

Gas Valve Conversion Kit

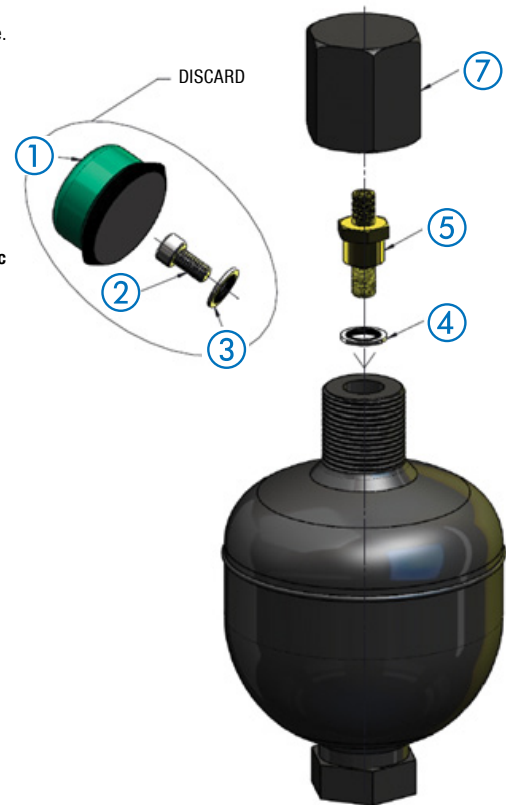
STDA-X-AK

Easily converts the standard M28 X 1.5 gas valve on diaphragm accumulators to the "US Style" cored type gas valve.

Parts included in the adapter kit:

- Aluminum Protective cap (item 7)
- Gas valve adapter assembly with installed gas valve core (item5)
- Gas Valve seal (item4)
- Assembly instructions

- **IMPORTANT: Before installing the new gas valve, make sure the accumulator is isolated from the hydraulic system and that the gas pressure has been released from the accumulator using the proper charging kit. Please see the operating and maintenance instructions for details.**



Charging Kit

STDA-CK-M-P3

Charging kit for diaphragm accumulators with the M28 X 1.5 gas Valve 3625 PSI (250 bar) rated

Includes:

- STDA-PCM2155 Charge Valve assembly and test point
- SPG-063-0250-01-P-B04 Gauge 0 ... 3625 PSI (0 ... 250 bar)
- STBA-P3-3048MM-B 3000 PSI Nitrogen bottle adapter and hose assembly, 3048mm (12 in) long
- STDA-AW6MM 6 mm hexagon wrench
- STBA-C-1 Case with foam

STBA-CK-B-P3

Charging kit for diaphragm accumulators with the US style cored gas valve 3625 PSI (250 bar) rated

Includes:

- STBA-PC2157 Charge Valve assembly and test point
- SPG-063-0250-01-P-B04 Gauge 0 ... 3625 PSI (0 ... 250 bar)
- STBA-P3-3048MM-B 3000 PSI Nitrogen bottle adapter and hose assembly, 3048mm (12 in) long
- STBA-50019 Fitting Adaptor, .305-32 UNS (female) to 5/8"-18-2AUNF(Male)
- STBA-10143 Fitting Adaptor, 7/8"-14 UNF (female) to 5/8"-18-2AUNF (Male)
- STBA-C-1 Case with foam



Pre-Charging Diaphragm Accumulators with US Style Cored Gas Valve

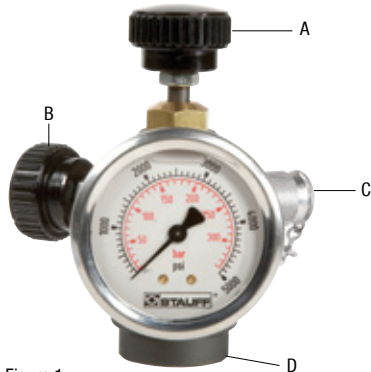


Figure 1.



Figure 2.

1. Isolate the accumulator from the system and make sure hydraulic fluid pressure is zero.
2. Remove the gas valve protection guard and then the gas valve cap from the accumulator.
3. To charge the accumulator, use a charging hose and gauge assembly similar to Stauff Charging Kit # STBA-CK-B-P3 rated for 3,000 psig minimum (higher pressure kits are available).
4. Before using the charging assembly (Figure 1.) make sure that valve **A** is completely open (counter-clockwise), ensure that bleed valve **B** (Figure 1.) is completely closed (clockwise) and that the non-return valve **C** (Figure 1.) is capped.
5. Connect the charging unit to the gas fill valve on the accumulator by means of knurled cap **D** (Figure 1.).
6. Make sure the valve on the nitrogen bottle is completely closed, then fit the nitrogen gas valve adapter/hose assembly (included in Stauff charging kit # STBA-CK-B-P3) onto the nitrogen bottle (Figure 2.).
7. Connect the other end of gas hose to the non-return valve **C** (Figure 1.), after taking off the cap.
8. Turn valve **A** (Figure 1.) clockwise until it stops (**Do not over Torque**).
9. **SLOWLY** open the valve on nitrogen bottle (Figure 2.) and allow the nitrogen gas to flow into the accumulator. The pressure gauge should begin to register pressure.
10. Once the desired gas pre-charge pressure has been reached, close valve on nitrogen bottle (Figure 2.).
11. Open valve **A** (Figure 1.) (Fully counter-clockwise) to bleed the trapped pressure in the gas line to zero by means of bleed valve **B** (Figure 1.), open valve **B** (turn counter-clockwise) until gauge reads 0 psig.
12. Remove hose from non-return valve **C** (Figure 1.) and replace cap.
13. Close the bleed valve **B** (Figure 1.) and wait a few minutes for pressure to stabilize.
14. Screw valve **A** (Figure 1.) clockwise until pressure can be read on gauge. This should be slightly higher than the required pressure.
15. Adjust to desired pressure by means of bleed valve **B** (Figure 1.), then remove charging unit from the accumulator gas valve and from the nitrogen bottle (after making sure that the nitrogen bottle valve is completely closed).
16. Reinstall the gas valve cap and protective guard cap on the accumulator. The accumulator is now ready for use.

NOTE: Allow the accumulator to rest for approximately 10-15 minutes after gas pre-charging. This will allow gas temperature to adjust and equalize. Recheck gas pressure and adjust if necessary. Check accumulator gas valve for any leaks with soapy water. Always wear safety glasses.