

 **Engineered
Valves**
Maintenance Manual

Advantage® 2.1 Actuator



ITT





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1 Introduction and Safety

1.1 Safety message levels

Definitions

Safety message level	Indication
 DANGER:	A hazardous situation which, if not avoided, will result in death or serious injury
 WARNING:	A hazardous situation which, if not avoided, could result in death or serious injury
 CAUTION:	A hazardous situation which, if not avoided, could result in minor or moderate injury
 ELECTRICAL HAZARD:	The possibility of electrical risks if instructions are not followed in a proper manner
NOTICE:	<ul style="list-style-type: none"> • A potential situation which, if not avoided, could result in an undesirable result or state • A practice not related to personal injury

1.2 User health and safety

General precautions

This product is designed and manufactured using good workmanship and materials, and meets all applicable industry standards. This product should be used only as recommended by ITT.



WARNING:

- Misapplication of the valve can result in injury or property damage. Select valves and valve components of the proper materials and make sure that they are consistent with your specific performance requirements. Incorrect application of this product includes but is not limited to:
 - Exceeding the pressure or temperature rating
 - Failing to maintain this product according to the recommendations
 - Using this product to contain or control media that is incompatible with the materials of construction

Qualifications and training

The personnel responsible for the assembly, operation, inspection, and maintenance of the valve must be appropriately qualified. The operating company must do the following tasks:

- Define the responsibilities and competency of all personnel handling this equipment.
- Provide instruction and training.

- Ensure that the contents of the operating instructions have been fully understood by the personnel.

Instruction and training can be carried out by either ITT or the reseller of the valve by order of the operating company

**WARNING:**

California Proposition 65 Cancer <http://www.P65Warnings.ca.gov>. Plastics in product contain Glass Wool Fibers, known to the State of California to cause cancer. Wash hands after handling.

Non-compliance risks

Failure to comply with all safety precautions can result in the following conditions:

- Death or serious injury due to electrical, mechanical, and chemical influences
- Environmental damage due to the leakage of dangerous materials
- Product damage
- Property damage
- Loss of all claims for damages

Operational safety precautions

Be aware of these safety precautions when operating this product:

- Do not remove the contact guard for moving parts when the product is in operation. Never operate the product without the contact guard installed.
- Do not hang items from the product. Any accessories must be firmly or permanently attached.
- Do not use the product as a step or hand hold.
- Do not paint over the identification tag, warnings, notices, or other identification marks associated with the product.

Maintenance safety precautions

Be aware of these safety precautions when performing maintenance on this product:

- You must decontaminate the product if it has been exposed to harmful substances such as caustic chemicals.

Use of unauthorized parts

Reconstruction or modification of the product is only permissible after consultation with ITT. Genuine spare parts and accessories authorized by ITT serve to maintain safety. Use of non-genuine ITT parts can annul liability of the manufacturer for the consequences. ITT parts are not to be used in conjunction with products not supplied by ITT as this improper use can annul all liability for the consequences.

Unacceptable modes of operation

The operational reliability of this product is only guaranteed when it is used as designated. The operating limits given on the identification tag and in the data sheet may not be exceeded under any circumstances. If the identification tag is missing or worn, contact ITT for specific instructions.

2 Product Description

2.1 Actuator identification

Design Overview

The actuator is a spring or double acting pneumatic actuator.

To determine if you have an Advantage actuator or an Advantage actuator 2.1 locate the spindle compressor connection and determine if you have a pin connection or modular compressor design.



Figure 1: Pin connection for Advantage actuator



Figure 2: Compressor for Advantage 2.0 actuator

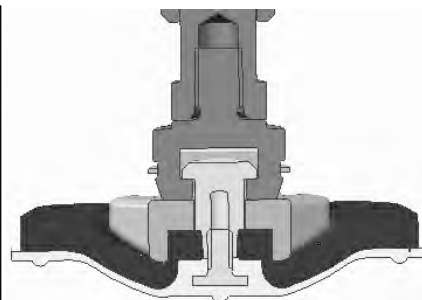


Figure 3: Modular compressor with snap ring retention for Advantage 2.1 actuator

Model number

The actuator model number is located on the ITT identification tag. The model number is a four digit number defining the actuator as follows.

Table 1: Actuator

Code	Description
B	Advantage 2.1 actuator

Table 2: Mode of operation

Code	Description
1	Fail open (spring to open, air to close) (direct acting)
2	Fail close (spring to close, air to open) (reverse acting)
3	Double acting (air to open, air to close)

Table 3: Actuator series

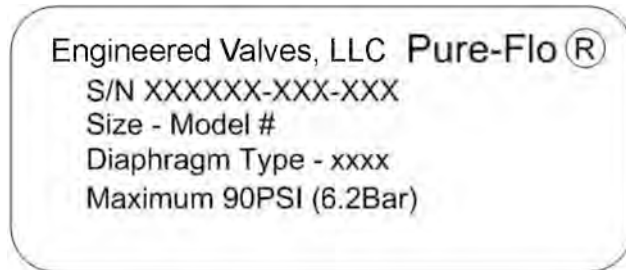
Code*1	Actuator series*2
03, 04	3
05, 06	5
08, 09	8
16, 17	16

*1 For fail close actuators, codes are specific spring combinations.

*2 Series number equates to diaphragm effective area.

Table 4: Examples

Model number	Description
B308	Advantage 2.1 actuator, double acting, series 8
B216	Advantage 2.1 actuator, fail close, series 16 with a spring set

Identification tag

Line	Description
1	Valve serial number
2	Valve size and model number
3	Valve diaphragm type
4	Maximum recommended actuation pressure

2.2 Bonnet description

Non-Sealed bonnet

The non-sealed bonnet has a weep hole that indicates a diaphragm failure by allowing process fluid that accumulates in the bonnet to pass through the hole.

2.3 Valve diaphragm identification

Diaphragm tab codes

All diaphragm materials and physical properties are batch traceable via permanent codes molded into the diaphragm tabs. The molding date, grade of diaphragm, and size provide traceability to original batch records.



1. Date code
2. Supplier code

Figure 4: Elastomer diaphragm front



1. Valve size
2. Grade of diaphragm

Figure 5: Elastomer diaphragm back



1. Material code
2. Date code

Figure 6: PTFE diaphragm

3 Maintenance

3.1 Precautions



WARNING:

- All procedures must be performed by qualified personnel.
- When the process fluid is hazardous, thermal (hot or cold), or corrosive, take extra precautions. Employ the appropriate safety devices and be prepared to control a process media leak.
- Always wear protective clothing and equipment to safeguard the eyes, face, hands, skin, and lungs from the fluid in the line.
- Do not disassemble the actuator in the field. The actuator contains energized springs which can cause injury. The product is designed to be recycled in its entirety.



CAUTION:

- Disconnect electrical, pneumatic, and hydraulic power before servicing actuator or automation components.

3.2 Inspection

Inspection area	What to look for	Action if problem is found
External valve parts	Excessive wear or corrosion	<ul style="list-style-type: none"> • Replace the affected parts • Contact ITT to obtain replacement parts or for specific instructions
Non sealed bonnet	Fluid weeping from the plug	Replace the valve diaphragm
Actuator's bonnet weep hole and air ports	Air pressure	Contact ITT for specific instructions
Topworks	Spindle binding, excessive noise, or dried lubricant	Contact ITT for specific instructions
Diaphragm and valve body	Leakage between the diaphragm and valve body	Tighten the bonnet fasteners

For more information, see:

- [3.5 Replace the valve diaphragm on page 8](#)
- [3.3 Tighten the bonnet fasteners on page 7](#)

3.3 Tighten the bonnet fasteners



CAUTION:

Do not tighten fasteners while the system is pressurized or at elevated temperatures (greater than 38°C | 100°F).

1. Depressurize the system.
2. Use regulated air pressure to position diaphragm so that valve is slightly open. You may need to use air pressure to actuate the valve.

3.4 Disassemble the valve

- Tighten the bonnet fasteners in a crisscross pattern.
For more information, see [3.3.1 Fastener torque table for valve body to topworks on page 8](#).
- Make multiple crisscross passes to build up torque to the final table value. Make additional crisscross passes using final table values to evenly tighten each fastener to within 5% of torque value.
- Retighten the bonnet fasteners as noted above at ambient conditions after the system has cycled through operating pressure and temperature.
- Monitor the valve for leakage:

If leakage ...	Then ...
Occurs at the body/bonnet flange sealing area	Depressurize the system and retighten the bonnet fasteners as noted above.
Continues	Depressurize the system and retighten the bonnet fasteners as noted above. (maximum 3rd re-torque)
Continues	Replace the valve diaphragm.

For more information, see [3.5 Replace the valve diaphragm on page 8](#).

3.3.1 Fastener torque table for valve body to topworks

Values given are for lubricated fasteners.

Valve size		Bolt size		PTFE diaphragm		Elastomer diaphragm	
DN	Inch	Metric	Imperial	N-m	in-lb	N-m	in-lb
Bio-Tek (8, 10, 15)	Bio-Tek (0.25, 0.375, 0.50)	M4	#6	2.3-2.8	20-25	2.3-2.8	20-25
15	0.50	M6	1/4"	2.8-6.8	25-60	2.3-4.5	20-40
20	0.75	M6	1/4"	5.7-9.1	50-65	2.3-5.7	20-50
25	1.00	M8	5/16"	7.4-11.3	65-90	5.1-7.9	45-70
40	1.50	M10	3/8"	23-25	200-225	8.5-14.7	75-130
50	2.00	M12	7/16"	25-31	225-275	11-20	100-180

3.4 Disassemble the valve

- Remove all line pressure.
- If the actuator mode of operation is fail open or fail close, then load the actuator with air.

If the actuator mode of operation is ...	Then ...
Fail open	Load the actuator with sufficient air to partially close the valve.
Fail close	Load the actuator with sufficient air to partially open the valve.

- Remove the bonnet fasteners.
- Lift the topworks assembly from the valve body.
- If the actuator mode of operation is fail open, then remove pressure load from the actuator.

3.5 Replace the valve diaphragm

- Disassemble the valve.
For more information, see [3.4 Disassemble the valve on page 8](#).
- Unscrew the diaphragm from the compressor by turning the diaphragm counterclockwise.
The replacement diaphragm should be identical in size and grade to the original diaphragm.
- Rotate the diaphragm until hard stop or heavy resistance is achieved and additional force does not significantly rotate the diaphragm into the compressor.



4. If replacing a PTFE diaphragm, re-invert the diaphragm.



5. If the actuator mode of operation is fail open or fail close, select one of these steps.

If the actuator mode of operation is ...	Then ...
Fail open	Reduce the air pressure until the back of the diaphragm is flat against the bonnet.
Fail close	<ol style="list-style-type: none"> 1. Connect the air line to the bonnet's cylinder. 2. Load the chamber with sufficient air to move the diaphragm upward until the back of diaphragm is flat against the bonnet. Do not apply excessive air pressure that results in inversion of the diaphragm.

6. For more information, see [3.3 Tighten the bonnet fasteners on page 7](#).
7. If the actuator mode of operation is fail open, then release the air, allowing the valve to open.

3.6 Adjust the travel (closing) stop

The travel stop is designed to prevent overloading of the diaphragm, thus prolonging diaphragm life. Travel stops are factory set and do not require routine adjustment. However, travel stop adjustment is recommended when replacing a valve diaphragm.

A travel stop is optional on series 3, 5, 8, and 16 actuators.

1. Release the air pressure in the actuator covers.
2. Loosen the jam nuts and back off one turn.
3. If the actuator is a double acting or fail open actuator, then apply enough pressure in the upper cover to close the valve.
4. For all modes of operation, turn the lower nut clockwise while preventing the adjusting bushing from rotating until the valve begins to leak.

5. Turn the lower nut counterclockwise while continuing to prevent the adjusting bushing from rotating until the valve stops leaking.
6. Tighten the jam nuts together.

3.7 Change the compressor, tube nut, and snap ring

To switch diaphragm types between EPDM and PTFE, the tube nut must be changed. Follow the steps below before you switch diaphragm types.

1. Insert a screw driver or similar thin blade between compressor and bonnet flange.



Figure 7: Remove the compressor

2. Apply light pressure to back side of compressor finger.
3. Remove compressor and snap ring assembly.



Figure 8: Compressor assembly

4. Replace with new snap ring, tube nut and compressor (only 0.5 and 0.75" sizes). Do not re-use snap ring.

3.8 Replace the spindle o-rings

1. Disconnect the air lines.
2. Remove any control packages.
3. Disassemble the valve.
For more information, see Disassemble the valve in this manual.
4. Disassemble the actuator.

- For more information, see Replace the actuator diaphragm and spring for proper mode of operation (fail open, fail close, or double acting) in this manual.
5. Withdraw the valve diaphragm, compressor, and spindle assembly from the bonnet.
 6. Replace the o-rings and lubricate the new o-rings.
For more information, see Lubrication requirements in this manual.
 7. Replace the valve diaphragm, compressor, and spindle assembly on the bonnet. Care must be used on the Bio-Tek to align the compressor T-slot with molded tabs in lower cover.
 8. Reassemble the actuator.
For more information, see Replace the actuator diaphragm and spring for proper mode of operation (fail open, fail close, or double acting) in this manual.
 9. Reassemble the valve.
 10. Reconnect the air lines.
 11. If the actuator mode of operation is fail open or double acting, then follow the steps below:
 - a) Examine the actuator upper cover for leakage past the indicating spindle o-ring seal.
 - b) If leakage is present, then replace the spindle o-rings.

3.9 Lubrication requirements

Lubrication schedule

Remove residual grease prior to re-lubrication. Lubricate the spindle, o-rings, and mating surfaces whenever the topworks is disassembled.

Acceptable lubricants

Brand	Lubricant type
Chevron	

3.10 Replace the actuator diaphragm and spring for fail open actuator

One fixture exists for the series 3, 5, and 8 actuators and one for the series 16 actuator.



CAUTION:

Actuator plates are under load. Series 3, 5, 8, and 16 fail open actuators contain powerful springs and should not be disassembled unless using ITT approved fixturing and fixturing methods.

1. If present, remove the switch package.
2. Disconnect the air lines.
3. ITT recommends that the following steps be performed on a bench with the body removed from the actuator:
 - a) Disassemble the valve.
For more information, see Disassemble the valve in this manual.
 - b) Unscrew the diaphragm from the compressor by turning it counterclockwise.
4. Remove the actuator fasteners and lift off the top cover.
5. Disassemble the actuator with a fixture:
 - a) Place the actuator in a fixture.
 - b) Loosen the indicator spindle two turns.

- c) Place the actuator centrally in the fixture, locating the compressor over the correct spacer, dependent on valve size, in the fixture lower plate.
 - d) Place the support plate and spacer plate on the actuator top plate.
 - e) Turn the fixture handwheel clockwise to remove the load from the indicator spindle.
 - f) Remove the spindle and turn the fixture handwheel counterclockwise until the spring load is relieved.
- Use care, as the spindle thread may pinch the actuator diaphragm and restrict spring extension.
6. Replace the actuator diaphragm and spring:
- a) Place the spring in the lower cover and set an actuator plate, concave side down, over the valve spindle.
 - b) Position the actuator in the fixture over the spacer.
 - c) Place the support plate on the actuator plate.
 - d) Set the spacer plate on top.
 - e) Turn the fixture handwheel clockwise and compress the spring until the actuator plate shoulders on the spindle.
- Use care to ensure the spindle goes through the actuator plate center hole.
- f) Slide the actuator diaphragm over the valve spindle using care to ensure the top hat is in the upper cover.
 - g) Position the actuator diaphragm so the bolt clearance holes line up with threaded inserts in lower cover.
7. Reassemble the actuator with a fixture:
- a) Place an actuator plate, concave side up, over the valve spindle.
 - b) Prepare spindle nut surface with Loctite 7649 Primer N.
 - c) Apply Blue Loctite #242 and thread the indicating spindle on the valve spindle by hand.
 - d) Turn the fixture handwheel counterclockwise to remove the load and remove the actuator from the fixture.
 - e) Clamp the slotted plate in a vise and pull so the actuator slips free.
 - f) Tighten the indicator spindle with a wrench using care to ensure the actuator diaphragm remains properly aligned.
 - g) Position the upper actuator cover so the 1/8" NPT inlets in the upper and lower covers are in line.
 - h) Tighten the actuator cover to cover fasteners.
- For more information, see Tighten the actuator cover to cover fasteners in this manual.

3.11 Replace the actuator diaphragm and spring for fail close actuator

One fixture exists for the series 3, 5, and 8 actuators and one for the series 16 actuator.

1. If present, remove the switch package.
 2. Disconnect the air lines.
 3. ITT recommends that the following steps be performed on a bench, with the body removed from the actuator:
 - a) Disassemble the valve.
- For more information, see Disassemble the valve in this manual.

- b) Unscrew the diaphragm from the compressor by turning it counterclockwise.
4. Apply air to the lower cover to simplify disassembly from the body, then release the air.
5. Remove the valve diaphragm and plastic indicator spindle plug (found on the spindles) by turning them counterclockwise.
6. Disassemble the actuator with a fixture:
 - a) Position the actuator centrally in a fixture, locating the compressor over the correct spacer in the fixture lower plate.
 - b) Drop the stem guide through the center of the fixture handwheel and position it in the actuator indicator spindle #10-24 UNC tapped hole (former plug location).
 - c) Turn the fixture handwheel clockwise until the stem rests on the actuator top cover.
 - d) Remove all the cover to cover caps, fasteners, and washers.
 - e) Turn the fixture handwheel counterclockwise until the spring load is relieved.
 - f) Remove the actuator upper cover, lift out spring(s), and unthread the indicator spindle.
 - g) Remove the top actuator plate and actuator diaphragm.
7. Replace the actuator diaphragm and spring:
 - a) Install the new actuator diaphragm (top hat up).
Be sure the diaphragm is positioned so the diaphragm bolt holes line up with the actuator cover bolt holes with no stretching of the diaphragm.
 - b) If the spring needs to be replaced, then install a new spring.
 - c) If the spring does not need to be replaced, then install an old spring.
8. Reassemble the actuator with a fixture:
 - a) Place the correct spacer, dependent on valve size, over the pin in the fixture lower plate.
 - b) Position the actuator sub-assembly, including spring(s) and upper cover, over the spacer (the compressor rests on the spacer).
 - c) Drop the stem guide through center of the fixture handwheel, actuator upper cover, and locate it in the actuator indicator.
 - d) Position the actuator upper cover so the 1/8" NPT inlets in the upper and lower covers are in line and the rod guides slide through the clearance holes.
 - e) Turn the handwheel clockwise to compress the spring(s) until the covers almost touch.
 - f) Remove the four threaded rod guides.
 - g) Start tightening the actuator cover fasteners and continue to compress the spring(s) until the covers touch.
 - h) Place the remaining washers and fasteners in the top cover.
 - i) Tighten the actuator cover to cover fasteners.
For more information, see Tighten the actuator cover to cover fasteners in this manual.

3.12 Replace the actuator diaphragm for double acting actuator

1. If present, remove the switch package
2. Disconnect the air lines.
3. ITT recommends that the following steps be performed on a bench with the body removed from the actuator:
 - a) Disassemble the valve.
For more information, see Disassemble the valve in this manual.
4. Remove the actuator fasteners and lift off the upper cover.

3.13 Tighten the actuator cover to cover fasteners

5. Remove the actuator top plate and actuator diaphragm.
6. Remove the indicating spindle
7. Install the new actuator diaphragm (top hat up).
Be sure the actuator diaphragm is positioned so the diaphragm bolt holes line up with the cover bolt holes with no stretching of the diaphragm.
8. Replace the actuator top plate and actuator diaphragm:
 - a) Prepare the spindle nut surface with Loctite 7649 Primer N.
 - b) Apply Blue Loctite #242 to the indicating spindle.
 - c) Replace the indicating spindle.
9. Assemble the upper cover using care to keep the air fitting in line with the lower cover air fitting.
10. Tighten the actuator cover to cover fasteners.
For more information, see Tighten the actuator cover to cover fasteners in this manual.

3.13 Tighten the actuator cover to cover fasteners

Tighten the bonnet fasteners in a crisscross pattern with proper torque.

1. Tighten the bonnet fasteners in a crisscross pattern in accordance with Fastener torque table for actuator cover to cover.
2. Make multiple crisscross passes to build up torque to final table values.

3.13.1 Fastener torque table for actuator cover to cover

Actuator series	Bolt size	Torque	
		Imperial	in-lb N-m
Series 3, 5, 8	#10	20	2.3
Series 16	1/4"	35	4.0

Values given are for lubricated fasteners.

Torques should be applied at near ambient conditions (less than 38°C | 100°F).

4 Parts Listing and Cross-Sectional Drawings

4.1 Advantage 2.1 actuator parts

List of parts

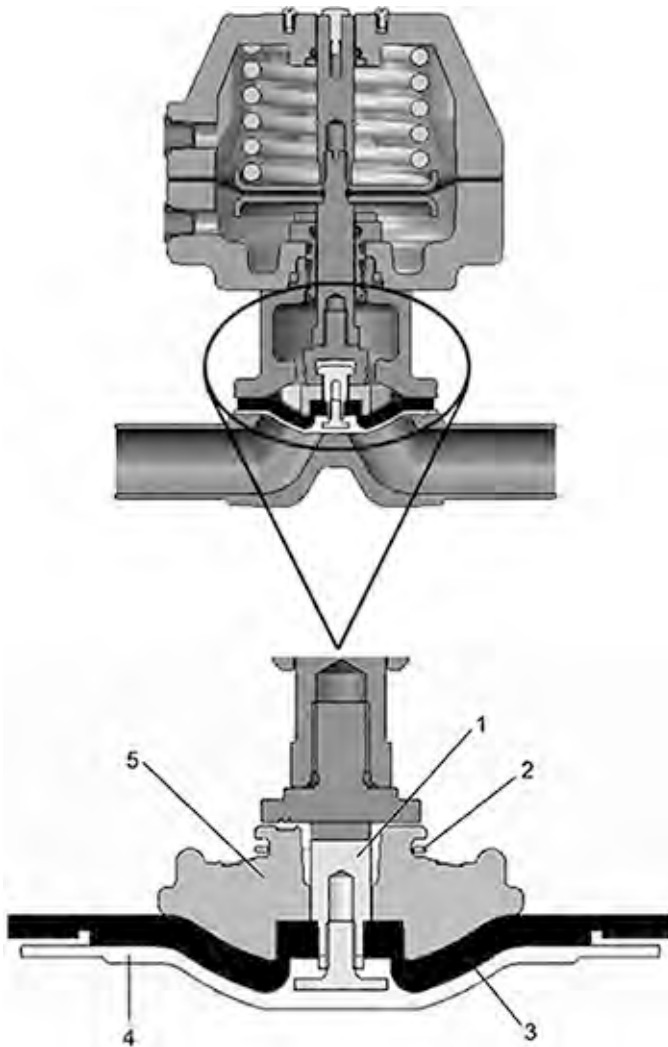


Figure 9: Fail closed actuator with compressor detail

Item	Description
1	Tube Nut
2	Snap Ring
3	Backing Cushion
4	PTFE Diaphragm
5	Compressor

5 Certifications

5.1 Declaration of Conformity



EC-Declaration of Conformity (Example only. Signed, applicable original declaration is included in valve's certification pack separately to this operating manual)

We herewith declare,

ITT Bornemann GmbH
Postfach 11 62, 31676 Obernkirchen, Germany
Fon +49 (0) 5724 390-0, Fax +49 (0) 5724 390-290,

that the valves of the series

Pure-Flo, EnviZion, BioviZion, Dia-Flo

are in conformity with the following EC-Directives, provided that the site conditions for the commissioning are met as specified in the engineering documents, in particular in the operation manual:

Machinery - Directive (2006/42/EC)

If applicable (please see certification package delivered with the product) the following separate declaration of conformity will be delivered with the individual order:

EMC - Directive (2014/30/EU)

ATEX - Directive (2014/34/EU)

PED - Directive (2014/68/EU)

Harmonized standards used:

- | |
|--|
| <ul style="list-style-type: none">• EN 19• EN 12516-3 |
|--|

Person authorized to compile the technical file: Maik Spannuth – Quality Manager

Obernkirchen, Date:

Managing Director

Technical Manager

05/2022, Rev. 01

<http://www.bornemann.com>





UKCA-Declaration of Conformity – (Example only. Signed, applicable original declaration is included in valve's certification pack separately to this operating manual)

We herewith declare,

ITT Bornemann GmbH
 Postfach 11 62, 31676 Obernkirchen, Germany
 Fon +49 (0) 5724 390-0, Fax +49 (0) 5724 390-290,

that the valves of the series

Pure-Flo, EnviZion, BioviZion, Dia-Flo

are in conformity with the following UK Regulations, provided that the site conditions for the commissioning are met as specified in the engineering documents, in particular in the operation manual:

Supply of Machinery (Safety) Regulation 2008 No 1597

If applicable (please see certification package delivered with the product) the following separate declaration of conformity will be delivered with the individual order:

Electromagnetic Compatibility Regulation 2016 No 1091

Equipment and Protective Systems Intended for Use in Potentially Explosive Atmospheres Regulations 2016 No 1107

Pressure Equipment (Safety) Regulations 2016 No 1005

Designated standards used:

- EN 19
- EN 12516-3

Person authorized to compile the technical file:

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 Norton House
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 United Kingdom

Obernkirchen, Date:

 Managing Director

 Technical Manager

05/2022, Rev. 01

<http://www.bornemann.com>



5.2 Declaration of Incorporation



EC-Declaration of Incorporation - (Example only. Signed, original declaration is included in valve's certification pack, separately to this operating manual)

according to Machinery Directive 2006/42 EC Annex II B

c

ITT Bornemann GmbH

Postfach 11 62, 31676 Obernkirchen, Germany

Fon +49 (0) 5724 390-0, Fax +49 (0) 5724 390-290,

that the incomplete machinery, actuators only, type:

Advantage 2.1, Advantage S33, ACS, Dia-Flo, ZA, ZB

Conform to the following basic requirements of the Machinery Directive (2006/42/EC) Annex I, article 1.1.2, 1.1.3, 1.1.5, 1.1.6, 1.2.1, 1.2.2, 1.2.3, 1.3.1, 1.3.2, 1.3.4, 1.3.7, and 1.3.9

Harmonized standards used:

- | |
|--|
| <ul style="list-style-type: none">• EN 19• EN 12516-3 |
|--|

The commissioning is prohibited until it has been established, that the machinery, into which the above mentioned machinery is to be installed, complies with the Machinery Directive (2006/42/EC).

We also declare that the relevant technical documentation for this incomplete machine was prepared according to Annex VII, Part B and commit ourselves to provide them in copy on demand to the market surveillance authorities.

For the compilation of this documentation is authorized: Maik Spannuth (Head of Quality Management)

Obernkirchen, Date:

Managing Director

Technical Manager

05/2022, Rev. 01

<http://www.bornemann.com>





UKCA-Declaration of Incorporation - (Example only. Signed, original declaration is included in valve's certification pack, separately to this operating manual)

according to Supply of Machinery (Safety) Regulation 2008 No 1597 annex II B

we herewith declare,

ITT Bornemann GmbH
 Postfach 11 62, 31676 Obernkirchen, Germany
 Fon +49 (0) 5724 390-0, Fax +49 (0) 5724 390-290,

that the incomplete machinery, Actuators only, Type:

Advantage 2.1, Advantage S33, ACS, Dia-Flo, ZA, ZB

Conform to the following basic requirements of the Supply of Machinery (Safety) Regulation 2008 No 1597: Annex I, article 1.1.2, 1.1.3, 1.1.5, 1.1.6, 1.2.1, 1.2.2, 1.2.3, 1.3.1, 1.3.2, 1.3.4, 1.3.7, and 1.3.9

Designated standards used:

- EN 19
- EN 12516-3

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