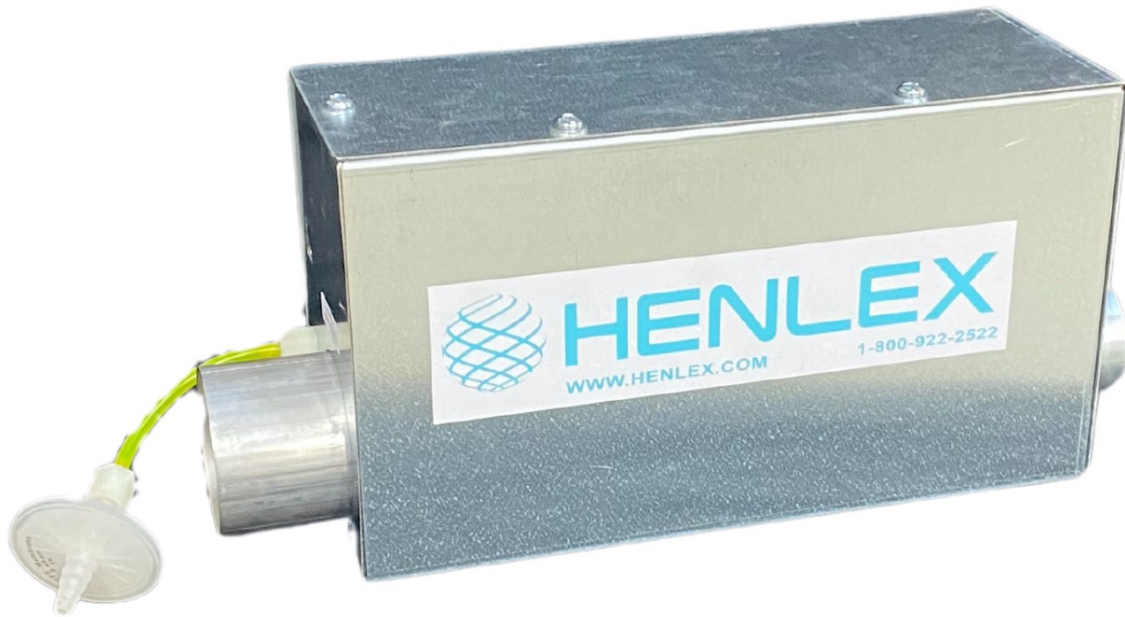




OPERATION AND MAINTENANCE MANUAL



AUTOMATIC VALVE HVAV-3

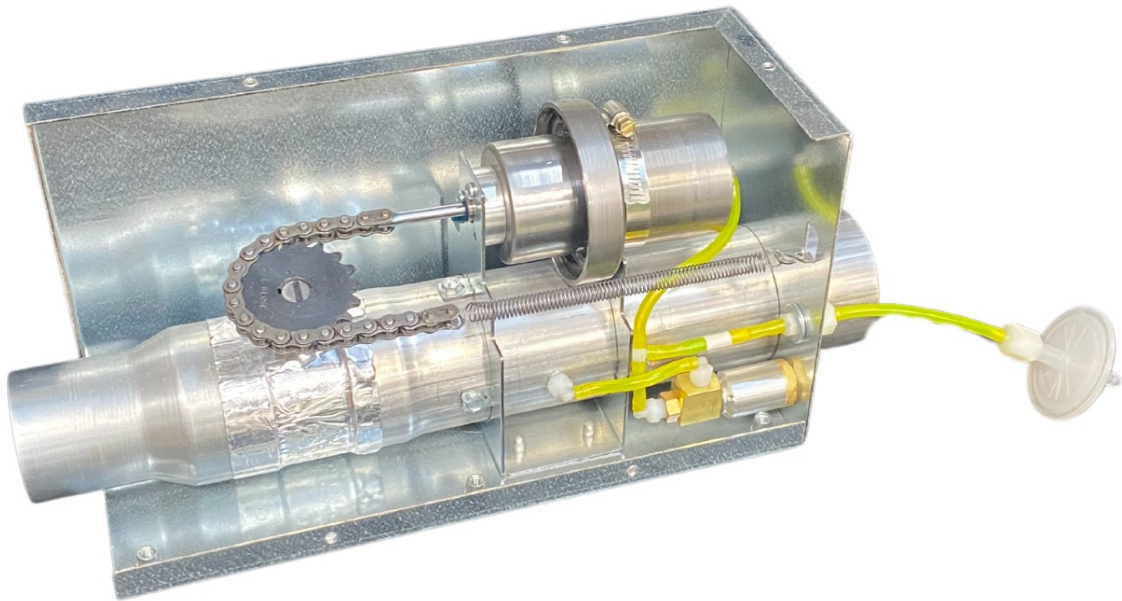
HENLEX INC. - 2600 DIAB, MONTREAL, CANADA
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INTRODUCTION

Our automatic valve aims to optimize suction for each workstation. Suction is activated when the welder operates the welding gun. When the worker is not welding, the suction is stopped completely. This has the effect of efficiently distributing the available vacuum to the workstations that need it. This also reduces the noise level at the workplace, as the noise generated by the suction is only emitted when the welding gun is activated.

CHARACTERISTICS

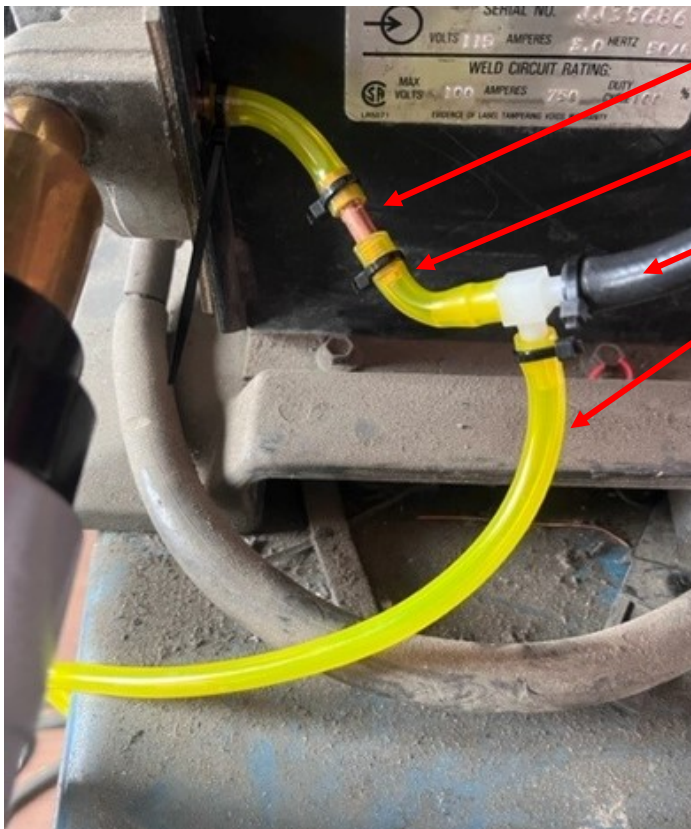
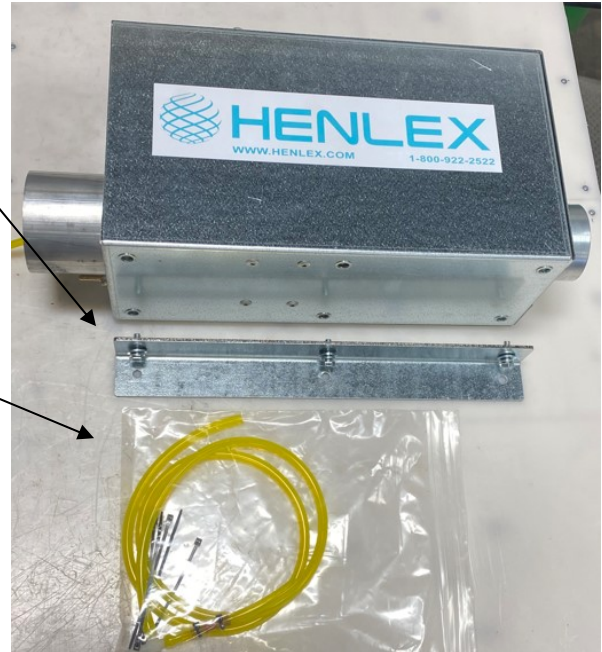
No electrical connection required	Multi-Position case support
Activated by the vacuum network	16GA Galvanized steel casing
Opening the shutter instantly	Normally closed valve
Adjustable shutter closing time	Suction optimization



Overview of the automatic valve and connection

Multi-Position support

Hose assembly, fitting and nylon tie-wraps



Orifice (must be on the gun side)

Gun gas connection

Shielding gas supply hose

Connection to the automatic valve

- Connect the shielding gas supply hose to one side of the tee fitting
- Connect the short yellow tygon hose to the gas connection of the gun
- Connect the long yellow tygon hose to the automatic valve

Note : There is no leak of gas or pressure, because it is in closed circuit. It is important to put the nylon tie-wrap on each connections.

TROUBLESHOOTING

Problem	Cause	Action
<p>The automatic valve does not open, or opens for a few seconds and closes again.</p>	<p>Insufficient vacuum at the valve inlet</p>	<p>Check for any connections, leaks, obstructions in the network or flexible hoses.</p> <p>Check turbine, direction of rotation, open motorized damper and protective grill</p> <p>Check that the adjustment of the pressure gauge on the control cabinet (Anti surge system) is at least 70" H2O.</p>
	<p>Obstruction in the valve</p>	<p>Disconnect the hoses from the "vacuum side" and "gun side" of the valve and check for any obstruction inside the connections.</p>
	<p>Insufficient gas pressure at the valve inlet</p>	<p>Measure the gas flow with a handheld flow meter at the end of the gun (Gas nozzle). The gas flow must be from 35 CFH to 40 CFH</p> <p>Adjust the pressure to the gas regulator, if needed.</p> <p>Check the connections from the wire feeder to the valve.</p> <p>Check the condition of the o-rings on the wire feeder and gun.</p>
<p>The automatic valve does not close, or leaks significantly</p>	<p>Obstruction in the valve</p>	<p>Disconnect the hoses</p>
	<p>Obstruction of the vent filter or hose</p>	<p>Disconnect the hoses from the "vacuum side" and "gun side" of the valve and check for any obstruction inside the connections.</p>
	<p>Gas pressure always maintained at the valve</p>	<p>Check the gas hose connections on the gun side</p>