

It is solely the responsibility of the system designer and user to select products suitable for their specific application requirements and to ensure proper installation, operation, and maintenance of these products. Materials compatibility, product ratings and application details should be considered in the selection. Improper selection or use of products described herein can cause personal injury or property damage.

For Your Safety

Hoke offers a wide range of 2, 3, 4, and 5-way valves in both ball and trunnion styles. 2-way valves are used for quick, 90°, on-off service. 3-way valves use 180° operation for diverting flow from one line to another. 4-way valves are dual switching valves using 90° operation to change both flow paths at the same time. A 5-way valve is basically an expanded three way valve for diverting flow through any one of four flow paths. A line of three piece ball valves are available as well. All ball valves except 5-way can be air actuated with Hoke's 07 series actuators, the 07L series is for valves requiring more torque output while the 0700 series is for lower output requirements. In addition Hoke offers electric actuators. An electric actuator is available for all ball valves including the 5-ways. For more information see Hoke's Ball Valve and Actuator Valve catalogs.

Hoke Ball Valves and Actuators



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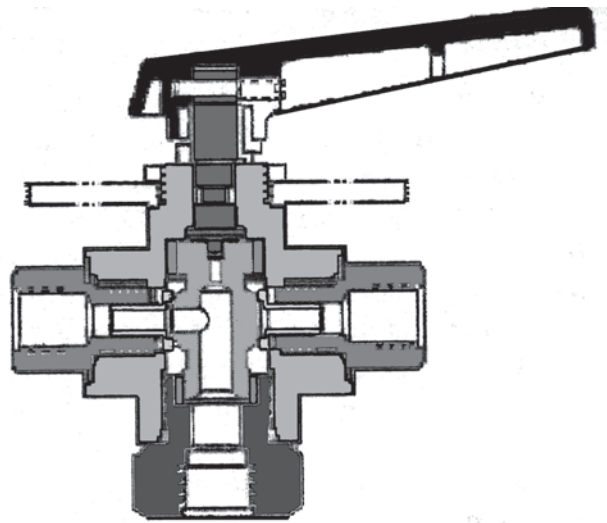
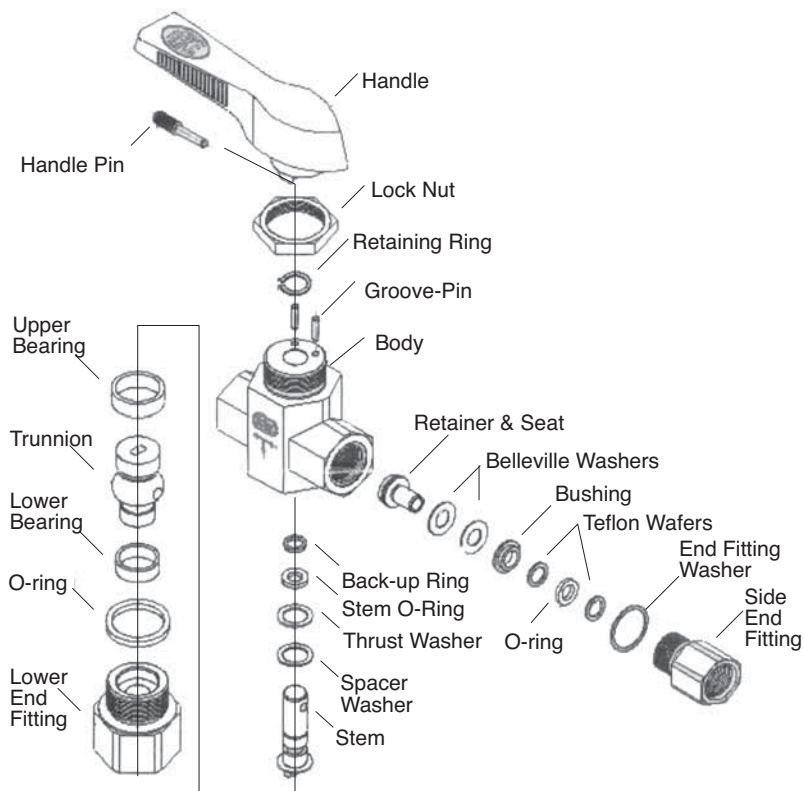
## **PACKING AND SEAT REPLACEMENT KIT SP7644K2**

**For all Standard 7644  
Series Valves**

**Kit Includes: Plastic Stem Thrust Washer (1), 316 Stem Spacer Washer (1), Stem o-ring (1), Split TFE Stem Backup Ring (1), Seat Assemblies (2), Belleville Washer (4), Seat Bushing (2), TFE Seat Wafers (4), Seat o-ring (2), TFE End Fitting Washer (2), Lower End Fitting o-ring (1).**

# 7644 Series Valves: Major Components

## 7644 Valves



### USAGE INSTRUCTIONS:

#### Disassembly

1. Unscrew side end fittings, remove end fitting washers and all related internal parts (including: seat assembly, belleville washers, bushings, teflon wafers, and fitting washer).
2. Unscrew bottom end fitting, remove trunnion and related parts (including: upper trunnion bearing, trunnion, lower trunnion bearing, o-ring, and lower end fitting).
3. Unscrew pin and remove handle.
4. Remove stem retaining ring (save), push stem assembly down through body, removing spacer and thrust washers, (including: back-up ring, stem o-ring, thrust washer, spacer washer, and stem).
5. Inspect stem, trunnion and trunnion bearings. If surfaces are badly worn, replace with applicable parts.

### USAGE INSTRUCTIONS:

#### Cleaning/Lubrication

1. If necessary, clean all metallic sealing surfaces with Acetone or Trichloroethylene.
2. Lubricate stem, stem washers, seat assembly parts, end fitting washers, entire trunnion, trunnion bearings, all o-rings and all threads with Krytox 206 grease.

### ASSEMBLY

#### Stem Assembly

1. Install spacer washer, thrust washer, o-ring and back-up ring on stem as indicated.
2. Insert stem assembly into valve and secure with retaining ring.

#### Trunnion Assembly

1. Making sure upper trunnion bearing is in place insert trunnion into valve and orient it so that tang on stem engages with groove in trunnion.
2. Assemble o-ring on bottom end fitting/trunnion assembly. Then screw into body with 50-60 ft. lbs.

#### Seat & End Fitting Assembly

1. Slide two Belleville washers, bushing, Teflon® wafer, o-ring, and Teflon wafer onto seat assembly.
2. Insert this seat sub-assembly into side end fitting.
3. Check trunnion port to be certain that it is in line with fitting axis.
4. Place end fitting washer into the counterbore of side port.
5. Screw seat and end fitting sub-assembly into port of valve body (hand tight).
6. Repeat steps 1 through 5 on opposite port.
7. After both fittings are installed, alternately torque to 50-60 ft. lbs.

#### Handle Assembly

1. Orient handle to indicate correct flow port. Secure with pin.

Note: Valve should be tested at maximum operating pressure prior to installation.