



# Operating Instructions

## Model 7000-033

### PEEK Stator Assembly Kit

#### 1.0 INTRODUCTION

Model 7000-033, PEEK Stator Assembly Kit, contains all the necessary parts to convert stainless steel Models 7010, 7000, 7030, 7040 Switching Valves and Model 7125 Sample Injector into biocompatible PEEK valves with no metal contact in the fluid stream.

#### 2.0 SUPPLIED WITH THE VALVE

- PEEK Stator Assembly:
  - a) Set Screw Ring Assembly
  - b) Stator Face Assembly
  - c) PEEK Stator
  - d) Stator Support Ring
- 8-32, 31.3 mm (1.25") Stator Screws (3)

#### 3.0 SPECIFICATIONS

- Maximum Operating Pressure: 34 MPa (345 bar, 5000 psi)
- Maximum Operating Temperature: 50°C
- Wetted Surfaces: PEEK and ceramic

#### 4.0 IMPORTANT SAFETY NOTICES

**4.1 Warning:** A pinhole rupture in the PEEK tubing can cause a high velocity jet of fluid that can penetrate skin and eye tissue.

**4.2 Caution:** When using the converted PEEK valve, use only RheoFlex® PEEK fittings sets in the stator ports. Metal ferrules can cause irreparable damage to the PEEK stator.

**4.3 Caution:** Temperature, solvents, and time of exposure affect the burst pressure of PEEK tubing. PEEK tubing usually burst at pressures much lower than the rated pressure of the valve.

#### 5.0 INSTALLATION

Refer to Figure 1 and proceed as follows:

- a) Unscrew the stator screws.
- b) Remove the stator and stator ring.
- c) Put the new stator ring on the body of the valve. The two stop pins on the body should enter the mating holes in the new stator ring. Be sure the rotor pin on the shaft assembly is located between the two stop pins.
- d) Put the PEEK stator assembly onto the stator ring. Ensure that the stator face assembly remains in place on the stator while the two pins in the set screw ring mounts into the mating holes in the stator ring.

**Note:** The arrow on the set screw ring and stator support ring should point toward the shaft end. The orange dot on the PEEK stator should be in line with the arrows.

e) Insert the three new stator screws supplied into the stator.

f) Tighten each screw a 1/2 turn past fingertight and visually inspect that the gap between the stator ring and stator is even all around the valve.

#### 6.0 PRESSURE ADJUSTMENT

If there is leakage between the stator and stator ring proceed as follows: The three set screws should be loosened about 1/20 turn each (18° of rotation) and the three stator screws tightened an equal amount. If this new setting fails to accomplish leak-free operation at the desired pressure, repeat the procedure by an additional 1/20 turn. Avoid excessive tightening which will only increase wear of the rotor seal.

If leakage cannot be stopped by tightening the valve, or if, as a result of tightening to stop the leakage, the handle is too hard to turn, the rotor seal needs replacing. See the operating instructions for your valve.

#### 7.0 WARRANTY

All Rheodyne products are warranted against defects in materials and workmanship for a period of one year following the date of shipment by Rheodyne. Rheodyne will repair or replace any Rheodyne product that fails during the warranty period due to a defect in materials or workmanship at no charge to the customer. The product must be returned to Rheodyne's factory in original packaging or equivalent, transportation prepaid. Damage occurring in transit is not covered by the warranty. This limited warranty is Rheodyne's sole warranty of its products, and all other warranties of merchantability or fitness for any particular purpose are hereby disclaimed. Under no circumstances will Rheodyne be liable for any consequential or incidental damages attributable to a claimed failure of a Rheodyne product, even if Rheodyne has been placed on notice of possibility of such damages.

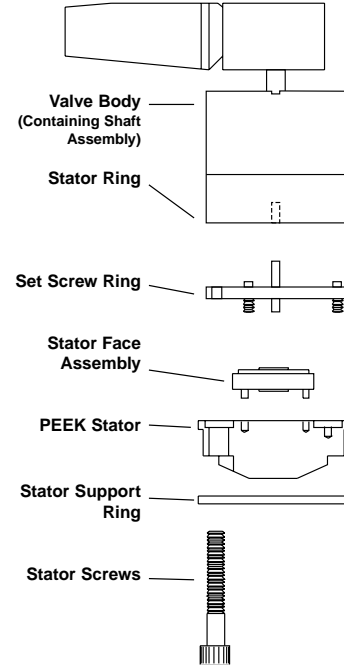


Fig. 1. Exploded view of converted PEEK valve.