VEKTEK, INC.
1334 E. SIXTH AVE.
P.O. BOX 625
EMPORIA,KS. 66801
U.S.A.

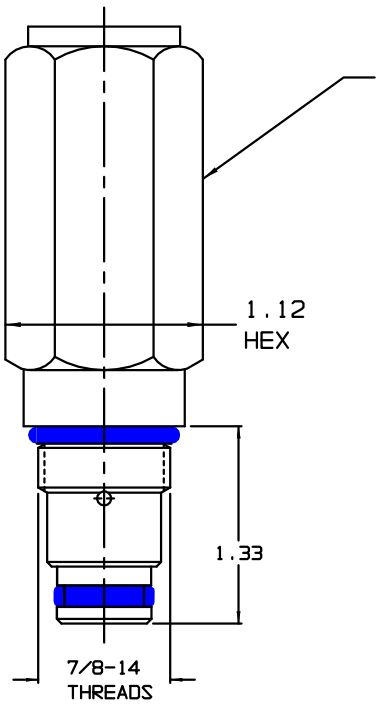
INSTALLATION INSTRUCTIONS

IS7002
REV. C ECN 2567
PAGE 1 OF 1

CAVITY DIMENSIONS FOR P.L.V. AND P.R.V.

DRAWN/DATE JDW 4-20-05

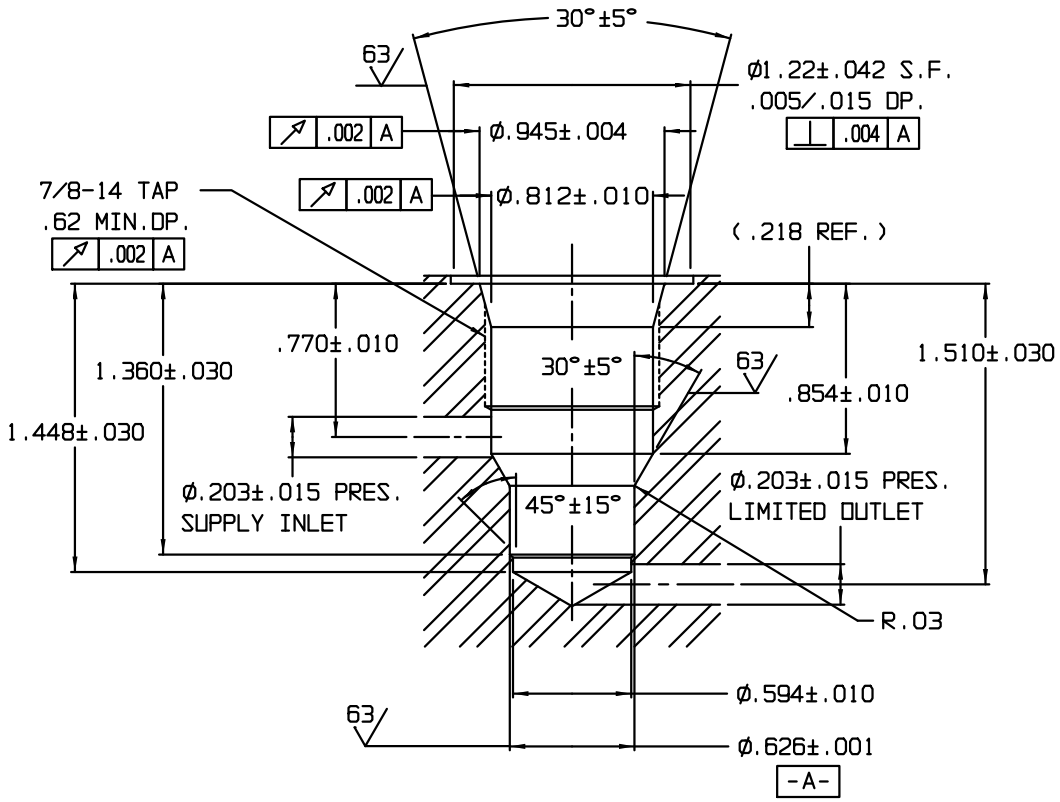
NOTE: THERE IS NO STANDARD PORTING TOOL AVAILABLE FOR THIS CAVITY.



PRESSURE LIMITING VALVE CARTRIDGE
70-5430-06; 70-5430-07; 70-5430-08

RECOMMENDED TOOLING SEQUENCE

1. SPOT DRILL TO Ø.460±.030
2. SPOTFACE Ø1.22±.042 TO .010±.005 DEEP.
   (THE FOLLOWING DEPTHS ARE DIMENSIONED FROM THE Ø1.22 SPOTFACE SURFACE)
3. FORM Ø.812±.010 TO .854±.010 DEEP AND 30°±5°.
4. DRILL Ø.594±.010 TO 1.448±.030 DEEP.
5. BORE OR REAM Ø.626±.001 TO 1.360±.030 DEEP.
6. FORM 30°±5° ANGLE AT Ø.945±.004 (.218 DEEP REFERENCE).
7. THREAD 7/8-14 TO .620 MINIMUM FULL THREAD DEPTH.



PRESSURE LIMITING AND PRESSURE REDUCING VALVE CARTRIDGE
CAVITY DIMENSIONS FOR MACHINING WITHOUT PORT TOOL.