PPVS Infusion Vacuum Sensor Valve

Component Manual

This manual is applicable to the following models:

- 22458-2



MAGNUM VENUS PRODUCTS

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MAGNUM VENUS PRODUCTS

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Use of this product confirms that Magnum Venus Products, Inc.'s standard terms and conditions of sale apply.

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Safety & Warning Information

Warnings

Due to the vast number of chemicals that could be used and their varying chemical reactions, the buyer and user of this equipment should determine all factors relating to the fluids used, including any of the potential hazards involved. Particular inquiry and investigation should be made into potential dangers relating to toxic fumes, fires, explosions, reaction times, and exposure of human beings to the individual components or their resultant mixtures. MVP assumes no responsibility for loss, damage, expense or claims for bodily injury or property damage, direct or consequential, arising from the use of such chemical components.

The end user is responsible for ensuring that the end product or system complies with all the relevant laws in the country where it is to be used and that all documentation is adhered to.

Recommended Occupational Safety & Health Act (OSHA) Documentation:

- 1910.94 Pertaining to ventilation
- 1910.106 Pertaining to flammable liquids
- 1910.107 Pertaining to spray finishing operations, particularly paragraph (m), Organic Peroxides and Dual Component Coatings

For Additional information, contact the Occupational Safety and Health Administration (OSHA) at https://www.osha.gov/about.html.

Recommended National Fire Protection Association (NFPA) Documentation:

- NFPA No.33 Chapter 14 Organic Peroxides and Dual Component Materials
- NFPA No. 63 Dust Explosion Prevention
- NFPA No. 70 National Electrical Code
- NFPA No. 77 Static Electricity
- NFPA No. 91 Blower and Exhaust System
- NFPA No. 654 Plastics Industry Dust Hazards

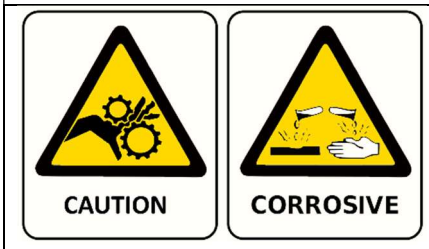
Fire Extinguisher – code ABC, rating number 4a60bc using Extinguishing Media –Foam, Carbon Dioxide, Dry Chemical, Water Fog, is recommended for this product and applications.

The following general warnings and guidelines are for the setup, use, grounding, maintenance, and repair of equipment. Additional product-specific warnings may be found throughout this manual as applicable. Please contact your nearest MVP Technical Service Representative if additional information is needed.

Safety Precautions
• Avoid skin contact and inhalation of all chemicals.
• Review Material Safety Data Sheet (MSDS) to promote the safe handling of chemicals in use.
• Restrict the use of all chemicals to designated areas with good ventilation.
• Chemicals are flammable and reactive.
• Noxious fumes released when combusted.
• Operate equipment in a ventilated environment only.
• Uncured liquid resins are highly flammable unless specifically labeled otherwise.
• Cured laminate, accumulations of overspray, and laminate sandings are highly combustible.
• Do not operate or move electrical equipment when flammable fumes are present.
• Ground all equipment.
• If a spark is seen or felt, immediately halt operation. Do not operate the equipment until the issue has been identified and repaired.
• Contaminated catalyst may cause fire or explosion.
• Containers may explode if exposed to fire / heat.
• Use and store chemicals away from heat, flames, and sparks.
• Do not smoke in work areas or near stored chemicals.
• Do not mix Methyl Ethyl Ketone Peroxide (MEKP) with materials other than polyethylene.
• Do not dilute MEKP.
• Keep food and drink away from work area.


Physical Hazards

- Never look directly into the spray gun fluid tip. Serious injury or death can result.
- Never aim the spray gun at or near another person. Serious injury or death can result.
- Chemical compounds can be severely irritating to the eyes and skin.
- Inhalation, ingestion, or injection may damage internal organs and lead to pulmonary disorders, cancers, lymphomas, and other diseases or health conditions.
- Other potential health effects include: irritation of the eyes and upper respiratory tract, headache, light-headedness, dizziness, confusion, drowsiness, nausea, vomiting, and occasionally abdominal pain.
- Eye contact: Immediately flush with water for at least 15 minutes and seek immediate medical attention.
- Skin Contact: Immediately wash with soap and water and seek immediate medical attention.
- Inhalation: Move the person to fresh air and seek immediate medical attention.
- Do not remove shields, covers, or safety features on equipment that is in use.
- Never place fingers, hands, or any body part near or directly in front of the spray gun fluid tip. The force of the liquid as it exits the spray tip can shoot liquid through the skin.
- Keep hands and body parts away from any moving equipment or components.
- Do not stand under plunger
- An improperly loaded drum may lead to an imbalance, causing a unit to tip over



Personal Protective Equipment (PPE)

- MVP recommends the use of personal safety equipment with all products in our catalog.
- Wear safety goggles, hearing protection, a respirator, and chemical resistant gloves.
- Wear long sleeve shirts or jackets and pants to minimize skin exposure.
- PPE should be worn by operators and service technicians to reduce the risk of injury.



For Additional information, contact the Occupational Safety and Health Administration (OSHA). https://www.osha.gov/about.html

Symbol Definitions



Indicates the risk of contact with chemicals that are hazardous, which may lead to injury or death.



Indicates the risk of contact with voltage / amperage that may lead to serious injury or death



Indicates that the materials being used are susceptible to combustion



Indicates the risk of contact with moving components that may lead to serious injury or death.



Indicates that the system or component should be grounded before proceeding with use or repair.



Indicates the use of lit cigarettes or cigars is prohibited, because the materials being used are susceptible to combustion.



Indicates that the materials and/or the process being performed can lead to ignition and explosion.



A recommendation for the use of Personal Protective Equipment (PPE) before using or repairing the product.

Polymer Matrix Materials: Advanced Composites

Potential health hazards associated with the use of advanced composites can be controlled through the implementation of an effective industrial hygiene and safety program.

https://www.osha.gov/dts/osta/otm/otm_iii/otm_iii_1.html#t iii:1_1

Resins		
Composite Component	**Organ System Target (Possible Target)**	**Known (Possible) Health Effect**
Epoxy resins	Skin, lungs, eyes	Contact and allergic dermatitis, conjunctivitis
Polyurethane resins	Lungs, skin, eyes	Respiratory sensitization, contact dermatitis, conjunctivitis
Phenol formaldehyde	Skin, lungs, eyes	As above (potential carcinogen)
Bismaleimides (BMI)	Skin, lungs, eyes	As above (potential carcinogen)
Polyamides	Skin, lungs, eyes	As above (potential carcinogen)
Reinforcing materials		
Composite Component	**Organ System Target (Possible Target)**	**Known (Possible) Health Effect**
Aramid fibers	Skin (lungs)	Skin and respiratory irritation, contact dermatitis (chronic interstitial lung disease)
Carbon/graphite fibers	Skin (lungs)	As noted for aramid fibers
Glass fibers (continuous filament)	Skin (lungs)	As noted for aramid fibers
Hardeners and curing agents		
Composite Component	**Organ System Target (Possible Target)**	**Known (Possible) Health Effect**
Diaminodiphenylsulfone	N/A	No known effects with workplace exposure
Methylenedianiline	Liver, skin	Hepatotoxicity, suspect human carcinogen
Other aromatic amines		
Composite Component	**Organ System Target (Possible Target)**	**Known (Possible) Health Effect**
Meta-phenylenediamine (MPDA)	Liver, skin (kidney, bladder)	Hepatitis, contact dermatitis (kidney and bladder cancer)
Aliphatic andcyclo-aliphatic amines	Eyes, skin	Severe irritation, contact dermatitis
Polyaminoamide	Eyes, skin	Irritation (sensitization)
Anhydride	Eyes, lungs, skin	Severe eye and skin irritation, respiratory sensitization, contact dermatitis

Catalyst - Methyl Ethyl Ketone Peroxide (MEKP)

MEKP is among the more hazardous materials found in commercial channels. The safe handling of the "unstable (reactive)" chemicals presents a definite challenge to the plastics industry. The highly reactive property which makes MEKP valuable to the plastics industry in producing the curing reaction of polyester resins also produces the hazards which require great care and caution in its storage, transportation, handling, processing and disposal. MEKP is a single chemical. Various polymeric forms may exist which are more or less hazardous with respect to each other. These differences may arise not only from different molecular structures (all are, nevertheless, called "MEKP") and from possible trace impurities left from the manufacture of the chemicals, but may also arise by contamination of MEKP with other materials in its storage or use. Even a small amount of contamination with acetone, for instance, may produce an extremely shock-sensitive and explosive compound.



WARNING

Contamination with promoters, materials containing promoters (such as laminate sandings), or with any readily oxidizing material (such as brass or iron) will cause exothermic redox reactions which can be explosive in nature. Heat applied to MEKP or heat buildup from contamination reactions can cause the material to reach its Self-Accelerating Decomposition Temperature (SADT).

Researchers have reported measuring pressure rates-of-rise well over 100,000 psi per second when certain MEKP's reach their SADT. For comparison, the highest-pressure rate-of-rise listed in NFPA Bulletin NO.68, "Explosion Venting", is 12,000 psi per second for an explosion of 12% acetylene and air. The maximum value listed for a hydrogen explosion is 10,000 psi per second. Some forms of MEKP, if allowed to reach their SADT, will burst even an open topped container. This suggests that it is not possible to design a relief valve to vent this order of magnitude of pressure rate-of-rise. The user should be aware that any closed container, be it a pressure vessel, surge chamber, or pressure accumulator, could explode under certain conditions. There is no engineering substitute for care by the user in handling organic peroxide catalysts. If, at any time, the pressure relieve valve on top of the catalyst tank should vent, the area should be evacuated at once and the fire department called. The venting could be the first indication of a heat, and therefore, pressure build-up that could eventually lead to an explosion. Moreover, if a catalyst tank is sufficiently full when the pressure relief valve vents, some catalyst may spray out, which could cause eye injury. For this reason, and many others, anyone whose job puts them in an area where this vented spray might go, should always wear full eye protection even when laminating operations are not taking place.

Safety in handling MEKP depends to a great extent on employee education, proper safety instructions, and safe use of the chemicals and equipment. Workers should be thoroughly informed of the hazards that may result from improper handling of MEKP, especially regarding contamination, heat, friction and impact. They should be thoroughly instructed regarding the proper action to be taken in the storage, use, and disposal of MEKP and other hazardous materials used in the laminating operation. In addition, users should make every effort to:

- Store MEKP in a cool, dry place in original containers away from direct sunlight and away from other chemicals.
- Keep MEKP away from heat, sparks, and open flames.
- Prevent contamination or MEKP with other materials, including polyester over spray and sandings, polymerization accelerators and promoters, brass, aluminum, and non-stainless steels.

- Never add MEKP to anything that is hot, since explosive decomposition may result.
- Avoid contact with skin, eyes, and clothing. Protective equipment should be worn at all times. During clean-up of spilled MEKP, personal safety equipment, gloves, and eye protection must be worn. Firefighting equipment should be at hand and ready.
- Avoid spillage, which can heat up to the point of self-ignition.
- Repair any leaks discovered in the catalyst system immediately, and clean-up the leaked catalyst at once in accordance with the catalyst manufacturer's instructions.
- Use only original equipment or equivalent parts from Magnum Venus Products in the catalyst system (i.e.: hoses, fitting, etc.) because a dangerous chemical reaction may result between substituted parts and MEKP.
- Catalyst accumulated from the purging of hoses or the measurement of fluid output deliveries should never be returned to the supply tank, such catalyst should be diluted with copious quantities of clean water and disposed of in accordance with the catalyst manufacturer's instructions.

The extent to which the user is successful in accomplishing these ends and any additional recommendations by the catalyst manufacturer determines largely the safety that will be present in his operation.

Clean-Up Solvents and Resin Diluents



WARNING

A hazardous situation may be present in your pressurized fluid system! Hydro carbon solvents can cause an explosion when used with aluminum or galvanized components in a closed (pressurized) fluid system (pump, heaters, filters, valves, spray guns, tanks, etc.). An explosion could cause serious injury, death, and/or substantial property damage. Cleaning agents, coatings, paints, etc. may contain Halogenated Hyrdrocarbon solvents. Some Magnum Venus Products spray equipment includes aluminum or galvanized components and will be affected by Halogenated Hydrocarbon solvents.

There are three key elements to the Halogenated Hyrdocarbon (HHC) solvent hazard.

1.	The presence of HHC solvents.	1,1,1 – Trichloroethane and Methylene Chloride are the most common of these solvents. However, other HHC solvents are suspect if used; either as part of paint or adhesives formulation, or for clean-up flushing.
2.	Aluminum or Galvanized Parts.	Most handling equipment contains these elements. In contact with these metals, HHC solvents could generate a corrosive reaction of a catalytic nature.
3.	Equipment capable of withstanding pressure.	When HHC solvent contact aluminum or galvanized parts inside a closed container such as a pump, spray gun, or fluid handling system, the chemical reaction can, over time, result in a build-up of heat and pressure, which can reach explosive proportions. When all three elements are present, the result can be an extremely violent explosion. The reaction can be sustained with very little aluminum or galvanized metal; any amount of aluminum is too much.

- The reaction is unpredictable. Prior use of an HHC solvent without incident (corrosion or explosion) does NOT mean that such use is safe. These solvents can be dangerous alone (as a clean-up or flushing agent) or when used as a component or a coating material. There is no known inhibitor that is effective under all circumstances. Mixing HHC solvents with other materials or solvents such as MEKP, alcohol, or toluene may render the inhibitors ineffective.
- The use of reclaimed solvents is particularly hazardous. Reclaimers may not add any inhibitors. The possible presence of water in reclaimed solvents could also feed the reaction.
- Anodized or other oxide coatings cannot be relied upon to prevent the explosive reaction. Such coatings can be worn, cracked, scratched, or too thin to prevent contact. There is no known way to make oxide coatings or to employ aluminum alloys to safely prevent the chemical reaction under all circumstances.
- Several solvent suppliers have recently begun promoting HHC solvents for use in coating systems. The increasing use of HHC solvents is increasing the risk. Because of their exemption from many state implementation plans as Volatile Organic Compounds (VOCs), their low flammability hazard, and their not being classified as toxic or carcinogenic substances, HHC solvents are very desirable in many respects.



WARNING

Do not use Halogenated Hydrocarbon (HHC) solvents in pressurized fluid systems having aluminum or galvanized wetted parts.
Magnum Venus Products is aware of NO stabilizers available to prevent HHC solvents from reaction under all conditions with aluminum components in closed fluid systems. HHC solvents are dangerous when used with aluminum components in a closed fluid system.

- Consult your material supplier to determine whether your solvent or coating contains Halogenated Hydrocarbon solvents.
- Magnum Venus Products recommends that you contact your solvent supplier regarding the best non-flammable clean-up solvent with the heat toxicity for your application.
- If, however, you find it necessary to use flammable solvents, they must be kept in approved, electrically grounded containers.
- Bulk solvent should be stored in a well-ventilated, separate building, 50 feet away from your main plant.
- You should only allow enough solvent for one day's use in your laminating area.
- NO SMOKING signs must be posted and observed in all areas of storage or where solvents and other flammable materials are used.
- Adequate ventilation (as covered in OSHA Section 1910.94 and NFPA No.91) is important wherever solvents are stored or used, to minimize, confine and exhaust the solvent vapors.
- Solvents should be handled in accordance with OSHA Section 1910.106 and 1910.107.

Catalyst Diluents

Magnum Venus Products spray-up and gel-coat systems currently produced are designed so that catalyst diluents are not required. Magnum Venus Products therefore recommends that diluents not be used to avoid possible contamination which could lead to an explosion due to the handling and mixing of MEKP and diluents. In addition, it eliminates any problems from the diluent being contaminated through rust particles in drums, poor quality control on the part of the diluents suppliers, or any other reason. If diluents are absolutely required, contact your catalyst supplier and follow his instructions explicitly. Preferably the supplier should premix the catalyst to prevent possible "on the job" contamination while mixing.



WARNING

If diluents are not used, remember that catalyst spillage and gun, hose, and packing leaks are potentially more hazardous since each drop contains a higher concentration of catalyst and will therefore react more quickly with overspray and the leak.

Cured Laminate, Overspray and Laminate Sandings Accumulation

- Remove all accumulations of overspray, Fiberglass Reinforced Plastic (FRP) sandings, etc. from the building as they occur. If this waste is allowed to build up, spillage of catalyst is more likely to start a fire; in addition, the fire would burn hotter and longer.
- Floor coverings, if used, should be non-combustible.
- Spilled or leaked catalyst may cause a fire if it comes in contact with an FRP product, over-sprayed chop or resin, FRP sandings or any other material with MEKP.

To prevent spillage and leakage, you should:

1.	Maintain your Magnum Venus Products System.	Check the gun several times daily for catalyst and resin packing or valve leaks. REPAIR ALL LEAKS IMMEDIATELY.
2.	Never leave the gun hanging over or lying inside the mold.	A catalyst leak in this situation would certainly damage the part, possibly the mold, and may cause a fire.
3.	Inspect resin and catalyst hoses daily for wear or stress at the entry and exits of the boom sections and at the hose and fittings.	Replace if wear or weakness is evident or suspected.
4.	Arrange the hoses and fiberglass roving guides so that the fiberglass strands DO NOT rub against any of the hoses at any point.	If allowed to rub, the hose will be cut through, causing a hazardous leakage of material which could increase the danger of fire. Also, the material may spew onto personnel in the area.

Toxicity of Chemicals

- Magnum Venus Products recommends that you consult OSHA Sections 1910.94, 1910.106, 1910.107 and NFPA No.33, Chapter 14, and NFPA No.91.
- Contact your chemical supplier(s) and determine the toxicity of the various chemicals used as well as the best methods to prevent injury, irritation and danger to personnel.
- Also determine the best methods of first aid treatment for each chemical used in your plant.

Equipment Safety

Magnum Venus Products suggest that personal safety equipment such as EYE GOGGLES, GLOVES, EAR PROTECTION, and RESPIRATORS be worn when servicing or operating this equipment. Ear protection should be worn when operating a fiberglass chopper to protect against hearing loss since noise levels can be as high as 116 dB (decibels). This equipment should only be operated or serviced by technically trained personnel!



CAUTION

Never place fingers, hands, or any body part near or directly in front of the spray gun fluid tip. The force of the liquid as it exits the spray tip can cause serious injury by shooting liquid through the skin. NEVER LOOK DIRECTLY INTO THE GUN SPRAY TIP OR POINT THE GUN AT OR NEAR ANOTHER PERSON OR AN ANIMAL.



DANGER

Contaminated catalyst may cause fire or explosion. Before working on the catalyst pump or catalyst accumulator, wash hands and tools thoroughly. Be sure work area is free from dirt, grease, or resin. Clean catalyst system components with clean water daily.



DANGER

Eye, skin, and respiration hazard. The catalyst MEKP may cause blindness, skin irritation, or breathing difficulty. Keep hands away from face. Keep food and drink away from work area.

Treatment of Chemical Injuries



CAUTION

Refer to your catalyst manufacturer's safety information regarding the safe handling and storage of catalyst. Wear appropriate safety equipment as recommended.

Great care should be used in handling the chemicals (resins, catalyst and solvents) used in polyester systems. Such chemicals should be treated as if they hurt your skin and eyes and as if they are poison to your body. For this reason, Magnum Venus Products recommends the use of protective clothing and eye wear in using polyester systems. However, users should be prepared in the event of such an injury.

Precautions include:

1. Know precisely what chemicals you are using and obtain information from your chemical supplier on what to do in the event the chemical gets onto your skin or into the eyes, or if swallowed.
2. Keep this information together and easily available so that it may be used by those administering first aid or treating the injured person.
3. Be sure the information from your chemical supplier includes instructions on how to treat any toxic effects the chemicals have.



WARNING

Contact your doctor immediately in the event of an injury. If the product's MSDS includes first aid instructions, administer first aid immediately after contacting a doctor.

Fast treatment of the outer skin and eyes that contact chemicals generally includes immediate and thorough washing of the exposed skin and immediate and continuous flushing of the eyes with lots of clean water for at least 15 minutes or more. These general instructions of first aid treatment may be incorrect for some chemicals; you must know the chemicals and treatment before an accident occurs. Treatment for swallowing a chemical frequently depends upon the nature of the chemical.

Emergency Stop Procedure

In an emergency, follow these steps to stop a system:

1. The ball valve located where the air enters the power head of the resin pump, should be moved to the "OFF" or closed position.

Note ***The "open" or "on" position is when the ball valve handle is parallel (in line) with the ball valve body. The "closed" or "off" position is when the ball valve handle is perpendicular (across) the ball valve body.***

2. Turn all system regulators to the "OFF" position (counter-clockwise) position.
3. Verify / secure the catalyst relief line, located on the catalyst relief valve.
4. Verify / secure the resin return line, located on the resin filter.
5. Place a container under the resin pump ball valve to catch ejected resin.
6. Locate the ball valve on the resin pump.
7. Rotate the ball valve 90 degrees to the "On" or open position.

Grounding

Grounding an object means providing an adequate path for the flow of the electrical charge from the object to the ground. An adequate path is one that permits charge to flow from the object fast enough that it will not accumulate to the extent that a spark can be formed. It is not possible to define exactly what will be an adequate path under all conditions since it depends on many variables. In any event, the grounding means should have the lowest possible electrical resistance.

Grounding straps should be installed on all loose conductive objects in the spraying area. This includes material containers and equipment. Magnum Venus Products recommends grounding straps be made of AWG No.18 stranded wire as a minimum and the larger wire be used where possible. NFPA Bulletin No77 states that the electrical resistance of such a leakage path should be 1 meg ohm (10^6 ohms) or less.



CAUTION

Whenever flammable or combustible liquids are transferred from one container to another, or from one container to the equipment, both containers or container and equipment shall be effectively bonded and grounded to dissipate static electricity. For further information, see National Fire Protection Association (NFPA) 77, titled "Recommended Practice on Static Electrical". Refer especially to section 7-7 titled "Spray Application of Flammable and Combustible Materials".

Introduction

This manual provides information for the operation, maintenance, and simple repair of the MVP PPVS Infusion Vacuum Sensor Valve (PPVS-INF). The PPVS-INF is a control valve to provide a positive signal to a Turbo Autosprue (TAS) or IVX3 Injection Valve to open and close, depending on the pressure sensed under an infusion film/vacuum membrane. The PPVS-INF fits into the MVP universal insert port.

In operation the PPVS-INF provides a positive signal when the mold cavity vacuum injection pressures are below the set point pressure. This signal keeps the IVX3 or TAS open. When the injection pressure reaches the set point, the PPVS stops sending an air signal and closes the connected valve to stop the injection resin flow. This control mode continues until the mold is full.

The pressure set point of the PPVS is always set below atmospheric pressure to ensure the injecting resin never increases in sufficient pressure to force the infusion film away from the fiber pack. It is normally factory set at 300 – 400 mb absolute.

Note ***We recommend using the PPVS-INF with only 60-70% of full vacuum to start. Once the resin has passed under the PPVS nose, the vacuum level can be increased to full vacuum. This will reduce the possibility of resin being pulled up into the nose.***

The following procedures are included in this manual:

- Installation instructions
- Step-by-step operation instructions



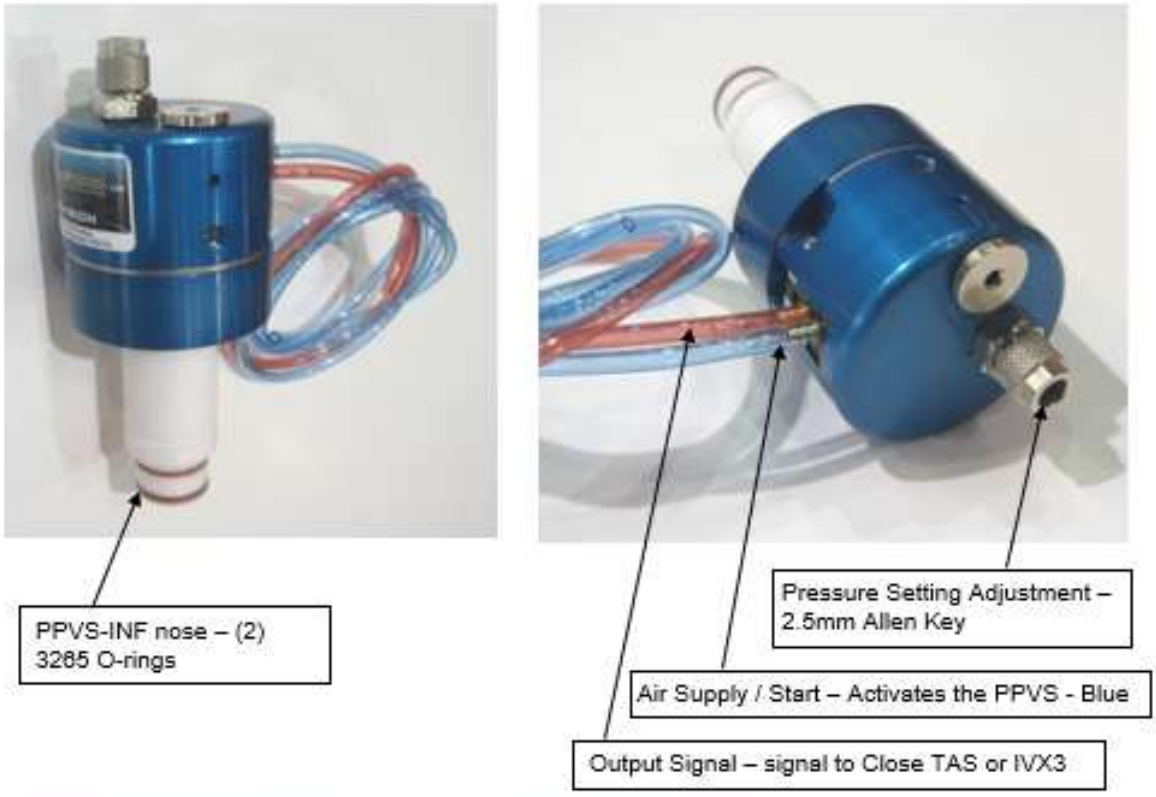
Please read this manual carefully and retain for future reference. Follow the steps in the order given, otherwise you may damage the equipment or injure yourself.

As you disassemble the equipment, lay out the components in the correct order and direction to assist with reassembly. Have the current component drawing available for reference to assist in identifying the correct parts.

Use red grease or Magnum Gun Lube to lubricate the O-rings on the valve nose when reassembling.

Unit Overview

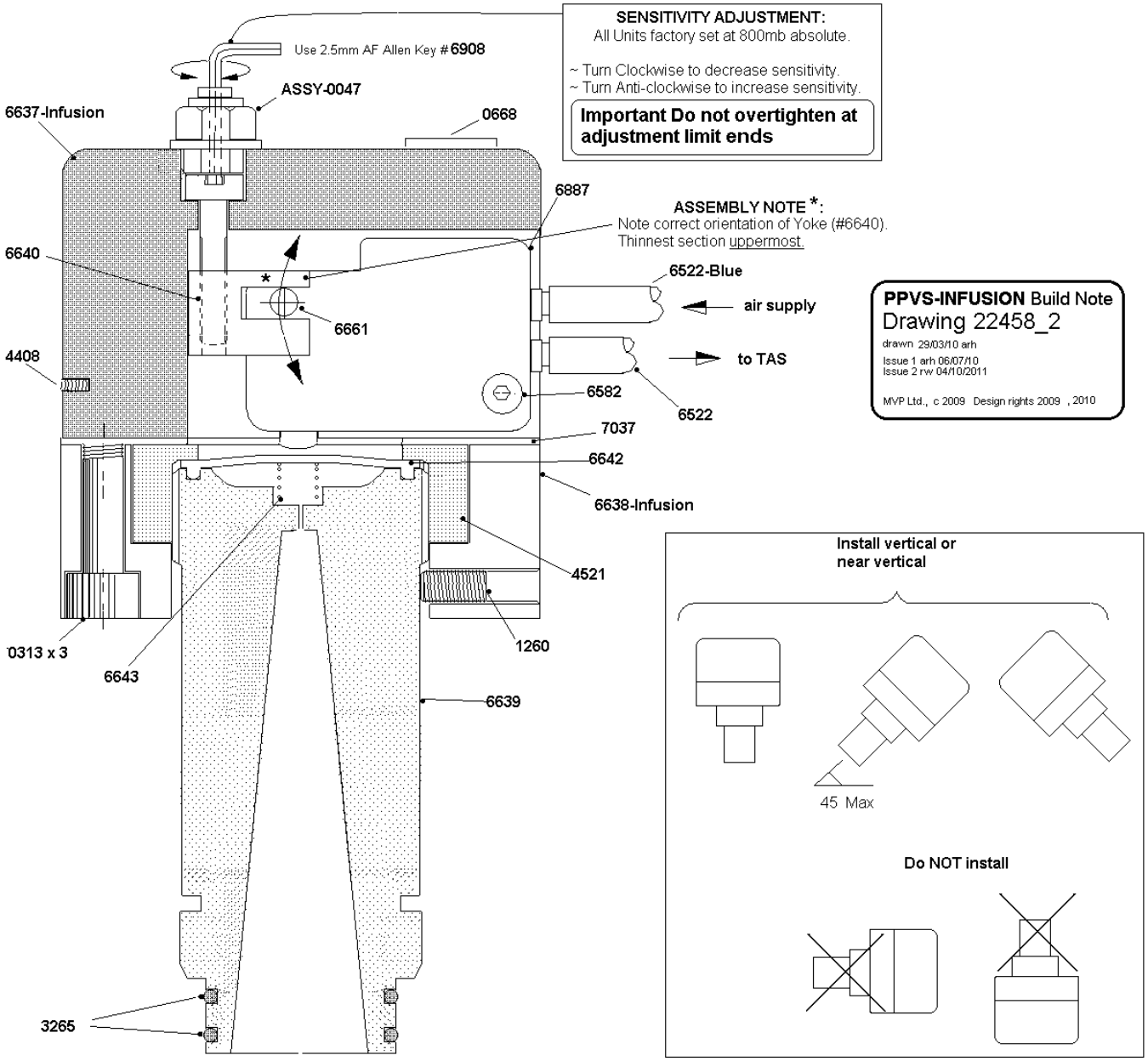
Below helps identify the main components the operator needs to know for proper operation.





Complete Kit – with connection for the Innovator and Innovator II

Unit Overview, continued



Mode Overview

OFF Mode – No air supplied to the Start/Air Supply port of the valve. The valve is inactive

On / **Start** Mode – When air is supplied to this Start/Air Supply port (blue line) the valve becomes active. When the vacuum level is reached the valve will send an air signal to open the connected valve to allow material flow.

When the vacuum level decreases (nears zero or positive), the valve becomes inactive; closing the connected valve and stopping material flow.

Positioning in Mold

CAUTION

Use an air supply of <u>at most</u> 90 psi (6 bar) of the PPVS-INF will be damaged.

CAUTION

Too much silicon grease will prevent the PPVS-INF being pushed far enough into the universal insert to the lock position due to hydraulic effect between the O-ring seals. If it is obvious that the unit will not fully insert, remove and clean off excess grease from the O-ring, the PTFE nose section, and the mold universal insert before re-inserting.

CAUTION

This valve is being placed in a possible resin pressure zone of the production mold, which under certain circumstances could result in the PPVS-INF being forced up and out of the insert if not locked in.

Position the PPVS-INF upright at no more than a 45 degree angle from vertical and 3 inches (80 mm) from the injection point (IVX3 or TAS). When arranging the infusion film or building a reusable film, situate the universal insert for the PPVS-INF and the IVX3 or TAS and laminate in as recommended. Failure to follow this recommendation will result in either a too sensitive signal response or too little response signal from the PPVS-INF. Too little signal could result in over-pressurization and pressure inflation of the film.

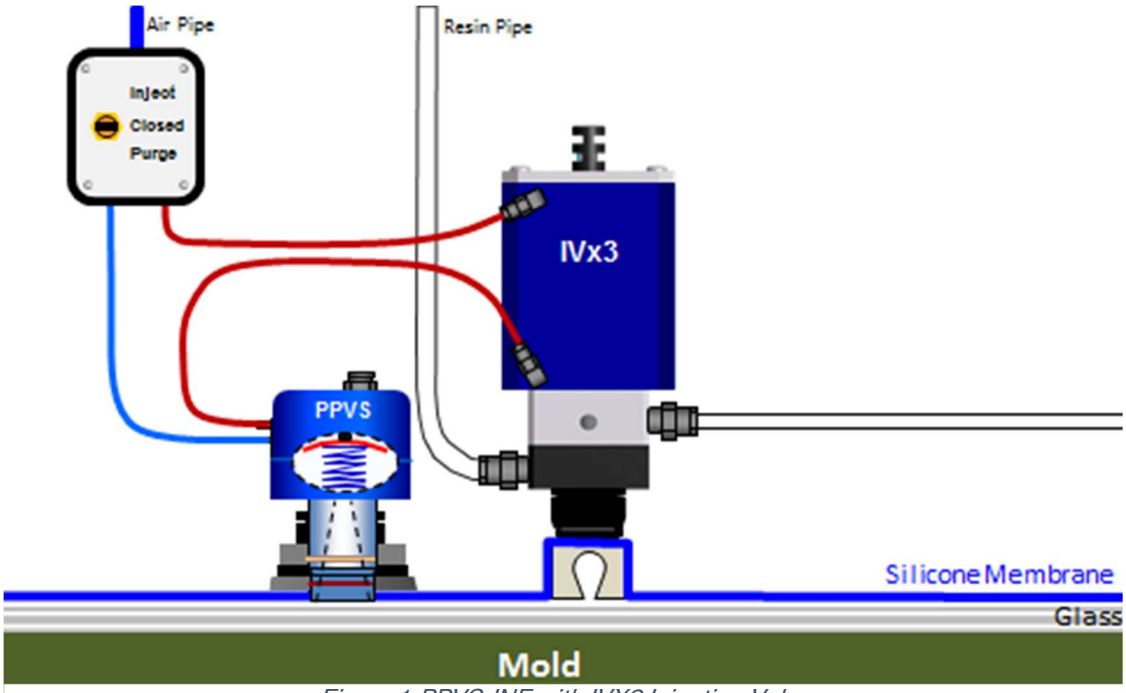


Figure 1. PPVS-INF with IVX3 Injection Valve

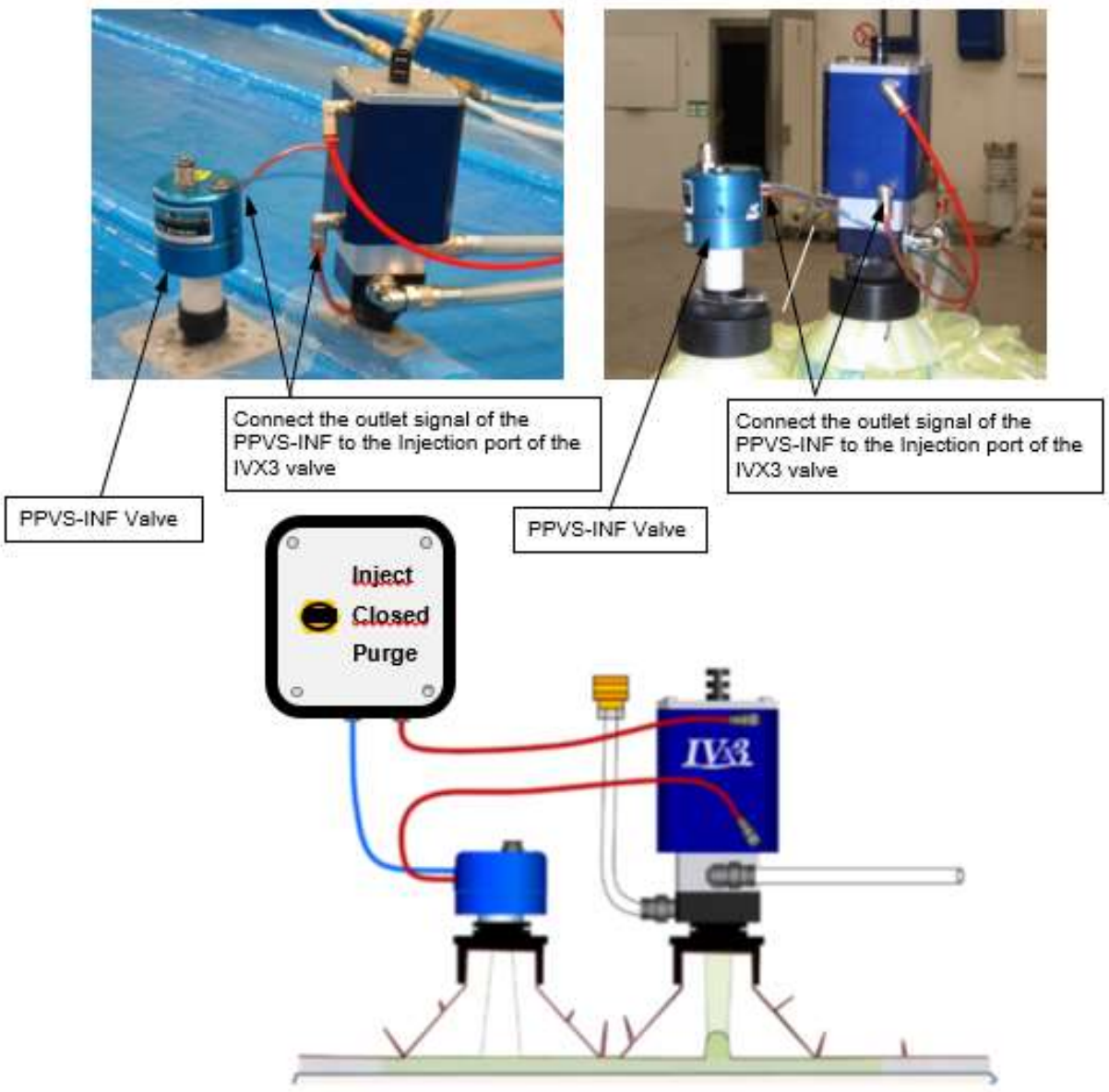
Connecting Valve

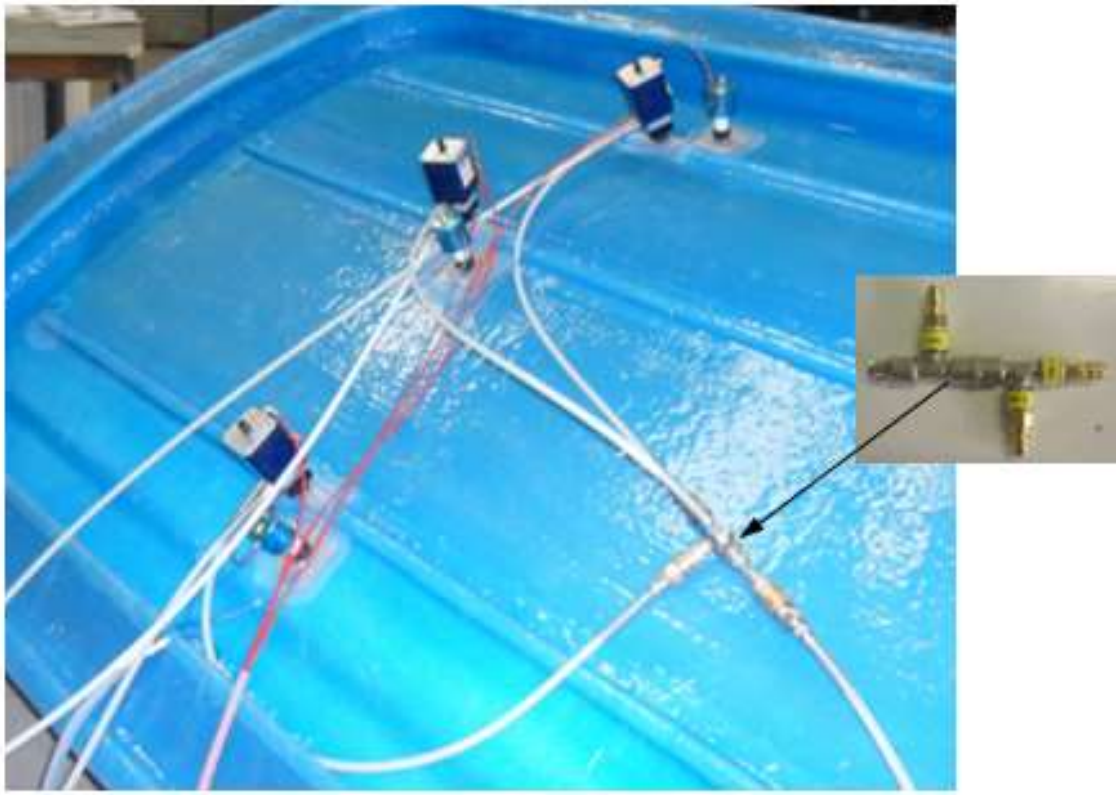
With IVX3

Connecting the PPVS-INF to the IVX3 injection valve will allow for automatic open/close control of the IVX3 based on the vacuum level.

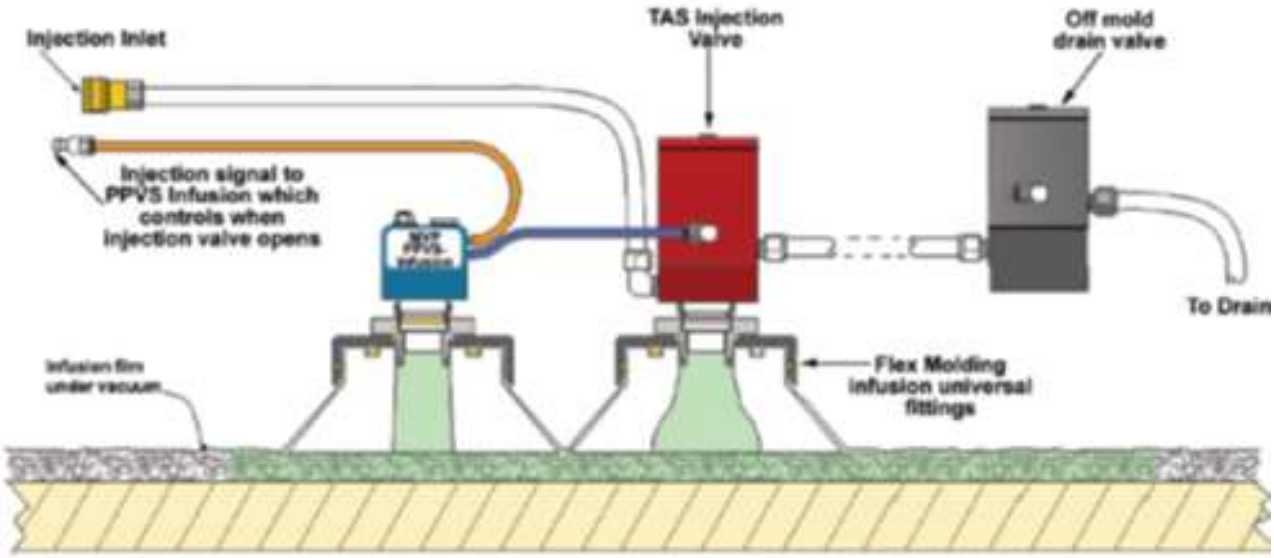
1. Connect the output signal of the PPVS-INF to the inject signal port on the IVX3 valve.
2. Connect the resin supply inlet and outlet the same way.
3. Connect the purge signal port to a purge valve or flush signal.

Note ***The PPVS-INF should be positioned 3 inches (80 mm) from the valve as noted in the Positioning in Mold section.***





Multiple PPVS-INF Valves with Multiple IVx3 Injection Valves and ASSY-0464 3way Resin Manifold



Innovator using PPVS-INF Valve with TAS and Pinch/Drain Valve

To Innovator II Control Box

1. Use the fitting provided and connect the blue PPVS-INF supply line to the indicated port on the control box
2. Connect the red PPVS-INF supply line to the indicated port.

Note ***Connecting to the Innovator II control box will allow the PPVS-INF to activate the control box to turn on and off the injection head as the pressure changes in the mold.***

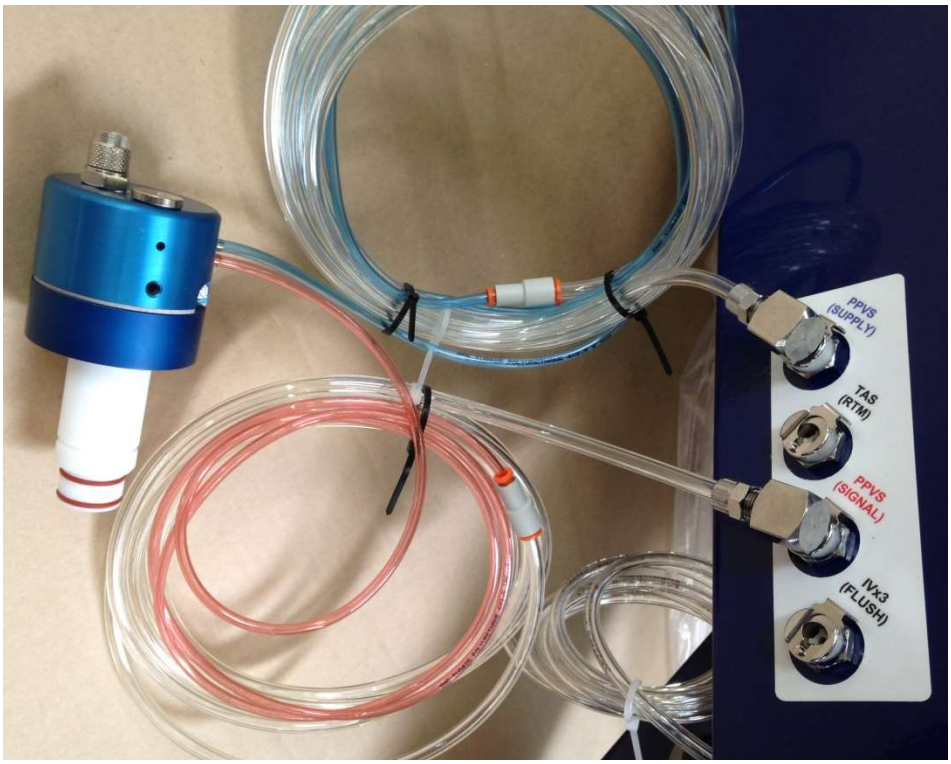


Figure 2. PPVS-INF to Innovator II Control Box

Operating Unit

Note ***Limit air pressure to the 90 psi (6 bar) or the PPVS can be damaged.***

Note ***Apply a release agent to the internal bore of the valve (inside the nose) when the valve is actuated in the inject position (shaft up-most) to prevent the seal sticking.***

Operating Using PPVS-INF and IVX3

1. Put the IVX3 valve in OFF mode (closed).
2. Set the mold pressure guard (MPG) pressure and pump pressure.

CAUTION

Do not exceed the pressure rating of the injection hose for the MPG or pump pressure. Note the ratio of the pump powerhead to fluid section in this calculation.

3. Put the IVX3 in purge mode.
4. Start the machine and wait for the resin to begin to flow into the supply line.
5. Prime the valve so that resin flows into the flush line.
6. Put the IVX3 back into OFF mode (closed).
7. Reset the counter before injecting into the mold to ensure an accurate count.
8. When you are ready to inject, put the IVX3 into inject mode.

   The PPVS-INF should open and close the IVX3 automatically, stopping the unit on the MPG when the valve closes.
9. When the mold is full, put the IVX3 back into OFF mode (closed) and stop the machine.
10. Put the IVX3 into purge mode and then flush the system.
11. Leave the valve in purge mode until the material is gelled.

Note ***Leaving the IVX3 in purge mode with air on the actuator while the resin cures stops resin from gelling in the valve.***

Operating Using PPVS-INF with TAS & Drain Valve

1. Put the TAS into Off or Purge mode and the drain valve into Off mode (closed).
2. Set the MPG pressure and pump pressure.

CAUTION

Do not exceed the pressure rating of the injection hose for the MPG or pump pressure. Note the ratio of the pump powerhead to fluid section in this calculation.

3. Open the drain valve to purge.
4. Start the machine and wait for the resin to begin to flow into the supply line.
5. Prime valves so resin flows into flush line.

Note ***Do not start the PPVS-INF at this time or resin will enter the mold.***

6. Put the drain valve into Off mode (closed).
7. Reset the counter before injecting for an accurate count.
8. When you are ready to inject, supply the PPVS-INF start valve (inject mode).

   The PPVS-INF should open and close the IVX3 automatically, stopping the unit on the MPG when the valve closes.
9. When the mold is full, turn off/stop the PPVS-INF to stop the machine.
10. Put the TAS into Purge mode and flush the system.
11. Leave in purge mode until the material is gelled.

Adjusting PPVS-INF

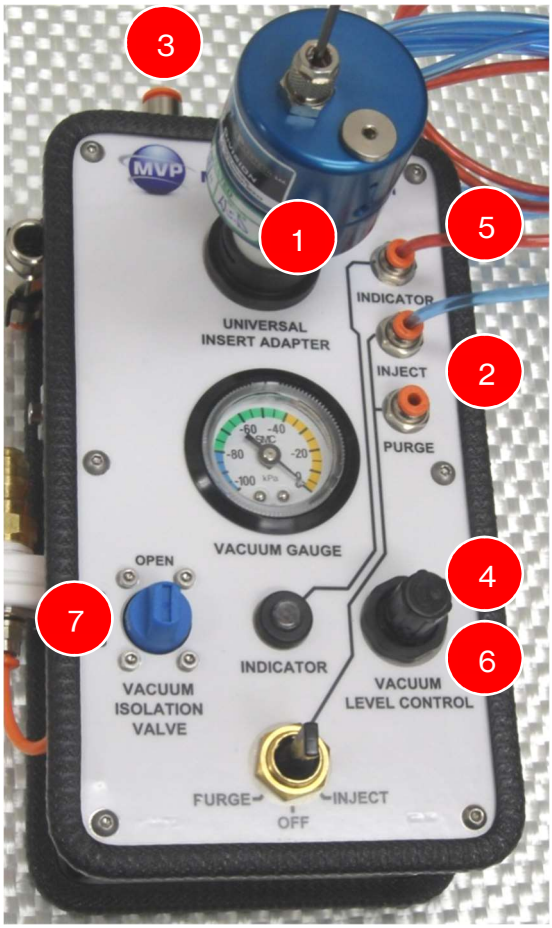
The PPVS-INF is factory set to signal at 800 mb absolute pressure. If you wish to change this setting, follow these steps:

Using Calibration Box

Test Vacuum Activation Level

1. Push the PPVS-INF firmly into the socket at the top of the calibration box.
2. Connect the inject output on the control box to the PPVS-INF supply port using 4 mm tube.
3. Connect the 6 mm air supply to the calibration box and turn air on at the supply.
4. Using the vacuum level control on the calibration box, adjust the vacuum level up and down to determine at what vacuum pressure the valve activates and deactivates.

Note ***The indicator will signal red when the valve is active.***



Test for Vacuum Leak

5. Connect the PPVS-INF signal line to the pneumatic indicator on the control box.
6. Use the vacuum level control to adjust the vacuum to the desired level.
7. Turn the vacuum isolator valve to the closed position (horizontal) to lock the level.

   If the vacuum level move (leaks) down the seal in the valve is not holding vacuum.

Adjust Vacuum Activation Level

8. Insert a 2.5 mm Allen key into the adjustment screw on top of the valve.
9. Turn the adjustment screw clockwise to lower the vacuum pressure (closer to zero) required to activate the PPVS-INF.

Note ***Make sure the nut is secure on top of the adjustment screw.***

10. Adjust the vacuum level to determine the switching point of the PPVS-INF.
11. Repeat until the desired switching point is achieved.

Using Mold Vacuum

1. With the PPVS-INF valve mounted in the mold, block any other ports so that the mold vacuum is tight.
2. Connect the PPVS-INF supply (blue poly tube) to an air supply.
3. Using the vacuum regulator connected to the system vacuum, slowly increase and decrease the vacuum level to determine the PPVS-INF set point.
4. To adjust the vacuum pressure, use a 2.5 mm Allen key to turn the adjustment screw clockwise to switch closer to atmosphere (nearer to zero) or counterclockwise to switch down to higher vacuum pressure.
5. Set to desired level and retest to determine the valve activates at desired set point.

Blind Adjustment

The term blind adjustment means that adjustment can be made without any reference to the actual switching point of the PPVS-INF. To adjust without checking the set level:

1. Use a 2.5 mm Allen key to turn the adjustment screw on top of the valve clockwise the lower the vacuum level (less sensitive) or counterclockwise to make it more sensitive (higher vacuum level).

Maintaining Valve

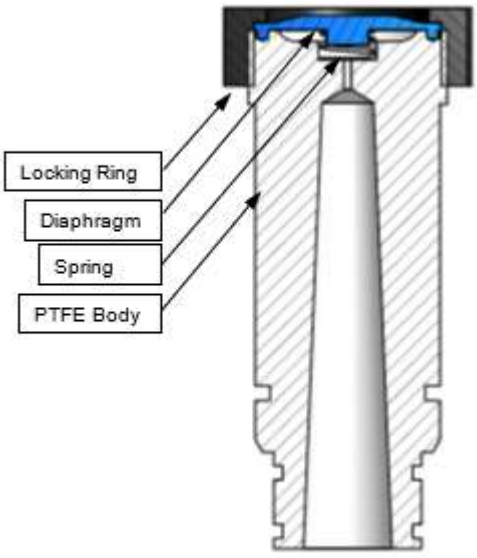
The only maintenance required for the PPVS-INF is that he front internal PTFE cone body is kept clean and free from any resin buildup. It is not normal that resin sticks and builds up inside the PTFE body, however should this occur and impact performance, follow these steps:

1. Disassemble the unit by removing the three body screws and locking ring.

Note ***If you remove the diaphragm, take care to remove the internal spring and keep it safe.***

2. Remove any resin or dirt which may have accumulated in the PTFE body top.
3. Reassemble the unit; do not overtighten the locking ring.
4. Test the PPVS-INF for proper function.

Note ***If no test device is available, connect the air supply and the output to the TAS and suck the clean end of the valve to see if it functions correctly.***



Note ***Mouth suction vacuum is not normally higher than 500 mb absolute.***

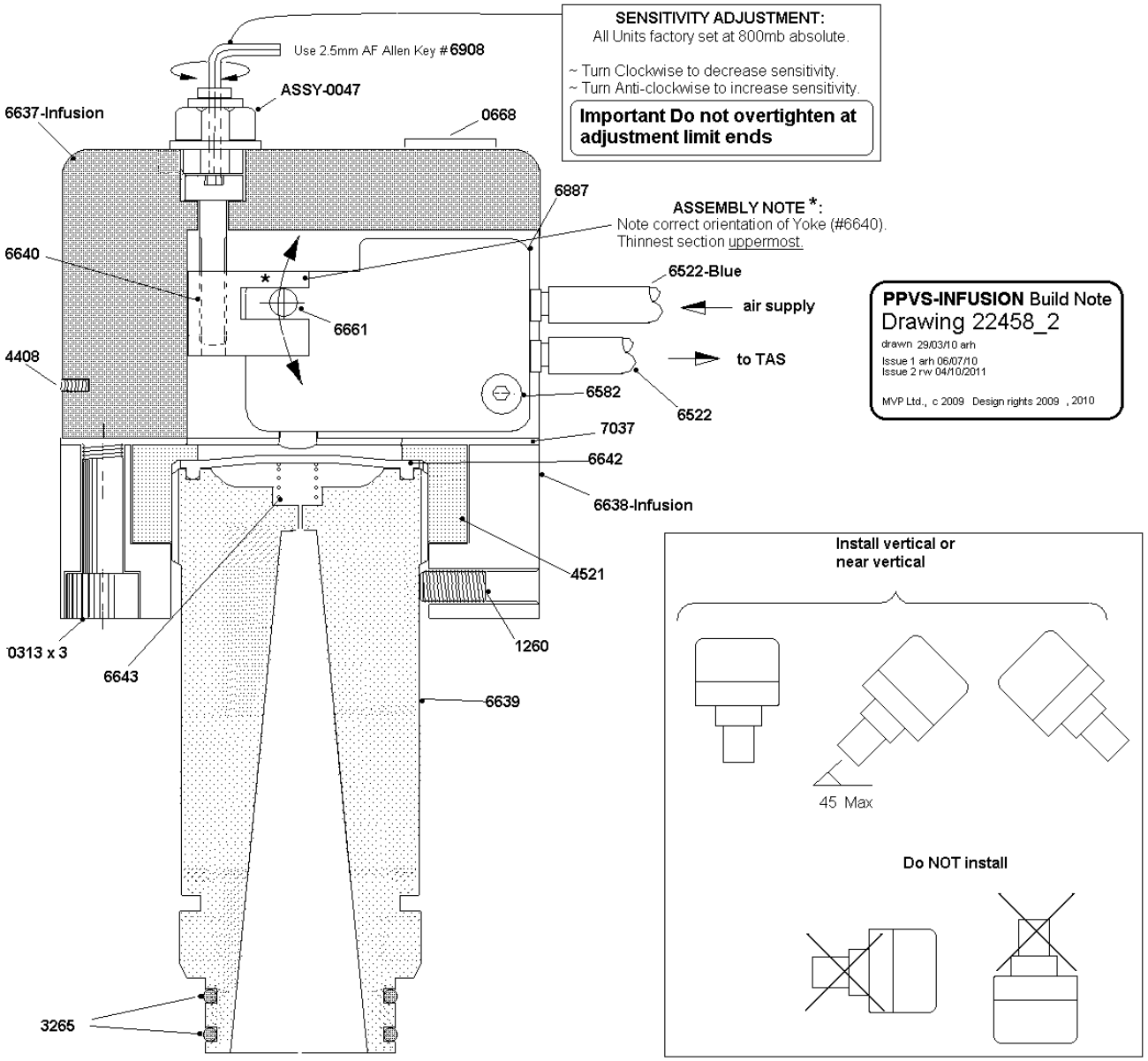
Specifications

PPVS-INF Specifications	
Parameter	**Specification**
Supply Pressure	29 – 90 psi (2 – 6 bar). Use 5 micron filtration
Operating Range	300 – 1000 mb absolute max
Connection Port	Stepped 20 and 25 diameters
Connection Lock	Proprietary spring clip
Pipe Connections	4 mm OD, 2.5 mm ID recommended flexible polyurethane
Adjustment	2.5 Allen key
Contact Materials	PTFE, cured silicon, and stainless steel
Weight, dims	290 grams – 50 mm diameter x 86 mm H

Parts Drawings

The following illustrations are included for reference when disassembling or servicing equipment and ordering parts.

- 22458-2 PPVS-INF Assembly


SENSITIVITY ADJUSTMENT:
All Units factory set at 800mb absolute.
~ Turn Clockwise to decrease sensitivity.
~ Turn Anti-clockwise to increase sensitivity.
Important Do not overtighten at adjustment limit ends
Use 2.5mm AF Allen Key # 6908
ASSY-0047
6637-Infusion
0668
6887
ASSEMBLY NOTE *:
Note correct orientation of Yoke (#6640).
Thinnest section uppermost.
6640
6522-Blue
air supply
6661
4408
to TAS
6582
6522
7037
6642
6638-Infusion
4521
1260
0313 x 3
6643
6639
3265
PPVS-INFUSION Build Note
Drawing 22458_2
drawn 29/03/10 arh
Issue 1 arh 06/07/10
Issue 2 rw 04/10/2011
MVP Ltd., c 2009 Design rights 2009 , 2010
Install vertical or near vertical
45 Max
Do NOT install

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