

VXE Series Ball Valves

Submittal Data Sheet

Installation Procedures

1. For socket and threaded style connections, remove the union nuts (part #13 on previous page) and slide them onto the pipe. For flanged connections, remove the union nut / flange assemblies from the valve.
2. Please refer to the appropriate connection style sub-section:
 - a. For socket style, solvent cement the end connectors (7 or 12) onto the pipe ends. For correct joining procedure, please refer to the section entitled, "Joining Methods – Solvent Cementing" in the IPEX Industrial Technical Manual Series, "Volume I: Vinyl Process Piping Systems".
Be sure to allow sufficient cure time before continuing with the valve installation.
 - b. For threaded style, thread the end connectors (7) onto the pipe ends. For correct joining procedure, please refer to the section entitled, "Joining Methods – Threading" in the IPEX Industrial Technical Manual Series, "Volume I: Vinyl Process Piping Systems".
3. Open and close the valve to ensure that the ball seat support (8) is at the desired adjustment. If adjustment is required, ensure that the valve is in the closed position then remove the handle (12 or 2) from the valve stem. Line up the moldings on the handle with the slots in the ball seat support. Tighten or loosen to the desired position then replace the handle on the valve stem.
4. Ensure that the valve is in the closed position, and that the socket o-rings (10) are properly fitted in their grooves. Carefully place the valve in the system between the two end connections.
5. Tighten the union nut on the side opposite to that which is marked "ADJUST". Hand tightening is typically sufficient to maintain a seal for the maximum working pressure. If additional tightening is required, the Easyfit multifunctional handle tool can be used to tighten the union nuts an additional 1/4 turn.
6. Tighten the union nut on the side marked "ADJUST". Tightening the union nuts in this order results in the best possible valve performance due to optimum positioning and sealing of the ball and seat support system.
Over-tightening may damage the threads on the valve body and/or the union nut and may even cause the union nut to crack. It is recommended to use the Easyfit handle to prevent damage.
7. Open and close the valve to again ensure that the cycling performance is adequate. If adjustment is required, place the valve in the closed position, loosen the union nuts, remove the valve from system and then continue from Step 3.



VXE Series Ball Valves

Submittal Data Sheet

Valve Maintenance

Disassembly

1. If removing the valve from an operating system, isolate the valve from the rest of the system. **Be sure to depressurize and drain the isolated branch and valve before continuing.**
2. Loosen both union nuts (13) and drop the valve out of the line. If retaining the socket o-rings (10), take care that they are not lost when removing the valve from the line.
 - a. For 1/2" to 2" remove the handle (12) and the transparent service plug (1a). Turn handle over, and seat on valve stem, ensuring the integrated gear teeth on the handle mesh with the union nut teeth. Turn clockwise to loosen.
 - b. For 2-1/2" to 6" remove handle (2). Remove the Easyfit multifunctional tool (1) from the bottom of the handle (2), turn it over and re-install it. Engage the tool (1) with the outer ring profile on the union nut (13) and loosen.
3. To disassemble, place the valve in the closed position and locate the ball seat support adjustment tool on the multifunctional handle. This is found on the bottom of 1/2" to 2" handles and on the top of 2-1/2" to 6" handles.
4. Line up the moldings on the handle with the slots in the ball seat support (found on the side marked "ADJUST"). Loosen and remove the ball seat support (8 or 11) by turning in a counterclockwise direction.
5. Carefully press the ball (5 or 6) out of the valve body, taking care not to score or damage the outer surface.
6. To remove the stem (3 or 4), remove the central hub (15) on 2-1/2" to 6" sizes, press the stem into the valve body (4 or 7) from above.
7. The stem o-rings (2 or 3), body o-ring (6 or 9), friction reducing bushing (16) and ball seats (9 or 5) can now be removed and/or replaced.

1/2" – 2" VXE Ball Valves



2-1/2" – 6" VXE Ball Valves



VXE Series Ball Valves

Submittal Data Sheet

Valve Maintenance

Assembly

NOTE: Before assembling the valve components, it is advisable to lubricate the o-rings with a water soluble lubricant. **Be sure to consult the "IPEX Chemical Resistance Guide" and/or other trusted resources to determine specific lubricant-rubber compatibilities.**

1. Firmly place the ball seat (9 or 5) in the groove on the opposite end inside the valve body (4 or 7).
2. Properly fit the stem o-rings (2 or 3) in the grooves on the stem (3 or 4) and the friction reducing bushing (16) onto the stem, then insert the stem from the inside of the valve body.
3. Ensure that the valve stem is in the closed position then insert the ball (5 or 6) into the valve body taking care not to score or damage the outer surface.
4. Check that the ball seat (9 or 5) and body o-ring (6 or 9) are properly fitted on the ball seat support (8 or 11), then slightly hand tighten into the valve body. Line up the moldings on the handle (12 or 2) with the slots in the ball seat support then tighten by turning in a clockwise direction.
5. Replace the handle on the valve stem then cycle the valve open and closed to determine whether or not the performance is adequate. If so desired, the handle can be removed and used to make further adjustments.
6. Properly fit the socket o-rings (10) in their respective grooves.
7. Place the end connectors (7 or 12) into the union nuts (13), then thread onto the valve body taking care that the socket o-rings remain properly fitted in their grooves.
 - a. For 1/2" to 2" remove the handle (2) and the transparent service plug (1a). Turn handle over and seat over stem ensuring the integrated gear teeth mesh with the union nut teeth. Turn counter-clockwise to tighten.
 - b. For 2-1/2" to 6" remove handle (12). Remove the Easyfit multifunctional tool (1) from the bottom of the handle (12), turn it over and re-install it. Engage the tool (1) with the outer ring profile on the union nut (13) and tighten.
8. Replace the handle on the valve stem then cycle the valve open and closed to determine whether or not the performance is adequate.



Testing & Operating

The purpose of system testing is to assess the quality of all joints and fittings to ensure that they will withstand the design working pressure, plus a safety margin, without loss of pressure or fluid. Typically, the system will be tested and assessed in sub-sections as this allows for improved isolation and remediation of potential problems. With this in mind, the testing of a specific installed valve is achieved while carrying out a test of the overall system.

An onsite pressure test procedure is outlined in the IPEX Industrial Technical Manual Series, "Volume I: Vinyl Process Piping Systems" under the section entitled "Testing". The use of this procedure should be sufficient to assess the quality of a valve installation. **In any test or operating condition, it is important to never exceed the pressure rating of the lowest rated appurtenance in the system.**

IMPORTANT POINTS:

- Never test thermoplastic piping systems with compressed air or other gases including air-over-water boosters.
- When testing, do not exceed the rated maximum operating pressure of the valve.
- Avoid the rapid closure of valves to eliminate the possibility of water hammer which may cause damage to the pipeline or the valve.

For safety reasons, please contact IPEX customer service and technical support when using volatile liquids such as hydrogen peroxide (H₂O₂) and sodium hypochlorite (NaClO). These liquids may vaporize causing a potentially dangerous pressure increase in the dead space between the ball and the valve body. Special VXE ball valves are available for these types of critical applications.

Please contact IPEX customer service and technical support with regard to any concern not addressed in this data sheet or the technical manual.

About the IPEX Group of Companies

As leading suppliers of thermoplastic piping systems, the IPEX Group of Companies provides our customers with some of the world's largest and most comprehensive product lines. All IPEX products are backed by more than 50 years of experience. With state-of-the-art manufacturing facilities and distribution centers across North America, we have established a reputation for product innovation, quality, end-user focus and performance.

Markets served by IPEX group products are:

- Electrical systems
- Telecommunications and utility piping systems
- Industrial process piping systems
- Municipal pressure and gravity piping systems
- Plumbing and mechanical piping systems
- Electrofusion systems for gas and water
- Industrial, plumbing and electrical cements
- Irrigation systems
- PVC, CPVC, PP, PVDF, PE, ABS, and PEX pipe and fittings

This literature is published in good faith and is believed to be reliable. However, it does not represent and/or warrant in any manner the information and suggestions contained in this brochure. Data presented is the result of laboratory tests and field experience.

A policy of ongoing product improvement is maintained. This may result in modifications of features and/or specifications without notice.