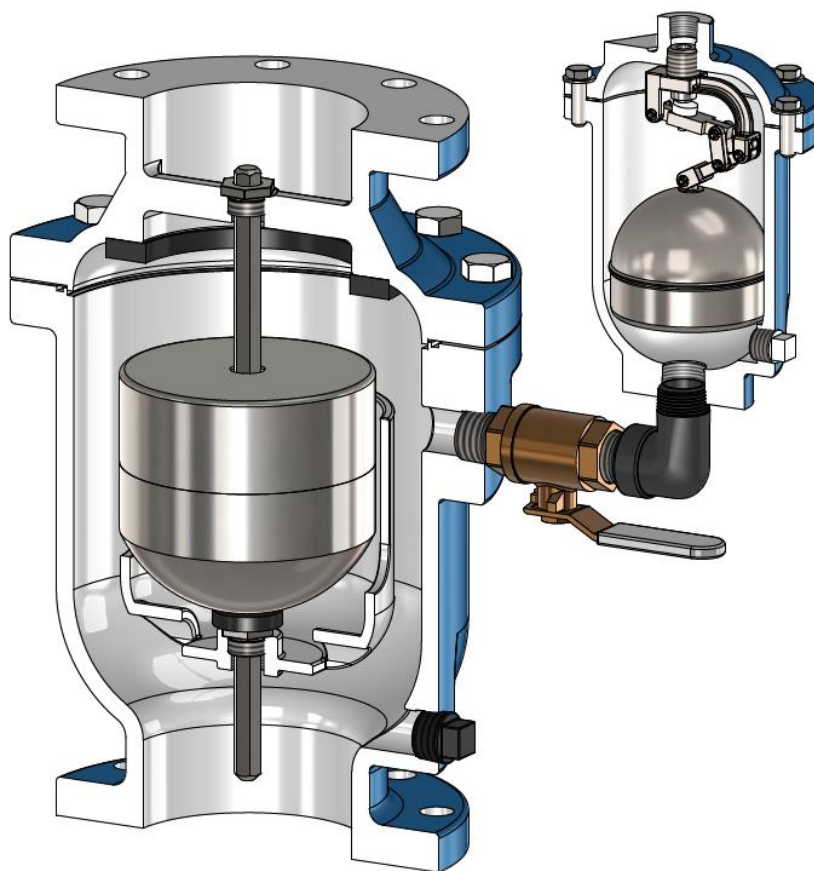


# APCO AVV-1800/1800K DUAL BODY COMBINATION AIR VALVES



Instruction **D12024**  
March 2023

## Instructions

These instructions are for use by personnel who are responsible for the installation, operation and maintenance of DeZURIK valves, actuators or accessories.

## Safety Messages

All safety messages in the instructions are identified by a general warning sign and the signal word CAUTION, WARNING or DANGER. These messages indicate procedures to avoid injury or death.

Safety label(s) on the product indicate hazards that can cause injury or death. If a safety label becomes difficult to see or read, or if a label has been removed, please contact DeZURIK for replacement label(s).

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### **⚠WARNING**

**Personnel involved in the installation or maintenance of valves should be constantly alert to potential emission of pipeline material and take appropriate safety precautions. Always wear suitable protection when dealing with hazardous pipeline materials. Handle valves which have been removed from service with suitable protection for any potential pipeline material in the valve.**

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## Inspection

Your DeZURIK product has been packaged to provide protection during shipment; however, items can be damaged in transport. Carefully inspect the unit for damage upon arrival and file a claim with the carrier if damage is apparent.

## Parts

Replaceable wear parts are listed on the assembly drawing. These parts can be stocked to minimize downtime. Order parts from your local DeZURIK sales representative or directly from DeZURIK. When ordering parts please provide the following information:

**If the valve has a data plate:** please include the 7-digit part number with either 4-digit revision number (example: 9999999R000) or 8-digit serial number (example: S1900001) whichever is applicable. The data plate will be attached to the valve assembly. Also, include the part name, the assembly drawing number, the balloon number and the quantity stated on the assembly drawing.

**If there isn't any data plate visible on the valve:** please include valve model number, part name, and item number from the assembly drawing. You may contact your local DeZURIK Representative to help you identify your valve.

## DeZURIK Service

DeZURIK service personnel are available to maintain and repair all DeZURIK products. DeZURIK also offers customized training programs and consultation services. For more information, contact your local DeZURIK sales representative or visit our website at [DeZURIK.com](http://DeZURIK.com).

## Table of Contents

Description .....	4
Handling and Storage .....	4
Installation .....	4
Fusion Bonded Epoxy Coated Valves.....	5
AVV-1800K Assembly .....	5
Maintenance.....	7
Disassembly Procedure .....	7
AVV- 140 and 140H Valve 1-3" (25-80mm).....	7
AVV-140 with AVRT Option Disassembly Procedure .....	8
AVV-150 Air/Vacuum Valve 4-18" (100-450mm) Disassembly .....	9
ARV-50A/200A/200 Air Release Valve Disassembly.....	9
Assembly Procedure.....	10
ARV-50A/200A/200 Air Release Valve Assembly .....	10
AVV-150 Air/Vacuum Valves 4-18" (100-450mm) Assembly .....	10
AVV-140/140H Air/Vacuum Valves 1-3" (25-75mm) Assembly .....	10
AVV-140 with AVRT Option Assembly Procedure.....	11
Testing.....	11
Operation .....	11
Drawings .....	12
Figure 1: Connecting Parts for Dual Body AVV .....	12
Figure 2A: AVV-140 0.5-3" (15-80mm) Air/Vacuum Valve.....	13
Figure 2B: AVV-140 AVRT Option .....	14
Figure 3: AVV-140H 1-3" (25-80mm) Air/Vacuum Valve for High Pressure Service .....	15
Figure 4: AVV-150 4-18" (100-450mm) Air/Vacuum Valve .....	16
Figure 5: ARV-50A Air Release Valve.....	17
Figure 6: ARV-200A Air Release Valve .....	18
Figure 7: ARV-200 Air Release Valve .....	19
Troubleshooting.....	20

## Description

The AVV-1800/1800K are Dual Body Combination Valves with an Air/Vacuum Valve piped to an Air Release Valve. The AVV-1800 and AVV-1800K are functionally the same. The AVV-1800 ships fully assembled from the factory. The AVV-1800K ships with the Air/Vacuum Valve, Air Release Valve, and piping kit. The customer will pipe the Air Release Valve to the Air/Vacuum Valve.

The APCO AVV-1800 Dual Body Combination Air Valve should always be installed in a vertical position. An isolation valve between this unit and the transmission (pipeline) system is recommended. Where to use:

- High points in pipelines where the hydraulic gradient and flow conditions are such that a negative pressure can possibly occur.
- High points on sections of pipeline having water velocities in excess of 10 F.P.S.
- Adjacent to any quick closing valve in a pipeline such as a check or gate valve where vacuum can occur upon closure.
- On the discharge of larger deep well turbine pumps between the pump and the check valve.
- If an Air/Vacuum Valve is to be installed inside a pump house, use threaded or flanged connections and pipe back into the well or to outside. This will greatly muffle the high noise level caused by the air being discharged and provide for drainage of any small amount of water or water vapor that may accumulate.

## Handling and Storage

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**NOTICE**

**Lifting the valve improperly may damage it. Do not fasten lifting devices to piping, or attached components. Lift the valve with slings, chains, or cables fastened around the valve body, or fastened to bolts or rods through bolt holes in the flanges.**

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If installation will be delayed, refer to **Form 1454 – Recommended Long & Short-Term Storage Procedures**

## Installation

- Before installation, remove foreign material such as weld spatter, oil, grease, and dirt from the pipeline.
- Prepare pipe ends and install valves in accordance with the pipe manufacturer's instructions for the joint used.
- Tighten the flange bolts or studs in a crisscross pattern and minimum of four stages.

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## **Fusion Bonded Epoxy Coated Valves**

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**NOTICE**

Valves with fusion bonded epoxy coated exterior paint require flat washers to be installed under the flange nuts when installing the valve to the pipeline flange to prevent the coating from cracking or chipping.

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## **AVV-1800K Assembly**

**⚠ WARNING**

Assembling the Combination Valve incorrectly or while not wearing appropriate Personal Protective Equipment (PPE) can cause personal injury. In addition, when lifting, use appropriate lifting hooks/straps to avoid personal injury.

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**NOTICE**

Do not deflect the piping joints. While applying torque to tighten components, minimize bending stresses in the piping kit components.

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For the AVV-1800K, assemble the valves together as stated below:

1. Place the fully assembled AVV (Air/Vacuum Valve) on a flat surface.
2. Locate piping kit shipped with the valves.
3. **For 1-3" (25-80mm) AVV-140/140H Only:**

See Figures 1, 2, and 3 for part identification.

- a. Remove **ONLY** the pipe plug (A25) in the side of body (A01) if applicable.
  - i. **DO NOT remove pipe plug (A25) in the cover (A02).**
- b. Apply thread sealant to the threads in the port on the side of the Air/Vacuum Valve body (A01).
- c. Apply Teflon tape to the threads on the nipple (P6).
- d. Thread the nipple (P6) into the side port of the body (A01).
- e. Apply thread sealant to the threads in the elbow (P7).
- f. Thread the elbow (P7) onto the nipple (P6).
- g. Using a wrench, tighten the elbow (P7) until secure and until the elbow is orientated vertically with the exposed threads toward the top.
- h. Apply Teflon tape to the threads on the outside of the elbow (P7).
- i. Apply thread sealant to the threaded inlet of the Air Release Valve.
- j. Thread the inlet of the fully assembled Air Release Valve onto the elbow (P7).
- k. Using a chain wrench, tighten the Air Release Valve until secure.

**AVV-1800K Assembly (Continued)****4. For 4-18" (100-450mm) AVV Only:**

See Figures 1, 4, 5, 6, and 7 for part identification.

For information regarding larger Air/Vacuum Valves, contact your local DeZURIK sales representative.

- a. Remove **ONLY** the upper pipe plug (A44) in the side of the body (A01) if applicable.
  - i. **DO NOT remove the lower pipe plug (A44) in the side of the body (A01).**
- b. Apply thread sealant to the threads in the upper port on the side of the body (A01).
- c. Apply Teflon tape to the threads on the nipple (P5).
- d. Thread the nipple (P5) into the side port of the body (A01).
- e. Apply thread sealant to the threads in the ball valve (P8).
- f. Thread the ball valve (P8) onto the nipple (P5).
- g. Using a wrench, tighten the ball valve (P8) until secure and until the handle is positioned toward the side or bottom (**NOTE: The handle will be in the way if it is on top.**)
- h. Apply Teflon tape to the threads on the nipple (P6).
- i. Thread the nipple (P6) into the ball valve (P8).
- j. Apply thread sealant to the threads in the elbow (P7).
- k. Thread the elbow (P7) onto the nipple (P6).
- l. Using a wrench, tighten the elbow (P7) until secure and until the elbow is orientated vertical with the exposed threads toward the top.
- m. Apply Teflon tape to the threads on the outside of the elbow (P7).
- n. Apply thread sealant to the threaded inlet of the ARV Air Release Valve.
- o. **For the ARV-200 Air Release Valve Only** (refer to Figure 7):
  - i. Apply Teflon tape to the threads on the outside of the reducer bushing (P9).
  - ii. Thread the reducer bushing (P9) into the inlet of the ARV-200.
  - iii. Using a wrench, tighten the reducer bushing (P9) until secure.
  - iv. Apply thread sealant to the threads on the inside of the reducer bushing (P9).
- p. Thread the inlet of the fully assembled ARV Air Release Valve onto the elbow (P7).
- q. Using a chain wrench, tighten the ARV Air Release Valve until secure.

5. Test the unit according to number 9 of the assembly procedure in the Maintenance section.

## Maintenance

Combination Air Valves are automatic in operation and require very little or no maintenance. It is recommended that they be checked visually semi-annually for leakage. A malfunction of the valve will be evident by leakage of the media out of the orifice of plug stem or by the seating area of the exhaust port. Should a malfunction occur, the following steps should be taken to repair the valve.

### ***Disassembly Procedure***

#### ***AVV- 140 and 140H Valve 1-3" (25-80mm)***

See Figure 1 and Figure 2 for part identification.

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**▲WARNING**

**Servicing the Air Valve while the pipeline is under pressure can cause personal injury or equipment damage. Relieve pipeline pressure or shut off isolation valve before servicing the Air Valve.**

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1. Relieve pipeline pressure or shut off isolation valve on inlet pipe.
- 

**▲WARNING**

**Do not completely remove pipe plug or cover screws while the valve is under pressure.**

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2. Loosen pipe plug in cover (A02) to relieve internal pressure. Do not completely remove pipe plug (A02) while the valve is under pressure.
3. Inspect exhaust port on top. If any foreign matter or dirt is preventing float (A14) from seating properly against the seat (A06), clean or replace as necessary.
4. Perform a seat test: Replace pipe plug and slowly fill valve chamber by cracking open isolation valve on inlet pipe. If seepage persists, repeat steps 1 and 2 and proceed as follows:
5. Remove cover screws (A04) and cover (A02) with all the internal components together from the valve body (A01).

***Maintenance (Continued)******AVV-140 with AVRT Option Disassembly Procedure***

See Figures 1A & 1B for part identification.

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**⚠WARNING**

**Servicing the Air/Vacuum Valve while the pipeline is under pressure can cause personal injury or equipment damage. Relieve pipeline pressure or shut off isolation valve before servicing the Air/Vacuum Valve.**

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1. Relieve pipeline pressure or shut off isolation valve on inlet pipe.
- 

**⚠WARNING**

**Do not completely remove pipe plug or cover screws while the valve is under pressure**

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2. Loosen pipe plug (A25) in cover (A02) to relieve internal pressure. Do not completely remove pipe plug (A25) while the valve is under pressure.
3. Inspect exhaust port and mushroom cap assembly (A28, A29, & A30). If any foreign matter or dirt is preventing float (A14) from seating properly against the seat (A06), clean or replace as necessary.
4. Perform a seat test: Replace pipe plug (A25) and slowly fill valve chamber by cracking open isolation valve on inlet pipe. If seepage persists, repeat steps 1 and 2 and proceed as follows:
5. Remove cover screws (A04) and cover (A02) with all the internal components together from the valve body (A01).
6. Remove baffle screws (A34) and baffle (A24) and lift out seat (A06) from the recess in the cover (A02).
7. Remove float (A14), spring (A42), float guide (A33) and baffle plug (A41) from baffle (A24).
8. Clean all surfaces before re-assembly. Replace all defective parts.



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**Maintenance (Continued)****AVV-150 Air/Vacuum Valve 4-18" (100-450mm) Disassembly**

See Figure 4 for part identification.

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**⚠ WARNING**

**Servicing the Air/Vacuum Valve while the pipeline is under pressure can cause personal injury or equipment damage. Relieve pipeline pressure or shut off isolation valve before servicing the Air/Vacuum Valve.**

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1. Relieve pipeline pressure or shut off isolation valve at inlet to Air/Vacuum Valve before servicing the Air Valve.
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**⚠ WARNING**

**Do not completely remove pipe plugs or cover bolts while the valve is under pressure.**

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2. Slowly remove pipe plug near inlet of valve body (A01) to relieve internal pressure and to drain the unit.
  3. Check to see if foreign matter or dirt is preventing float (A14) from seating properly against seat (A06). Clean as necessary.
  4. Perform a seat test. Replace pipe plug and slowly fill valve chamber by cracking open isolation valve on inlet pipe. If seepage persists, repeat Steps 1 and 2 and proceed as follows:
  5. Remove cover bolts (A04) and cover (A02).
  6. Remove seat screws (A16/A34) and remove seat (A06) from cover (A02).
  7. Inspect seat (A06) and float (A14) seating surfaces for damage. Replace if necessary.
  8. Inspect all other parts of the valve such as guide bushings (A26 & A43), bumper (A40), and float guide (A33) if applicable. Replace if necessary.
- 

**ARV-50A/200A/200 Air Release Valve Disassembly**

See Figures 5, 6, and 7 for part identification.

1. Remove cover bolts (R04) and cover (R02) from the valve body (R01).  
**Note:** All internals are attached to the cover.
2. If cover gasket (R03) is torn or damaged, clean flange surfaces of cover (R02) and body (R01), replace cover gasket (R03).
3. Clean and inspect all components attached to the cover (R02).
4. Inspect float (R10/R14) for the presence of water inside float. Replace float if damaged.

## ***Maintenance (Continued)***

### ***Assembly Procedure***

#### ***ARV-50A/200A/200 Air Release Valve Assembly***

See Figures 5, 6, and 7 for part identification.

1. Assemble cover (R02) and attached components to body (R01), installing new gasket (R03) if necessary. Tighten bolts (R04) opposite each other in rotation.

#### ***AVV-150 Air/Vacuum Valves 4-18" (100-450mm) Assembly***

See Figures 4 for part identification.

1. Clean surface of recess in cover (A02) and install seat (A06) with seat screws (A16).
2. Install bumper (A40) and float (A14) in place.
3. Assemble cover (A02) and gasket (A03) to body (A01). Tighten cover screws (A04) alternating in a crisscross pattern.
4. Install and secure pipe plug (A44) and move onto **Testing** section to perform a seat test.

#### ***AVV-140/140H Air/Vacuum Valves 1-3" (25-75mm) Assembly***

See Figures 2 and 3 for part identification.

1. Install float (A14) and baffle plug (A41) if included with float guide (A33) to baffle (A24).

**For 3" valve size:** Secure float (A14) together with float guide (A33) to the baffle (A24) with float bushing (A26).

2. Install seat (A06) to cover (A02).
3. With cover (A02) lying upside down on a level work bench, set the baffle assembly created in steps 1 & 2 in cover (A02). Align and match screw holes through the baffle (A24), seat (A06), and cover (A02), by inserting and turning baffle screw (A34) with fingers.
4. Before tightening baffle screws (A34) with an open (box) wrench, position baffle (A24) by allowing float (A14) to center perfectly in the seat (A06), then tighten baffle screws (A34) alternating in a crisscross pattern.
5. If water diffuser is required, remove baffle plug (A41) with the float guide (A33) and slip the water diffuser around the baffle (A24). Then secure float (A14) and water diffuser to baffle (A24) with baffle plug (A41) and float guide (A33).

**For 3" valve size:** Remove float guide (A33) and slip water diffuser around the baffle (A24). Then secure float (A14) and water diffuser in place with the float guide (A33).

6. Install new cover gasket (A03) and set cover (A02) assembly to the body (A01), then tighten cover screws (A04) alternating in a crisscross pattern.
7. Install and secure pipe plug (A25) and move onto **Testing** section to perform a seat test.

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**Maintenance (Continued)****AVV-140 with AVRT Option Assembly Procedure**

1. Install baffle plug (A41), float guide (A33), spring (A42), and float (A14) to baffle (A24). Replace any damaged parts.

**For 3" valve size:** Secure float (A14), spring (A42), and float guide (A33) to the baffle (A24) with float bushing (A26).

2. Install seat (A06) to cover (A02).
3. With cover (A02) lying upside down on a level work bench, set the baffle assembly on cover (A02). Align and match screw holes through the baffle (A24), seat (A06), and cover (A02), by inserting and turning baffle screw (A34) with fingers.
4. Before tightening baffle screws (A34) with an open (box) wrench, position baffle (A24) by allowing float (A14) to center perfectly in the seat (A06), then tighten baffle screws alternating in a crisscross pattern.
5. If water diffuser is required, remove baffle plug (A41) with the float guide (A33) and slip the water diffuser around the baffle (A24). Then secure float (A14), spring (A42), and float guide (A33) to the baffle (A24) with float bushing (A26).

**For 3" valve size:** Remove float guide (A33) and slip water diffuser around the baffle (A24). Then secure float (A14) and water diffuser in place with the float guide.

6. Install new cover gasket (A03) and set cover (A02) assembly to the body (A01), then tighten cover screws (A04) alternating in a crisscross pattern.
7. Install and secure pipe plug (A25) and move onto **Testing** section to perform a seat test.

**Testing**

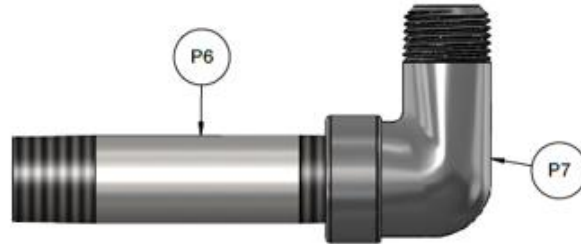
See Figures 2-6 for part identification.

1. Perform a seat test. Restore pipeline pressure and slowly fill the Air/Vacuum valve chamber by cracking open the isolation valve below Air/Vacuum Valve. If seepage occurs once the float (A14) or needle (R07) is in contact with the seat (A06/R06), reference to the "Disassembly Procedure" and replace seat, needle, and/or float.
2. If there is no seepage during the seat test, fully open isolation valve.

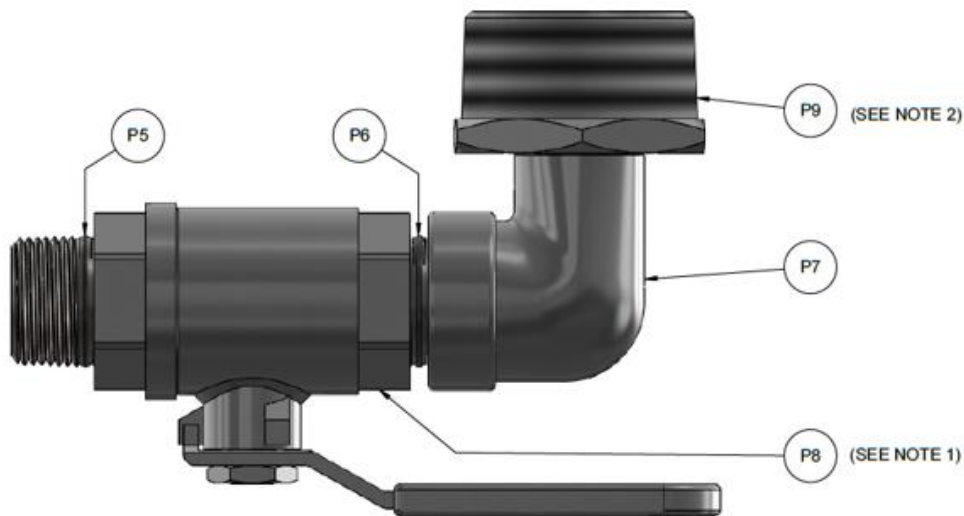
**Operation**

Combination Air Valves prevent accumulation of air at high points within a system by exhausting large volumes of air as the system is filled and releasing accumulated pockets of air while the system is operational and under pressure. They also prevent potentially destructive vacuums from forming by admitting large quantities of air into the system. This can occur during power outage, water column separation or sudden rupture of the pipeline. Additionally, these valves allow the system to be easily drained because air will re-enter as needed.

## Drawings



FOR 1-3" AVV DUAL BODY ONLY

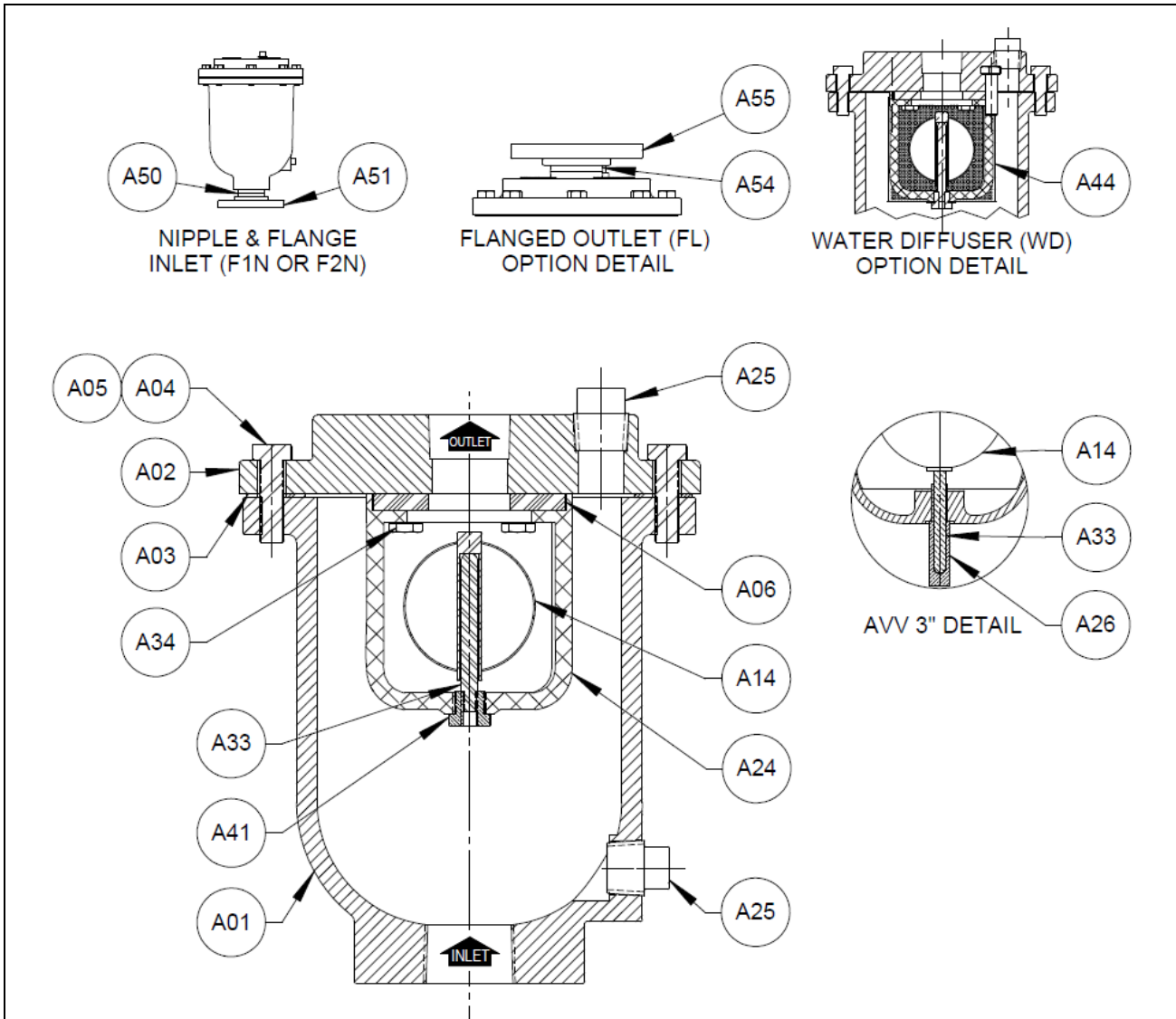


FOR 4-18" AVV DUAL BODY ONLY

<i>Item No.</i>	<i>Description</i>
P5	Nipple
P6	Nipple
P7	Elbow
P8	Ball Valve or Gate Valve (See Note 1)
P9	Reducer Bushing (See Note 2)
Notes:	
1. A ball valve is used for clean water and a gate valve is used for sewage valves.	
2. The reducer bushing is only used when the ARV 200 is used.	

**Figure 1: Connecting Parts for Dual Body AVV**

### Drawings (Continued)

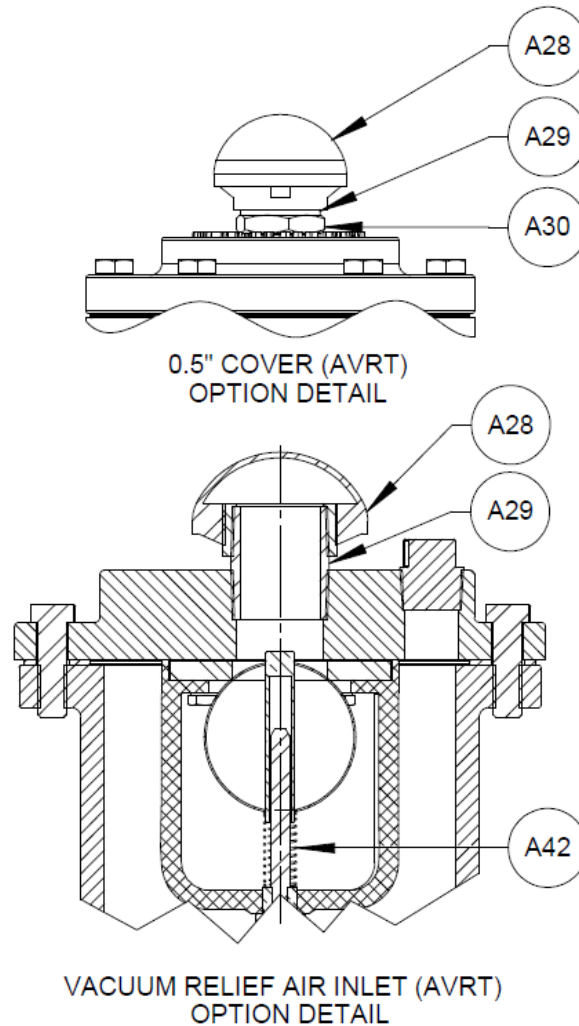


Part No.	Description
A01	Body
A02	Cover
A03	Cover Gasket
A04	Cover Bolts
A05	Washer
A06	Seat
A14	Float
A24	Baffle
A25	Pipe Plug

Part No.	Description
A26	Float Bushing
A33	Float Guide
A34	Baffle Screws
A41	Baffle Plug
A44	Water Diffuser (WD Option)
A50	Inlet Nipple (F1N/F2N Only)
A51	Inlet Flange (F1N/F2N Only)
A54	Outlet Nipple (FL Only)
A55	Outlet Flange (FL Only)

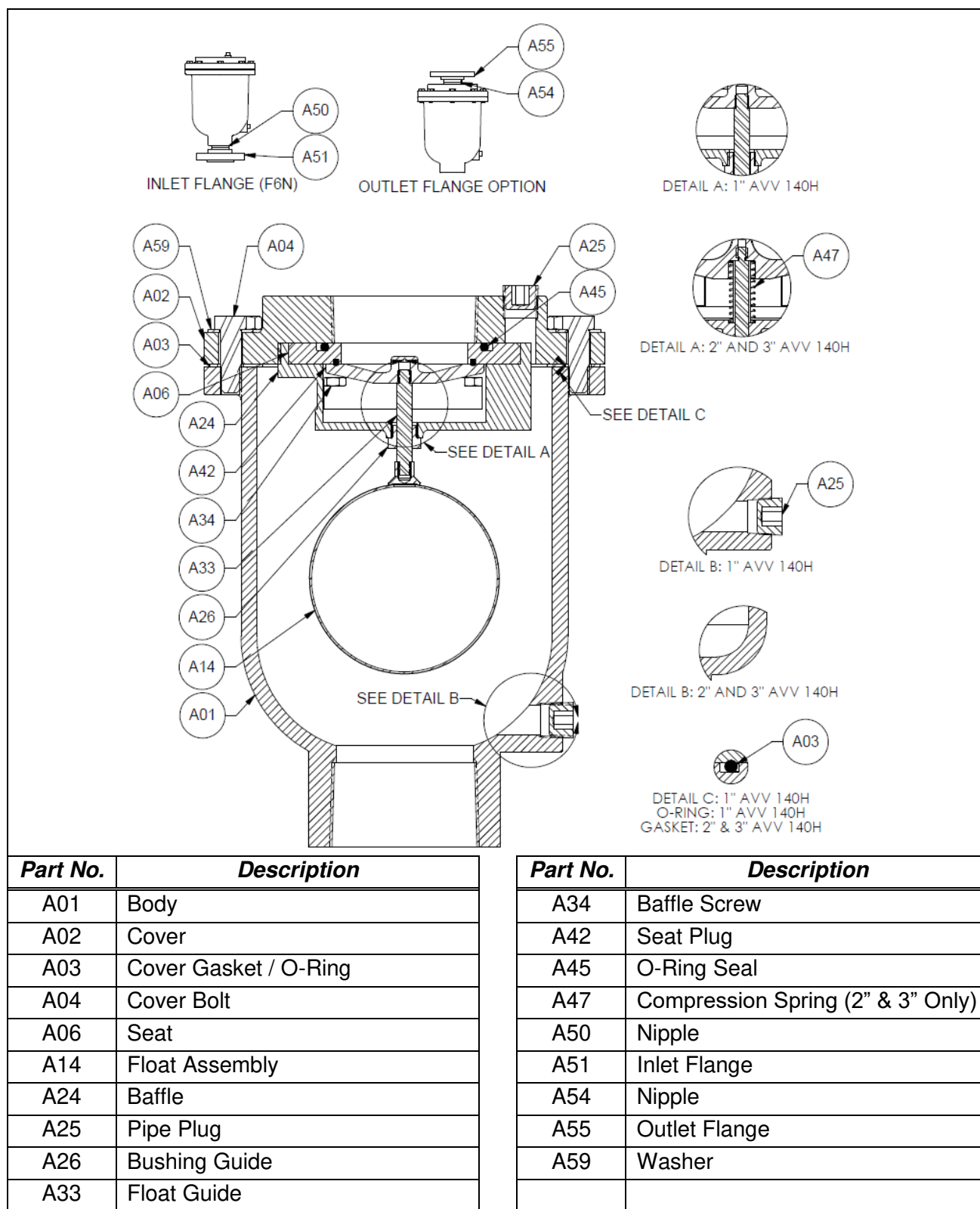
**Figure 2A: AVV-140 0.5-3" (15-80mm) Air/Vacuum Valve**

**Drawings** *(Continued)*



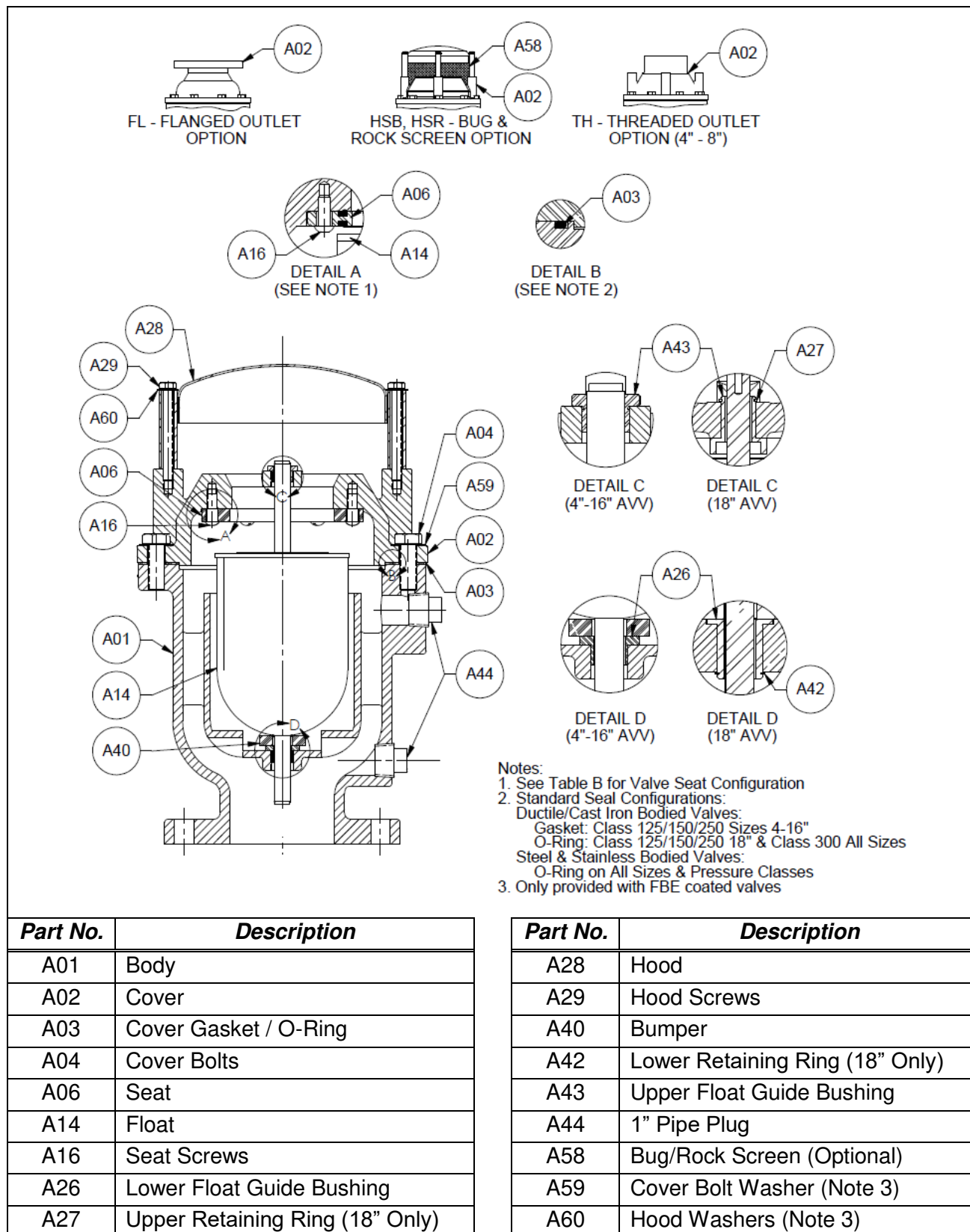
<b>Part No.</b>	<b>Description</b>
A28	Mushroom Cap
A29	Pipe Nipple
A30	Reducer Bushing (0.5" AVRT Option Only)
A42	Spring

**Figure 2B: AVV-140 AVRT Option**

**Drawings (Continued)**


**Figure 3: AVV-140H 1-3" (25-80mm) Air/Vacuum Valve for High Pressure Service**

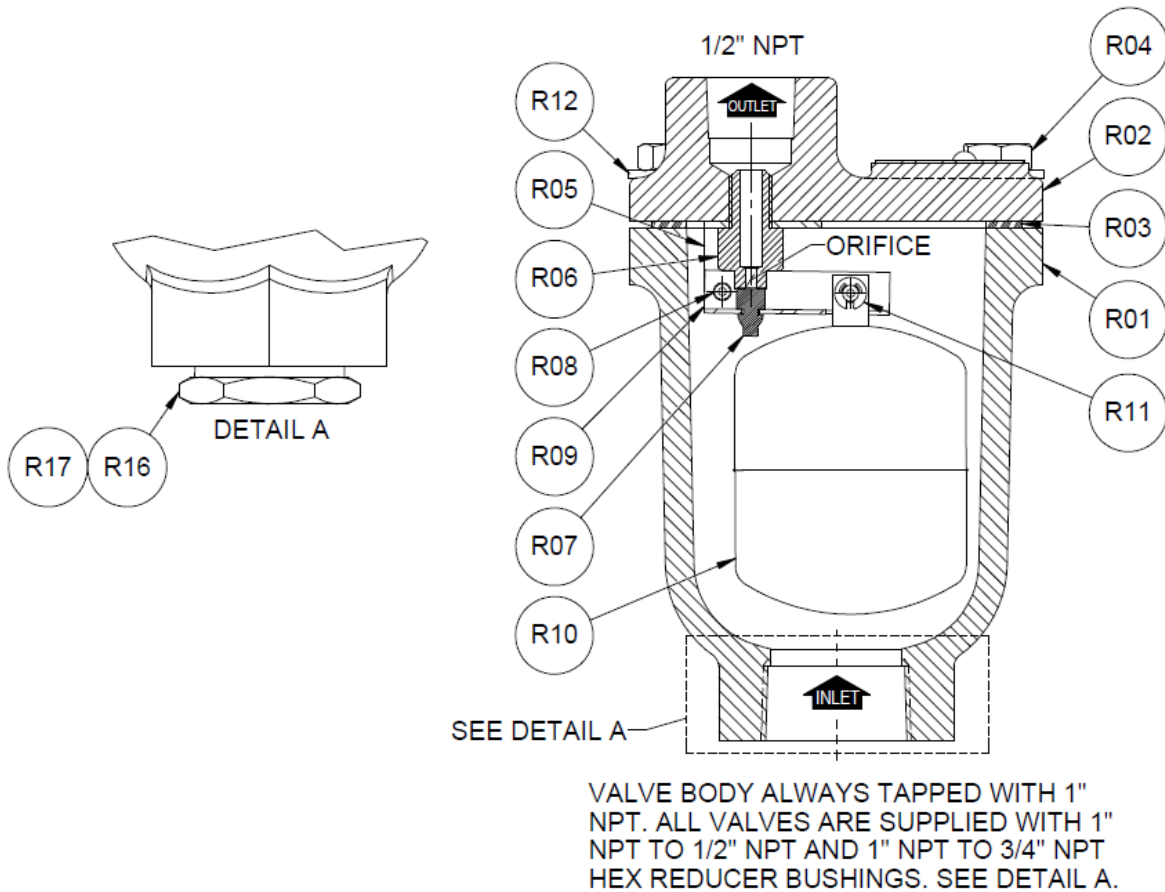
**Drawings (Continued)**



**Figure 4: AVV-150 4-18" (100-450mm) Air/Vacuum Valve**



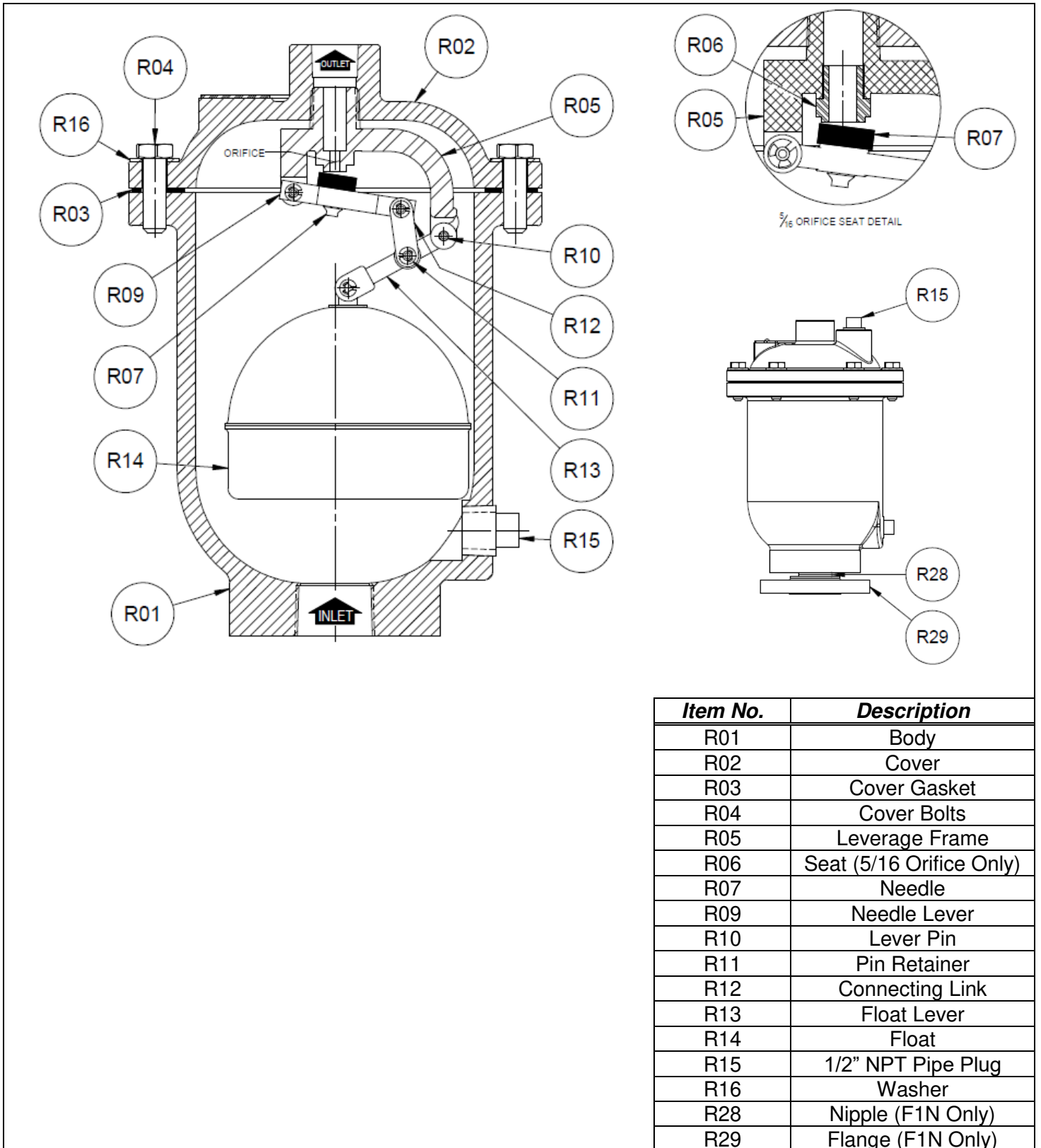
**Drawings** (Continued)



Item No.	Description
R01	Body
R02	Cover
R03	Cover Gasket
R04	Cover Bolts
R05	Lever Frame
R06	Seat
R07	Needle
R08	Lever Pin
R09	Float Lever
R10	Float
R11	Pin Retainer
R12	Washer (Epoxy/FBE Coating Only)
R16	1" NPT to 3/4" NPT Reducer
R17	1" NPT to 1/2" NPT Reducer

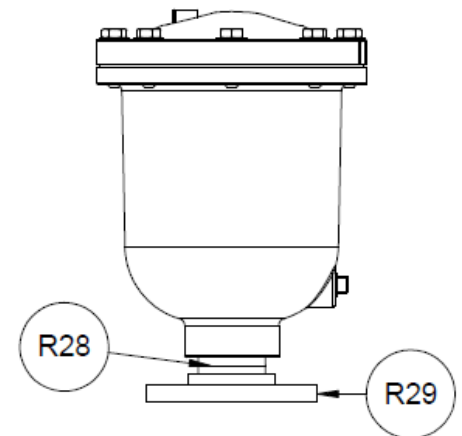
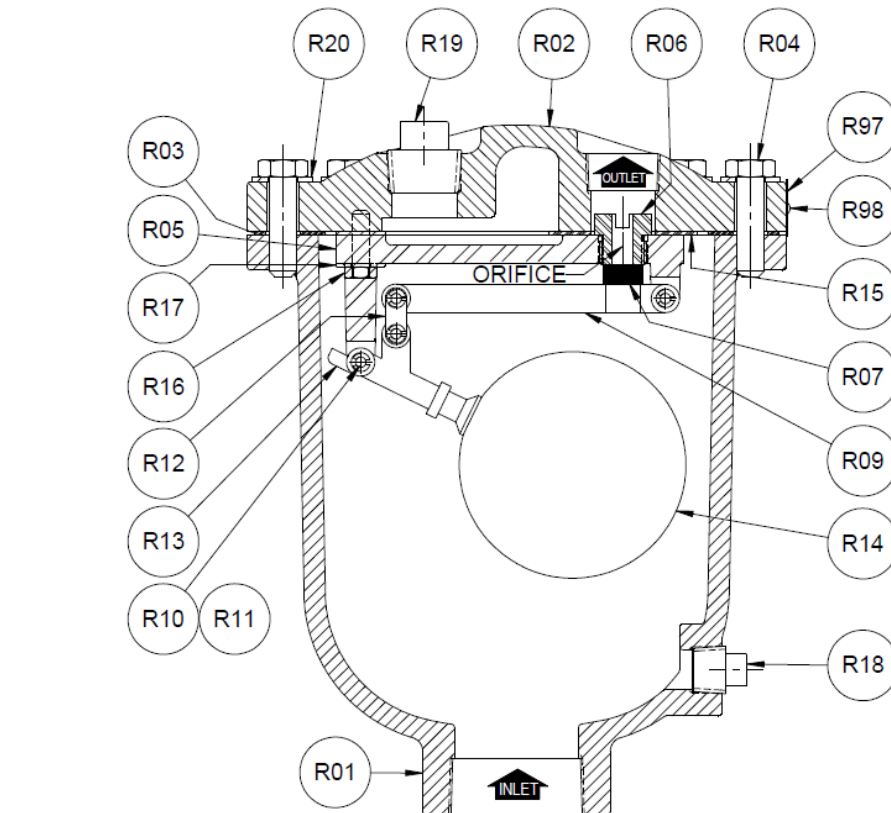
**Figure 5: ARV-50A Air Release Valve**

**Drawings** (Continued)



**Figure 6: ARV-200A Air Release Valve**

**Drawings** (Continued)



OPTIONAL NIPPLE AND FLANGE  
INLET (F1N OR F2N)

Item No.	Description
R01	Body
R02	Cover
R03	Cover Gasket
R04	Cover Bolts
R05	Leverage Frame
R06	Seat
R07	Needle
R09	Needle Lever
R10	Lever Pin
R11	Retaining Ring/Cotter Pin
R12	Connecting Link
R13	Float Lever
R14	Float
R15	Leverage Frame Gasket
R16	Leverage Frame Screw
R17	Leverage Frame Washer
R18	1/2" NPT Drain Pipe Plug
R19	1" NPT Pipe Plug
R20	SAE Flat Washer
R28	Nipple (F1N and F2N Only)
R29	Flange (F1N and F2N Only)

**Figure 7: ARV-200 Air Release Valve**

## Troubleshooting

Condition	Possible Cause	Corrective Action
Valve leaks at flange joint.	Loose flange bolting.	Tighten flange bolting.
	Blown flange gasket.	Replace flange gasket.
	Misalignment or damage to field piping and supports.	Adjust misalignment or repair piping or supports.
	Damaged flange face/s or improper flange connections.	Repair flange, replace valve body or adjust flange connections.
Valve leaks out of outlet port.	Line pressure is under 10 psi (70kPa).	Contact factory for low pressure application information.
	Worn needle and/or orifice.	Replace needle and/or orifice.
	Float does not move freely.	Readjust position of leverage frame to cover.
	Float has liquid in it.	Replace float.
	Dirty seat and/or float.	Clean seat and/or float.
	Worn seat and/or float.	Replace seat and/or float.
	Dirty needle and/or orifice of leverage frame.	Clean needle and/or orifice of leverage frame.
	Float linkage is dirty.	Clean float linkage.

## Limited Warranty

DeZURIK, Inc. ("Seller") manufactured products, auxiliaries and parts thereof that we manufacture for a period of twenty-four (24) months from date of shipment from Seller's factory, are warranted to the original purchaser only against defective workmanship and material, but only if properly stored, installed, operated, and serviced in accordance with Seller's recommendations and instructions.

For items proven to be defective within the warranty period, your exclusive remedy under this limited warranty is repair or replacement of the defective item, at Seller's option, FCA Incoterms 2020 Seller's facility with removal, transportation, and installation at your cost.

Products or parts manufactured by others but furnished by Seller are not covered by this limited warranty. Seller may provide repair or replacement for other's products or parts only to the extent provided in and honored by the original manufacturer's warranty to Seller, in each case subject to the limitations contained in the original manufacturer's warranty.

No claim for transportation, labor, or special or consequential damages or any other loss, cost or damage is being provided in this limited warranty. You shall be solely responsible for determining suitability for use and in no event shall Seller be liable in this respect.

This limited warranty does not warrant that any Seller product or part is resistant to corrosion, erosion, abrasion or other sources of failure, nor does Seller warrant a minimum length of service.

Your failure to give written notice to us of any alleged defect under this warranty within twenty (20) days of its discovery, or attempts by someone other than Seller or its authorized representatives to remedy the alleged defects therein, or failure to return product or parts for repair or replacement as herein provided, or failure to store, install, or operate said products and parts according to the recommendations and instructions furnished by Seller shall be a waiver by you of all rights under this limited warranty.

This limited warranty is voided by any misuse, modification, abuse or alteration of Seller's product or part, accident, fire, flood or other Act of God, or your failure to pay entire contract price when due.

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