

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

7921 & 7941 Series Valves

7921F4Y 7941F4Y
7921G4Y 7941G4Y



Kit #SP7900K6 7921 & 7941 Series Valves

Packing and Seat Replacement

Kit includes: Belleville washers (8), wave washer (1), stem O-ring (1), seat O-ring (4), lower O-ring (1), backup ring (1), TFE wafers (8), thrust washer (1), end fitting washers (4), seat assemblies (4), friction washer (1), spacer washer (1), bushings (4).

For Complete Listing of Model Numbers See Back Panel

DISASSEMBLY

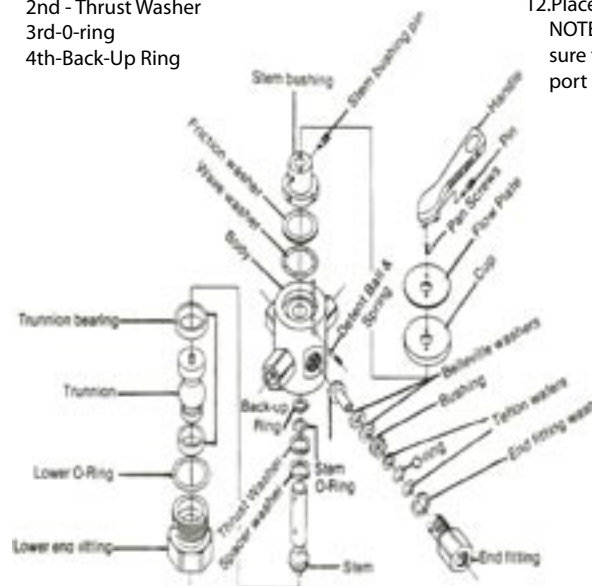
1. Unscrew end fittings and remove all internal parts from each port, including end fitting washer.
2. Unscrew bottom end fitting and remove trunnion and O-ring.
3. Unscrew pin and remove handle.
4. Remove pan head screws and lift flow direction plate and cup from stem bushing.
5. Unscrew stem bushing 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.

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 a 4:1 mixture of Freon/Fluorolube T-80 oil.
3. Lubricate seat assemblies, all O-rings, cam surface of stem bushing, entire trunnion, and detent ball with Fluorolube GR-290 grease. 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 - 2 Belleville Washers
2nd - Bushing
3rd - TFE Wafer
4th - O-ring
5th - 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.

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 a 4:1 mixture of Freon/Fluorolube T-80 oil.
 - 3. Lubricate seat assemblies, all O-rings, cam surface of stem bushing, entire trunnion, and detent ball with Fluorolube GR-290 grease.
- Use above lubricants or equivalent Fluorocarbon grease or oil.

ASSEMBLY

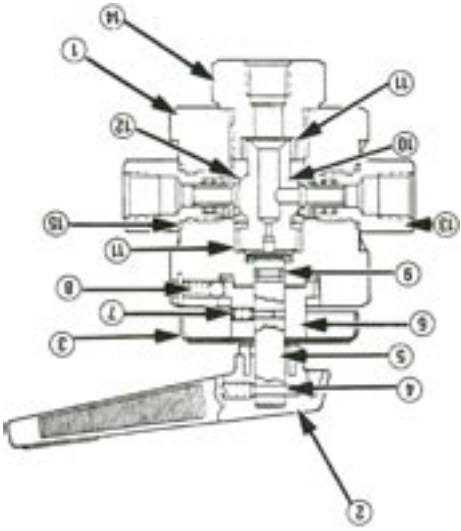
- 1. Install following parts onto stem in order shown.
 - 1st - Spacer Washer
 - 2nd - Thrust Washer
 - 3rd-O-ring
 - 4th-Back-Up Ring

- 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 - 2 Belleville Washers
 - 2nd - Bushing
 - 3rd - TFE Wafer
 - 4th - O-ring
 - 5th - 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.



End Fitting Washer	15
Lower End Fitting	14
End Fitting	13
Seat Assembly	12
Trunnion Bearing	11
Trunnion	10
Packing	9
Detent	8
Stem Pin	7
Stem Bushing	6
Stem	5
Pin	4
Cup	3
Handle	2
Body	1
Key No.	Part Description
7921 & 7941 Series Valves	



Kit #SP7900K6
7921 & 7941
Series
Valves

Packing and Seat
Replacement

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Kit includes: Belleville washers (8), wave washer (1), stem O-ring (1), seat O-ring (4), lower O-ring (1), backup ring (1), TFE wafers (8), thrust washer (1), end fitting washers (4), seat assemblies (4), friction washer (1), spacer washer (1), bushings (4).

