



MANUAL AND MAINTENANCE GUIDELINES



PNEUMATIC ACTUATOR

Type PT

Documentnr.: BWA.PT.210130.EN | Issued: January 2021

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Chapter 1: Preparation

Content:

- Marking of safety instructions
- Safety fundamentals
- Instructions for storage

1.1 Marking of safety instructions



This symbol indicates safety instructions which can cause personal injury if not respected.



This symbol indicates an important note.

1.2 Safety fundamentals



Failure to follow the safety basics can void the warranty claims.



Rotary actuators must be isolated both pneumatically and electrically before any intervention.

The installation, assembly, commissioning, maintenance and any other work on pneumatic actuators must be performed by qualified personnel.

This manual is part of the device and must be available for the operating personnel at all times. This manual must be read and understood before operation.

The device may only be operated in perfect condition. No safety devices are removed or deactivated. A rebuilding or modification of the device is strictly prohibited.

1.3 Transport, storage and packaging



Installation, operation and maintenance of the products are strictly subject to the local safety and accident prevention regulations!

The devices must be carefully handled, transported and stored.

The devices should be transported to the end destination in their original packaging and unpacked immediately before installation.

The actuators are to be stored in a clean, dry storage, which is neither exposed to excessive vibration nor to rapid temperature changes.

Prevent ingress of dirt or moisture into the actuator. Close or tighten both air connections.

Proper disposal of packaging is the customer's responsibility.



Failure to comply may void the warranty claims.

Chapter 2: Preliminary

Content:

- Design description
- Intended use
- Technical information
- Type code

2.1 Description

Actuators of the PT series are pneumatic double-piston rotary actuators. They are generally used in two different modes: single acting and double-acting.

Double piston principle means that two pistons create two pressure chambers. By inflating one of these chambers the pistons are moved into opposite directions either towards or away from each other. The resulting force is provided to the central actuator pinion via toothed racks which are connected with the pistons and so creates a constant torque over the entire pivoting angle.

The actuator series PT offer standardized interfaces for component assembly (VDI/VDE3845, NAMUR, ISO5211, DIN3337).

In the single acting type integrated springs ensure the closing or opening in the event of a failure of the control medium ("spring to close" or "spring to open").

2.2 Intended use

Actuators of the PT series are primarily used for the automation of quarter-turn valves such as ball valves, butterfly valves or plug valves, but can also be used for other applications. Contact our qualified personnel where required.

The specified operating and limiting values for temperature, pressure, control medium, etc. must be observed.

In operation of valves high kinetic energies may arise, which are transmitted to the actuator. Make sure that the drive is protected from damage by complying with the minimum travel times safely. Control speed can be reduced by the use of choke valves, which can be purchased through our sales department.

For valve types with high flywheel mass and low torque requirements the operating conditions of the drive must be coordinated with us in advance.

The actuator may only be used:

- in perfect condition
- as stipulated
- safety- and danger-conscious in consideration of the operating instructions
- if all safety devices are in place and functioning.

In particular faults which may affect safety are to be eliminated!



Any use not pre-approved by the manufacturer is considered improper!

2.3 Technical data

Construction principle	Pneumatic double-piston rotary actuator in rack&pinion-design with self-centering pistons; double- and single-acting execution	
Materials	Stainless steel 304 or 316	
Temperature range	Standard	-20°C to +80°C
	Tieftemperaturvariante	-40°C to +80°C
	Hochtemperaturvariante:	-10°C to +150°C
Control pressure	2 to 8 bar	
Pressure media	dry, filtered air or inert gases in respect of remaining oil-, dust and water-content according to DIN ISO 8573-1 / class 4, maximum particle diameter 30µm, dew point minimum 10°C below ambient temperature	
Nominal rotation angle	90° Adjustable in one end position +/-5° (optional 100% stroke adjustment)	
Torque range	double-acting: 6 ... 1069 Nm single-acting: 4 ... 542 Nm	
Standards	Interface actuator/control-unit:	VDI/VDE 3845 resp. NAMUR
	Interface actuator/control media supply:	VDI/VDE 3845 bzw. NAMUR
	Interface actuator/valve:	ISO 5211 und DIN 3337

Typcode

	PT	E	-	2A	-	085	/	090	.	11	.	F05/F07	-	V	17	-	F
Type																	
Function																	
D: double-acting E: single-acting																	
Stainless steel type																	
2A: V2A (1.4301) 4A: V4A (1.4404)																	
Size																	
Rotation angle																	
Rotation angle in degree																	
Spring set																	
ISO valve interface																	
Stem connection																	
V: Square acc.to ISO 5211 and DIN 3337																	
Stem connection dimensions																	
Dimension in mm																	
Mounting direction																	
E: transversal to pipe, spring direction CW F: parallel to pipe, spring direction CW G: transversal to pipe, spring direction CCW H: parallel to pipe, spring direction CCW																	

Chapter 3: Function

Content:

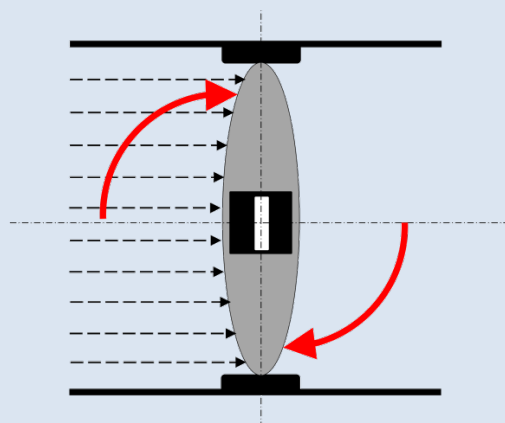
- Fundamentals
- Mounting versions (mounting direction/spring rotation sense)

3.1 Fundamentals

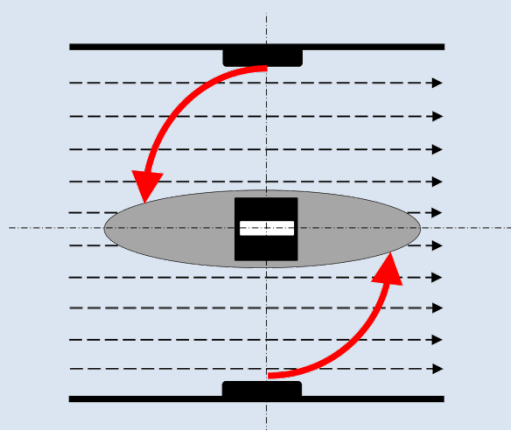
General rule is that valves are closed clockwise (CW) and opened counterclockwise (CCW).

The angle of view is to be understood as “from the top onto the valve shaft”. All statements in this manual are based on this rule and have to be taken into account accordingly.

Closing process clockwise (CW)



Opening process counter-clockwise (CCW)



3.2 Mounting versions

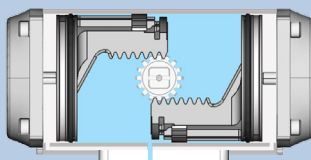
Depending on the orientation of the actuator to the pipeline (parallel or transverse) and the switching function (clockwise or counterclockwise), there are 4 resulting mounting versions which need to be differentiated.

Mounting version F

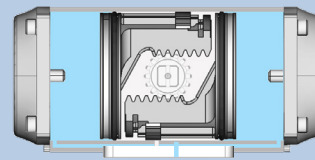
Actuator parallel to pipeline
Spring rotation sense clockwise (CW)
SPRING TO CLOSE

Double-acting

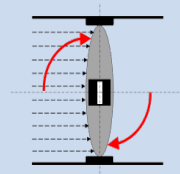
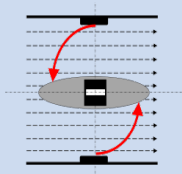
Port „A“ pressurized, actuator moves in switched position 90°, valve opens



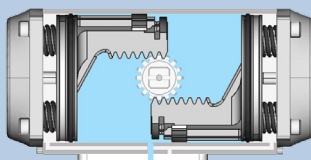
Port „B“ pressurized, actuator moves in initial position 0°, valve closes



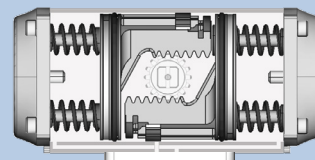
Valve position



Single-acting



Port „A“ pressurized, actuator moves in switched position 90°, valve opens



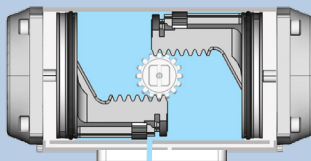
Port „A“ vented, actuator moves in initial position 0°, valve closes

Mounting version H

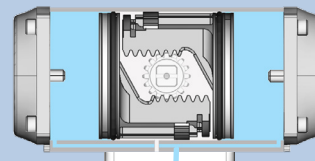
Actuator parallel to pipeline
Spring rotation sense counter-clockwise (CCW)
SPRING TO OPEN

Double-acting

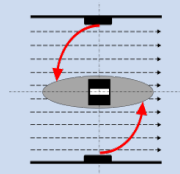
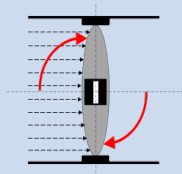
Port „A“ pressurized, actuator moves in switched position 90°, valve closes



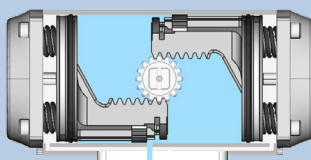
Port „B“ pressurized, actuator moves in initial position 0°, valve opens



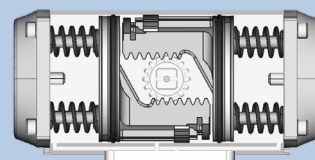
Valve position



Single-acting



Port „A“ pressurized, actuator moves in switched position 90°, valve closes



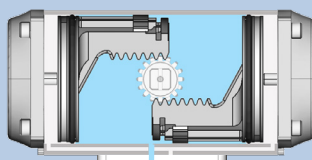
Port „A“ vented, actuator moves in initial position 0°, valve opens

Mounting version E

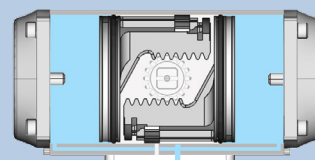
Actuator transversal to pipeline
Spring rotation sense clockwise (CW)
SPRING TO CLOSE

Double-acting

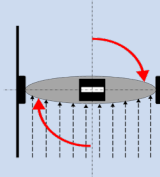
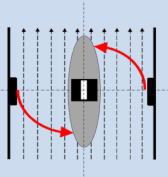
Port „A“ pressurized, actuator moves in switched position 90°, valve opens



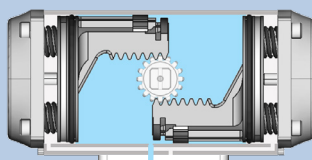
Port „B“ pressurized, actuator moves in initial position 0°, valve closes



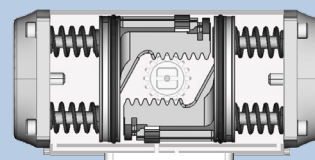
Valve position



Single-acting



Port „A“ pressurized, actuator moves in switched position 90°, valve opens



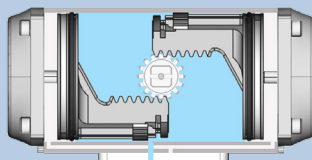
Port „AB“ vented, actuator moves in initial position 0°, valve closes

Mounting version G

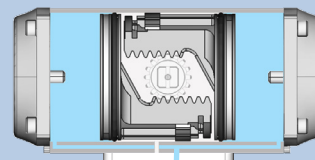
Actuator transversal to pipeline
Spring rotation sense counter-clockwise (CCW)
SPRING TO OPEN

Double-acting

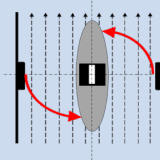
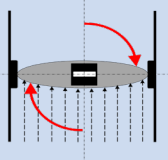
Port „A“ pressurized, actuator moves in switched position 90°, valve closes



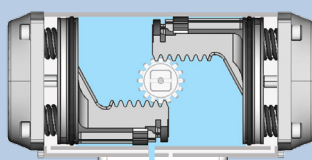
Port „B“ pressurized, actuator moves in initial position 0°, valve opens



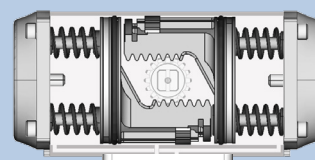
Valve position



Single-acting



Port „A“ pressurized, actuator moves in switched position 90°, valve closes



Port „A“ vented, actuator moves in initial position 0°, valve opens

4. Installation

Content:

- Attachment to a valve
- Pneumatic connection
- End stop and stroke adjustment

4.1 Attachment to a valve

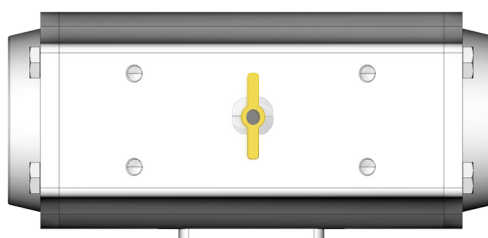
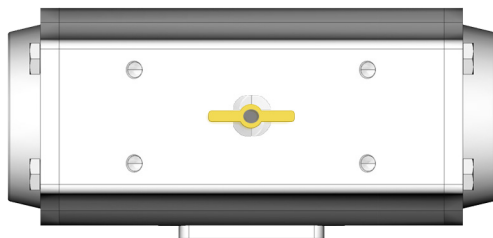


Perform any kind of installation work on rotary actuators exclusively when the device is fully vented!



Verify that the maximum actuator torque is below the maximum valve torque (MAST) to avoid further damage.

- During the installation of the actuator the tap hole (with ball and plug valves) respectively the disc (butterfly valves) must correspond with the groove at the top of the drive pinion in order to ensure the proper function of further adapted signal- or control units. The groove (according to VDI / VDE 3845) symbolically represents the valve position.



- After correct installation of the actuator to the valve ensure that the visual position indicator is also programmed correctly by adjusting the signal plates. These must correspond to the pinion groove and thus with the valve position.
- Make sure that the valve shaft corresponds to the terminal in the actuator pinion in terms of shape and dimension. For direct mounting possible differences can usually be compensated by the use of reduction inserts. These can be ordered via our sales department separately.
- Check whether valve and actuator have a corresponding adaption interface. If not, an additional mounting kit is required, which can be ordered via our sales department.
- Secure the drive with screws on the valve. We recommend using stainless steel screws to ensure a corresponding corrosion resistance. The number of screws is relevant for the stability of the mounting and power transmission. Therefore, don't leave any fixation point unused. Take into account the tightening torques in section 5.3 when fixing the screws.

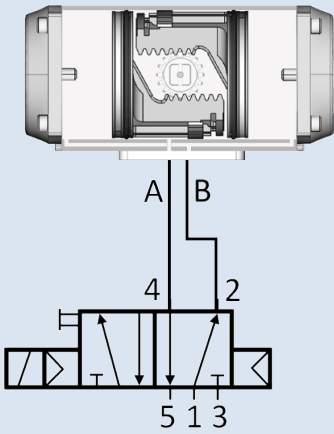
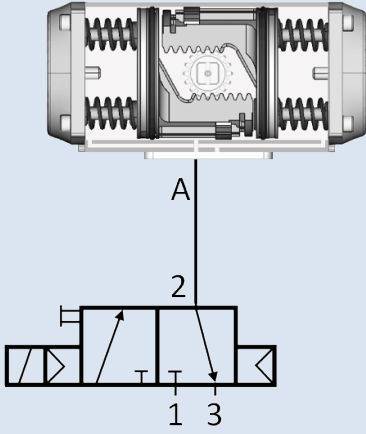
4.2 Pneumatic connection

Actuators of the PT series can either be controlled via a rigid or flexible tube system, with the control valve mounted apart from the actuator, or by a control valve that is directly mounted to the NAMUR interface according to VDI/VDE3845 in the body of the actuator.

By the design and mounting direction of the control valve security functions for the event of a power failure can be preset in double acting applications. For spring return actuators, the initial position is in principle understood as a safety position in case of power failure or failure of the control media.

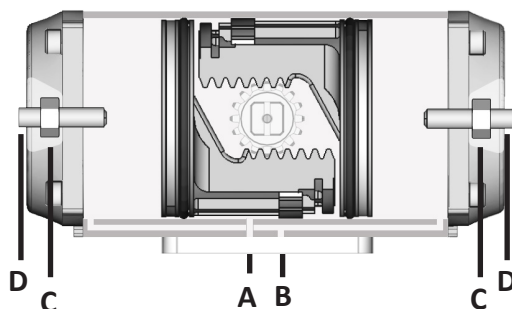
Single-acting actuators are factory wise equipped with a silencer in port "B". Prior to any installation of a directly mounted control valve that silencer is to be removed.

Pneumatic controls

Double-acting	Single-acting
	
<p>Control via 5/2-way valve Sample safety function: power-off in initial position</p>	<p>Control via 3/2-way valve</p>

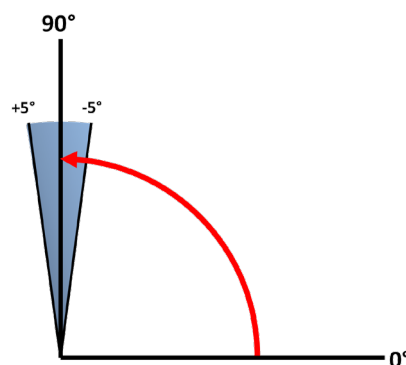
4.3 Stroke adjustment

All actuators of the PT series offer an adjustable switching position $\pm 5^\circ$, optionally even for the complete rotation range (i.e. 100%).



Rotary actuators must be isolated both pneumatically and electrically before any work is performed.

1. Rotate the actuator to its switched position by pressurizing port "A". Check the rotation angle and vent the actuator again
2. Loosen the lock nuts "C" and "D", set position by using adjustment screw "D" and tighten lock nut "C" again. Secure the drive pinion using a wrench on the pinion square, turn adjusting screw "D" so far, until you feel an increase in the resistance to rotation and tighten lock nut "C" again.
3. Pressurize port "A" and check the setting.
Repeat the setting if necessary.



The adjustment screws may be turned in only so far that the adjustment screws fully remain in the lock nut threads.

5. Maintenance

Content:

- General
- Safety instructions
- Tightening torques for screw connections
- Actuator components and spare parts
- Dismounting from a valve
- Disassembly / assembly of an actuator

5.1 General

Actuators of the PT series are designed for “no need of maintenance” during the normal lifecycle and are supplied with sufficient lubrication for their normal span of duty. The normal span of duty depends on the actuator size and is subject to EN 15714-3.

Perform periodic inspections to ensure trouble-free operation. Check whether visible or audible defects are present. Regular replacement of the seals and bearings in the actuator extend the normal span of duty. Appropriate spare parts kit can be ordered via our sales department.

5.2 Safety instructions

Rotary actuators must be isolated both pneumatically and electrically before any work is performed.

Actuators and the connected valve can move when the control pressure and/or an electrical control signal is removed.



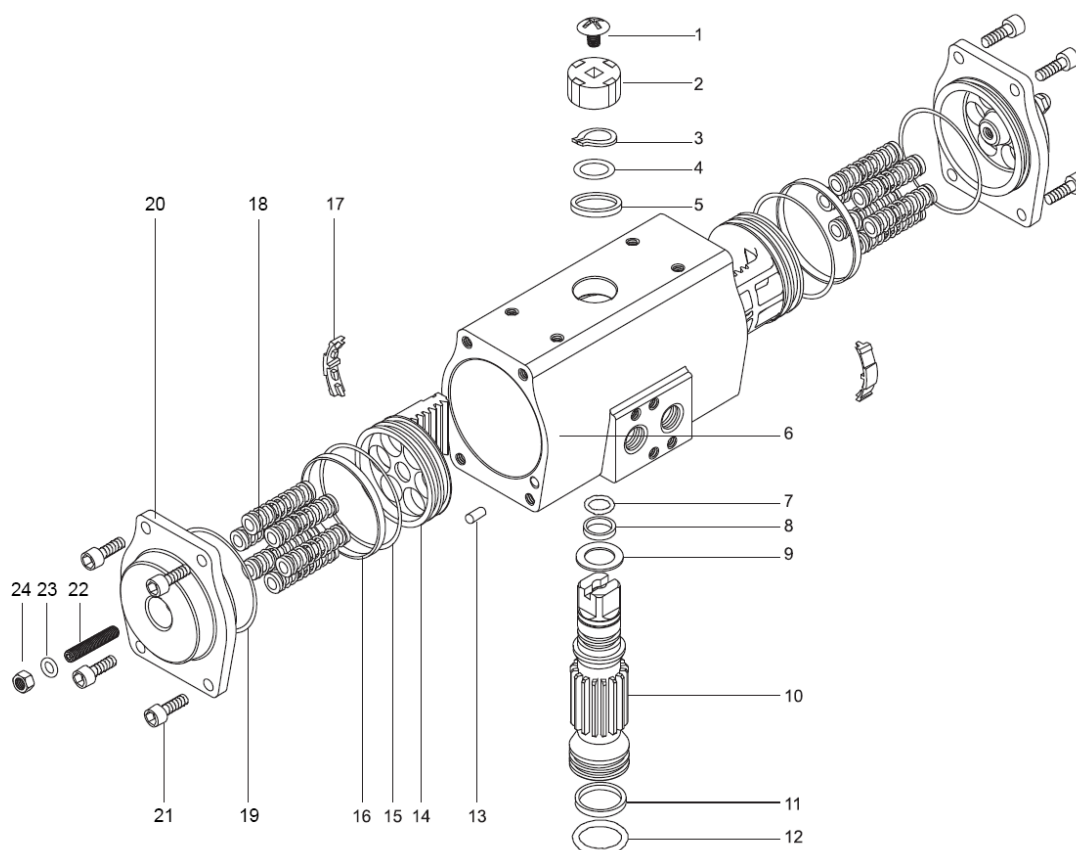
Single acting actuators with incomplete spring stroke contain a high spring force that can trigger a sudden rotation during dismounting of the actuator. This can cause serious injuries or property damage.

Work on electrical installations must be carried out exclusively by suitably qualified persons. A disabled supply must be protected against accidental reconnection.

5.3 Tightening torques for screw connections

Tightening torques in Nm		
Nominal size	min.	max.
M5	4,9	6
M6	8	10
M8	20	25
M10	40	49
M12	69	86
M16	170	210
M18	235	290
M20	330	410

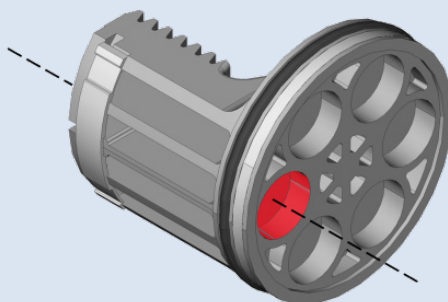
5.4 Components



Nr.	Bezeichnung	Menge
1	Screw visual indicator	1
2	Visual indicator	1
3	Circlip	1
4	Thrust washer	1
5	Outside washer	1
6	Body	1
7	Inside washer	1
8	O-ring (pinion top)	1
9	Bearing (pinion top)	1
10	Pinion	1
11	Bearing (pinion bottom)	1
12	O-ring (pinion bottom)	1

Nr.	Bezeichnung	Menge
13	Plug	2
14	Piston	2
15	O-ring (piston)	2
16	Guidance ring (piston)	2
17	Guidance segment	2
18	Safety spring	0-12
19	O-ring (end cap)	2
20	End cap	2
21	Cap screw	8
22	Stroke adjustment screw	2
23	O-ring (stroke adjustment screw)	2
24	Nut (stroke adjustment screw)	2

5.5 Arrangement of safety springs



The drive pistons are not symmetrical due to the attached racks. In order to ensure optimal flow of force and minimize internal wear, the springs must be installed according to the following installation schemes. Pay attention that in the following illustration the spring pocket, which is aligned with the piston, is highlighted with a point.

	Pistons left/right			Pistons left/right	
5 springs			6 springs		
7 springs			8 springs		
9 springs			10 springs		
11 springs			12 springs		

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