

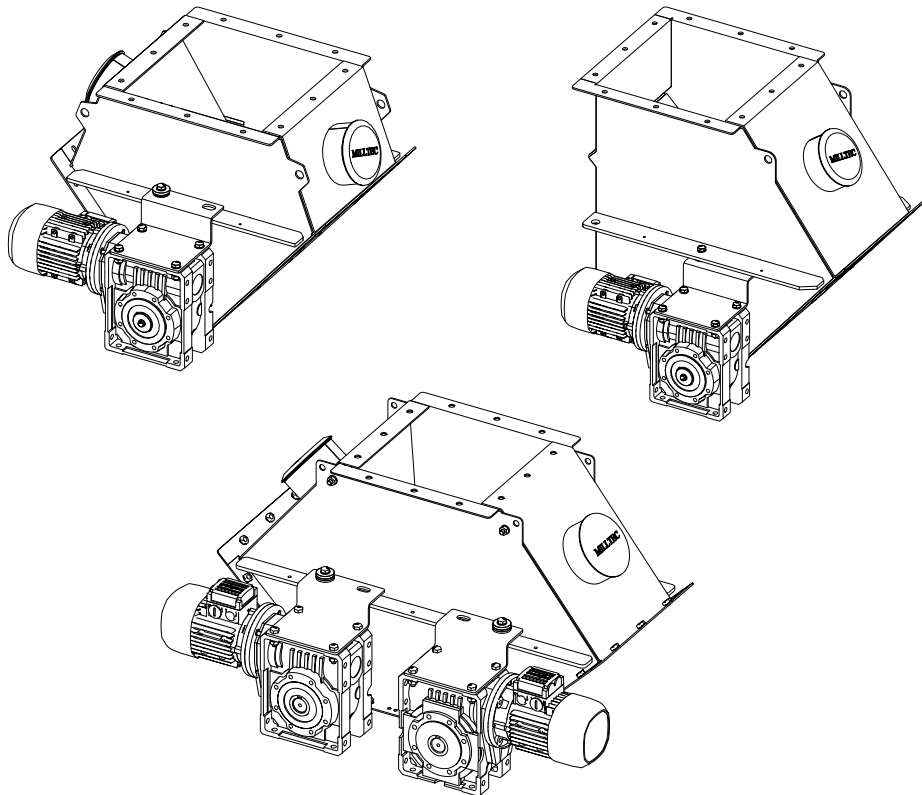
Flop Valves

Diverter Valves Assembly and Operation Manual

This manual applies to the following models:

Two-Way Valve: DVAC-701-M-01, DVSD-701-M-01, DVAD-701-M-01, DVSF-701-M-01

Three-Way Valve: DVSW-701-M-01, DVSY-701-M-01



Read this manual before using product. Failure to follow instructions and safety precautions can result in serious injury, death, or property damage. Keep manual for future reference.

Part Number: 8210-30068 R0

Revised: September 2024

Original Instructions

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1. Introduction

This manual will help you safely use and maintain the valve. Read and follow the manual before using. Keep the manual handy to refer to and review it with others.

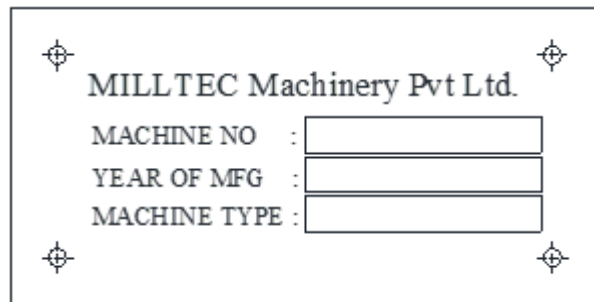
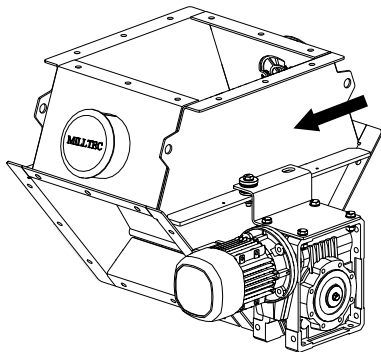
1.1. Intended Use

The valve is intended for use as described throughout this manual and as specified on the approval drawing. Use in any other way is considered contrary to the intended use and is not covered by the warranty.

1.2. Serial Number Location

The serial number location for your valve is shown in the figure below. Have the serial number ready when ordering parts or requesting service or other information. Record information in the table below for easy reference.

Model Number	
Serial Number	
Date Received	




2. Safety


2.1. Safety Alert Symbol and Signal Words





This safety alert symbol indicates important safety messages in this manual. When you see this symbol, be alert to the possibility of injury or death, carefully read the message that follows, and inform others.

Signal Words: Note the use of the signal words **DANGER**, **WARNING**, **CAUTION**, and **NOTICE** with the safety messages. The appropriate signal word for each message has been selected using the definitions below as a guideline.

 **DANGER** Indicates an imminently hazardous situation that, if not avoided, will result in serious injury or death.

 **WARNING** Indicates a hazardous situation that, if not avoided, could result in serious injury or death.

 **CAUTION** Indicates a hazardous situation that, if not avoided, may result in minor or moderate injury.

 **NOTICE** Indicates a potentially hazardous situation that, if not avoided, may result in property damage.

2.2. General Safety Information

Read and understand all safety instructions, safety decals, and manuals and follow them when operating or maintaining the equipment.

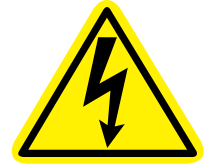
- Owners must give instructions and review the information initially and annually with all personnel before allowing them in the work area. Untrained users/operators expose themselves and bystanders to possible serious injury or death.
- Use for intended purposes only.
- Modification of the valve in any way without written permission from the manufacturer is not covered by the warranty.
- Follow a health and safety program for your worksite. Contact your local occupational health and safety organization for information.
- Follow applicable local codes and regulations.



2.3. Electrical Equipment Safety

WARNING Power Source

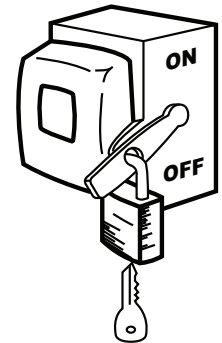
- Electrical equipment and controls shall be installed and serviced by a qualified electrician and must meet all local codes and standards.
- Locate main power disconnect switch within reach from ground level to permit ready access in case of an emergency.
- All electrical equipment must be properly grounded.
- Covers and guards must be in place and secure.
- Ensure electrical wiring and cords remain in good condition; replace if necessary.



Lockout

- Lockout power source before making adjustments, cleaning, maintaining equipment or when not in use. Ensure that all personnel are clear before turning on power to equipment

SERVICE DISCONNECT



2.4. Personal Protective Equipment

The following Personal Protective Equipment (PPE) should be worn when assembling, operating or maintaining the equipment.

- **Safety Glasses**



Wear safety glasses at all times to protect eyes from debris.

- **Steel-Toe Boots**



Wear steel-toe boots to protect feet from falling debris.

- **Coveralls**



Wear coveralls to protect skin.

- **Work Gloves**



Wear work gloves to protect your hands from sharp and rough edges.

2.5. Safety Decals

- Keep safety decals clean and legible at all times.
- Replace safety decals that are missing or have become illegible. See decal location figures that follow.
- Replaced parts must display the same decal(s) as the original part.
- Replacement safety decals are available **free of charge** from your distributor, dealer, or factory as applicable.

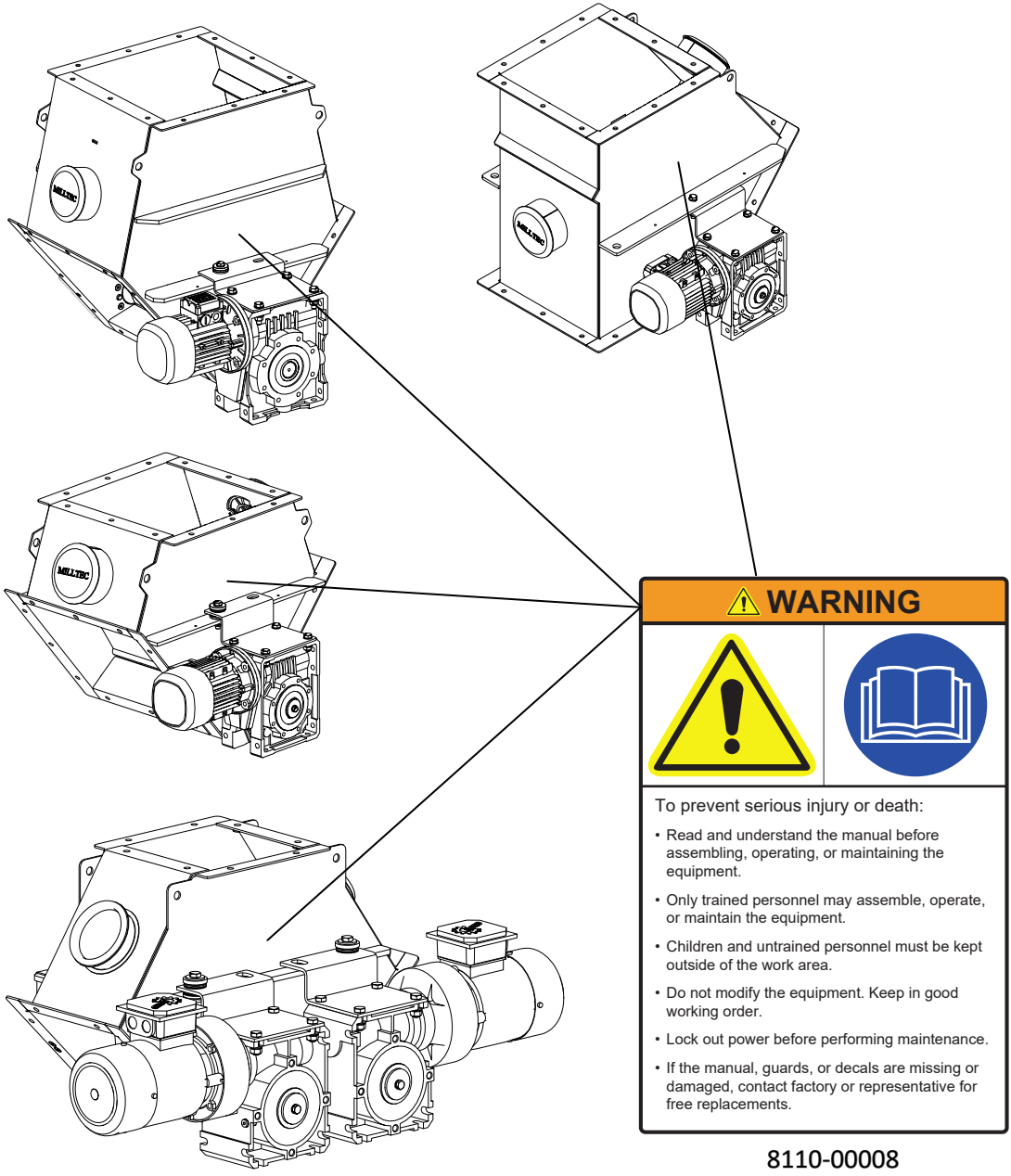
2.5.1 Safety Decal Locations and Details

Replicas of the safety decals that are attached to the valve and their messages are shown in the figure(s) that follow. Safe operation and use of the valve requires that you familiarize yourself with the various safety decals and the areas or particular functions that the decals apply to, as well as the safety precautions that must be taken to avoid serious injury, death, or damage.

2.5.2 Decal Installation/Replacement

1. Decal area must be clean and dry, with a temperature above 50°F (10°C).
2. Decide on the exact position before you remove the backing paper.
3. Align the decal over the specified area and carefully press the small portion with the exposed sticky backing in place.
4. Slowly peel back the remaining paper and carefully smooth the remaining portion of the decal in place.
5. Small air pockets can be pierced with a pin and smoothed out using the decal backing paper.

Safety Decal Details

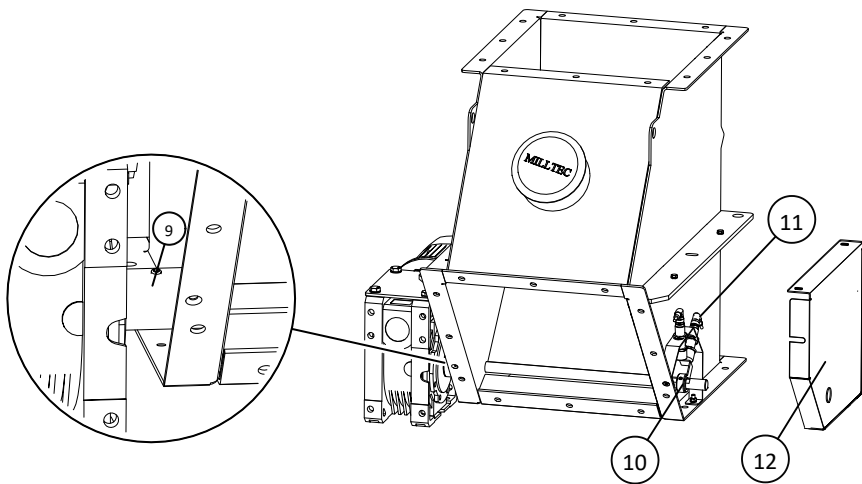
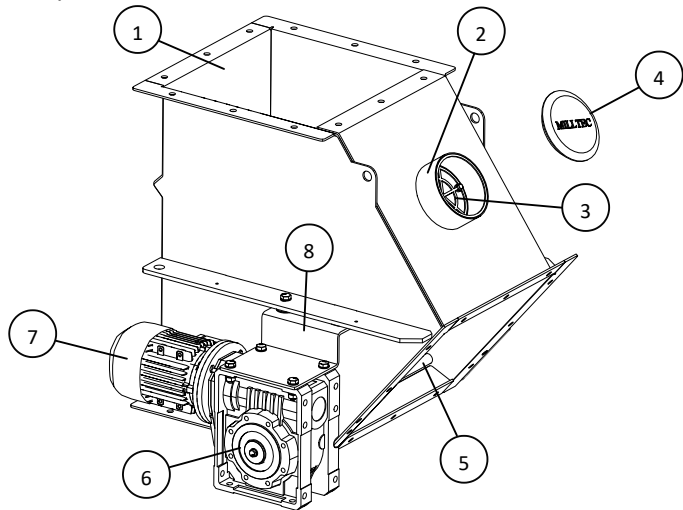


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3. Features

Two-Way Valve

DVAC-701-M-01/DVAD-701-M-01

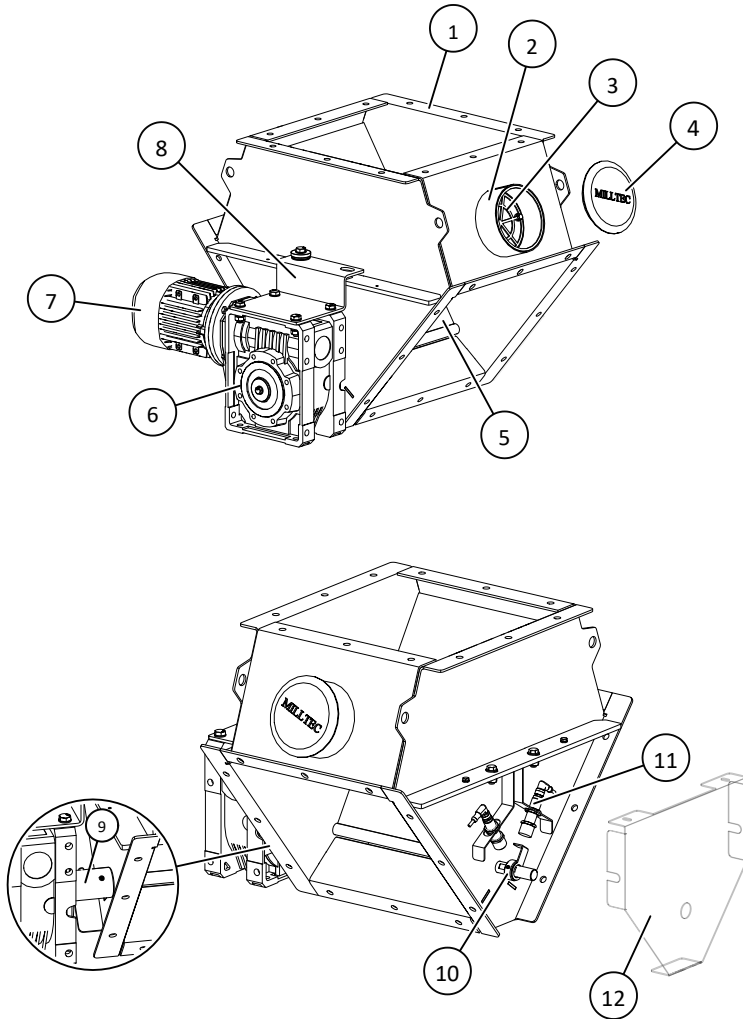


Item	Description
1	Valve Housing
2	Vent
3	Vent Shield
4	Vent Cover

Item	Description
5	Valve Flap
6	Gear Reducer
7	Electric Motor
8	Motor Mount Bracket

Item	Description
9	Shaft Coupling
10	Sensing Arm
11	Sensor
12	Sensor Guard

DVSD-701-M-01

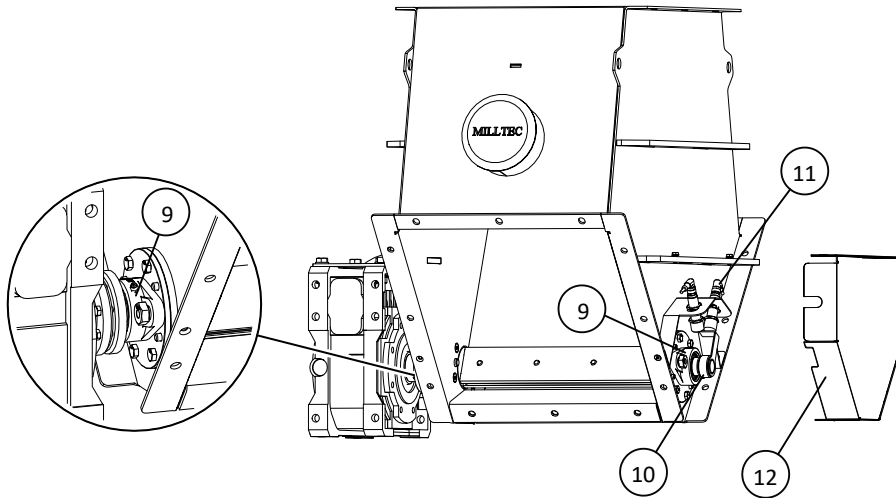
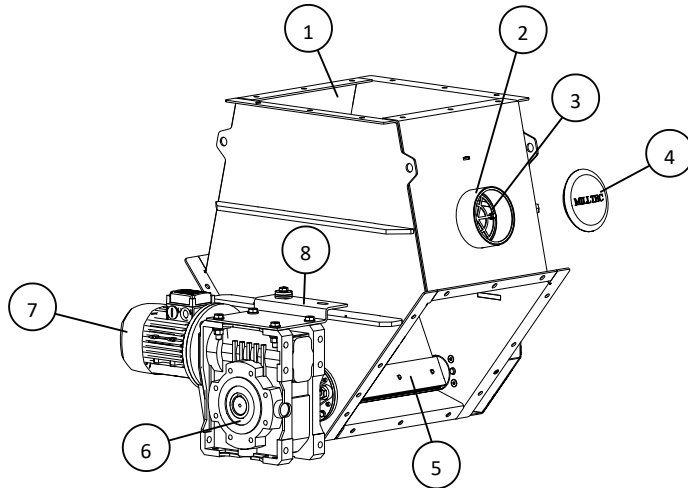


Item	Description
1	Valve Housing
2	Vent
3	Vent Shield
4	Vent Cover

Item	Description
5	Valve Flap
6	Gear Reducer
7	Electric Motor
8	Motor Mount Bracket

Item	Description
9	Shaft Coupling
10	Sensing Arm
11	Sensor
12	Sensor Guard

DVSF-701-M-01

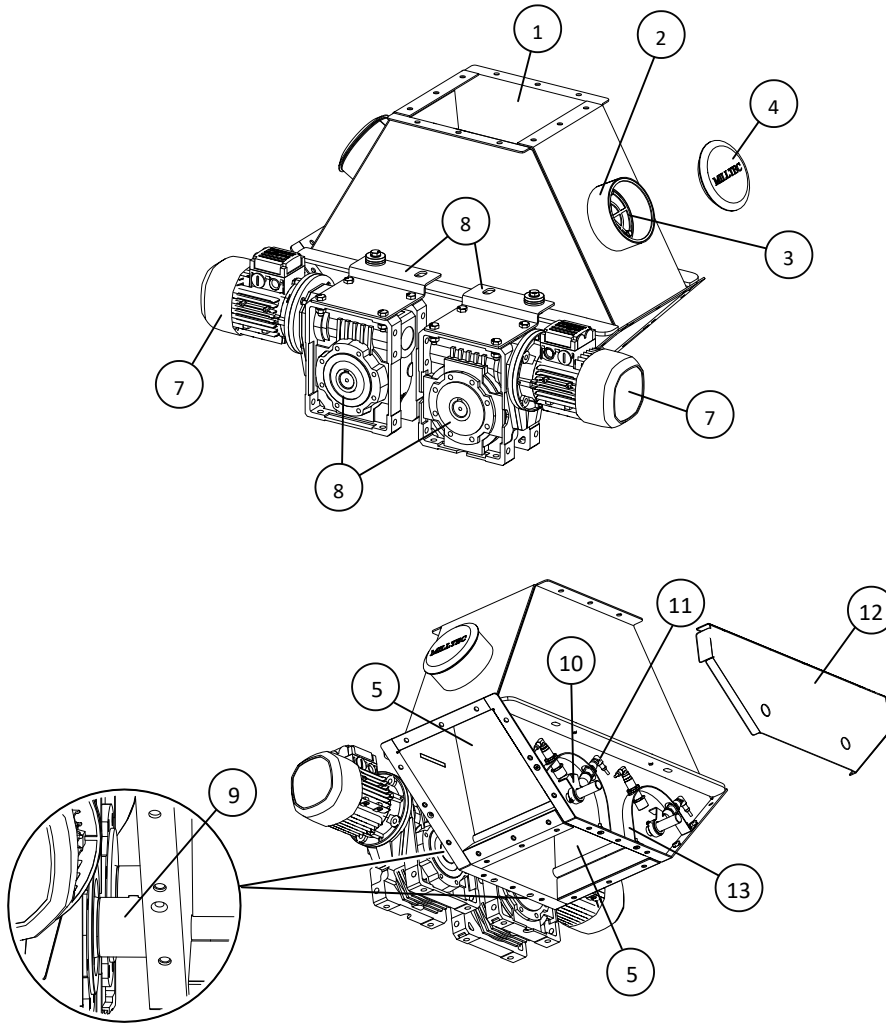


Item	Description
1	Valve Housing
2	Vent
3	Vent Shield
4	Vent Cover

Item	Description
5	Valve Flap
6	Gear Reducer
7	Electric Motor
8	Motor Mount Bracket

Item	Description
9	Bearing
10	Sensing Arm
11	Sensor
12	Sensor Guard

Three-Way Valve



Item	Description
1	Valve Housing
2	Vent
3	Vent Shield
4	Vent Cover
5	Valve Flap

Item	Description
6	Gear Reducer
7	Electric Motor
8	Motor Mount Bracket
9	Shaft Coupling
10	Sensing Arm

Item	Description
11	Sensor
12	Sensor Guard
13	Sensor Holder

4. Pre-Installation

4.1. Approval Drawing

An approval drawing from AGI Milltec is provided with the valve. Use the approval drawing when assembling/installing as it contains specific information about component placement and locations.

4.2. Before Unloading the Shipment

1. Check if the loads have shifted or have been damaged during transport.
2. Inspect all sides of the shipment for any visible signs of damage. Look for dents, misaligned flanges and shafts. Take photos of the damaged components on the truck.
3. If components are damaged or missing, note these on the delivery receipt and immediately report missing or damaged parts to the manufacturer and freight company.

4.3. Unload the Shipment

1. Determine the appropriate area for unloading the shipment.
2. Make sure the area is clear before unloading.
3. Unload the valve parts on a solid and clean flat surface.

 **CAUTION** Use proper unloading and lifting techniques to prevent injury or component damage.

4. Thoroughly inspect components for any damage.
5. Compare the packing slip to the shipment and confirm all items have arrived.
6. Report missing or damaged parts to AGI Milltec or your representative. Report immediately to receive proper credit and so missing parts can be shipped quickly. Take pictures of shipments after unloading if there are any damaged parts.

Important

Do not assemble or install damaged components.

4.4. Product Storage

If storing components before installation, follow the instructions below to prevent dirt and moisture accumulation, damage, or injury. Damage to components resulting from improper storage is not covered by warranty.

- Store motors indoors in a clean, dry, and vibration-free environment. If storing for long-term, follow the manufacturer's storage requirements.
- Do not lay bundles on the bare ground. Raise all bundles 6" to 8" off the ground on wood blocks or timbers.
- All other bundles material should be placed so that they are well sloped to promote good drainage.
- Temporary storage can be provided by erecting a simple framework supporting a waterproof tarp.
- All hardware boxes should be stored inside. These are not waterproof, and will deteriorate in normal weather conditions, allowing moisture to contact the parts inside.
- Keep all bundles dry before assembly of the valve.
- Start assembly as soon as possible.

4.5. Before You Begin

Before you assemble the valve:

- Familiarize yourself with all the sub-assemblies, components, and hardware that make up the equipment.
- Have all parts and components on hand, and arrange them for easy access.
- Separate the hardware (bolts, nuts, etc.) and lay them out into groups for easier identification during assembly.

5. Installation

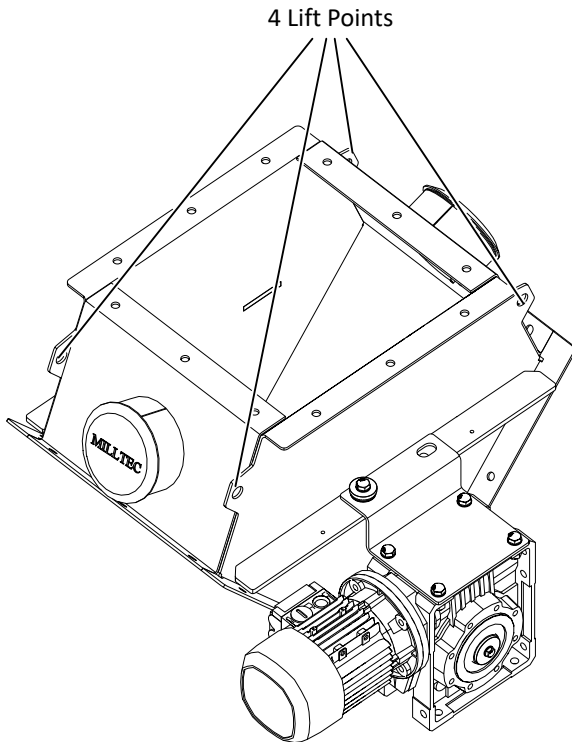
5.1. Installation Safety

⚠ WARNING

- Do not take chances with safety. The components can be large, heavy, and hard to handle. Always use the proper tools, rated lifting equipment, and lifting points for the job.
- Do not stand on, under, or near any component that is not secured.
- Always have two or more people assembling the valve.
- Make sure you have sufficient lighting for the work area.
- Tighten all fasteners according to their specifications. Do not replace or substitute bolts, nuts, or other hardware that is of lesser quality than the hardware supplied by the manufacturer.
- Install the equipment in accordance with applicable local codes and regulations.
- Install the position sensors by following the manufacturer's instructions and ensuring all requirements are met.
- All installation and servicing operations are to be carried out by qualified technicians.
- All electrical connections shall be made by a qualified electrician and must meet the applicable local codes and regulations.
- When testing the valve, be aware of moving components and avoid all potential pinch points.

5.2. Lifting and Moving

- Inspect all slings and lifting equipment prior to each lift.
- Extreme care must be taken to prevent damage when moving assembled equipment or components.
- Consider unusually heavy items such as drives when choosing support points due to loading balance and its shifting effects.
- Create a barrier using tape or rope to prevent bystanders from entering the work area.
- Never lift with only one support point. Refer to the following figure as required.

Figure 1. Typical Valve Lift Points

5.3. Installing the Valve

This section provides general instructions for installation of valves. Details may vary depending on the application. Install the valve according to the following steps to ensure smooth operation.

1. Check the valve assembly mounting flanges and other mating flanges for bends, warping, debris, and damage.

Note

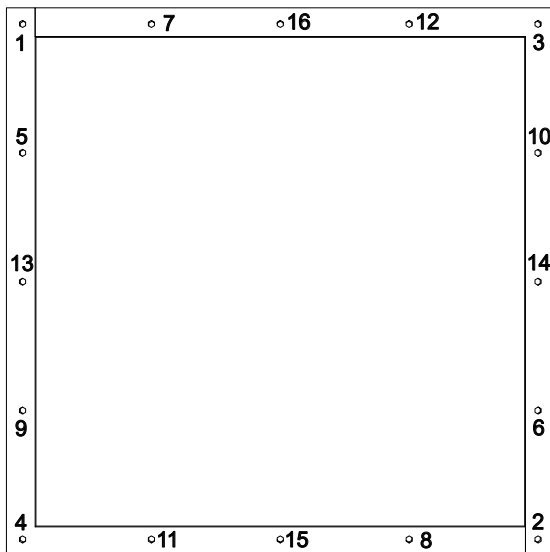
Sealant can also be applied before placing the valve into position. If this method is preferred, use care not to disturb the sealant during lifting and positioning procedures.

2. Using the appropriate slings (attached to the lift points) raise the valve assembly and move into position for installation. Refer to [Section 5.2 – Lifting and Moving on page 15](#) for additional lifting information.
3. Install flange bolts and nuts in four corners of the mounting flange (near the lifting points) and the mounting flange of the equipment to be connected.
4. Hand-tighten four flange bolts, keeping a square alignment between the flanges. Leave a small gap between flange mating surfaces for sealant.
5. Apply a small bead of silicone sealant to one flange of each connection.
6. Install all remaining fasteners. Carefully draw all flange connections together evenly keeping flanges square and straight with one another. Use a cross-pattern sequence as shown in the following figure. Snug all fasteners in sequence and in several stages to minimize distortion. Tighten all bolts (in sequence) to the recommended torque. Refer to [Section 9.1 – Bolt Torque on page 27](#) as required.

Important

Flanges must be clean, flat, and square with all attached equipment before tightening any bolts.

Figure 2. Flange Bolt Tightening Sequence Example



7. Connect the position switches following the manufacturer’s instructions and ensure all requirements are met.
8. After the valve assembly is fully installed and connected, operate the valve fully through it’s range of travel. Check for proper operation with valve in all commanded positions. Refer to [Section 7.6 – Position Sensor Maintenance on page 22](#) as required.

Important

Do not adjust the position sensors as they are preset at the factory and ready for use.

9. Reinstall dust covers as necessary.

6. Operation

For optimal operation, follow these safety precautions, checklists, and instructions.

6.1. Operation Safety

- ⚠ WARNING**
- Read and understand the operation of the system for which the valve is installed.
 - Keep away from rotating and moving parts.
 - Always operate with guards, covers, and shields in place.
 - Have another trained person nearby who can shut down the equipment in case of accident.
 - Ensure maintenance has been performed and is up to date.

6.2. Pre-Start Inspection Checklist

Before using the valve for the first time, check and verify the following:

1. Visually inspect the valve, see [Section 7.3 – Visually Inspect the Equipment on page 21](#).
2. Check tightness of all bolts/nuts, fasteners, and hardware (re-torque if necessary).
3. Ensure the valve is properly grounded in accordance with the local codes.

6.3. Start-Up Procedure

1. Test functionality of the valve before running the products. If any unusual noises occur, disconnect and lock out the power.
2. After equipment is known to be operating normally, engage full-flow of product through the system. Cycle the valve several times when loaded with product.
3. Monitor for proper valve function and no product leakage. If no problems, the valve can be used in normal operation. If problems are encountered, refer to [Section 8. – Troubleshooting on page 25](#) for more information.

6.4. Operation

This section does not cover specific operation of the valve, as operation may depend on the system in which the valve is integrated into.

Below are some general guidelines to keep in mind when operating the valve.

- Read and understand the operation of the system for which the valve is installed.
- Familiarize with the method of valve operation.
- Monitor equipment regularly during normal operation.
- Perform scheduled maintenance as required.

6.5. Shutdown

When operation has been completed:

1. Once the valve is clear of product, lock out the power source.
2. Clean the entire work area.

6.6. Extended Shutdown

After the season's use, the valve should be thoroughly inspected and prepared for extended shutdown.

1. Clean the valve thoroughly and remove all dirt, mud, debris, or residue.
2. Inspect all moving and rotating parts. Check if debris has become entangled. Remove any entangled material.
3. Touch up all paint nicks and scratches to prevent rusting.
4. Remove access covers and clean all components of the flop valve, including the top and bottom of the valve assembly. Ensure magnetic targets are clean, and have a clear path of travel to between the two position sensors.
5. Inspect the valve for cracks and tightness of fasteners. Replace worn or damaged components as necessary.
6. If possible, use waterproof covering to protect components if stored outside. Do not seal coverings around the equipment. Always provide a path for moisture to evaporate.
7. Cycle the valve (without product) through the full range of travel 2-3 times per month when not in use.

7. Maintenance

Proper maintenance will improve safety, efficiency, and will keep the valve operating reliably.

7.1. Maintenance Safety

WARNING

- Keep components in good condition. Follow the maintenance procedures.
- Ensure the service area is clean, dry, and has sufficient lighting.
- Do not modify any components without written authorization from the manufacturer. Modification can be dangerous and result in serious injuries.
- Shut down and lock out power before maintaining equipment.
- After maintenance is complete, replace all guards, service doors, and/or covers.
- Use only genuine AGI Milltec replacement parts or equivalent. Use of unauthorized parts will void warranty. If in doubt, contact AGI Milltec or your local dealer.



7.2. Maintenance Schedule

Follow the Maintenance Schedule below. Keep good records of the hours the valve has been operated and the maintenance performed.

Maintenance Intervals
Daily:
Check equipment for proper operation during and after startup up. If a problem is encountered, repair the problem before continuing normal operations. Refer to Section 8. – Troubleshooting on page 25 as necessary.
Monthly:
Refer to Section 7.3 – Visually Inspect the Equipment on page 21 . Refer to Section 7.7 – Lubricating the Equipment – For DVSF-701-M-01 on page 23
Quarterly:
Refer to Section 7.4 – Cleaning the Valve on page 21 .
Annually:
Refer to Section 7.5 – Inspecting the Wiring, Controls, and Electric Motor on page 21 .
As required:
Refer to Section 7.6 – Position Sensor Maintenance on page 22 . Refer to Section 7.8 – Gear Drive Maintenance on page 23 .

7.3. Visually Inspect the Equipment

Before inspection, ensure all spouts connected to the valve are clear of any product.

1. Examine the valve for damage or unusual wear.
2. Check that the valve path is free of obstruction. Remove obstructions as necessary.
3. Check valve assembly for dirt, debris, or other obstructions that may restrict valve flap movement. Clean and remove obstructions as necessary.
4. Check valve assembly for missing, loose, or worn hardware. Replace or tighten hardware as required.
5. Check that all components of the valve assembly are properly aligned and tightly secured. Realign parts and tighten hardware as necessary.
6. Check that the two position sensors are not damaged and are tightly secured. Replace sensor if damaged. If sensor is loose or has been replaced, verify proper sensor-to-magnetic target air gap and tighten sensors. Refer to [Section 7.6 – Position Sensor Maintenance on page 22](#), as required.
7. Check that all valve safety decals are in place and legible. Replace decals as required.

7.4. Cleaning the Valve

1. Use vacuum to remove any buildup from exterior of the valve assembly. Remove any material from control wiring, mechanical linkages, magnetic target, and position sensors as required.
2. If access permits, use vacuum to remove any material left on the inside of the valve.
3. Ensure valve flap is clean and clear of material buildup. Flap should move into each position and seal completely against stop bars.
4. Ensure that the magnetic target's path is clear of all obstructions and debris.
5. Ensure that the valve is operating smoothly through its entire range of travel.

7.5. Inspecting the Wiring, Controls, and Electric Motor

- Check electric motor, external components, and wiring connections for damage. Repair as necessary.
- Check for frayed/exposed wiring. Replace wiring as necessary.
- Ensure all electrical connections are secure. Tighten and secure wiring connections as required.
- Ensure the strain reliefs retain wiring firmly and are properly attached to the valve's body.
- Replace damaged and defective components.
- Follow the electric motor manufacturer's instructions for routine maintenance.

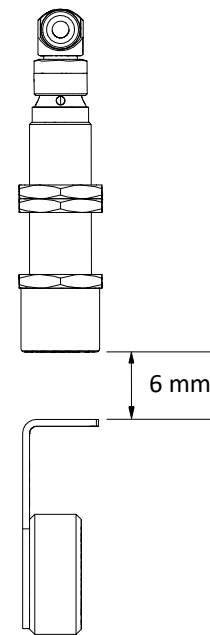
7.6. Position Sensor Maintenance

- Check position sensors for damage. Replace defective or damaged sensors as required and perform the air-gap adjustment procedure.
- Check that sensors are attached tightly and that they do not screw in or out by hand. If a loose sensor is found, perform the following air-gap adjustment procedure.
- Check that sensing arm is tightly secured.
- Check for loose or damaged wiring or connectors at sensors. Secure or repair as required.

Position Sensor Air-Gap Adjustment

1. Move the valve fully to the position to be adjusted.
2. Lock out flop valve power.
3. Check that sensing arm is tightly secured and properly aligned with sensor. Sensor should be at center of the sensing arm.
4. Measure air-gap between sensing arm and tip of sensor. Air-gap specification is 6 mm.
5. Loosen and rotate sensor jam-nuts and adjust to the specified air-gap as required.
6. While keeping the sensor body in position, tightly snug the jam-nuts to prevent sensor movement.
7. After securing the sensor, recheck air-gap. Readjust as necessary.
8. Tighten one sensor jam nut to 14-22 ft- lb (20–30 Nm).
9. Remove lock out and restore flop valve power.
10. Operate valve and verify proper function and control.

Figure 3. Typical Position Sensor Air Gap Specification



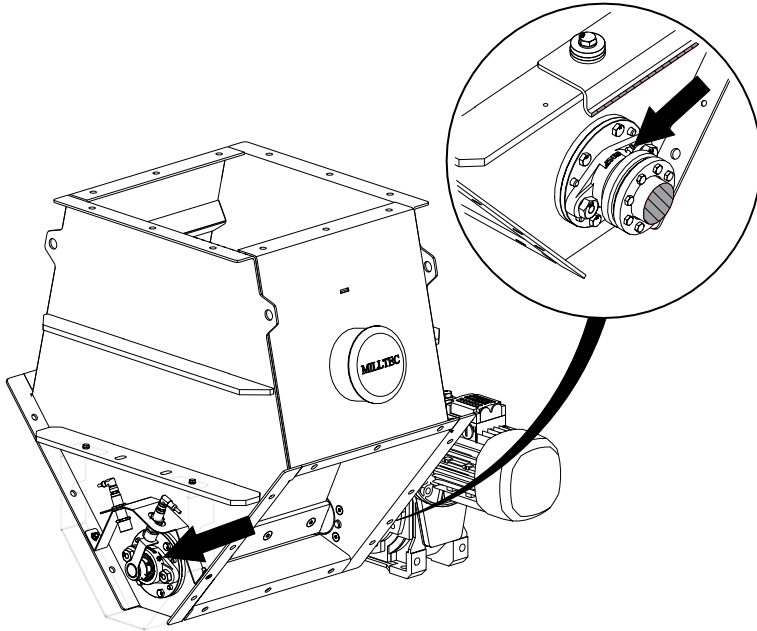
7.7. Lubricating the Equipment – For DVSF-701-M-01

Note

The lubrication frequency of a bearing is dependant upon speed, load, and working environment. Determine the lubrication frequency that suits your specific operating conditions.

1. Locate the lubrication points.
2. Apply grease at each lubrication point until a small amount of grease is forced out of the bearing ends. Use the grease specified in the manufacturer's documentation.

Figure 4. Lubrication Points



7.8. Gear Drive Maintenance

Check the following regularly:

- Check the exterior of the gear drive unit and attached components for damage. Replace damaged components as required.
- Check gear drive seals for leakage. Replace seals as required. Refer to gear drive manufacturer's documentation.
- Check the gear drive's breather vent for obstructions and clogging. Clean or replace breather vent as required.

NOTICE

Restricted breather vent may cause drive seal leakage and premature seal failure.

Inspect breather vent regularly. Clean or replace vent as required.

Note

The gear motor is pre-lubricated and does not require routine oil draining and refilling. Refer to the manufacturer's documentation for detailed guidelines.

7.9. Replacement Parts

Ordering Replacement Parts

Call 1(800) 425-8431. Provide the following information.

- Equipment to repair sales order number.
- Part number and paint color, when applicable. Refer to the installation drawing (if this valve came with an installation drawing), packing list, or invoice.
- Priority level of the order.
- Your name, complete mailing address, and phone number.



The image is a promotional graphic for AGI MILLTEC. On the left is a circular logo divided into eight segments, each representing a different stage of the mill process: PARBOILING & DRYING, PROCESSING, COLOR SORTING, BLENDING, PACKING, HANDLING, CLEANING, and STORAGE. The center of the logo features the text "AGI MILLTEC". To the right of the logo is the AGI logo, which consists of a green telephone handset icon and the letters "AGI" in a bold, green, sans-serif font. Below the AGI logo, the text "CALL US @ TOLL FREE NO:" is written in black. Underneath this, two phone numbers are listed in a large, bold, blue font: "1800 102 8431" and "1800 425 8431". At the bottom of the graphic, the text "FOR ALL SUPPORT SERVICES" is written in a bold, red font.

8. Troubleshooting

Find causes and solutions to common problems that can be encountered.

⚠ WARNING Shut down and lock out all power sources before diagnosing any of the causes or attempting any of the solutions below.

The following section covers some causes and solutions to some of the problems that may be encountered.

If there is a problem that is difficult to solve, even after having read through this section, please contact your representative or AGI. Have this manual and the serial number available.

Table 1. Valve Troubleshooting

Problem	Cause	Solution
Product leaking from valve.	Valve flap not sealing.	<ul style="list-style-type: none"> • Check for proper operation of the valve. • Check valve flap for buildup. Clean valve as necessary. • Check valve flap for distortion or bends. Repair or replace parts as required. • Check for proper gap between flop valve shaft and valve body. Adjust as required.
Valve operates slowly.	Accumulated buildup or debris inside valve assembly.	<ul style="list-style-type: none"> • Remove debris and clean flop valve.
	Valve flap sticking or binding.	<ul style="list-style-type: none"> • Check valve flap for signs of sticking or binding. Repair or replace valve flap as necessary.
Motor inoperative or stops frequently.	Component not receiving full supply voltage.	<ul style="list-style-type: none"> • Check for proper supply voltage. Repair as necessary.
	Component may be damaged or defective.	<ul style="list-style-type: none"> • Motor windings may be shorted. Repair or replace motor as required. • Check for excessive heating or abnormal noise during component operation. Replace component as required.

Table 1 Valve Troubleshooting (continued)

Problem	Cause	Solution
Gear drive over heats.	Lack of lubrication in the gear drive.	<ul style="list-style-type: none"> • Fill gear drive lubrication to proper level.
Motor runs, gear drive inoperative.	Loose or damaged coupler.	<ul style="list-style-type: none"> • Inspect coupler for alignment and tightness. Realign and tighten coupler as required. • If coupler shows signs of damage, replace coupler.



9. Appendix

9.1. Bolt Torque

Table 2 provides the correct torque values for various bolts. The bolt diameter is measured to the outside of the threads. When tightening all bolts, tighten the nut on the bolt to the torque specified in the table, unless otherwise specified. Do not replace or substitute bolts, nuts, or other hardware that is of lesser strength than the hardware supplied by the manufacturer.

Torque values indicated below are valid for non-greased or non-oiled threads and head, unless otherwise specified. Therefore, do not grease or oil bolts unless otherwise specified in this manual. When using locking elements, increase torque values by 5%.

Table 2. Metric Bolt Torque






Bolt Diameter				
	(N·m)	(ft·lb)	(N·m)	(ft·lb)
M3	0.5	0.4	1.8	1.3
M4	3	2.2	4.5	3.3
M5	6	4	9	7
M6	10	7	15	11
M8	25	18	35	26
M10	50	37	70	52
M12	90	66	125	92
M14	140	103	200	148
M16	225	166	310	229
M20	435	321	610	450
M24	750	553	1050	774
M30	1495	1103	2100	1550
M36	2600	1917	3675	2710

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