

Key No.	Part Description
1	Body
2	Handle
3	Cup
4	Pin
5	Stem
6	Stem Bushing
7	Stem Pin
8	Detent
9	Packing
10	Trunnion
11	Trunnion Bearing
12	Seat Assembly
13	End Fitting
14	Lower End Fitting
15	End Fitting Washer

## 7911 & 7931 Series Valves

7911F4Y 7931F4Y  
7911G4Y 7931G4Y



# Kit #SP7900K5 7911 & 7931 Series Valves

## Packing and Seat Replacement

Kit includes: spring washers (8), washer (4), wave washer (1), stem O-ring (1), seat O-ring (4), lower O-ring (1), seat washers (8), seat assemblies (4), thrust washer (1), end fitting washers (4), friction washer (1), spacer washer (1), back up ring (1), bushings (4).

For Complete Listing of Model Numbers See Back Panel

## DISASSEMBLY

1. Unscrew end fittings and remove all internal parts from each port, including end fitting washer.
2. Unscrew bottom end fitting and remove trunnion and O-ring.
3. Unscrew pin and remove handle.
4. Remove pan head screws and lift flow direction plate and cup from stem bushing.
5. Unscrew stem bushing pin and push stem assembly down through body making sure spacer and thrust washer are removed.
6. Align notch in stem bushing with detent ball and pull stem bushing off body.
7. Remove wave washer and friction washers.
8. Inspect trunnion, trunnion bearings and stem surfaces for wear. If necessary, replace with respective parts.

## Cleaning & Lubrication

1. If necessary, clean all metallic sealing surfaces with Acetone or Trichloroethylene.
  2. Lubricate all threads, wave washer, end fitting washers, friction washer, stem subassembly (washer and O-ring areas only) and stem bushing pin with Krytox® oil.
  3. Lubricate seat assemblies, all O-rings, cam surface of stem bushing, ball section and ends of trunnion, and detent ball with Krytox® 206.
- Use above lubricants or equivalent Fluorocarbon grease or oil.

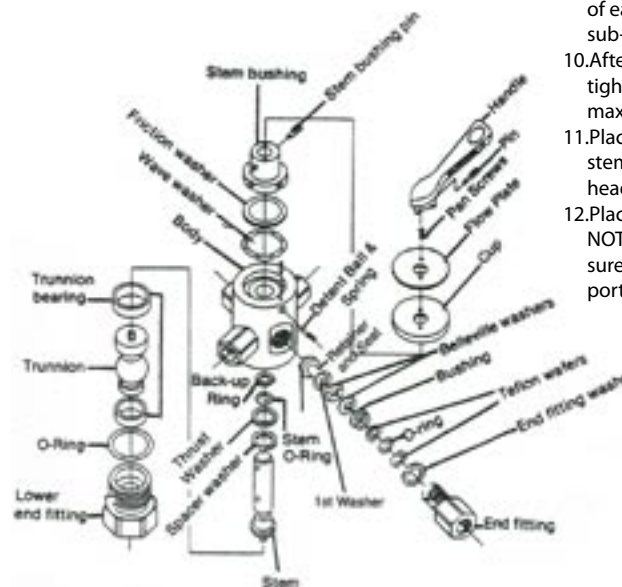
## ASSEMBLY

1. Install following parts onto stem in order shown.
  - 1st- Spacer Washer
  - 2nd - Thrust Washer
  - 3rd-O-ring
  - 4th-Back-Up Ring
2. Insert stem sub-assembly up through valve body and install the following parts over stem as shown.
  - 1st-Wave Washer
  - 2nd - Friction Washer
  - 3rd-Stem Bushing

(align detent ball with notch)
3. Align stem and stem bushing holes, insert stem bushing pin and tighten.

## SEAT SUB-ASSEMBLY

4. Place following parts on seat assemblies as shown.
    - 1st - Washer
    - 2nd - 2 Spring Belleville Washers
    - 3rd - Bushing
    - 4th - TFE Wafer
    - 5th - O-ring
    - 6th - TFE Wafer
  - 5- Insert each seat sub-assembly into an end fitting.
  6. Place trunnion into valve bearing so that stem tang engages with trunnion slot.
  7. Make sure that the trunnion is properly seated, place O-ring on lower end fitting and screw into body with 50-60 ft. lbs. torque.
  8. Check trunnion port orientation to be certain that it is in line with fitting axis.
  9. Place end fitting washers onto counterbore of each port. Then screw seat end fitting sub-assemblies into each body port.
  10. After all end fittings are installed, finger tight, alternately torque each fitting to a maximum of 50-60 ft. lbs.
  11. Place cup and flow direction plate over stem bushing and secure with two pan head screws.
  12. Place handle on stem and secure with pin.
- NOTE: When assembling 5-way valves, be sure that point of handle is facing outlet port of trunnion.



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

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



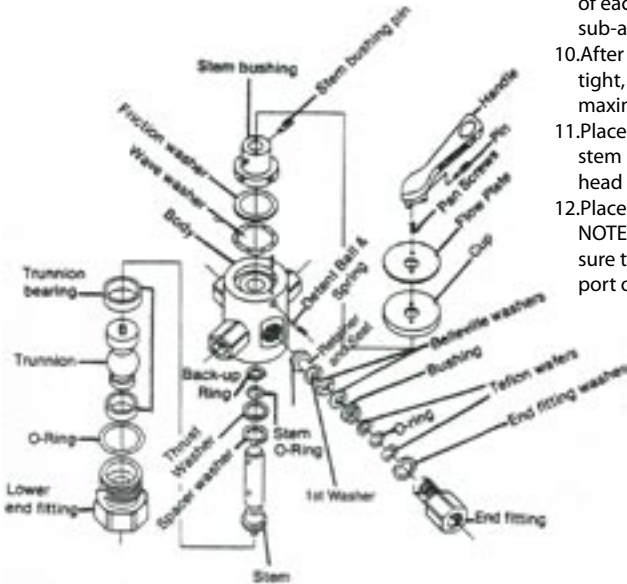
Hoke, Inc.  
405 Centura Court  
Spartanburg, SC 29303

DISASSEMBLY

- 1. Unscrew end fittings and remove all internal parts from each port, including end fitting washer.
- 2. Unscrew bottom end fitting and remove trunnion and O-ring.
- 3. Unscrew pin and remove handle.
- 4. Remove pan head screws and lift flow direction plate and cup from stem bushing.
- 5. Unscrew stem bushing pin and push stem assembly down through body making sure spacer and thrust washer are removed.
- 6. Align notch in stem bushing with detent ball and pull stem bushing off body.
- 7. Remove wave washer and friction washers.
- 8. Inspect trunnion, trunnion bearings and stem surfaces for wear. If necessary, replace with respective parts.

Cleaning & Lubrication

- 1. If necessary, clean all metallic sealing surfaces with Acetone or Trichloroethylene.
  - 2. Lubricate all threads, wave washer, end fitting washers, friction washer, stem subassembly (washer and O-ring areas only) and stem bushing pin with Krytox® oil.
  - 3. Lubricate seat assemblies, all O-rings, cam surface of stem bushing, ball section and ends of trunnion, and detent ball with Krytox® 206.
- Use above lubricants or equivalent Fluorocarbon grease or oil.



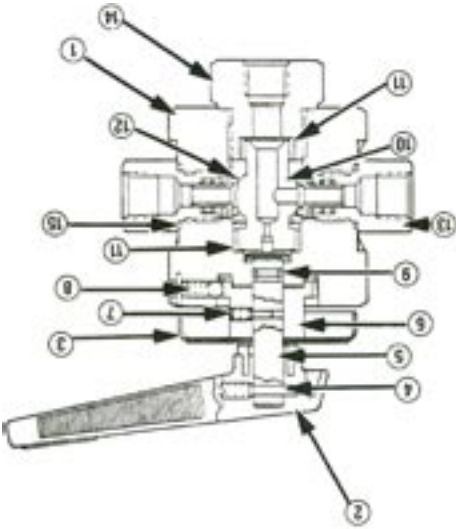
ASSEMBLY

- 1. Install following parts onto stem in order shown.
  - 1st- Spacer Washer
  - 2nd - Thrust Washer
  - 3rd-O-ring
  - 4th-Back-Up Ring
- 2. Insert stem sub-assembly up through valve body and install the following parts over stem as shown.
  - 1st-Wave Washer
  - 2nd - Friction Washer
  - 3rd-Stem Bushing (align detent ball with notch)
- 3. Align stem and stem bushing holes, insert stem bushing pin and tighten.

SEAT SUB-ASSEMBLY

- 4. Place following parts on seat assemblies as shown.
    - 1st - Washer
    - 2nd - 2 Spring Belleville Washers
    - 3rd - Bushing
    - 4th - TFE Wafer
    - 5th - O-ring
    - 6th - TFE Wafer
  - 5- Insert each seat sub-assembly into an end fitting.
  - 6. Place trunnion into valve bearing so that stem tang engages with trunnion slot.
  - 7. Make sure that the trunnion is properly seated, place O-ring on lower end fitting and screw into body with 50-60 ft. lbs. torque.
  - 8. Check trunnion port orientation to be certain that it is in line with fitting axis.
  - 9. Place end fitting washers onto counterbore of each port. Then screw seat end fitting sub-assemblies into each body port.
  - 10.After all end fittings are installed, finger tight, alternately torque each fitting to a maximum of 50-60 ft. lbs.
  - 11.Place cup and flow direction plate over stem bushing and secure with two pan head screws.
  - 12.Place handle on stem and secure with pin.
- NOTE: When assembling 5-way valves, be sure that point of handle is facing outlet port of trunnion.

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



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1	Body
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Kit #SP7900K5  
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Series  
Valves

Packing and Seat  
Replacement

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