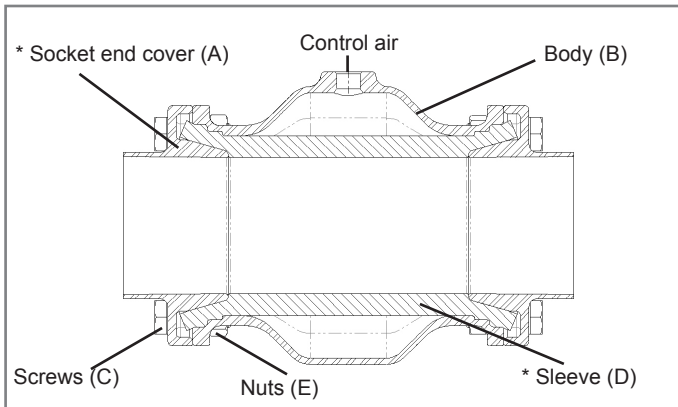


# Assembly Instruction for AKO Pinch Valves

## Series VMC DN 65 to 100 mm, type G, T, R, M



### Removing the old sleeve

Position the valve with screws (C) at the top and hold it tightly from the side. Unscrew the screws (C) and nuts (E) with a ratchet or screw-wrench and fitted tool (Screw head: hex SW 10/12). To avoid tension on the valve, ensure loosening of the screws (C) and nuts (E) from adjacent sides, then turn the valve through 180 degrees and unscrew the other screws in the same way. Afterwards remove both socket end covers (A) from the body (B) unit. Now either push the old sleeve (D) out of the body (B) or use a pipe wrench to pull it out.

This can be made easier by using the AKO-mounting paste (MP200 or MPL200) in-between the sleeve (D) and body (B). Now clean all single valve parts and check them for damage, particularly the socket end covers (A) for wear, and if necessary replace them.

### Installation of the new sleeve

**Picture 1:** Push sleeve (D) into body (A), so that the sleeve in the body protrudes about 5-6mm upward. In case it is too hard, please use some AKO mounting paste (MP200 or MPL200) in-between sleeve (D) and body (B). **Caution:** For pinch valves that are used in food or pharmaceutical industries, please use exclusively AKO mounting paste MPL200.

**Picture 2:** Lubricate both inside ends of the sleeve (D) and the cone surface of the socket end cover (A) with a bit of AKO-mounting paste (MP200 or MPL200).

**Picture 3:** Position the valve with one hand and hold it tightly from the side, then place the socket end cover (A) with the other hand by slightly angling one side into the sleeve (D) and push the socket end cover (A) in. Before screwing the screws (C) lubricate them with suitable grease so that the screw connection does not get damaged.

**Picture 4:** Now adjust the screw holes of the socket end cover (A) so they are aligned with the holes of the body (B), then insert the screws (C) with the other hand into the holes.

**Picture 5:** Keep the socket end cover (A) compressed and tighten the screws (C) and nuts (E) with the ratchet/screw-wrench until the socket end cover (A) is completely flush with the body (B).

**Picture 6:** Then turn the valve through 180 degrees and position it again ready for assembling.

**Picture 7:** Now mount the second socket end cover (A) the same way as described (pictures 3-5). Afterwards check all screws (C) for correct torque.

**Picture 8:** Finished + completed re-sleeve of VMC valve.

### \*Replacement / Maintenance parts:

Socket end cover (A), Screws (C), Sleeve (D), Nuts (E)  
**Assembly tool:** AKO mounting paste MP200 / MPL200



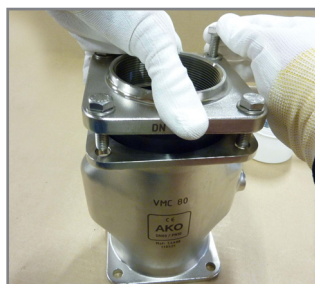
pic. 1



pic. 2



pic. 3



pic. 4



pic. 5



pic. 6



pic. 7



pic. 8

Technical details subject to change without notice