are .020" should be placed on the sides of the valve. Next, put the valve and notch plate assembly in the closed position and tap down on the valve to take out any slack within the assembly.

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5. Adjust the notch plate in or out before welding, this will take up any play between the plate and the handle. Also, make sure that the handle is rotated all the way to the right, this will take any slack out of the valve shaft assembly.



6. Tack weld the modified notch plate assembly to the existing back plate and check for proper valve operation. The valve should be able to rotate 90 degree's and not bind or stick within the center discharge tube. Once the gate has met these objectives, complete the weld on the back of the notch plate to the back plate.

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7. The last step in the upgrade will be the welding of the roll pin to the handle. Both sides of the roll pin must be tack welded to the handle. If handle has been tack welded, then this step can be skipped.