IMI FLOW DESIGN

Automatic Valve

WS Assembly Procedure
Wave Spring Design for Canister Bottom

Step 1

Insert gasket onto canister bottom.

Gasket should be flush with shoulder.

Step 2 Tools Required

Flat screwdriver, spring insert adapter, no-go gauge.

Spring clip, high side up.

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Step 3

Place wave ring on tool with high side. The high side is shown in the picture when ends of spring are pointing up.

Step 4

Insert wave spring into tool.

Step 4

Insert canister assembly into WS body starting with the outer circle.

Ensure that the direction of the valve is as shown in the picture above.

WS Assembly Procedure
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Step 5

Insert tool with wave spring onto canister bottom.

Step 6

Use screwdriver to insert spring clip into groove.

Pushing the tip of the spring into groove first.

WS Assembly Procedure
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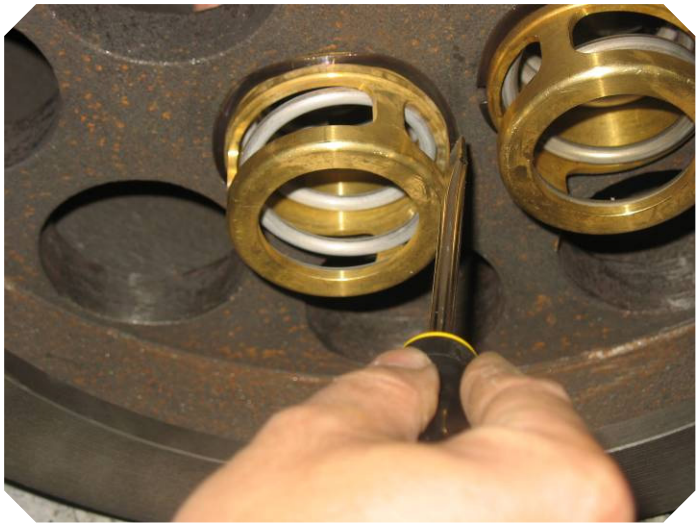
Step 6 *(Cont'd)*

Remove the spring insert adapter out of the body.

Use the flat screwdriver to push the spring into the groove.

Step 7



Make sure the spring is inside of groove.

Wave spring is inserted within groove.

WS Assembly Procedure
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Step 7 *(Cont'd)*

Insert tool with wave spring onto canister

- Checking the gap between spring tips
- Place the no-go gauge perpendicular to the surface of the modulate.
- If the gauge goes into the gap, then re-check the spring fitting in the slot with a screwdriver.
- If the gauge does not go into the gap between wave spring gap, the fitting is OK.

Step 8

Ensure that the wave spring is fitted correctly with the no-go gauge.

Recheck if the gauge goes into the gap as shown in the picture above.

WS Assembly Procedure
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Step 8 *(Cont'd)*

Wave spring is fitting correctly if the gauge doesnt go into gap as shown in picture above.

Wave Spring Removal Procedure

Place screwdiver on the gap and lift the spring out.

Take the spring out using a screwdriver as shown in the picture above.

Remove the canister.