

Key No.	Part Description
1	Body
2	Handle
3	End Fitting Washer
4	Stem
5	Stem Retainer
6	Packing
7	Seat Assembly
8	Ball
9	End Fitting

7670 Series Valves (except 7644)

7670 Series Valves

7671F4B 7673G2Y
7671G4B 7673G4Y
7673F4Y 7673G6Y



Kit #SP7670K2 7670 Series Valves

Seat Replacement

All Models except 7644

Kit includes: end fitting washers (2), seat wafers (4), seat O-rings (2), seat assemblies (2), bushings (2), Belleville washers (4).

For Complete Listing of Model Numbers See Back Panel

DISASSEMBLY

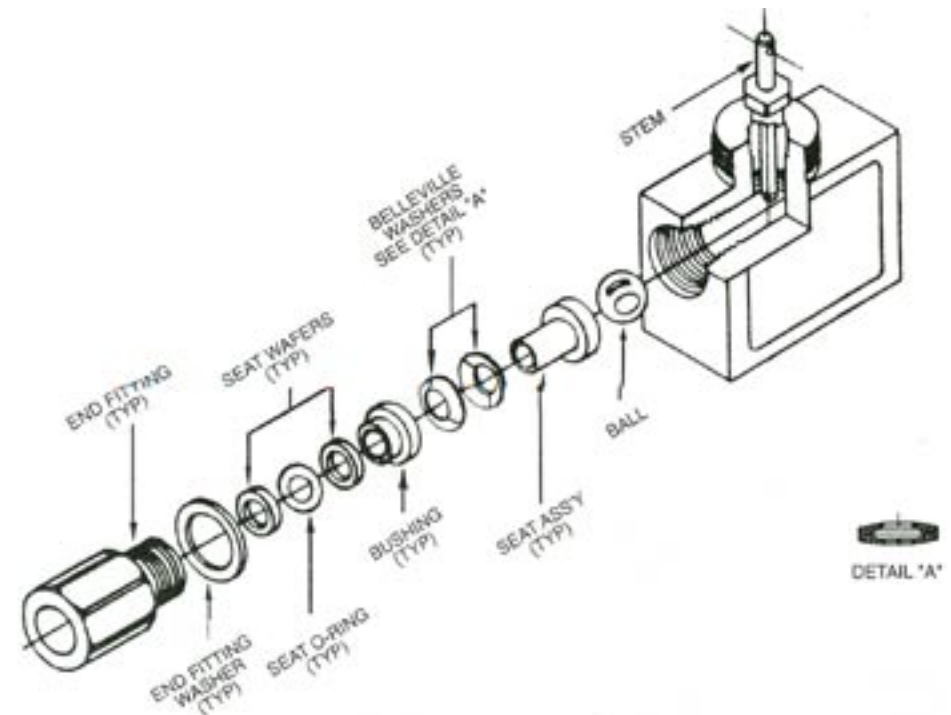
1. Unscrew end fittings, remove seat assemblies and all washers.
2. Turn handle 90° to body, drop ball out of valve.
3. Inspect ball. If groove is damaged or surface is worn, replace. NOTE: If ball groove is worn, check stem tang through valve body. If damaged, replace. (Use applicable Packing Kit).

Cleaning & Lubrication

1. Clean body and end fitting sealing surface, as well as interior of body with acetone or trichloroethane
2. Lubricate seat O-rings with Fluorolube GR-290 grease.
3. Lubricate ball and end fitting with Krytox® 206 or equivalent.

ASSEMBLY

1. Assemble onto both seat assemblies the following: Belleville washers, bushing, Teflon® wafer, O-ring and Teflon® wafer. See exploded view.
 2. Place an end fitting washer into body flat and insert one complete seat assembly into that port. Screw in end fitting hand tight.
 3. With stem tang still parallel to valve ports, drop ball into body so that stem tang engages with ball slot. Ball port should face same direction as handle.
 4. With handle still perpendicular to body, repeat step 2 on opposite port. NOTE: Washers, seats and ball must remain flush during installation.
 5. Tighten end fittings– **Important:** Valve must remain in the fully closed position during tightening to prevent seat damage.
- CAUTION: Valve should remain in the fully closed position for 12 hours to form seats.**



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

For catalog information, contact your local Hoke stocking distributor or call Hoke, Inc. at (864) 574-7966.



Hoke, Inc.
405 Centura Court
Spartanburg, SC 29303

DISASSEMBLY

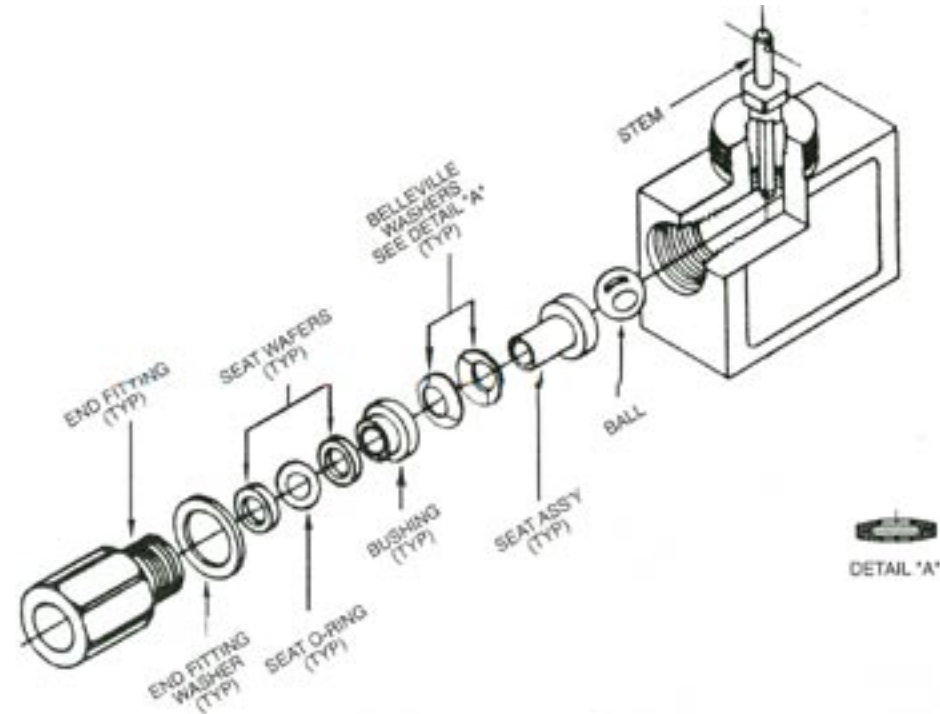
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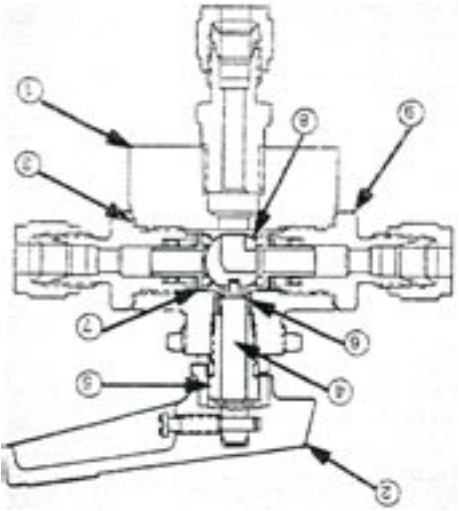
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