

Disassembly and Assembly of HECI Low Torque Plug Valve

1. With plug valve handle facing upward.
(Figure 1)



Figure 1

2. Remove Bolt from Center of plug valve handle. (



Figure 2

3. Remove plug valve handle. (Figure 3)



Figure 3

- 4. Remove Socket Head Cap Screw
(Figure 4)**



Figure 4

- 5. Turn Plug Valve over so that the Cap
Body is now facing upwards.**

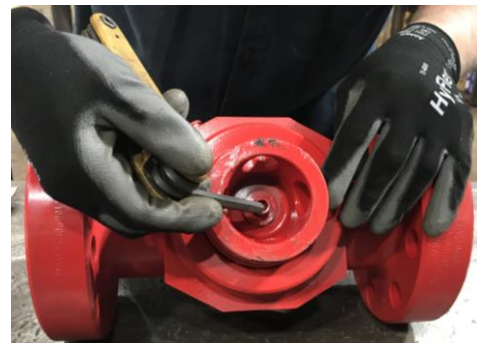


Figure 5

- 6. Remove Socket Head Cap Screw from
center of Cap Body.
(Figure 5 & Figure 6)**



Figure 6

7. Using a screw driver or a small bar, turn the cap screw counter-clockwise to unscrew it from the body. (Figure 7)



Figure 7

8. Turn Cap screw until you are able to pull it out of the body. (Figure 8)



Figure 8

9. Remove the plug body and seat carrier body with the cap screw. (Figure 9)



Figure 9

10. Remove plug seal from the body
(Figure 10)



Figure 10

11. Remove old seals from cap screw, seat carriers and plug body and prepare new seals to install. (Figure 11)

*Call Horn Equipment Sales for appropriate seal kit or rebuild kit



Figure 11

12. Apply grease to O-ring grooves on seat carrier bodies then place new O-rings into grooves. (Figure 12 & Figure 13)



Figure 12



Figure 13

13.Apply a thin layer of grease to plug body (Figure 14)



Figure 14

14.Apply thin layer of grease to the inside of the seat carrier bodies. (Figure 15)



Figure 15

15.Apply grease to the groove on the cap body (Figure 16)



Figure 16

16. Install O-ring on the cap body
(Figure 17)



Figure 17

17. Install plug seal into the cap body with
the brass side facing down (Figure 18)



Figure 18

18. Install plug seal into the plug body with
the brass side facing down. (Figure 19)



Figure 19

19.Apply grease to the inside of the plug body around the outlet holes.
(Figure 20)



Figure 20

20.Assemble the plug body, seat carrier body, and the cap screw together.
(Figure 21)



Figure 21

21.Install socket head cap screw into the plug body. Do not fully tighten screw.(Figure 22)



Figure 22

22. Spray lubricant into the plug valve body. (Figure 23)



Figure 23

23. When assembling the plug valve, the slots machined into the seat carrier bodies are made to align with the pins in the plug valve body. (Figure 24 & Figure 25)



Figure 24



Figure 25

24. Apply anti-seize to the threads on the cap screw before threading it into the body. (Figure 26)



Figure 26

25. Tighten the Cap screw into the body.
Use a screw driver or something similar
to tighten it down.. (Figure 27)



26. Using a wrench, turn the plug body
until the holes are lined up with the
bore. (Figure 28)



27. Once holes are lined up, tighten socket
head cap screw on the cap body.
(Figure 29)



1. Set the plug valve upright with the cap screw now sitting on the bottom. (Figure 30)



Figure 30

2. Install socket head cap screw to the top of the plug valve. (Figure 31)



Figure 31

3. Install plug valve handle and socket head cap screw and washer. (Figure 32 & Figure 33)



Figure 32



Figure 33