

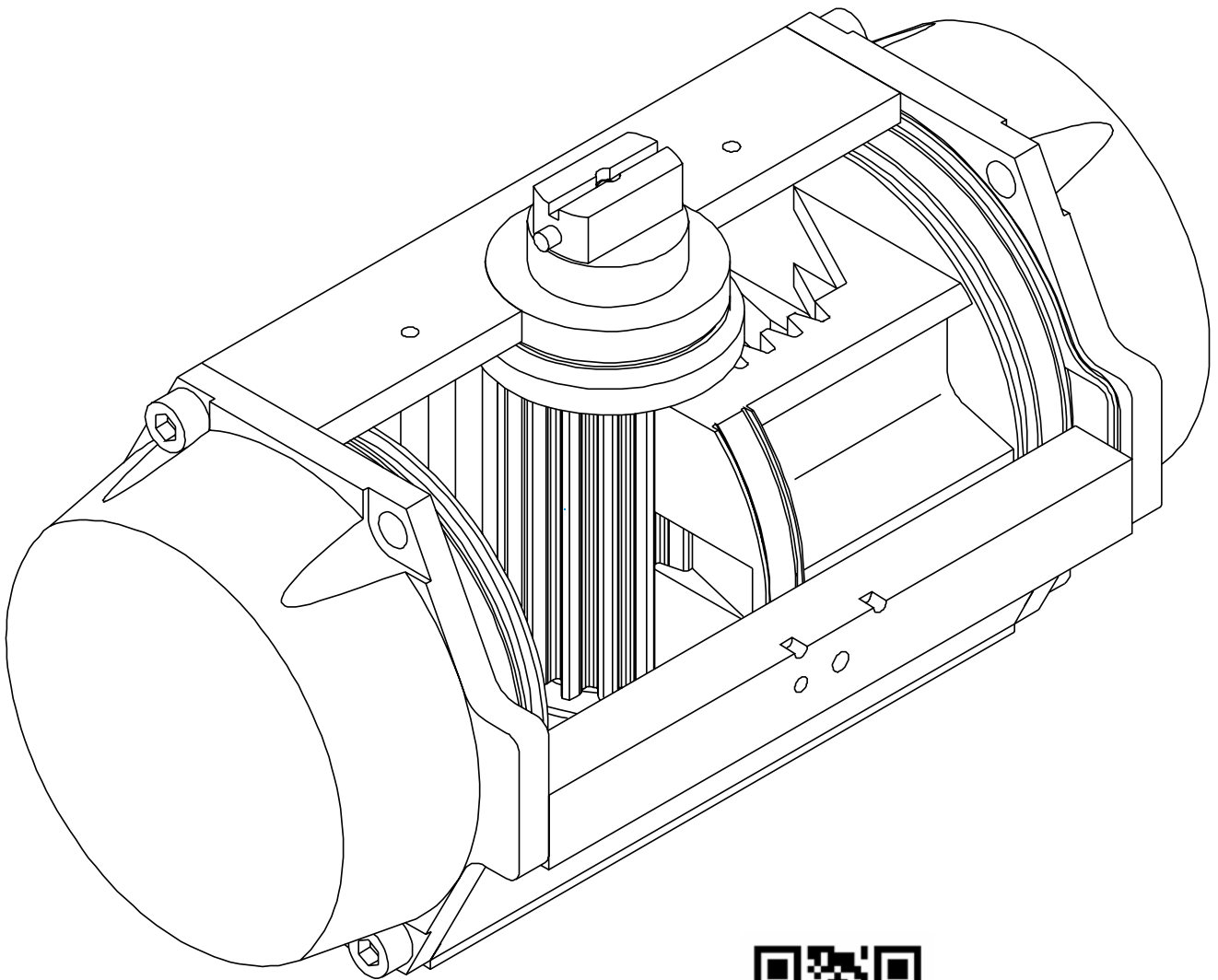


# Revo

## Pneumatic Part Turn Valve Actuator, Series R Double-Acting or with Spring Reset

Operating and Installation Instructions

Installation, Operation and Maintenance



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**This is the translation of the Original REVO Declaration of incorporation, Operating and Installation instructions**

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## 1. Area of Application

These instructions are applicable to

Revo pneumatic part turn actuator double-acting, series R

Revo pneumatic part turn actuator with spring reset, series R

XOMOX pneumatic semi rotary actuators series XRP, single and double acting

### Note 1:

When assembling the actuator to a valve, the instructions for the valve must be followed.

### Note 2:

For information that is already required during the planning phase, reference is made to Publications, which can be viewed on the Crane ChemPharma Homepage [www.cranecpe.com](http://www.cranecpe.com) or which are available from the manufacturer, in order to keep the arrangement of this instruction manual as clear as possible.

### Note 3:

“This range of Pneumatic Actuators is also suitable for use with other operating media and therefore hereafter will be referred to as The Actuator”.

## 2. Intended use

These Revo actuators are intended

- for installation to a valve, attachment of a solenoid valve and connection of this solenoid valve to a control provided by the customer,
- to be operated with the control medium compressed air, inert gas, water or hydraulic oil, at max. 8 bar, except sizes 001, 002, 006 up to max. 7 bar. Before applying compressed air to the spring chamber of spring loaded ac-tuators through port “B”, you should consult the manufacturer.

- that in normal operation a control pressure in compliance with the type plate is permanently applied to the pneumatic actuator and that this pressure is not exceeded,
- to actuate valves with 90° travel (e.g. butterfly valves and ball valves) by executing the commands of the above mentioned control (for special applications actuators are available with travel of 120°- or 180°).
- An actuator properly mounted on the valve shows the position of the valve by means of an optical indicator.
- An (optional) “position indicator” module mounted to the actuator is used to signalise the position of the valve to the control provided by the customer.

#### **Double/acting actuators**

stop at the current position in case of a control pressure failure. With control pressure applied, but after a shut-down or failure of the control voltage on the solenoid valve, it solely depends on the control of this solenoid valve to which position the actuator will travel.

Unless otherwise specified by the customer, the actuator should close.

**Spring resetting actuators with closing spring:** travel to safe position “CLOSED” in case of a control pressure failure / shut-down.

**Spring resetting actuators with opening spring:** travel to safe position “OPEN” in case of a control pressure failure / shut-down.

Design and control of the solenoid valve must ensure the above mentioned functions of a spring reset actuator.

#### **Notes on equipment for manual emergency actuation in case of control pressure failure:**

##### **Actuators**

can only be operated with the help of an (optionally available) auxiliary drive.

The actuator is not intended to be used for purposes other than the ones specified hereunder. We would particularly like to point out that the actuator has not been approved for:

- a manual emergency actuation using the extension of the control shaft while control pressure is applied.

- emergency operation of spring reset actuators using open-end spanner or similar tools.
- operation of electrical modules with inadequate protection class (acc. to EN 60529), especially the installation and operation of actuators with electric accessories (solenoid valves, position indicators and/or position controllers) without approved explosion protection in compliance with EN 50014, EN50018, EN50019 or EN 50020 in potentially explosive environments, .
- use of control media other than those specified in these instructions without the consent of the manufacturer.
- for operation with control medium compressed air, inert gas, water or hydraulic oil of maximum 8 bar, sizes 001, 002, 006 at max. 7 bar.
- to use the actuator in chemically aggressive environments without the consent of the manufacturer.
- to operate the actuator at ambient temperatures above 80°C or below minus 20°C without the consent of the manufacturer.
- Revo semi-rotary actuators are suitable for use in safety relevant applications (SIL Level, s. declaration of conformity). If attachments (such as valves, solenoid valves, positioners....) are installed, the complete unit must be examined with respect to the SIL Level for the entire unit.
- Sound pressure measurement acc. to DIN EN ISO 3744, at a distance of 1m, mean sound pressure level:
 

with silencer:	68 dB(A)
without silencer:	107 dB(A)
- The manufacturer will not assume warranty or liability when acting against the rules of intended use.
- All maintenance and repairwork should be done outside explosive area and atmosphere.

### 3. Declaration of Manufacturer

#### 3.1 Declaration of Incorporation for partly completed machines in the sense of the Machinery Directive 2006/42/EC, Anhang II, Nr 1 B

We hereby declare, that the pneumatic semi-rotary actuators manufactured in series production

Designation: Revo pneumatic semi-rotary actuator, series R, structurally identical with with Xomox pneumatic semi-rotary actuator series XRP

Series: RD double-acting and RS with spring accumulator, structurally identical with Xomox XRP

Manufacturer: Crane Process Flow Technologies GmbH  
Heerdter Lohweg 63-71  
D-40549 Düsseldorf

1. the following basic requirements as specified in appendix I of the above directive have been applied and complied with:

- General principles no. 1
- No. 1.1, 1.3, 1.5, 1.7, 2.1, 3.4, 3.6, 4.1 and 4.2
- 2. operation must only take place under due consideration of the operating and installation instructions
- 3. the units belong to the category of pressure equipment following the EC pressure equipment directive 2014/68/EU, acc. to chapter 1, article 1, section 2, abstract (j), issue (ii).

This incomplete machine must only be taken into service after it has been assured that the machine, into which this incomplete machine is to be incorporated, fully complies with the regulations of the machinery directive 2006/42/EC, whenever applicable.

The special technical documents were created in compliance with appendix VII, part B of the directive.

Applied technical specifications:

EC directives: 2006/42/EC

Harmonized standards: EN ISO 12100, EN ISO 5211,  
VDI / VDE 3844 / 3845

Mr. Ralf Rennwanz is authorized to compile the technical documents.

Address: Crane Process Flow Technologies GmbH  
Heerdter Lohweg 63-71  
D-40549 Düsseldorf

Place, date Düsseldorf, 31. December 2016

Signature of manufacturer:



Information on signatory: H.-D. Ptak, Managing Director

**This document is a translation of the original.**

#### 3.2 EU Declaration of Conformity acc. to the Directive 2014/34/EU (ATEX)

In compliance with EC-Directive 2014/34/EU from 26 February 2014 and with the legal requirements enacted for the purpose of their implementation, **the manufacturer:**

Crane Process Flow Technologies GmbH  
Heerdter Lohweg 63-71  
D-40549 Düsseldorf

declares that the explosion protected product described in the operating instructions and safety regulations:

**Type:** REVO pneumatic valve actuator of series:  
Series 5, 6, 7 and 8  
XOMOX XRP

##### Actuator sizes:

001-006, 012-180 (with and without overtravel and end position setting), 205, 380, 630, 960, H 15 double-acting with spring resetting, service unit, exhaust silencer, bridges, coupling, quick ventilation valve, piping and hoses

is a unit in compliance with article 1, (3) a) of the directive 2014/34/EU, and that the general requirements concerning health and safety, as specified in appendix II of directive 2014/34/EU, and the following harmonized directives are complied with:

**DIN EN ISO 80079 - 36:2016 -12**

  II 2GD Ex h IIB T6...T4 GbDb

Düsseldorf, Düsseldorf, August 23, 2019:



H.-D. Ptak, Managing Director

### 3.3 Note concerning pressure equipment guideline 2014/68/EU (PED)

These actuators are dimensioned as positioning device in accordance with Chapter 1, Article 1, Section 2, Abstract (j), Issue (ii) of the pressure equipment guideline and are therefore not pressure equipment within the meaning of the EC pressure equipment guideline 2014/68/EU.

### 3.4 Declaration of Manufacturer for Electric Accessories

are – if applicable – enclosed with the delivered accessories.

### 3.5 Torques According to DIN 3337 / EN 5211

size	valve connection	max. allow. torque acc. DIN	double acting		spring return		remarks
			max. allow. air supply pressure acc. DIN	torque at max. air supply pressure	max* number of springs	spring torque at max. number of springs	
001	F03	32 Nm	7 bar	7,7 Nm	- / -	- / -	max. 4 springs
002	F03	32 Nm	7 bar	19 Nm	12 (4)	11,7 Nm	
006	F03	32 Nm	5 bar	31 Nm	12 (4)	27,2 Nm	
006	F04	63 Nm	7 bar	43 Nm	12 (4)	27,2 Nm	
006	F05	125 Nm	7 bar	43 Nm	12 (4)	27,2 Nm	
012	F05	125 Nm	8 bar	99 Nm	14	57,1 Nm	
025	F05	125 Nm	5 bar	120 Nm	14	112 Nm	
050	F07	250 Nm	5,5 bar	244 Nm	14	207 Nm	
090	F07	250 Nm	3 bar	253 Nm	8	224 Nm	
090	F10	500 Nm	6 bar	506 Nm	14	392 Nm	
130	F10	500 Nm	4 bar	513 Nm	12	506 Nm	
130	F12	1000 Nm	7,5 bar	962 Nm	14	590 Nm	
180	F12	1000 Nm	6 bar	1012 Nm	14	776 Nm	
205	F14	2000 Nm	8 bar	2022 Nm	14	1180 Nm	
380	F14	2000 Nm	5 bar	1847 Nm	14	1769 Nm	
380	F16	4000 Nm	8 bar	3035 Nm	14	1769 Nm	
630	F16	4000 Nm	6 bar	3792 Nm	14	2949 Nm	
960	F16	4000 Nm	4 bar	3839 Nm	18	3792 Nm	
960	F25	8000 Nm	8 bar	7677 Nm	18	3792 Nm	
H15	F25	8000 Nm	5,5 bar	8079 Nm	14	6852 Nm	
H15	F30	16000 Nm	8 bar	11752 Nm	14	6852 Nm	

\*under the assumption that spring torque is + / - equal air torque

## 4. Notes on Safety

### 4.1 Important Information for the User

The actuators described hereunder have been designed and manufactured in compliance with standards and regulations stipulated above. They therefore comply with the latest technical standards and meet the requirements of these standards.

However, safety during operation in practice can only be achieved if all necessary measures are applied. It is the responsibility of design engineer and operator of pipeline systems equipped with valve and actuator to plan appropriate measures and to monitor their implementation and execution.

In particular the operator must ensure that

- the actuator is only used as described in section 2 <Intended Use>,
- the control medium is compatible with the material of the actuator (anodised aluminium),
- the actuator is only operated in fault-free, fully functional condition and the function of the safety installations in control pressure generation and distribution system and in the electric control provided by the customer are checked at regular intervals,
- all guards and safety installations for electrically and mechanically moved parts of the actuator and its accessory modules are maintained in as-delivered condition and the safety covers of junction boxes are properly closed again after electrical connection,
- only appropriately qualified and authorized personnel plans and connects the actuator, operates the control system and is regularly instructed about all relevant issues concerning local regulations for health and safety at work – also for electrical equipment,
- this personnel has the necessary equipment available to carry out the work steps described hereunder,
- For Single Acting Actuators, Port "B" has to be protected adequately to secure quality of entering medium.

- this personnel is familiar with these operating instructions and the instructions for the associated valve and observes the information contained therein,
- repairs and conversions on spring reset actuators are only carried out under the supervision of a safety expert.

If the information contained in these instructions is not observed, the liability of Crane Process Flow Technologies for the above mentioned products shall become null and void.

### 4.2 General Safety Regulations

Basically the same safety regulations apply for actuators as well as the equipment for the generation and distribution of control pressure and for the electrical control system they are connected to. Compliance with these regulations is also assumed for operation of the actuator.

The following must be additionally observed, especially for these pneumatic/hydraulic actuators:

- actuators are designed for control pressures of max. 8 bar, sizes 001, 002, 006 max. 7 bar, whereby compressed air, neutral gas, water or hydraulic oil at room temperature may be used. In order to protect the solenoid valves, the control medium should be filtered with a mesh size of 40 µm (see ISO 8573-1, class 5). Compressed air must be dried and may be slightly oiled for special applications.
- Before applying compressed air to the spring chamber of spring loaded actuators through port 'B', you should consult the manufacturer.
- Manual emergency actuation of actuators must only be performed using an additionally mounted manual emergency device (e.g. uncoupling worm gears). Do not actuate while control pressure is applied.
- work on electric connections must only be carried out by appropriately trained specialists with responsibility for the control of the entire plant.
- if these actuators are not delivered by the manufacturer together with the valve, but are to be installed by the customer, the information in section 9.1 <Installation of an Actuator...> must be strictly observed.

- The actuator does not heat up by itself during operation.

#### 4.3 Particular Types of Danger



**Under normal conditions the actuator must only be operated with the safety installations in place. If these need to be removed for adjustment or connecting work, all connections to the control medium must be disconnected beforehand.**



**Electrical assemblies shall only be operated with safety covers closed and connections covered. If these need to be removed for adjustment/connecting work, connections for supply and control voltage must be disconnected beforehand. Adjustments to be made in live condition must be performed with properly insulated tools.**

## 5. Transport and Storage

An actuator or an assembly is a high-quality product and as such must be handled, transported and stored with utmost care, in order to avoid damage to actuator and additional assemblies.



**If lifting tackle (ropes or similar) is used on the lifting eyelets (bores) of the actuator provided for this purpose, these must only be used to mount the actuator to the valve, but under no circumstances to transport the unit (valve + actuator).**

- If the actuator or the unit valve/actuator is to be stored prior to installation, it must be sufficiently protected against harmful influences from dust, dirt and moisture.
- The actuator or the valve/actuator unit shall be stored in its original packaging material (on a pallet or similar).
- The unit valve/actuator shall not be permanently exposed to full sunlight – even if properly packed.
- The actuator or the unit valve/actuator must not be actuated.

If the packaging does not show any transport damage the actuators or the unit valve/actuator should only be unpacked just before installation. Unpacked parts must be properly protected against any dirt, moisture and corrosion.

## 6. Installation and Connection to the Control System

For the most part actuators are delivered ready for installation together with the necessary electrical assemblies (solenoid valve, position indicator and/or position control). Should this not be the case, the actuators must be mounted to the valve and/or electrical assemblies to the actuator by the customer, before the valve is installed in the pipeline. The instructions in section 9.1 <Installation of an Actuator...> must be strictly followed.



When installing a solenoid valve the following section 6.2 must be observed.



**When starting installation work one must make sure that the system data for control pressure, control voltage and frequency for all assemblies are in compliance with the technical data specified on the type plate of the actuator and/or the module.**

Consumption of control medium and recommended supply line cross-sections are listed in table 1. The shortest possible closing speed mentioned in this table is a reference value for standard double-acting actuators without mounted valve and with optimal supply and discharge of control medium. Friction inside the valve will considerably extend this limit value.

As far as the following description refers to pneumatic control systems, the instructions analogically also apply for hydraulic systems with a pressure of up to 8 bar, sizes 001, 002, 006 up to 7 bar (e.g. water).

### 6.1 Installation of a Valve with Pneumatic Actuator into the Pipeline



**When connecting electric/pneumatic supplies to the accessory modules**

**for controlling the valves, the special instructions for these electrical accessory modules must be strictly observed.**

The actuator is normally delivered together with the valve and is in this case adjusted to the end positions of the valve. Position indicated included in the delivery are normally also adjusted to the end positions, a solenoid valve in the scope of delivery is normally mounted to the actuator.

If the electrical modules solenoid valve and/or position indicator and/or position controller are delivered as separate items, this (these) module(s) must first be mounted to the actuator, before the complete unit is installed into the pipeline, see section 6.2.

The interfaces for the installation of the modules solenoid valve and/or position indicator and/or position controller are standardised acc. to VDI / VDE 3845.



**On an actuator of standard design the supply of control medium through port "A" causes an anti-clockwise and the supply through port "B" a clockwise actuation. Spring reset actuators must only be supplied with control medium through port "A". See Fig. 1.**

If, for example, the actuator is separately delivered as a spare part, the instructions in sections 9.1, 9.3 and

**Table 1: Important actuator data**

Size	001	002	006	012	025	050	090
Volume/travel [L]	0,06	0,12	0,28	0,53	1,02	1,9	3,6
Compressed air line <sup>**</sup> (length up to 6m)	6 mm	6 mm	6 mm	6 mm	6 mm	8 mm	8 mm
Min. closing time [s] <sup>*</sup>	approx. 0,25	approx. 0,35	approx. 0,4	approx. 0,5	approx. 0,7	approx. 0,9	approx. 1,1

Size	130	180	205	380	630	960	H15
Volume/travel [L]	5,49	7,21	9,0	13,0	22,0	32,5	52,0
Compressed air line (length up to 6m)	8 mm	8 mm	15 mm	15 mm	15 mm	15 mm	15 mm
Min. closing time [s] <sup>*</sup>	approx. 1,3	approx. 1,4	approx. 1,6	approx. 2	approx. 2,5	approx. 2,8	approx. 3,5

<sup>\*</sup>) These data are limit or reference values for double-acting drives with 6 bar control pressure and apply only for the actuator (no valve attached). Shorter closing times on request.

<sup>\*\*</sup>) Refer Table on page no. 11, for more details.

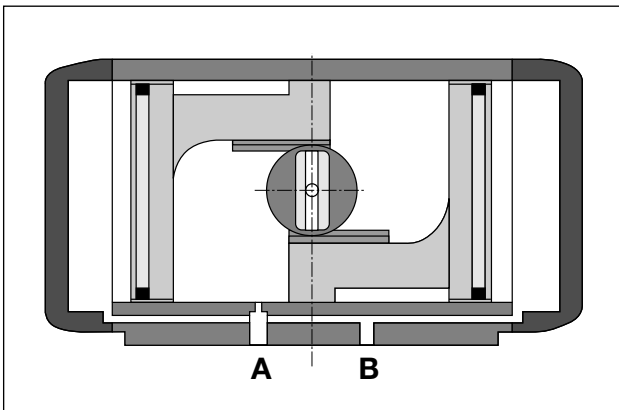


Fig. 1 Revo actuator series R

9.4 must be observed. In this case it is recommended to mount the actuator to the valve prior to the first installation of the valve into the pipeline and to the unit according to 6.1.1

Installation of valve with actuator should be performed in the following sequence:

### 6.1.1 Checking the Actuator Position before Installation

If not specified differently in the purchase order, the actuator is delivered in a space-saving position parallel to the pipeline.

If it needs to be installed 90° offset:

- convert the actuator as described in section 9.2 „Conversion of the actuator shaft“ in the detailed instructions.

### 6.1.2 Checking the Position Indicator before Installation

#### ■ if delivered without electrical position indicator:

- Slot diagonal to pipeline axis:  
Valve is closed,
- Slot parallel to pipeline axis:  
Valve is open.  
If the positions of valve and indicator do not match, see section 9.2 .

- if delivered with electrical position indicator:  
The optical indicator “OPEN” and “CLOSED” in the module must be compared with the position of the valve. If the positions of valve and indicator do not match: Plug the indicator in the accessory

module position indicator (electric/pneumatic) into a different socket.



**An incorrect position indication is a potential risk for later operation. Valves/ actuators with incorrect position indication must not be installed and should be rejected.**

### 6.1.3 Installation into the Pipeline

Installation of the unit valve/actuator into the pipeline is described in the operating instructions for the valve, these instructions must be treated with priority.

The following is additionally valid:



**Actuators must be appropriately supported in order to relieve the valve housing from excessive loads. They must be supported if their size and/ or installation orientation applies any bending strain to the valve.**



**Actuators of any size must not be subjected to any external loads, since this may damage or even destroy the valve. Actuators are no "stepladders".**

### 6.2 Connecting the Solenoid Valve

The actuator is controlled by a solenoid valve.

The solenoid valve is normally connected to the actuator via the standardized interface on the side of the actuator. The connection to the control must

- meet the prerequisites specified in section 2 "Intended Use",
- be in compliance with the documentation of the solenoid valve included in the delivery.

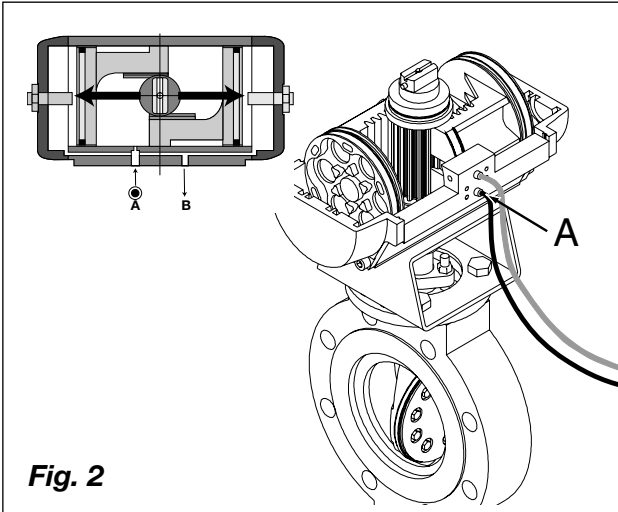


**Note: This must be observed particularly if the solenoid valve has not been delivered together with the actuator.**

- be in compliance with the following schematics in Fig. 2 to 5.

**Air connections double-acting**

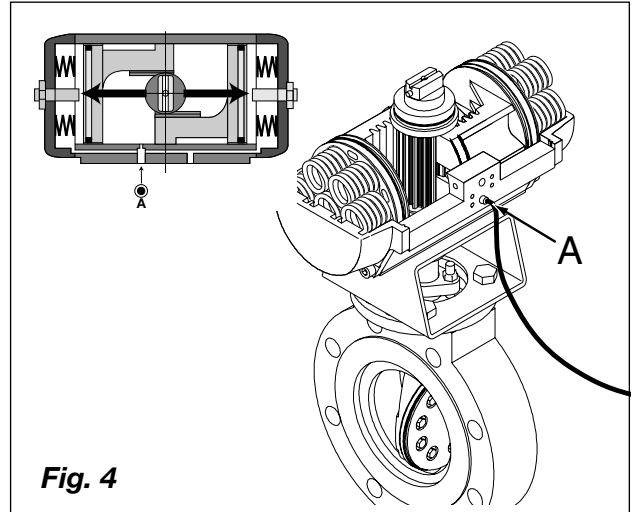
Air supply to port A: anti-clockwise/open



**Fig. 2**

**Air connections with spring reset**

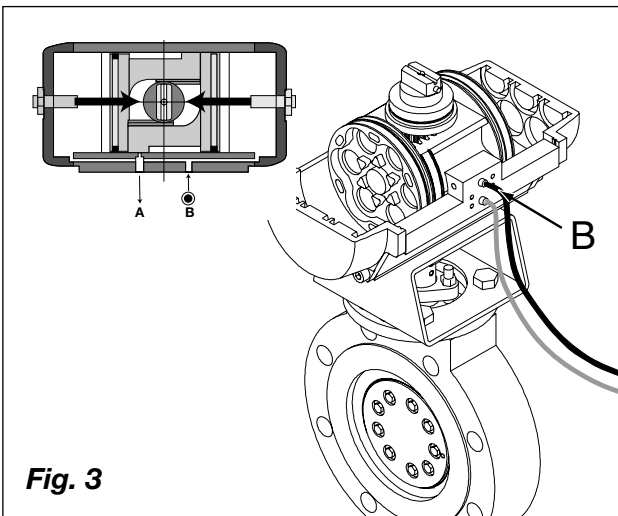
Air supply to port A: anti-clockwise/open



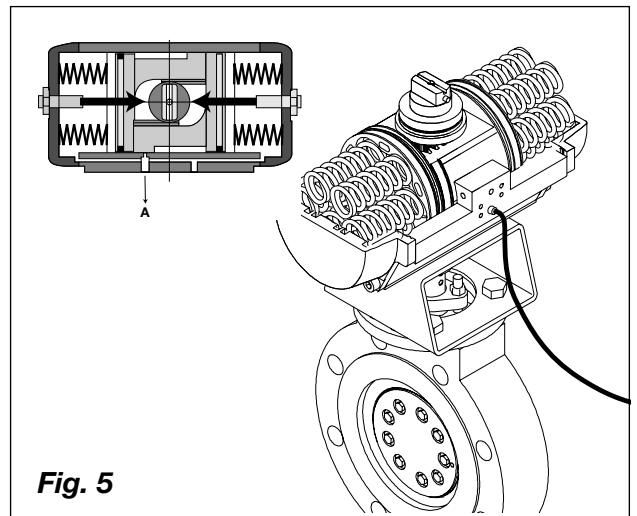
**Fig. 4**

Air supply to port B: clockwise/closed

Spring reset: clockwise/closed



**Fig. 3**



**Fig. 5**

**Recommended Pipe Diameters for Compressed Air Lines**

Actuator size	up to 1.20 m	longer than 1.20 m, max. upto 6 m
001 - 025	6 mm	6 mm
050 - 180	8 mm	8 mm
205 - H15	10 mm	15 mm

### 6.3 Connecting the Position Indicator and/or Position Controller Module (if present)

This type of module may already be installed (or can be mounted) to the interface on top of the actuator, instead of the optical position indicator. It has the purpose to signalize the position of the valve to the customer supplied control and signalizes the end positions "OPEN" and "CLOSED" and/or intermediate positions (on valves used for throttling/regulation).

Electric and pneumatic connections must be made in compliance with the documentation for position indicator and/or position controller.

### 6.4 Tests upon Completion of Installation

Once the installation of a valve/actuator unit is completed, it is highly recommended to perform the following test steps on each valve:

**Is the "local" control pressure sufficient?**

At least the control pressure determined by the design of the actuator must be available directly on the solenoid valve.

**Is the solenoid valve correctly connected?**

With control pressure applied, but failure of the control signal ( to check: pull out plug), the valve must travel to the following position:

**double-acting actuator:**

The valve closes or opens, see section 2, Intended Use, note 1

**actuator, spring closing:**

The valve must travel to safety position "CLOSED".

**actuator, spring opening:**

The valve must travel to safety position "OPEN".

If this fails check control system and/or solenoid valve.

**Check actuating function and indication:**

With control pressure applied the control commands "OPEN" and "CLOSE" must move the valve to the corresponding end positions. The optical indicator on the actuator must show this correctly. If this fails check the actuator control.

**Connection actuator/valve properly tightened?**

During the function test no relative movements should occur between valve, mounting bridge (if applicable) and pneumatic actuator.

If necessary tighten the fastening screws.

**(if module is available) check electrical position indicator:**

The electrical signals for indication "OPEN" and "CLOSED" can be compared with optical indication of the valve. Signal and indication must match.

If this fails check control system and/or position indicator.

If a valve cannot be actuated correctly as described above, even though it is properly connected, actuator and/or valve must be replaced.

## 7. Start-up

The actuator can only be started via the plant control after all tests described in the previous section 6.4 have been completed without objections. The instructions for valves specify whether and which additional steps are required for start-up.

The technical rating of the actuator for permanent operation can be found in section 6, table 1.



**Important for operation with short closing times: The wear inside the valve may be disproportionately high. With the installation of throttle valves in the supply line or in the discharge line for the control medium the travel time can be extended to a normal value.**



**In any case the travel frequency must be limited to such an extend, that the temperature measured on the actuator housing does not exceed 80°C during continuous operation.**

## 8. Troubleshooting

When rectifying a fault section 4: <Notes on Safety> must be strictly observed.

Note: In case of malfunctions in the valve: Follow the instructions for the valve.

Type of fault	Action	Remark
Actuator does not respond to control signal	Check control pressure on actuator: The minimum pressure for the rating of the actuator is required. If the control pressure is sufficient, but the actuator does still not respond: Check whether the valve hard to move: For remedy refer to the instructions for the valve. If the valve is also free of faults: Check control and/or dismantle the actuator, see section 9.4.	<u>Note 1:</u> When working on electric modules strictly observe the warnings in section 4.3!
Solenoid valve does not switch	Check whether the magnetic coil has burned out. Check whether the coil was is compatible with the control voltage. If the magnetic coil is OK: Observe the instructions for the solenoid valve.	<u>Note 2:</u> If a module needs replacement or spare parts: Always specify all data mentioned on the type plate of this module in your order.
Valve switches too quickly	Install a restrictor into the supply or discharge line on the solenoid valve.	
	If the leak is to be eliminated by changing the end position "CLOSED": Adjust the setscrew in the actuator, see section 9.5 of the detailed instructions.	
Valve is leaking Actuator consumes air in end position "OPEN" and "CLOSED"	Check the solenoid valve and its mounting on the actuator. If there is no leakage on the solenoid valve: Dismantle the actuator and renew the seals inside the actuator, see section 9.4.	

## 9. Work on the Pneumatic Actuator

The manufacturer normally delivers Revo pneumatic actuators

- in the design that has been ordered (double-acting or with springs),
- in size and rating adapted to the valve,
- with the required accessories, if ordered,
- adjusted and mounted to the valve – as standard positioned parallel to the pipeline.

If an actuator needs to be subsequently converted in exceptional cases, this may also be performed by the user. If the actuator needs to be dismantled for this purpose, this should generally be done in an appropriate workshop with experts for the assembly of high-quality function parts.

### 9.1 Mounting an Actuator to the Valve



For better understanding of the following instructions you may also use the publications mentioned in section 1, Area of Application, under note 2.

**Revo valve actuators** have an interface to the valve in accordance with ISO 5211 and a form-closed bore in the control shaft (4), which

- either in form of a square socket acc. to ISO 5211

in the end positions of the actuator positioned 45° “on the tip”,

- or as square socket acc. to ISO 5211 parallel to the longitudinal axis of the housing.
- With some drive sizes the installation of a square insert may be necessary. The installation/ dismantling takes place according to chapter 9.7.

The actuator ordered must match the valve.

The valve must

- have a fitting control spindle end and
- a matching fastening flange acc. to ISO 5211, this must be checked before the installation.

Please observe when mounting the actuator to the valve that

- the longitudinal axis of the actuator should normally be orientated parallel to the pipeline axis,
- the fastening screws match the standardized thread depth acc. to table 2 (see below). Screws too short or too long for the thread depth must not be used,
- the position indicator on the pneumatic drive matches the position of the valve. If a conversion is required, please refer to the next section 9.2.
- The piping system must be earthed to an appropriate extent by the installer.

Table 2: Connection measurements

Size	001	002	006	012	025	050	090
Thread depth [mm]	8	8	6,5/7,5/8	9	9	12	12/16
Square s =	9	9/11	11/14	14	14	17	17/22

Size	130	180	205	380	630	960	H15
Thread depth [mm]	16/18	18	20/25	20/25	25/32	25/32	25/32
Square s [mm] =	22/27	27	27/36	27/36	36/46	46/55	55/75



If the actuator has already been mounted by the supplier, the supplier is solely responsible for correct adjustment of the position indicator.

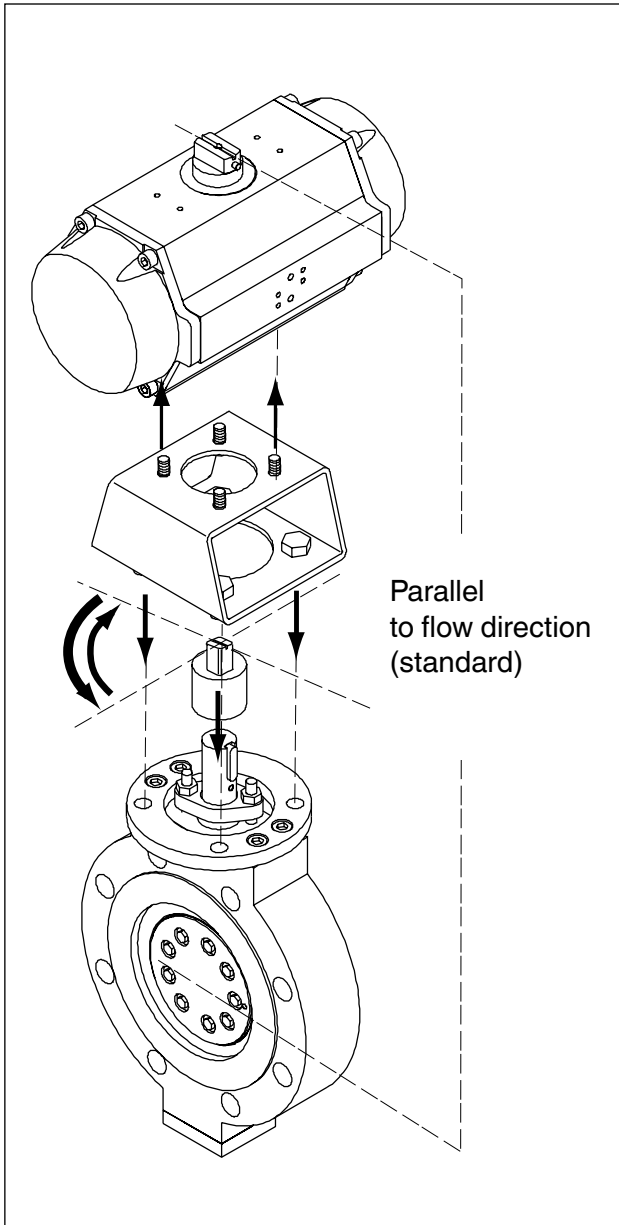


Fig. 6 Mounting an Actuator to the Valve

## 9.2 Conversion of Drive Shaft to Change the Position Indicator

If the position indicator is not correctly adjusted or the position of the actuator to the valve needs to be changed for 90° by the customer, the control shaft with its position indication must be turned by 90°.



**Be careful when removing the actuator from the valve installed in the pipeline: The actuator must only be removed after the pressure in the pipeline has been relieved.**

- Disconnect all connections to the control, unscrew the fastening screws to the mounting flange and take the actuator off the valve, see Fig. 6 in previous section 9.1,
- Disassemble the actuator, as described in section 9.4, Disassembling an Actuator,
- Assemble the actuator shaft 90° offset, reassemble the actuator (not series 6).



**Be careful when working on actuators with spring reset: Dismantling and assembly should be performed under the supervision of a safety expert or by the manufacturer.**

- Before mounting the actuator to the valve make sure that the position indicator is correctly adjusted, see Fig. 6 and section 9.1, Mounting an Actuator to the Valve.

## 9.3 Changing the Spring Force



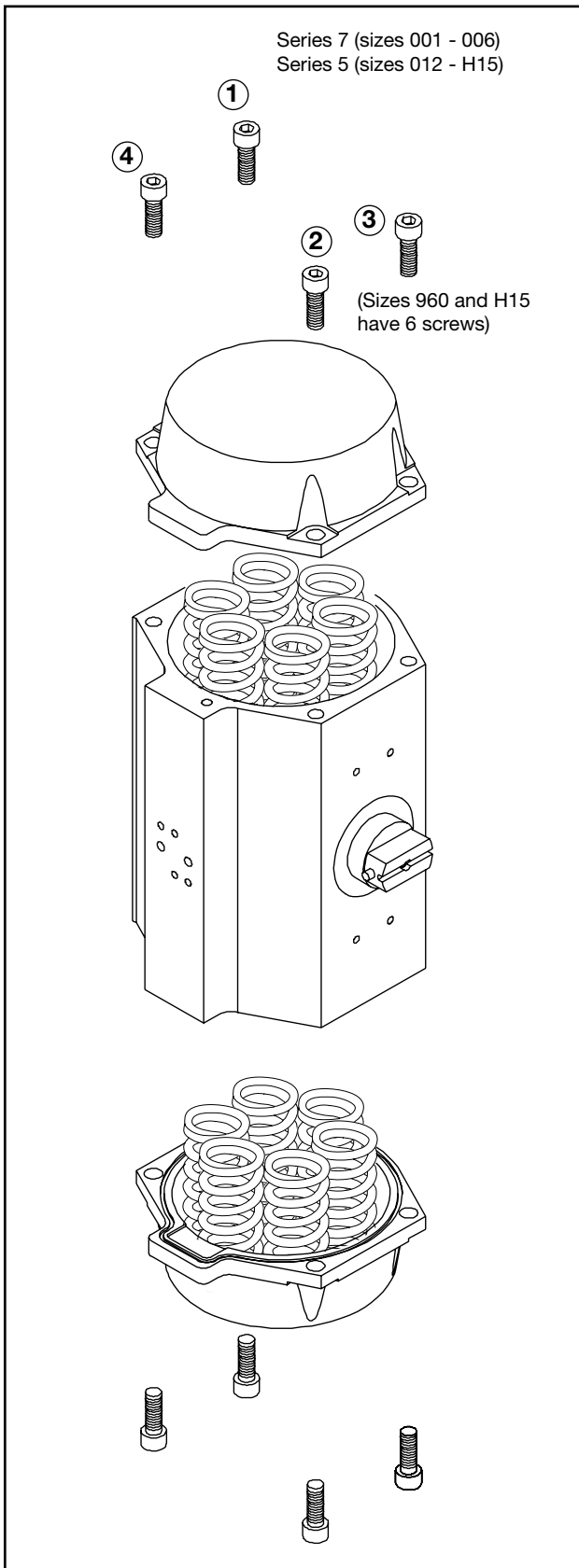
**Danger of injury: Spring reset actuators contain compressed spiral springs.**

In order to prevent a risk of injury caused by unprofessional work the following steps must be performed with greatest care and only under the supervision of a safety expert.







Since the spring reset is dimensioned by the manufacturer Crane Process Flow Technologies, any modifications to this dimensioning should also be coordinated with the manufacturer.

If the factory installed spring assembly in actuators with spring reset is to be changed, both covers (2) must be opened.

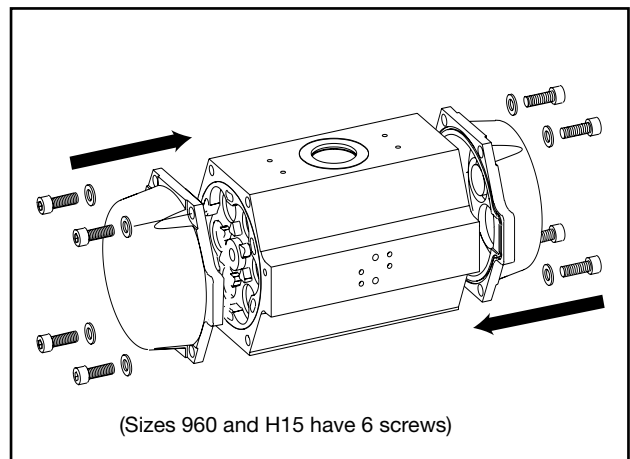


**Fig. 7 Mounting an Actuator to the Valve**

-  **Note 1: First read the following instructions to end before starting to disassemble!**
-  **Open the actuator only outside the danger zone.**
-  **Models 002 and 006 spring return actuators: Place actuator in a press before removing endcap bolts. The springs in these units are still compressed when the endcap bolts are disengaged from body.**
-  **Be extremely careful while disassembling the end caps on actuators with spring reset. Use of impact wrenches not permitted.**

The conversion should be performed in the following steps:

- a) Strictly depressurize the actuator beforehand, so that it travels to safety position. It is also mandatory to depressurize the valve,
- b) then mark the position of the actuator and remove it from the valve, disassemble all accessory modules (solenoid valve, position indicator and/or position controller),
- c) remove screws in the sequence 1-4 (Fig. 7) by each only 1 cm. That's important for an even load during the relaxation process of the endcap.
- d) repeat step c) so often until screws are completely removed.



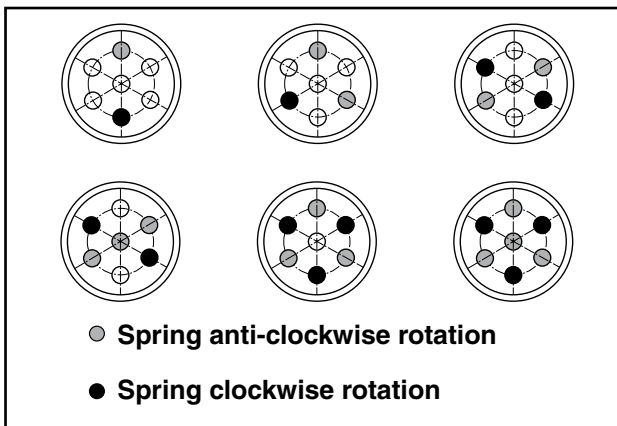
**Fig. 8 Disassembling the end cap**



- then loosen the first cover (2),

**Before loosening the screws (18) it must be assured that the actuator is completely depressurized.**

- slacken the screws (18) crosswise and in pairs uniformly and in small steps in order to relieve the springs slowly, then change the spring assembly as shown in Fig. 9 and retighten the cover (2) in reverse order.



**Fig. 9 Arrangement of springs on spring reset actuators**

- place the cover (2) centrally on the spring pack and press it slightly down, so that the screws (18) reach into the tapped bores.



**The strength of the housing material requires the reuse of all screws (18) with original length, do not use any shorter screws! (Observe the tightening torques given on page 24)**

- then turn the actuator around and change the springs on the opposite site in the same way.
- After this reassemble the electric modules (solenoid valve, position indicator and/or position controller).
- Then mount the actuator back to the valve, as described in section 9.1 <Mounting...>.
- Finally check the actuator with the control to find out whether the valve is correctly actuated and whether the position indication is correct.

## 9.4 Dismantling an Actuator

In case of a defect remove and dismantle the actuator and replace the defective part. You must only use original spare parts from the manufacturer CRANE Process Flow Technologies.



**Note: First read the following instructions to end before starting to disassemble!**



**Be careful when working on spring reset actuators: These actuators contain compressed spiral springs. For dismantling these actuators section 9.3 must be additionally strictly observed in order to prevent the risk of injury.**

- Close valves with double-acting actuators,
- depressurize double-acting and spring reset actuators,
- if possible disassemble the actuator from the valve. This requires depressurizing of the valve (if this is not possible clarify the procedure with the locally responsible safety officer!),
- then make a note of the currently indicated position of the position indicator on the actuator,
- then mark the position of the actuator on the valve and separate the actuator from the valve,
- then loosen screws (18) on covers (2) crosswise and uniformly and take off covers (2),
- then turn the dihedron on shaft head (5) and push both pistons (3) out of the drive housing, until they are disengaged,
- take both pistons (3) carefully out.

Both pistons (3) must be reassembled in correct position and with the racks to the right and left of control shaft (4), as they have been taken out, as otherwise the sense of rotation of the actuator will be reversed! See also Fig. 4 (spring closing) and Fig. 5 (spring opening).

You should therefore make a note of the position of both racks on the pistons before pulling them out of the housing.

- then disengage circlip (17) with a special pliers from inside, slide it up and push down Pos.(4) together with Pos.(7),

- then check which parts are damaged and need to be replaced. All O-rings and slide belts should be replaced in any case. These are available from Crane Flow as a spare part set.

The actuator must be reassembled and mounted to the valve in reverse order.

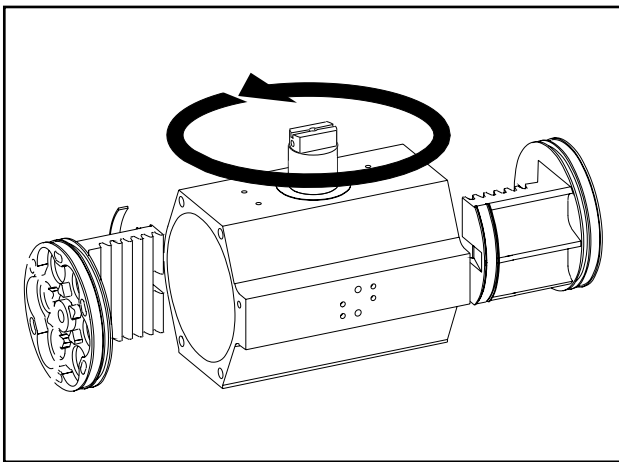


Fig. 10 Pushing down the pistons

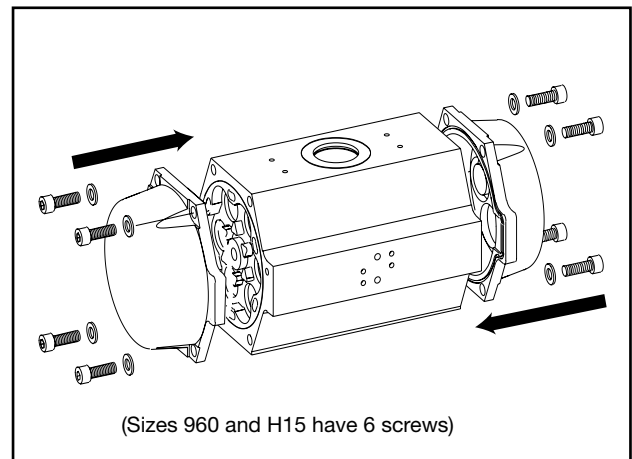


Fig. 12 Preparations for assembly

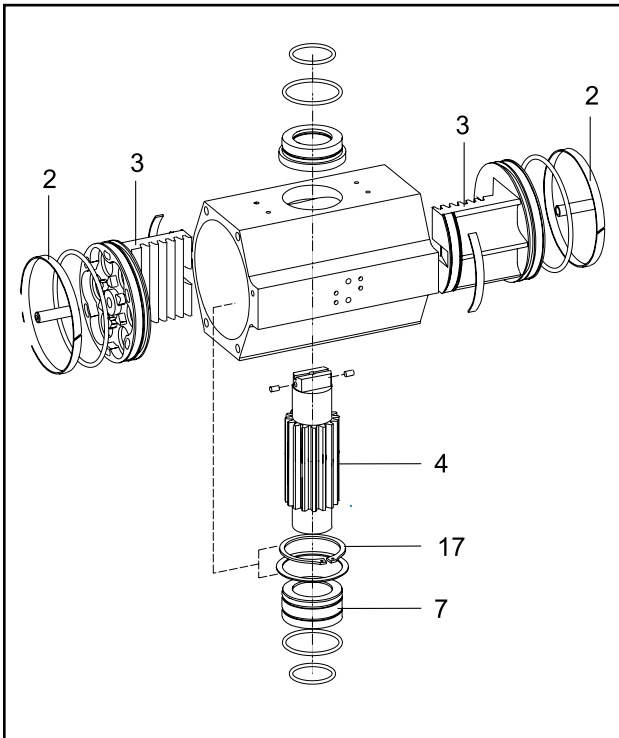


Fig. 11 Removing internal parts

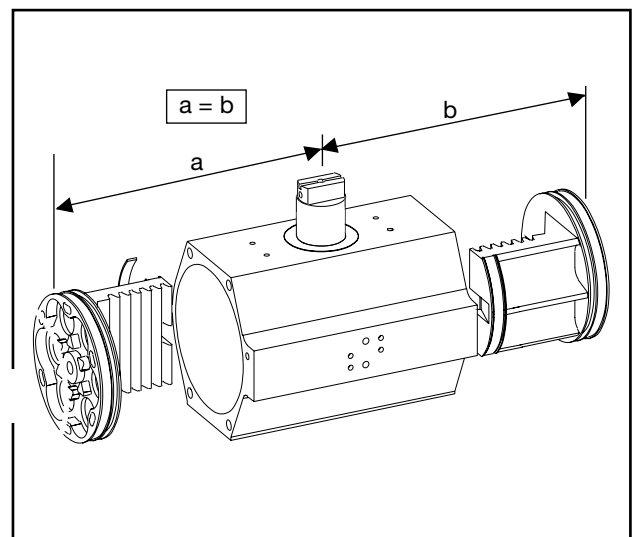


Fig. 13 Inserting the pistons



Both pistons (3) must be reassembled in correct position and with the racks to the right and left of control shaft (4), as they have been taken out, as otherwise the sense of rotation of the actuator will be reversed! See also Fig. 14 (spring closing) and Fig. 15 (spring opening).



For this purpose observe the positions of both pistons (3) noted before disassembly.

**Note:** Please observe Fig. 15 to 18 for the different types and sizes of actuators as guidance:

### 9.5 Setting the End Position on Series 6 (Sizes 012 - 180)

#### Setting the End Position Limitation

On valves with actuators delivered from the factory the travel limitations, e.g. for butterfly valves, are normally adjusted in a way that the valve is leak tight in position "CLOSED" and has a travel of 90°. For e.g. ball valves the possibility of an exact adjustment to position "OPEN" may be requested. The following procedure describes how this final adjustment can be readjusted for actuators starting from size 012.



All adjustment work must first be carried out with the unit disconnected from the compressed air supply. A test run with compressed air must only be carried out after this adjustment has been made. Only on actuators with resetting springs the setscrews should only be unloaded by means of compressed air.

#### Actuator size 012 - 180

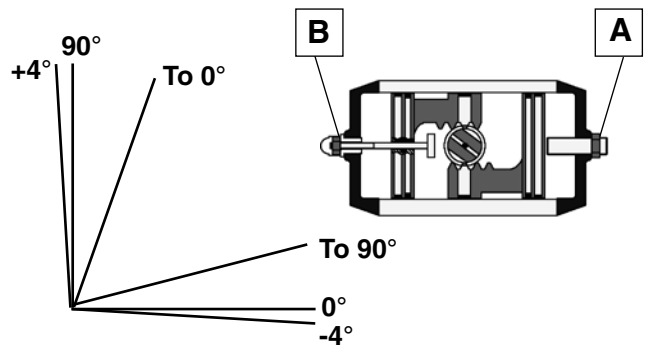
Setscrew „A“ for position „OPEN“ is located on the right hand side of the actuator (see adjacent Fig.). Setscrew for position „CLOSED“ is located on the left hand side. The total available adjustment range is 98°.

#### Setting to „normally OPEN“ for function „double-acting“ and „spring resetting“:

- Pull off the protection cap and loosen the locking nut.
- Turn setscrew „A“ by the hexagon socket in clockwise direction. This means „Reduction of travel in opening direction (94° to -4°)“. Turning setscrew anti-clockwise means „Increase of travel in closing direction“.
- After the adjustment retighten the locking nut and push the protective cap back on.

#### Setting to „normally CLOSED“ for function „double-acting“:

- Pull off the protection cap and loosen the locking nut.
- Turn setscrew „B“ by the hexagon socket in clockwise direction. This means „Increase of travel in closing direction (-4° to 94°)“. Turning the setscrew anti-clockwise means „Reduction of travel in opening direction“.
- After the adjustment retighten the locking nut and push the protective cap back on.



Actuator	Torque /Nm	
	A	B
012	12	12
025	12	12
050	15	16
090	15	15
130	20	20
180	20	20

**Setting to „normally CLOSED“ for function „spring resetting“:**

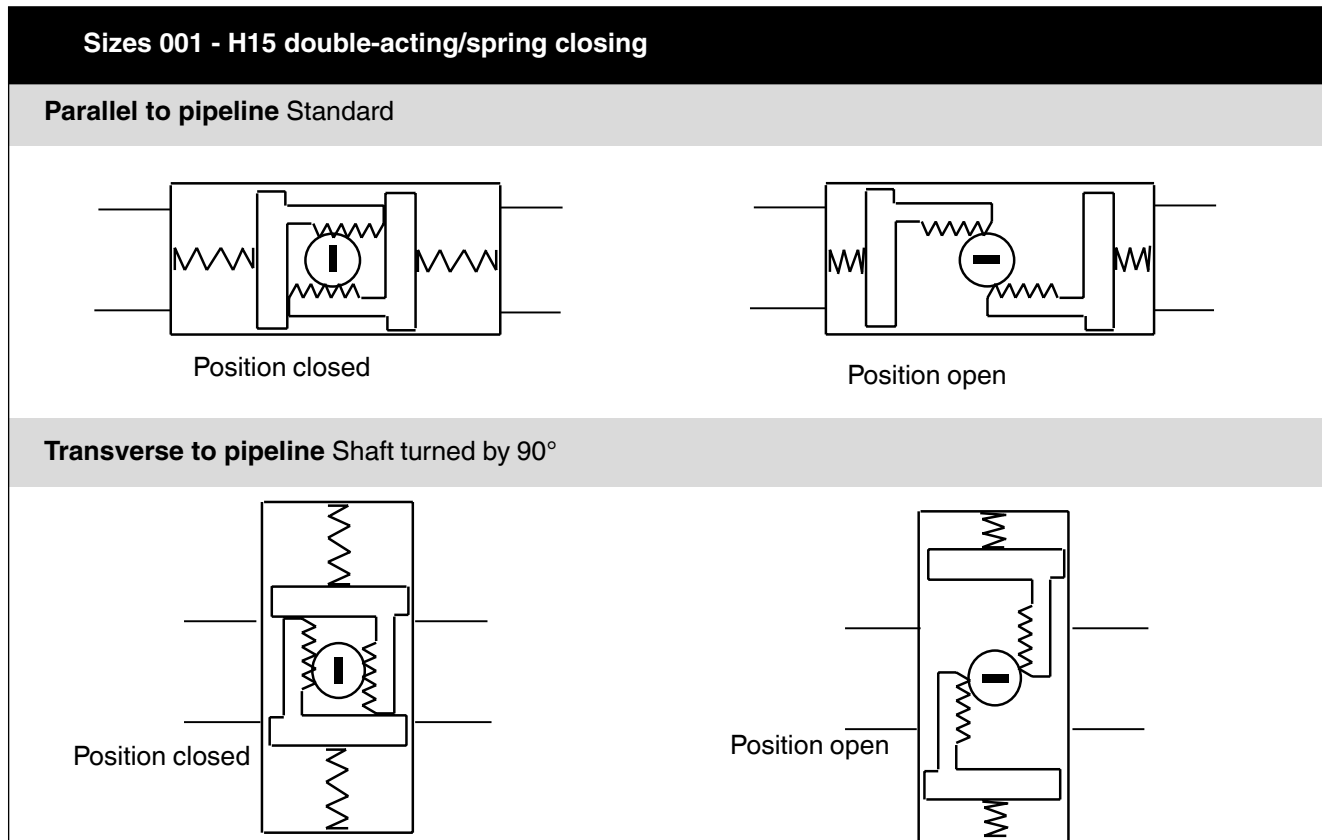
- Here the same applies as described under „double-acting“. However, setscrew „B“ must not be adjusted anti-clockwise against the tensioned resetting springs, thus to avoid excessive strain and damage. The adjustment of this screw in anti-clockwise direction is considerably accommodated by a carefully dosed supply of compressed air through air inlet port „A“ on the actuator. Only the amount of compressed air that is necessary to enable force-free turning of the setscrew shall be supplied.

**Actuator sizes 001 - 006**

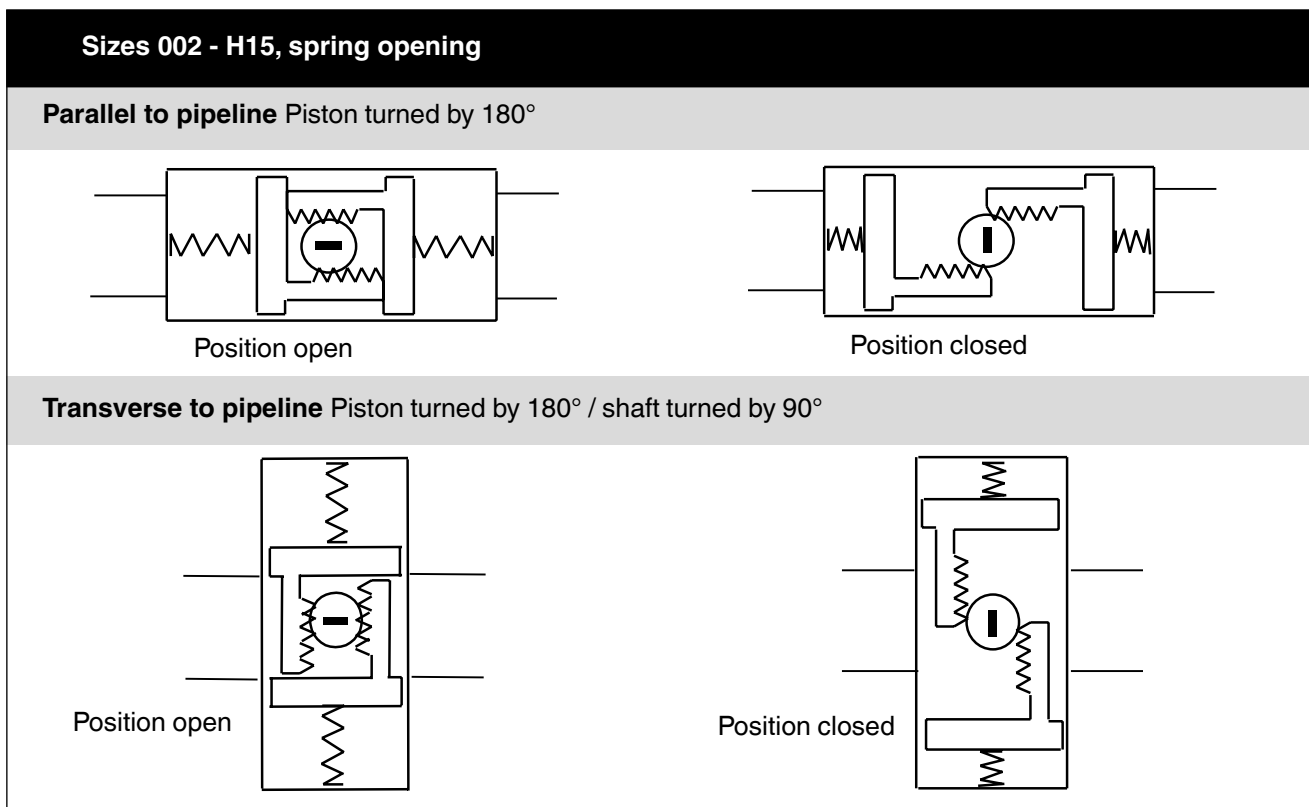
Setting the end position is only possible for position “normally Open”. Setscrews acc. to “A” are on both sides of the ac-tuator.

- Turn the setscrews “A” by the inner hexagon in clockwise direction to reduce the “travel in opening direction”.
- Turning setscrews anti-clockwise to increase “the travel in closing direction”.

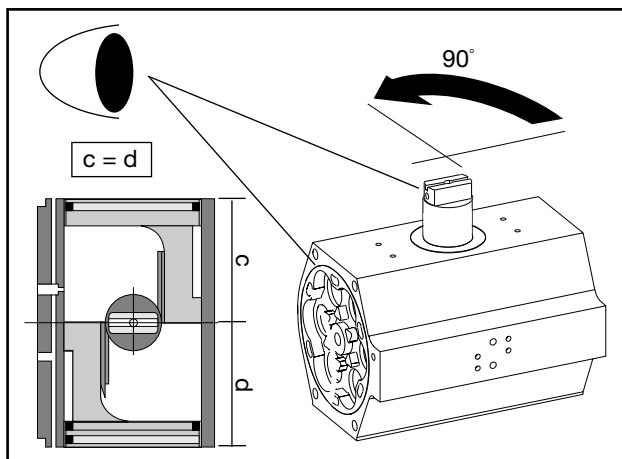
**9.6 Schematic Structure**



**Fig. 14 Schematic of actuator double-acting and with closing spring (sizes 001 to H15)**

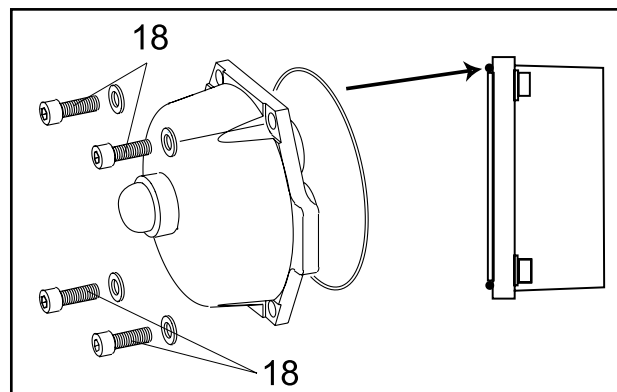


**Fig. 15 Schematic of actuator with opening spring (sizes 002 - H15)**



**Fig. 16 In "OPEN"-position pistons must be almost flush with the housing**

- When assembling the O-rings (14) it is advisable to lubricate these with grease on silicon or polyglycol basis before inserting them into their chamber in the cover. Do not use any mineral oil based greases or Vaseline. O-rings must not be "twisted" when being inserted into their seat.



**Fig. 17 Assembly of cover with O-ring**



**The strength of the housing material requires the reuse of all screws (18) with original length, do not use any shorter or longer screws!**

### 9.7 Installation of the shaft inserts for drives 001, 002, and 006

Revo Pneumatic Valve Actuators size 001 - 006 can be modified with diverse shaft inserts for different applications. This means the highest degree of flexibility. The installation/dismantling takes place according to the following layout:

#### A) Installation of the selected insert

Prior to installation of the insert, the drive is positioned according to Fig. 18. Positioning according to Fig. 19 is not permitted. The additional installation would cause damage to the drive!

With the installation of the selected insert it must therefore be ensured that it is not canted on the octagonal part of the shaft ( see Fig. 20 ). Prior to joining, check whether positioning of the square at 0° or 45° is desired. Now drive the insert into the shaft with a light strike from a soft hammer ( see Fig. 21 ). After completed assembly the square insert may not protrude.

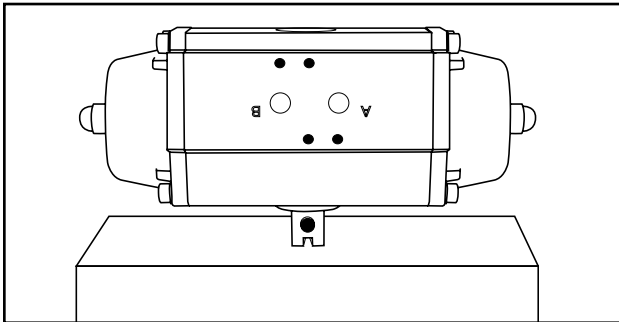


Fig. 18

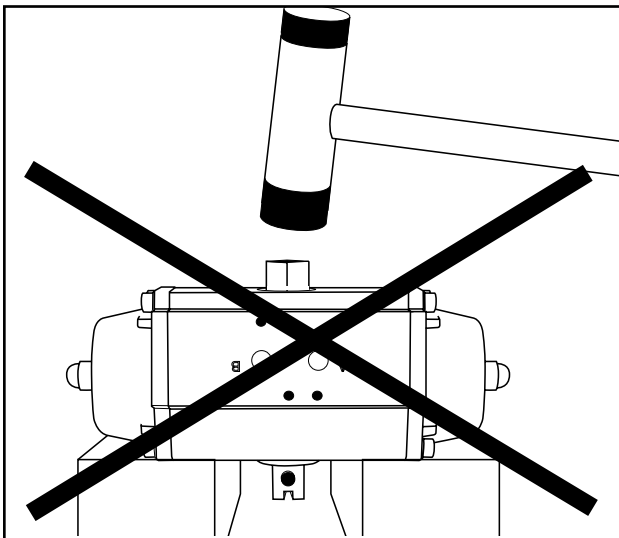


Fig. 19

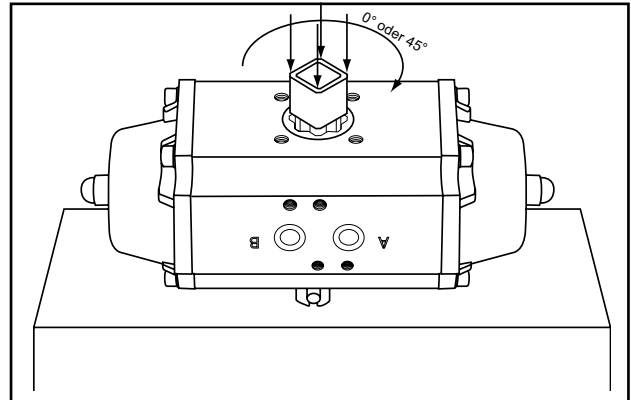


Fig. 20

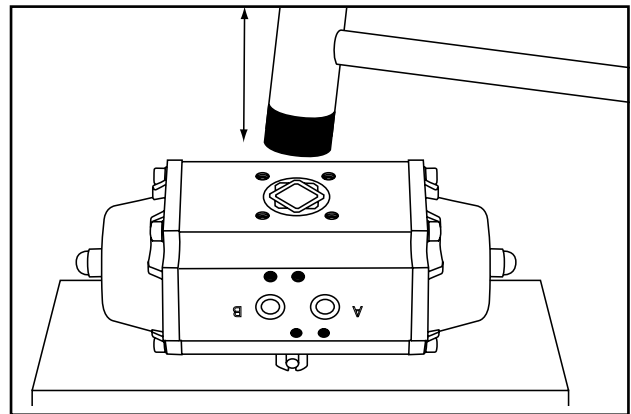


Fig. 21

#### B) Dismantling the installed insert

Depending on tolerances, this insert can be very firmly seated in the shaft. It is important with the dismantling that the insert is not canted. Please ensure uniform extraction! We recommend using an appropriate extraction tool ( see Fig. 22 ).

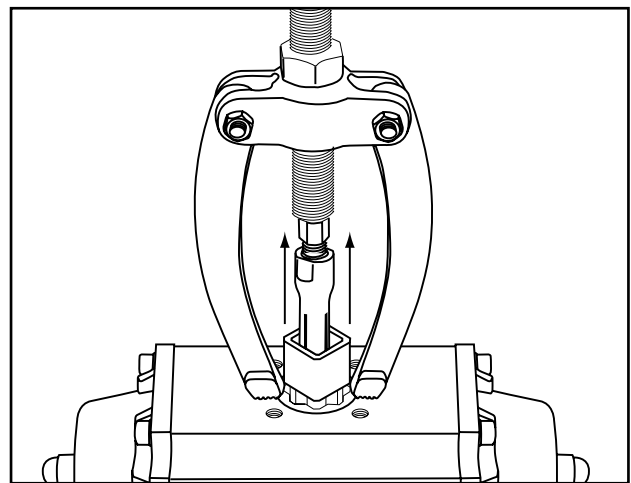


Fig. 22

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## 10. Maintenance

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Revo pneumatic actuators of series R normally do not require any maintenance.

We recommend to replace O-rings and sliding belts after 500.000 switching cycles.

It is quite adequate to check periodically that no control medium leaks out. In events of emergency section 8 "Troubleshooting" must be observed.

Table 1 in section 6 <Installation... into the pipeline> shows the expected lifetime under the specified rating conditions.



**Danger, before working with the actuator. The Actuator must be moved from possible ATEX area to work Area. No work on the Actuator in the ATEX areal.**



**Actuators for use in explosive hazard areas must always be kept clean of dust deposits.**

**The Following is generally valid :The Actuator should preferably be cleaned mechanically instead of using chemical means.**

## 11. Spare Parts

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Spare parts sets for the actuators are available from the manufacturer's stock and must be ordered with all details specified on the type plate.



**All parts made of elastomers are organic materials, which must be stored in an environment as cool, dry and dark as possible. Due to ageing these parts should not be stored for longer than 2-3 years.**

Spare parts for the valve are specified in the instructions contained in the complete delivery.

## 12. Further Information

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**can be obtained from your nearest office of CRANE Process Flow Technologies or from our head office.**

## 13. Mini Drives

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### Series 7 (sizes 001 - 006)

#### General

REVO Mini actuators differ from the bigger actuators in a few details. The following description explains these differences. All other points apply also for Mini actuators.

Revo Mini actuators have a standardized interface acc. to ISO 5211.

The control shaft is provided with an octagon to plug on a socket

- either in form of a square socket acc. to ISO 5211 in the end positions of the actuator positioned 45°,
- or as square socket at 0° in end position
- or, if demanded by the customer, as diehedron or another shape

#### Conversion of Drive Shaft to Change the Position Indicator

The procedure is as described under 9.2, however, it must be assured that the control shaft is not displaced axially in the housing. This is possible, because the shaft is not retained by a circlip, but the pistons are positively connected with the shaft and the shaft will float freely in the housing once the pistons have been removed.

#### Changing the Spring Force

Spring resetting Mini actuators of sizes 002 and 006 are equipped with max. 4 pieces of centrally arranged springs.



**The springs are pre-loaded can cannot be relieved by means of the cover fastening screws..**

The cover plate must be held in place to open the actuator. This can be accomplished by using a screw clamp, in a vice or by using longer screws.

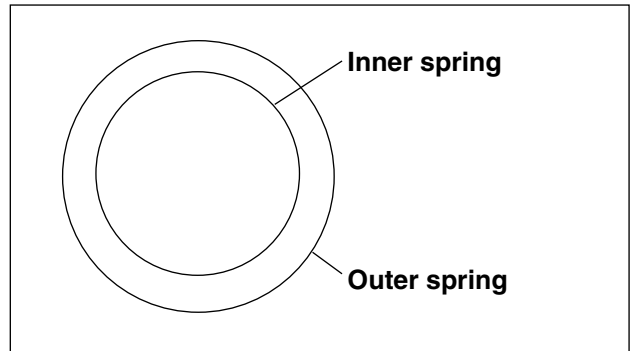
Also here the notes given under 9.4 must be additionally observed.

**Series 7**

**Concentric springs (sizes 001 - 006)**

In contrast to sizes 012 - H15 the coding of springs (digit 10 in code) does not correspond with the number of springs. The coding is made in accordance with the following list:

10. digit	Outer spring	Inner spring
2	0	1
4	0	2
6	1	1
8	2	0
10	2	1
12	2	2



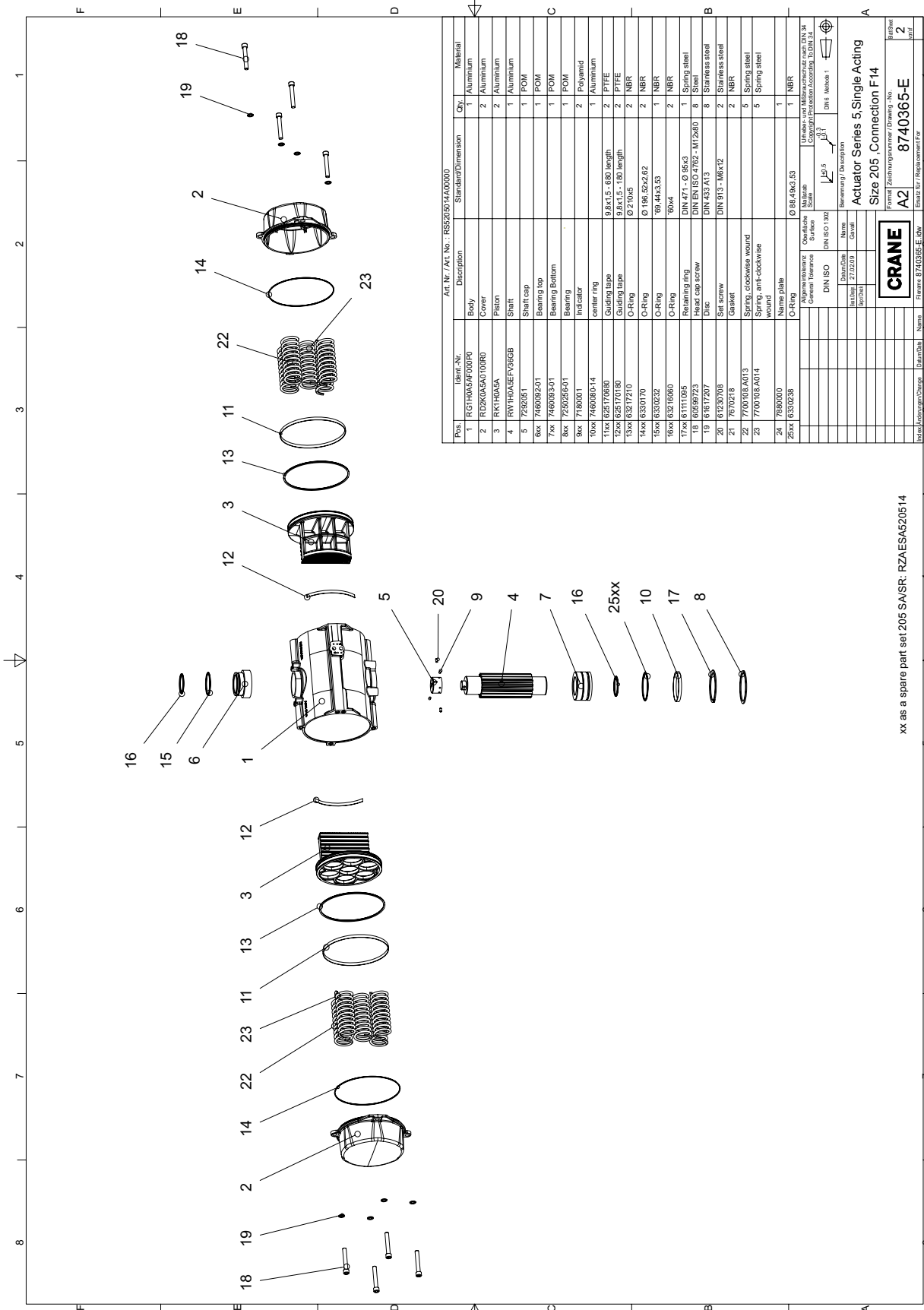
**14. Screw Tightening Torques**

**Tightening torques**

Actuator	Cover plate screws	Screwer used	adjusted stage	Tightening torque	Counter nut end position	Tightening torque
001	M 4 x 10 mm	-/-	-/-	2 - 2,5 Nm	M 5	2 Nm
002	M 4 x 20 mm	-/-	-/-	2 - 2,5 Nm	M 5	2 Nm
006	M 5 x 20 mm	-/-	-/-	2,5 - 3 Nm	M 6	4 Nm
012	M 6 x 40 mm	1	2	9 Nm	M 12 x 1	12 Nm
025	M 6 x 40 mm	1	2	9 Nm	M 16 x 1,5	12 Nm
050	M 8 x 50 mm	1	4	18 Nm	M 18 x 1,5	15 Nm
090	M 10 x 70 mm	2	9	30 Nm	M 20 x 1,5	15 Nm
130 / 180	M 10 x 80 mm	2	9	30 Nm	M 24 x 2	20 Nm
205 / 380	M 12 x 40 mm	2	9	35 Nm	-/-	-/-
205	M 12 x 80 mm	2	9	35 Nm	-/-	-/-
380	M 12 x 110 mm	2	9	35 Nm	-/-	-/-
630 - H15	M 16 x 50 mm	3	8	110 Nm	-/-	-/-
630 / 960	M 16 x 110 mm	3	8	110 Nm	-/-	-/-
H15	M 16 x 140 mm	3	8	110 Nm	-/-	-/-



# 15. Exploded View



Pos.	Ident.-Nr.	Description	Standard Dimension	Qty.	Material
1	RGTH0A5AF00P0	Body		1	Aluminum
2	RZ2KA5A0T00R0	Cover		2	Aluminum
3	RKTTH0A5A	Piston		2	Aluminum
4	RWTH0A5EFV3GGB	Shaft		1	Aluminum
5	Z292051	Shaft cap		1	POM
6xx	746035401	Bearing top		1	POM
7xx	746035501	Bearing bottom		1	POM
8xx	7180001	Indicator		2	Polyamid
10xx	746030614	Indicator center ring		1	Aluminum
11xx	625170880	Guide ring	9.8x15 - 680 length	2	PTFE
12xx	625170180	Guide ring	9.8x15 - 180 length	2	PTFE
13xx	63217210	O-Ring	Ø 2,10x5	2	NBR
14xx	6330170	O-Ring	Ø 106,52x2,62	2	NBR
15xx	6330132	O-Ring	160,44x3,53	1	NBR
16xx	63210860	O-Ring	160x4	2	NBR
17xx	E1111095	Retaining ring	DIN 911 - Ø B5x3	1	Spring steel
18	60589123	Head cap screw	DIN EN ISO 4762 - M7x26,0	8	Steel
19	6191267	Diac	DIN 913 A13	8	Stainless steel
20	6123708	Set screw	DIN 913 - M6x12	2	Stainless steel
21	7610216	Gasket		2	NBR
22	7700105.A013	Spring clockwise wound		5	Spring steel
23	7700105.A014	Spring anti-clockwise wound		5	Spring steel
24	7680300	Name plate		1	NBR
25xx	6330138	O-Ring	Ø 86,49x4,53	1	NBR

Art. Nr. / Art. No. : R55205014A0000	Material
	Aluminum
	POM
	Polyamid
	PTFE
	NBR
	Spring steel
	Steel
	Stainless steel

DIN ISO	General Reference
DIN ISO 1100	ISO 1100-1
DIN ISO 1100	ISO 1100-2
DIN ISO 1100	ISO 1100-3
DIN ISO 1100	ISO 1100-4
DIN ISO 1100	ISO 1100-5
DIN ISO 1100	ISO 1100-6
DIN ISO 1100	ISO 1100-7
DIN ISO 1100	ISO 1100-8
DIN ISO 1100	ISO 1100-9
DIN ISO 1100	ISO 1100-10
DIN ISO 1100	ISO 1100-11
DIN ISO 1100	ISO 1100-12
DIN ISO 1100	ISO 1100-13
DIN ISO 1100	ISO 1100-14
DIN ISO 1100	ISO 1100-15
DIN ISO 1100	ISO 1100-16
DIN ISO 1100	ISO 1100-17
DIN ISO 1100	ISO 1100-18
DIN ISO 1100	ISO 1100-19
DIN ISO 1100	ISO 1100-20
DIN ISO 1100	ISO 1100-21
DIN ISO 1100	ISO 1100-22
DIN ISO 1100	ISO 1100-23
DIN ISO 1100	ISO 1100-24
DIN ISO 1100	ISO 1100-25
DIN ISO 1100	ISO 1100-26
DIN ISO 1100	ISO 1100-27
DIN ISO 1100	ISO 1100-28
DIN ISO 1100	ISO 1100-29
DIN ISO 1100	ISO 1100-30
DIN ISO 1100	ISO 1100-31
DIN ISO 1100	ISO 1100-32

General Reference	Material
ISO 1100-1	Aluminum
ISO 1100-2	POM
ISO 1100-3	Polyamid
ISO 1100-4	PTFE
ISO 1100-5	NBR
ISO 1100-6	Spring steel
ISO 1100-7	Steel
ISO 1100-8	Stainless steel
ISO 1100-9	NBR
ISO 1100-10	Spring steel
ISO 1100-11	Spring steel
ISO 1100-12	NBR
ISO 1100-13	NBR
ISO 1100-14	NBR
ISO 1100-15	NBR
ISO 1100-16	NBR
ISO 1100-17	NBR
ISO 1100-18	NBR
ISO 1100-19	NBR
ISO 1100-20	NBR
ISO 1100-21	NBR
ISO 1100-22	NBR
ISO 1100-23	NBR
ISO 1100-24	NBR
ISO 1100-25	NBR
ISO 1100-26	NBR
ISO 1100-27	NBR
ISO 1100-28	NBR
ISO 1100-29	NBR
ISO 1100-30	NBR
ISO 1100-31	NBR
ISO 1100-32	NBR

Designation	Material
ISO 1100-1	Aluminum
ISO 1100-2	POM
ISO 1100-3	Polyamid
ISO 1100-4	PTFE
ISO 1100-5	NBR
ISO 1100-6	Spring steel
ISO 1100-7	Steel
ISO 1100-8	Stainless steel
ISO 1100-9	NBR
ISO 1100-10	Spring steel
ISO 1100-11	Spring steel
ISO 1100-12	NBR
ISO 1100-13	NBR
ISO 1100-14	NBR
ISO 1100-15	NBR
ISO 1100-16	NBR
ISO 1100-17	NBR
ISO 1100-18	NBR
ISO 1100-19	NBR
ISO 1100-20	NBR
ISO 1100-21	NBR
ISO 1100-22	NBR
ISO 1100-23	NBR
ISO 1100-24	NBR
ISO 1100-25	NBR
ISO 1100-26	NBR
ISO 1100-27	NBR
ISO 1100-28	NBR
ISO 1100-29	NBR
ISO 1100-30	NBR
ISO 1100-31	NBR
ISO 1100-32	NBR

Name	Material
ISO 1100-1	Aluminum
ISO 1100-2	POM
ISO 1100-3	Polyamid
ISO 1100-4	PTFE
ISO 1100-5	NBR
ISO 1100-6	Spring steel
ISO 1100-7	Steel
ISO 1100-8	Stainless steel
ISO 1100-9	NBR
ISO 1100-10	Spring steel
ISO 1100-11	Spring steel
ISO 1100-12	NBR
ISO 1100-13	NBR
ISO 1100-14	NBR
ISO 1100-15	NBR
ISO 1100-16	NBR
ISO 1100-17	NBR
ISO 1100-18	NBR
ISO 1100-19	NBR
ISO 1100-20	NBR
ISO 1100-21	NBR
ISO 1100-22	NBR
ISO 1100-23	NBR
ISO 1100-24	NBR
ISO 1100-25	NBR
ISO 1100-26	NBR
ISO 1100-27	NBR
ISO 1100-28	NBR
ISO 1100-29	NBR
ISO 1100-30	NBR
ISO 1100-31	NBR
ISO 1100-32	NBR

Designation	Material
ISO 1100-1	Aluminum
ISO 1100-2	POM
ISO 1100-3	Polyamid
ISO 1100-4	PTFE
ISO 1100-5	NBR
ISO 1100-6	Spring steel
ISO 1100-7	Steel
ISO 1100-8	Stainless steel
ISO 1100-9	NBR
ISO 1100-10	Spring steel
ISO 1100-11	Spring steel
ISO 1100-12	NBR
ISO 1100-13	NBR
ISO 1100-14	NBR
ISO 1100-15	NBR
ISO 1100-16	NBR
ISO 1100-17	NBR
ISO 1100-18	NBR
ISO 1100-19	NBR
ISO 1100-20	NBR
ISO 1100-21	NBR
ISO 1100-22	NBR
ISO 1100-23	NBR
ISO 1100-24	NBR
ISO 1100-25	NBR
ISO 1100-26	NBR
ISO 1100-27	NBR
ISO 1100-28	NBR
ISO 1100-29	NBR
ISO 1100-30	NBR
ISO 1100-31	NBR
ISO 1100-32	NBR

xx as a spare part set 205 SA/SR: RZAESA520514

## 16. Waste disposal after expiry of the expected service life

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The metal components used, such as aluminium, grey cast iron, high-grade steel and steel can be returned for recycling.

Plastic and rubber parts cannot be reused and must be disposed of as residual waste & Disposal shall be done as per state / local regulations.





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We reserve the right to modifications to all technical specifications.

