



OPERATING AND MAINTENANCE INSTRUCTIONS/  
SPARE PARTS

EDITION 01/2017

**Serving the Gas Industry  
Worldwide**

**Honeywell**

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#### 4.4 Parts for maintenance

item no.	designation	quantity	part number		
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##### Assembly unit for HON 330/332

			DN 80	DN 100	
403	damping washer	1	10 022 115	10 022 115	
407	O ring	1	00 020 430	00 020 430	
418	valve plate, vulcanised	1	10 008 606	10 008 606	
419	O ring	1	00 020 412	00 020 412	
421	O ring	1	00 020 243	00 020 243	
426	sealing ring	2	00 018 694	00 018 694	
429	diaphragm, at option				
429	for K4	1	10 008 545	10 008 545	
429	for K5	1	10 008 547	10 008 547	
429	for K6	1	10 008 549	10 008 549	
434	O ring	1	00 020 413	00 020 413	
436	O ring	1	00 020 383	00 020 383	
438	O ring	1	00 020 752	00 020 752	
442	O ring	1	00 020 266	00 020 268	
444	O ring	1	00 020 752	00 020 752	

##### Assembly unit for HON 408

			DN 50/100	DN 80/150	DN 100/200
403	damping washer	1	10 022 115	10 022 115	10 022 115
407	O ring	1	00 020 430	00 020 430	00 020 430
418	valve plate, vulcanised	1	10 008 606	10 008 606	10 008 606
419	O ring	1	00 020 412	00 020 412	00 020 412
421	O ring	1	00 020 243	00 020 243	00 020 243
426	sealing ring	2	00 018 694	00 018 694	00 018 694
429	diaphragm, at option				
429	for K4	1	10 008 545	10 008 545	10 008 545
429	for K5	1	10 008 547	10 008 547	10 008 547
429	for K6	1	10 008 549	10 008 549	10 008 549
434	O ring	1	00 020 413	00 020 413	00 020 413
436	O ring	1	00 020 383	00 020 383	00 020 383
438	O ring	1	00 020 752	00 020 752	00 020 752
442	O ring	1	00 020 596	00 020 266	00 020 268
444	O ring	1	00 020 752	00 020 752	00 020 752

##### Assembly unit for HON 402

			DNE 50	DNE 80	DNE 100
505	O ring	1	00 020 345	00 020 345	00 020 345
507	O ring	1	00 020 430	00 020 430	00 020 430
518	valve plate, vulcanised	1	10 008 606	10 008 606	10 008 606
519	O ring	1	00 020 412	00 020 412	00 020 412
521	O ring	1	00 020 243	00 020 243	00 020 243
526	O ring	2	00 018 694	00 018 694	00 018 694
529	diaphragm, at option				
529	for K4	1	10 008 545	10 008 545	10 008 545
529	for K5	1	10 008 547	10 008 547	10 008 547
529	for K6	1	10 008 549	10 008 549	10 008 549
534	O ring	1	00 020 413	00 020 413	00 020 413
536	O ring	1	00 020 383	00 020 383	00 020 383
538	O ring	1	00 020 752	00 020 752	00 020 752
542	O ring	1	00 020 596	00 020 266	00 020 268
543	damping washer	1	10 022 115	10 022 115	10 022 115

## 2. Special operating notices

### 2.1 Opening the safety shut-off valve (SAV)

The SAV is provided with an underpressure shut-off release. Re-engagement is possible only after pressure prevailing at the measuring point comes up to the service pressure. The pressure compensation necessary for re-opening is automatically effected by pressure compensating valve integrated in the valve plate.

#### Assembly unit for HON 330, HON 332, and HON 408

Press the top of the valve stem towards the main valve body.  
The sleeve (448) and a suitable tool (screwdriver) may be used as a lever. Press **slowly** and wait for pressure compensation.  
Push the valve stem all the way down to the stop and let it slide back slowly:  
*The SAV engages, and the valve plate stays open.*

#### Assembly unit for HON 402

Unscrew the re-engagement cap, turn over and screw onto the valve stem, then screw slowly onto the body:  
*The pressure compensating valve will then operate.*

Pull re-engagement cap back to the stop and allow to slide back slowly:



In order to ensure perfectly reliable SAV-release performance after re-engagement and to avoid damaging the valve stem, it is indispensable to screw the cap (501) back into its normal position.



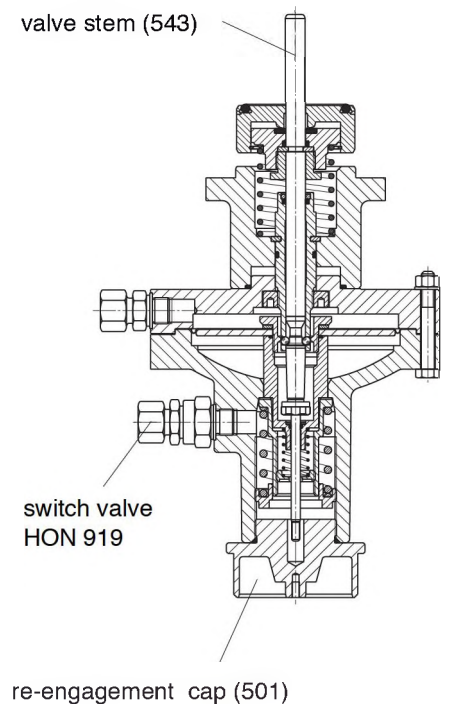
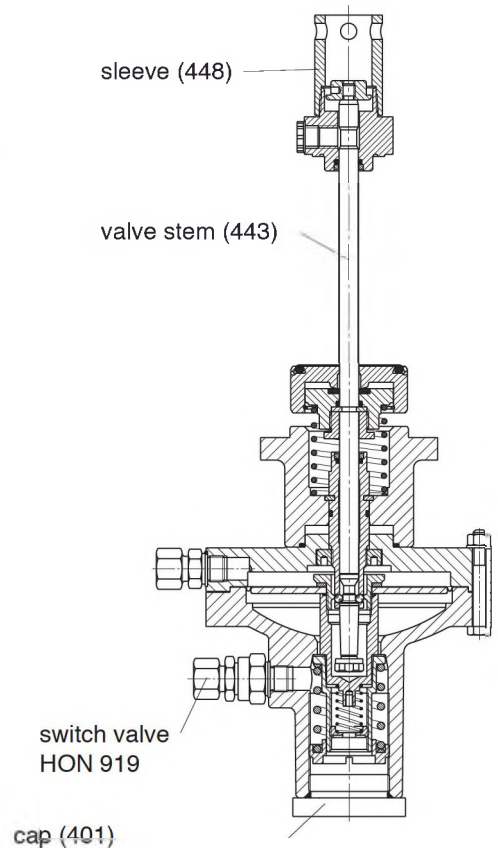
To avoid damaging the diaphragm the setpoint may only be adjusted with the valve engaged.

### 2.2 Test tripping

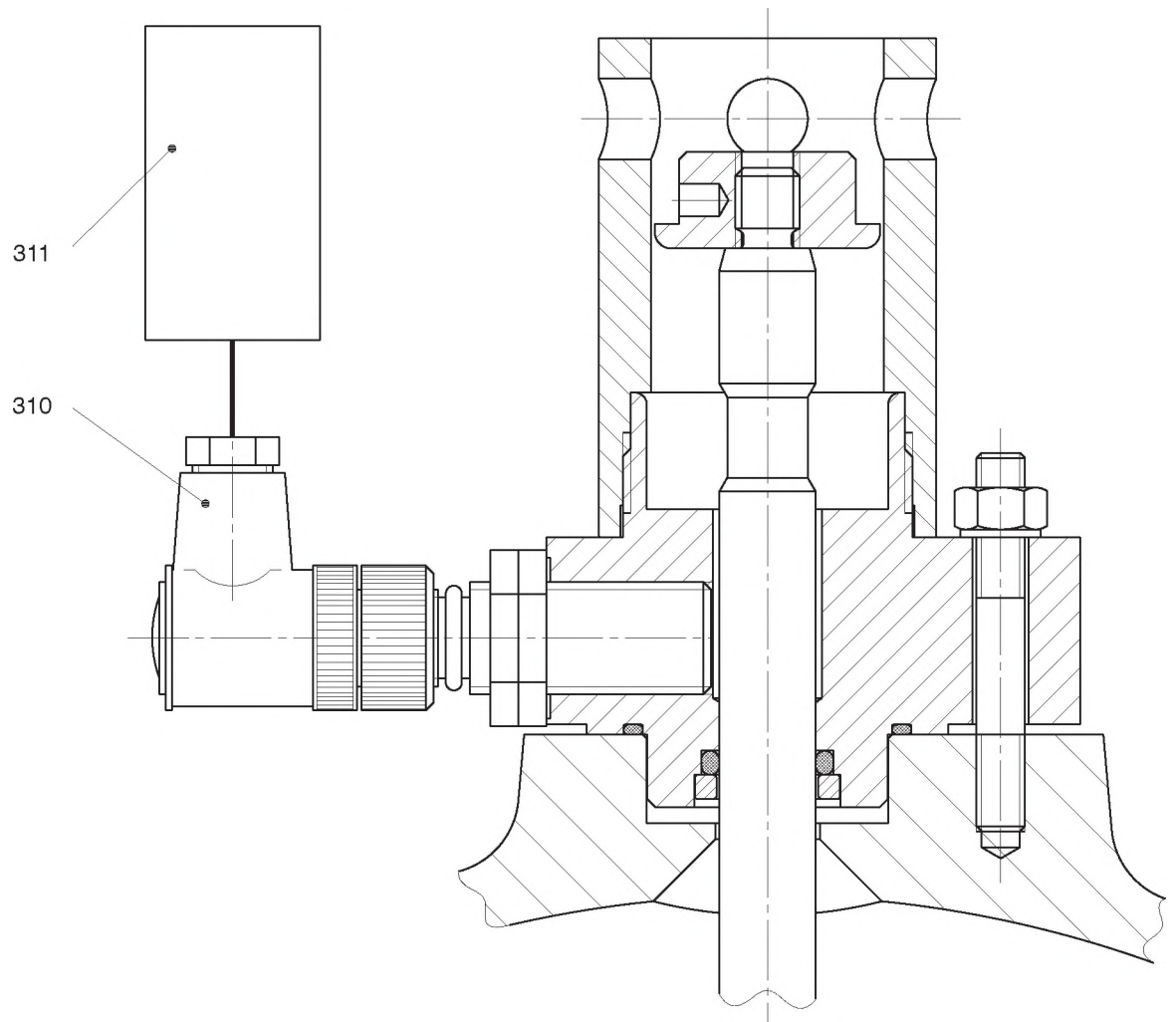
Test trippings are only permitted if the control devices are fitted to the main valve body, otherwise mechanical damage could result.



For gas pressure regulator HON 402 with control elements K4, K5, K6: test tripping may **not** be carried out when the re-engagement cap (501) has been screwed onto the valve stem.



# Electrical remote transmission

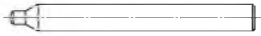
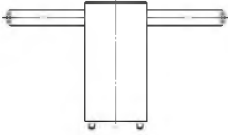


### 3.2 Lubricants

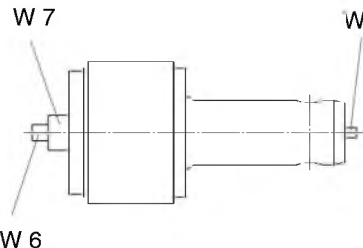
components (brush thinly)	lubricant	HON part number
setpoint adjustment screw (422, 522)	assembly paste	00 027 091
all O rings guiding range of valve stem (443, 543) arresting balls and arresting bushes (406, 433, 506, 533)	silicon grease	00 027 081
pipe connections (427, 430, 527, 530)	assembly grease	00 028 267

### 3.3 Assembly and setup tools

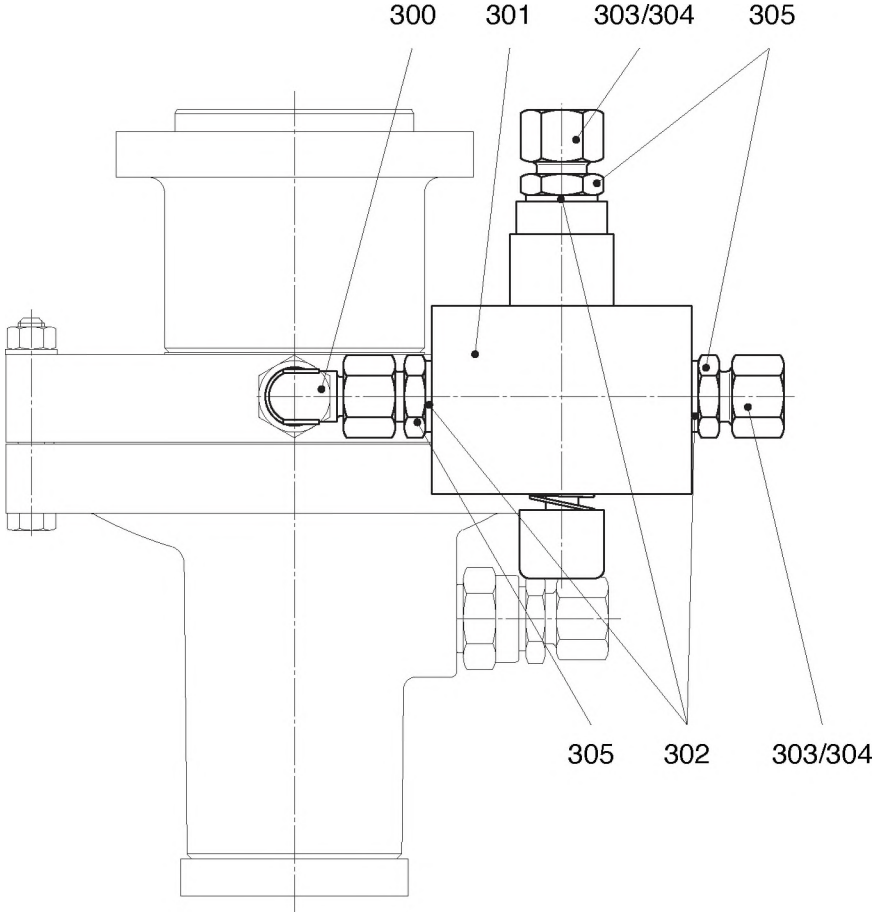
#### 3.3.1 Assembly tools

type	pipe size	for item no.	tool no.	designation	HON part no.
HON 330 HON 332	DN 80 and DN 100	440 540	W 2	pliers D 19 DIN 5256	00 026 532
HON 402	DN 50 to DN 100				
HON 330 HON 332	DN 80 to DN 100	443 543	W 4		10 008 583
HON 402 HON 408	DN 50 to DN 100				
HON 330 HON 332	DN 80 to DN 100	415 515	W 5		10 008 582
HON 402 HON 408	DN 50 to DN 100				

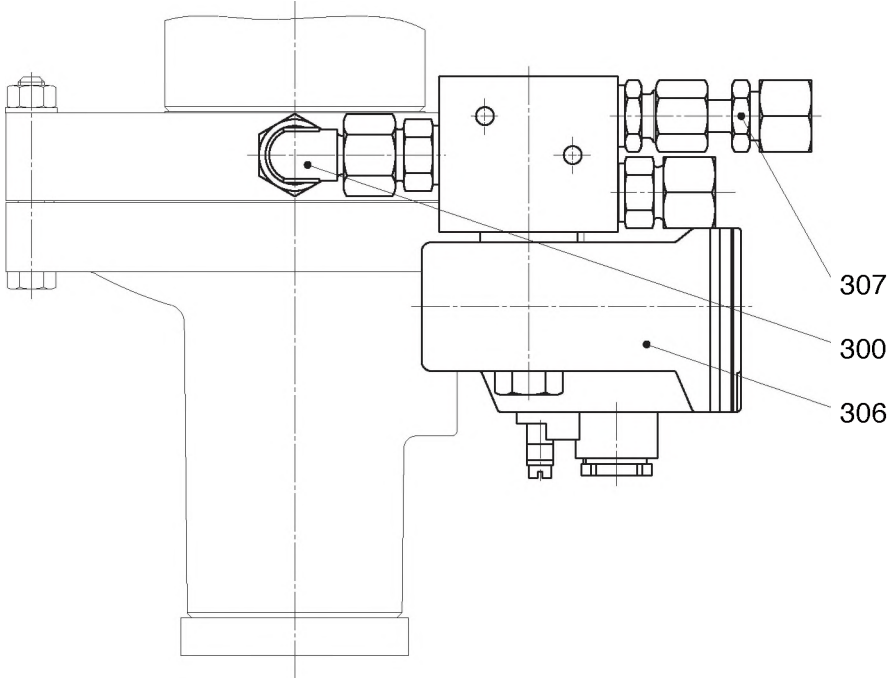
#### 3.3.2 Adjusting tool

type	pipe size	for item no.	tool no.	designation	HON part no.
HON 330 HON 332	DN 80 and DN 100	422 522	W 7		10 004 912
HON 402 HON 408	DN 50 to DN 100				
all designs		423, 523	W 8		

**4.3 Accessories**  
**Manual release**



**Remote release with current supply**



## 4.1.2 Assembly unit for HON 330/ HON 332 DN 80, and DN 100

item no.	designation	quant.	W	material	part number	
					DN 80	DN 100
401	closing cap	1		LM	10 008 569	10 008 569
402	hexagonal nut	1		St	10 021 404	10 021 404
<b>403</b>	<b>damping washer</b>	<b>1</b>	<b>W</b>	<b>KG</b>	<b>10 022 115</b>	<b>10 022 115</b>
404	spring retainer	1		K	10 008 563	10 008 563
405	guide sleeve	1		Ms	10 008 564	10 008 564
406	ball	1		NSt	00 005 108	00 005 108
<b>407</b>	<b>O ring</b>	<b>1</b>	<b>W</b>	<b>KG</b>	<b>00 020 430</b>	<b>00 020 430</b>
408	hexagonal screw					
408	for K4	10		St	00 010 043	00 010 043
408	for K5, K6	6		St	00 010 043	00 010 043
409	measuring unit cover, at option:					
409	for K 4	1		GLM	10 008 533	10 008 533
409	for K5 and K6	1		GLM	10 008 535	10 008 535
410	disc					
410	for K4	10		St	00 008 281	00 008 281
410	for K5, K6	6		St	00 008 281	00 008 281
411	hexagonal nut					
411	for K4	10		St	00 005 559	00 005 559
411	for K5, K6	6		St	00 005 559	00 005 559
412	measuring unit flange, at option:					
412	for K 4	1		LM	10 008 521	10 008 521
412	for K 5 and K 6	1		LM	10 008 523	10 008 523
413	disc	1		LM	00 014 135	00 014 135
414	cylinder bolt	1		St	00 017 201	00 017 201
415	round nut with drilled holes	1		St	10 008 567	10 008 567
416	guide cylinder, complete	1		Al/Bz	10 008 557	10 008 557
417	pressure spring	1		FSt	10 008 577	10 008 577
<b>418</b>	<b>valve plate, vulcanised</b>	<b>1</b>	<b>W</b>	<b>LM/KG</b>	<b>10 008 606</b>	<b>10 008 606</b>
<b>419</b>	<b>O ring</b>	<b>1</b>	<b>W</b>	<b>KG</b>	<b>00 020 412</b>	<b>00 020 412</b>
420	valve plate	1		LM	10 008 600	10 008 601
<b>421</b>	<b>O ring</b>	<b>1</b>	<b>W</b>	<b>KG</b>	<b>00 020 243</b>	<b>00 020 243</b>
422	spring plate	1		Ms	10 001 844	10 001 844
423	spring plate	1		K	10 000 856	10 000 856
424	pressure spring for lower response pressure, at option:					
424	dia. 1.2      white	1		FSt	10 001 837	10 001 837
424	dia. 1.6      green	1		FSt	10 032 955	10 032 955

**W** Parts to be kept in stock for maintenance purposes

### material key:

St ... steel	LM ... light alloy	SSt ... foam
NSt ... stainless steel	Ms ... brass	K ... plastic
FSt ... spring steel	Cu ... copper	KG ... rubbery plastic
NFSt ... stainless spring steel	Bz ... bronze	KGFP ... rubbery-like plastic material*
GS ... steel cast	GLM ... light alloy cast	FPM ... rubbery-like plastic material
GGG ... steel cast with spheroidal graphite	GMS ... brass cast	FP ... special plastic material
GZn ... zink cast	AlBz ... aluminium bronze	
GBz ... bronze cast		

\* with special coating



## 4.2.2 Assembly unit for HON 402 DNE 50 to DNE 100

item no.	designation	quant.	W	material	part number		
					DNE 50	DNE 80	DNE 100
501	closing cap	1		LM	10 021 413	10 021 413	10 021 413
504	spring retainer	1		K	10 008 563	10 008 563	10 008 563
505	guide sleeve with	1		Ms/KG/St	10 021 411	10 021 411	10 021 411
-	<b>O ring</b>	<b>1</b>	<b>W</b>	<b>KG</b>	<b>00 020 345</b>	<b>00 020 345</b>	<b>00 020 345</b>
506	ball			NSt	00 005 108	00 005 108	00 005 108
<b>507</b>	<b>O ring</b>	<b>1</b>	<b>W</b>	<b>KG</b>	<b>00 020 430</b>	<b>00 020 430</b>	<b>00 020 430</b>
508	hexagonal screw						
508	for K4	6		St	00 010 043	00 010 043	00 010 043
508	for K5, K6	10		St	00 010 043	00 010 043	00 010 043
509	measuring unit cover, at option:						
509	for K 4	1		GLM	10 008 533	10 008 533	10 008 533
509	for K5 and K6	1		GLM	10 008 535	10 008 535	10 008 535
510	disc						
510	for K4	6		St	00 008 281	00 008 281	00 008 281
510	for K5, K6	10		St	00 008 281	00 008 281	00 008 281
511	hexagonal nut						
511	for K4	6		St	00 005 559	00 005 559	00 005 559
511	for K5, K6	10		St	00 005 559	00 005 559	00 005 559
512	measuring unit flange, at option:						
512	for K 4	1		LM	10 008 521	10 008 521	10 008 521
512	for K 5 and K 6	1		LM	10 008 523	10 008 523	10 008 523
513	disc	1		LM	00 014 135	00 014 135	00 014 135
514	cylinder bolt	1		St	00 017 201	00 017 201	00 017 201
515	round nut with drilled holes	1		St	10 008 567	10 008 567	10 008 567
516	guide cylinder, pre-assembled	1		Al/Bz	10 008 557	10 008 557	10 008 557
517	pressure spring	1		FSt	10 008 577	10 008 577	10 008 577
<b>518</b>	<b>valve plate, vulcanised</b>	<b>1</b>	<b>W</b>	<b>LM/KG</b>	<b>10 008 606</b>	<b>10 008 606</b>	<b>10 008 606</b>
<b>519</b>	<b>O ring</b>	<b>1</b>	<b>W</b>	<b>KG</b>	<b>00 020 412</b>	<b>00 020 412</b>	<b>00 020 412</b>
520	valve plate	1		LM	10 008 599	10 008 600	10 008 601
<b>521</b>	<b>O ring</b>	<b>1</b>	<b>W</b>	<b>KG</b>	<b>00 020 243</b>	<b>00 020 243</b>	<b>00 020 243</b>
522	spring plate	1		Ms	10 001 844	10 001 844	10 001 844
523	spring plate	1		K	10 000 856	10 000 856	10 000 856
524	pressure spring for lower response pressure, at option:						
524	dia. 1.2 white	1		FSt	10 001 837	10 001 837	10 001 837
524	dia. 1.6 green	1		FSt	10 032 955	10 032 955	10 032 955
525	pressure spring for upper response pressure, at option:						
525	dia. 3.2 bright red	1		FSt	10 000 866	10 000 866	10 000 866
525	dia. 3.6 dark red	1		FSt	10 000 867	10 000 867	10 000 867
525	dia. 4.6 black	1		FSt	10 001 761	10 001 761	10 001 761

### 4.1.3 Assembly unit for HON 408 DN 50/100 to DN 100/200

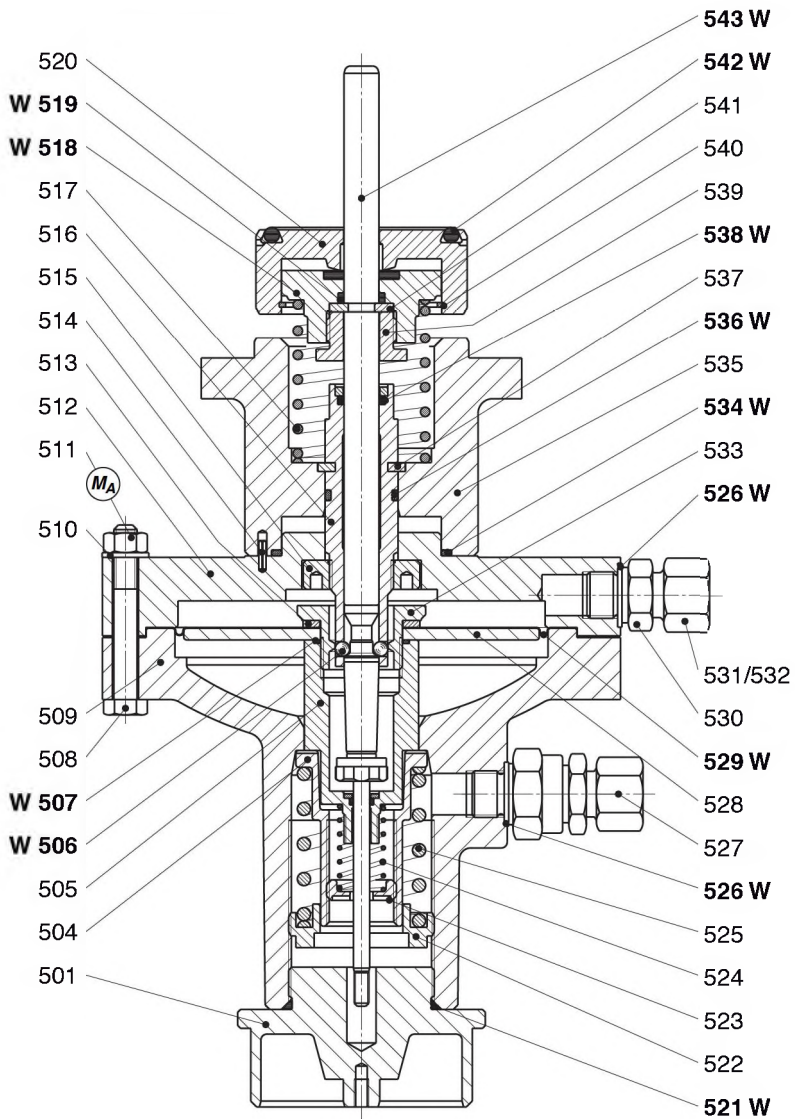
item no.	designation	quant.	W	material	part number		
					DN 50/100	DN 80/150	DN 100/200
401	closing cap	1		LM	10 008 569	10 008 569	10 008 569
402	hexagonal nut	1		St	10 021 404	10 021 404	10 021 404
<b>403</b>	<b>damping washer</b>	<b>1</b>	<b>W</b>	<b>KG</b>	<b>10 022 115</b>	<b>10 022 115</b>	<b>10 022 115</b>
404	spring retainer	1		K	10 008 563	10 008 563	10 008 563
405	guide sleeve	1		Ms	10 008 564	10 008 564	10 008 564
406	ball	4		NSt	00 005 108	00 005 108	00 005 108
<b>407</b>	<b>O ring</b>	<b>1</b>	<b>W</b>	<b>KG</b>	<b>00 020 430</b>	<b>00 020 430</b>	<b>00 020 430</b>
408	hexagonal screw						
408	for K 4	10		St	00 010 043	00 010 043	00 010 043
408	for K5 and K6	6		St	00 010 043	00 010 043	00 010 043
409	mesuring unit cover, at option:						
409	for K 4	1		GLM	10 008 533	10 008 533	10 008 533
409	for K5 and K6	1		GLM	10 008 535	10 008 535	10 008 535
410	disc						
410	for K 4	10		St	00 008 281	00 008 281	00 008 281
410	for K5 and K6	6		St	00 008 281	00 008 281	00 008 281
411	hexagonal nut						
411	for K 4	10		St	00 005 559	00 005 559	00 005 559
411	for K5 and K6	6		St	00 005 559	00 005 559	00 005 559
412	measuring unit flange, at option:						
412	for K 4	1		LM	10 008 521	10 008 521	10 008 521
412	for K 5 and K 6	1		LM	10 008 523	10 008 523	10 008 523
413	disc	1		LM	00 014 135	00 014 135	00 014 135
414	cylinder bolt	1		St	00 017 201	00 017 201	00 017 201
415	round nut with drilled holes	1		St	10 008 567	10 008 567	10 008 567
416	guide cylinder, complete	1		Al/Bz	10 008 557	10 008 557	10 008 557
417	pressure spring	1		FSt	10 008 577	10 008 577	10 008 577
<b>418</b>	<b>valve plate, vulcanised</b>	<b>1</b>	<b>W</b>	<b>LM/KG</b>	<b>10 008 606</b>	<b>10 008 606</b>	<b>10 008 606</b>
<b>419</b>	<b>O ring</b>	<b>1</b>	<b>W</b>	<b>KG</b>	<b>00 020 412</b>	<b>00 020 412</b>	<b>00 020 412</b>
420	valve plate	1		LM	10 008 599	10 008 600	10 008 601
<b>421</b>	<b>O ring</b>	<b>1</b>	<b>W</b>	<b>KG</b>	<b>00 020 243</b>	<b>00 020 243</b>	<b>00 020 243</b>
422	spring plate	1		Ms	10 001 844	10 001 844	10 001 844
423	spring plate	1		K	10 000 856	10 000 856	10 000 856
424	pressure spring for lower response pressure, at option:						
424	dia. 1.2 white	1		FSt	10 001 837	10 001 837	10 001 837
424	dia. 1.6 green	1		FSt	10 032 955	10 032 955	10 032 955
425	pressure spring for upper response pressure, at option:						
425	dia. 3.2 bright red	1		FSt	10 000 866	10 000 866	10 000 866
425	dia. 3.6 dark red	1		FSt	10 000 867	10 000 867	10 000 867
425	dia. 4.6 black	1		FSt	10 001 761	10 001 761	10 001 761

### 4.1.3 Assembly unit for HON 408 DN 50/100 to DN 100/200

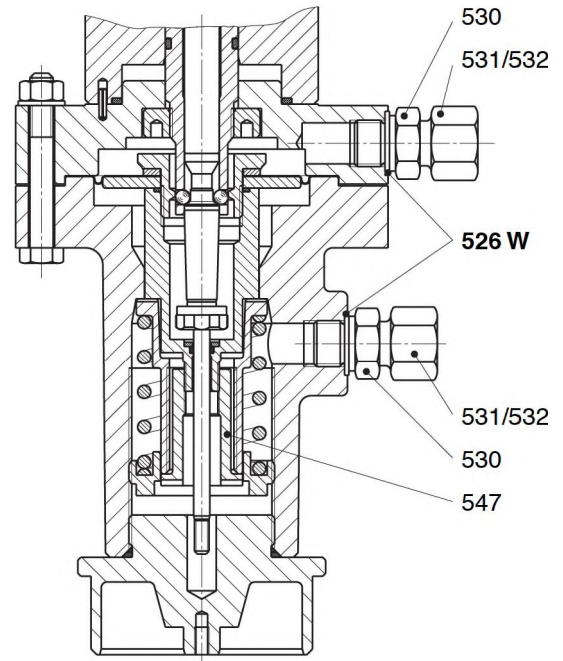
item no.	designation	quant.	W	material	part number		
					DN 50/100	DN 80/150	DN 100/200
<b>426</b>	<b>sealing ring</b>	<b>1</b>	<b>W</b>	<b>LM</b>	<b>00 018 694</b>	<b>00 018 694</b>	<b>00 018 694</b>
427	switch valve HON 919	1		-	10 022 971	10 022 971	10 022 971
428	diaphragm plate, at option:						
428	for K 4	1		LM	10 008 551	10 008 551	10 008 551
428	for K 5	1		LM	10 008 552	10 008 552	10 008 552
428	for K 6	1		LM	10 008 553	10 008 553	10 008 553
<b>429</b>	<b>diaphragm, at option:</b>						
<b>429</b>	<b>for K 4</b>	<b>1</b>	<b>W</b>	<b>KG</b>	<b>10 008 545</b>	<b>10 008 545</b>	<b>10 008 545</b>
<b>429</b>	<b>for K 5</b>	<b>1</b>	<b>W</b>	<b>KG</b>	<b>10 008 547</b>	<b>10 008 547</b>	<b>10 008 547</b>
<b>429</b>	<b>for K 6</b>	<b>1</b>	<b>W</b>	<b>KG</b>	<b>10 008 549</b>	<b>10 008 549</b>	<b>10 008 549</b>
430	adapter	1		St	00 030 113	00 030 113	00 030 113
430	adapter (without diaphragm leak shut-off)	2		St	00 030 113	00 030 113	00 030 113
431	union nut	1		St	00 030 804	00 030 804	00 030 804
431	union nut (without diaphragm leak shut-off)	2		St	00 030 804	00 030 804	00 030 804
432	cutting ring	1		St	00 030 904	00 030 904	00 030 904
432	cutting ring (without diaphragm leak shut-off)	2		St	00 030 904	00 030 904	00 030 904
433	switch bushing	1		NSt	10 008 616	10 008 616	10 008 616
<b>434</b>	<b>O ring</b>	<b>1</b>	<b>W</b>	<b>KG</b>	<b>00 020 413</b>	<b>00 020 413</b>	<b>00 020 413</b>
435	SAV connection flange	1		St	10 008 500	10 008 500	10 008 500
<b>436</b>	<b>O ring</b>	<b>1</b>	<b>W</b>	<b>KG</b>	<b>00 020 383</b>	<b>00 020 383</b>	<b>00 020 383</b>
437	ring segment	2		St	10 007 589	10 007 589	10 007 589
<b>438</b>	<b>O ring</b>	<b>1</b>	<b>W</b>	<b>KV</b>	<b>00 020 752</b>	<b>00 020 752</b>	<b>00 020 752</b>
439	nut	1		St	10 008 614	10 008 614	10 008 614
440	circlip	1		FSt	00 019 127	00 019 127	00 019 127
441	ring segment	2		St	10 008 612	10 008 612	10 008 612
<b>442</b>	<b>O ring</b>	<b>1</b>	<b>W</b>	<b>KG</b>	<b>00 020 596</b>	<b>00 020 266</b>	<b>00 020 268</b>
443	valve stem, complete	1		NSt/St	10 026 331	10 026 333	10 026 335
<b>444</b>	<b>O ring</b>	<b>1</b>	<b>W</b>	<b>KV</b>	<b>00 020 752</b>	<b>00 020 752</b>	<b>00 020 752</b>
445	screw plug	1		K	00 026 550	00 026 550	00 026 550
446	valve stem guide	1		LM	10 008 571	10 008 571	10 008 571
447	cap for valve stem	1		LM	10 008 579	10 008 579	10 008 579
448	cap	1		LM	10 008 581	10 008 581	10 008 581
449	protective pipe cap	1		K	00 026 363	00 026 363	00 026 363
450	disc	1		St	00 006 157	00 006 157	00 006 157
451	cylinder bolt	1		St	00 011 064	00 011 064	00 011 064
452	retention tube	1		LM	10 001 784	10 001 784	10 001 784
453	measuring unit ring (only for K6)	1		LM	10 008 538	10 008 538	10 008 538

## 4.2.1 Assembly unit for HON 402 DN<sub>E</sub> 50 to DN<sub>E</sub> 100

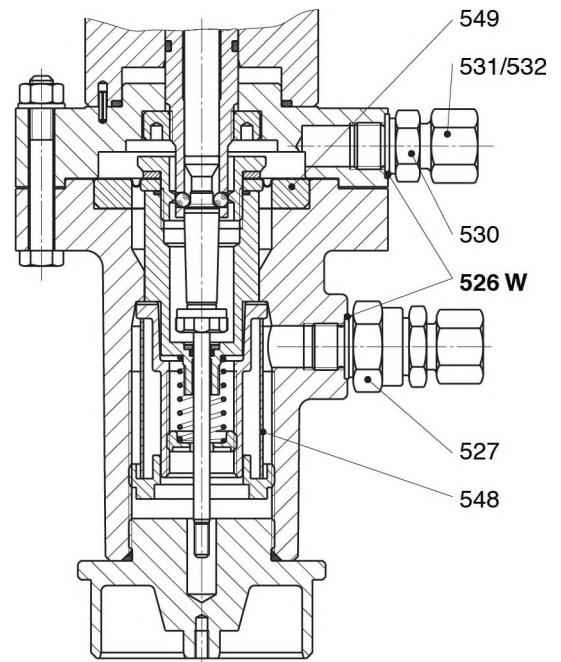
**K4 with release at upper and lower response pressure**



**K5 with release only at upper response pressure**  
 special design (without diaphragm leak shut-off)



**K6 with release only at lower response pressure**



**M<sub>A</sub>** See torques on page 5!

**W** Parts should be kept in stock for maintenance purposes.

#### 4.1.2 Assembly unit for HON 330/ HON 332 DN 80 and DN 100

item no.	designatiion	quant.	W	material	part number	
					DN 80	DN 100
425	pressure spring for upper response pressure, at option:					
425	dia. 3.2 bright red	1		FSt	10 000 866	10 000 866
425	dia. 3.6 dark red	1		FSt	10 000 867	10 000 867
425	dia. 4.6 black	1		FSt	10 001 761	10 001 761
<b>426</b>	<b>sealing ring</b>	<b>2</b>	<b>W</b>	<b>LM</b>	<b>00 018 694</b>	<b>00 018 694</b>
427	switch valve HON 919	1		-	10 022 971	10 022 971
428	diaphragm plate, at option:					
428	for K 4	1		LM	10 008 551	10 008 551
428	for K 5	1		LM	10 008 552	10 008 552
428	for K 6	1		LM	10 008 553	10 008 553
<b>429</b>	<b>diaphragm, at option:</b>					
<b>429</b>	<b>for K 4</b>	<b>1</b>	<b>W</b>	<b>KG</b>	<b>10 008 545</b>	<b>10 008 545</b>
<b>429</b>	<b>for K 5</b>	<b>1</b>	<b>W</b>	<b>KG</b>	<b>10 008 547</b>	<b>10 008 547</b>
<b>429</b>	<b>for K 6</b>	<b>1</b>	<b>W</b>	<b>KG</b>	<b>10 008 549</b>	<b>10 008 549</b>
430	adapter	1		St	00 030 113	00 030 113
430	adapter (without diaphragm leak shut-off)	2		St	00 030 113	00 030 113
431	union nut	1		St	00 030 804	00 030 804
431	union nut (without diaphragm leak shut-off)	2		St	00 030 804	00 030 804
432	cutting ring	1		St	00 030 904	00 030 904
432	cutting ring (without diaphragm leak shut-off)	2		St	00 030 904	00 030 904
433	switch bushing	1		NSt	10 008 616	10 008 616
<b>434</b>	<b>O ring</b>	<b>1</b>	<b>W</b>	<b>KG</b>	<b>00 020 413</b>	<b>00 020 413</b>
435	SAV connection flange	1		St	10 008 500	10 008 500
<b>436</b>	<b>O ring</b>	<b>1</b>	<b>W</b>	<b>KG</b>	<b>00 020 383</b>	<b>00 020 383</b>
437	ring segment	2		St	10 007 589	10 007 589
<b>438</b>	<b>O ring</b>	<b>1</b>	<b>W</b>	<b>FPM</b>	<b>00 020 752</b>	<b>00 020 752</b>
439	nut	1		St	10 008 614	10 008 614
440	circlip	1		FSt	00 019 127	00 019 127
441	ring segment	2		St	10 008 612	10 008 612
<b>442</b>	<b>O ring</b>	<b>1</b>	<b>W</b>	<b>KG</b>	<b>00 020 266</b>	<b>00 020 268</b>
443	valve stem, complete	1	W	NSt/St	10 026 333	10 026 335
<b>444</b>	<b>O ring</b>	<b>1</b>	<b>W</b>	<b>FPM</b>	<b>00 020 752</b>	<b>00 020 752</b>
445	screw plug	1		K	00 026 550	00 026 550
446	valve stem guide	1		LM	10 008 571	10 008 571
447	cap for valve stem	1		LM	10 008 579	10 008 579
448	cap	1		LM	10 008 581	10 008 581
450	disc	1		St	00 006 157	00 006 157
451	cylinder bolt	1		St	00 011 084	00 011 084
452	retention tube	1		LM	10 001 784	10 001 784
453	measuring unit ring (only for K6)	1		LM	10 008 538	10 008 538

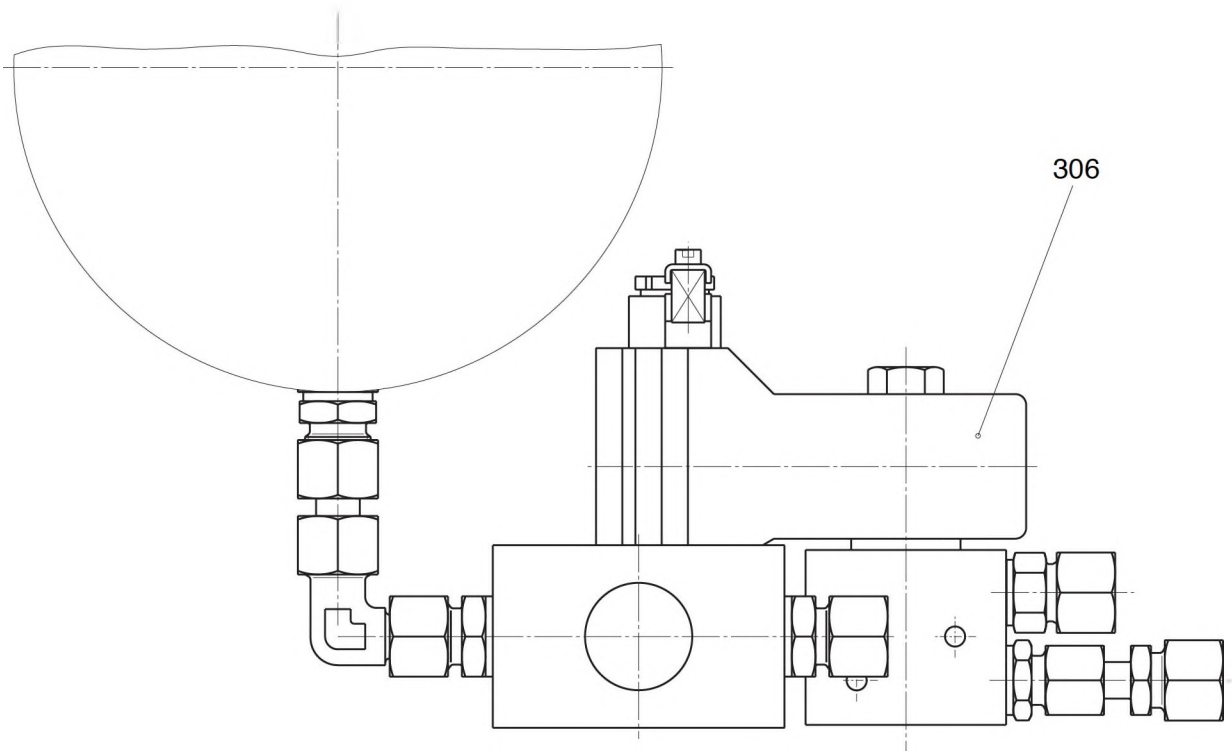
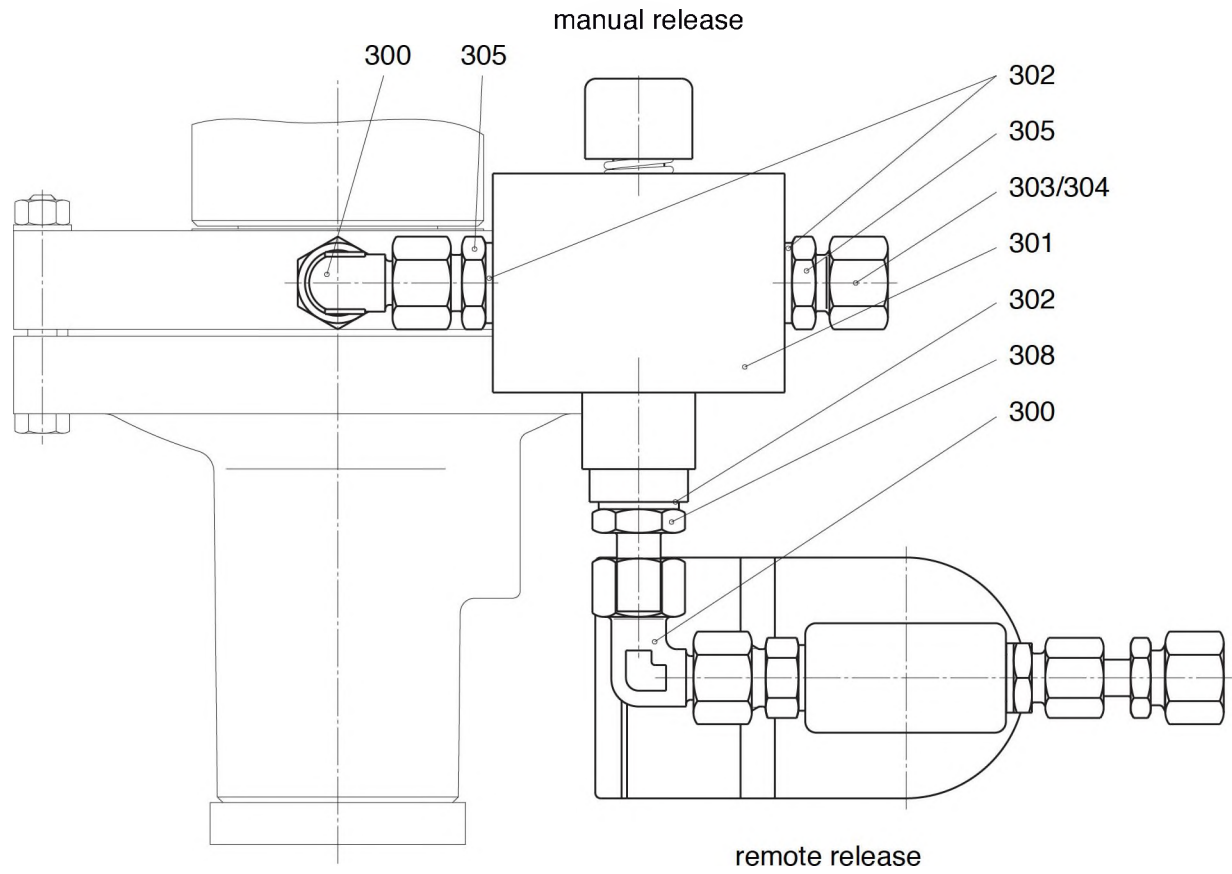
## 4.2.2 Assembly unit for HON 402 DN E 50 to DN E 100

item no.	designation	quant.	W	material	part number		
					DN E 50	DN E 80	DN E 100
<b>526</b>	<b>sealing ring</b>	<b>2</b>	<b>W</b>	<b>LM</b>	<b>00 018 694</b>	<b>00 018 694</b>	<b>00 018 694</b>
527	switch valve HON 919	1		-	10 022 971	10 022 971	10 022 971
528	diaphragm plate, at option:						
528	for K 4	1		LM	10 008 551	10 008 551	10 008 551
528	for K 5	1		LM	10 008 552	10 008 552	10 008 552
528	for K 6	1		LM	10 008 553	10 008 553	10 008 553
<b>529</b>	<b>diaphragm, at option:</b>						
<b>529</b>	<b>for K 4</b>	<b>1</b>	<b>W</b>	<b>KG</b>	<b>10 008 545</b>	<b>10 008 545</b>	<b>10 008 545</b>
<b>529</b>	<b>for K 5</b>	<b>1</b>	<b>W</b>	<b>KG</b>	<b>10 008 547</b>	<b>10 008 547</b>	<b>10 008 547</b>
<b>529</b>	<b>for K 6</b>	<b>1</b>	<b>W</b>	<b>KG</b>	<b>10 008 549</b>	<b>10 008 549</b>	<b>10 008 549</b>
530	adapter	1		St	00 030 113	00 030 113	00 030 113
530	adapter (without diaphragm leak shut-off)	2		St	00 030 113	00 030 113	00 030 113
531	union nut	1		St	00 030 804	00 030 804	00 030 804
531	union nut (without diaphragm leak shut-off)	2		St	00 030 804	00 030 804	00 030 804
532	cutting ring	1		St	00 030 904	00 030 904	00 030 904
532	cutting ring (without diaphragm leak shut-off)	2		St	00 030 904	00 030 904	00 030 904
533	switch bushing	1		NSt	10 008 616	10 008 616	10 008 616
<b>534</b>	<b>O ring</b>	<b>1</b>	<b>W</b>	<b>KG</b>	<b>00 020 413</b>	<b>00 020 413</b>	<b>00 020 413</b>
535	SAV connection flange	1		St	10 008 500	10 008 502	10 008 502
<b>536</b>	<b>O ring</b>	<b>1</b>	<b>W</b>	<b>KG</b>	<b>00 020 383</b>	<b>00 020 383</b>	<b>00 020 383</b>
537	ring segment	2		St	10 007 589	10 007 589	10 007 589
<b>538</b>	<b>O ring</b>	<b>1</b>	<b>W</b>	<b>FPM</b>	<b>00 020 752</b>	<b>00 020 752</b>	<b>00 020 752</b>
539	nut	1		St	10 008 614	10 008 614	10 008 614
540	circlip	1		FSt	00 019 127	00 019 127	00 019 127
541	ring segment	2		St	10 008 612	10 008 612	10 008 612
<b>542</b>	<b>O ring</b>	<b>1</b>	<b>W</b>	<b>KG</b>	<b>00 020 596</b>	<b>00 020 266</b>	<b>00 020 268</b>
543	valve stem, complete, consisting of:	1		NSt	10 024 062	10 024 063	10 024 063
-	valve stem, pre-assembled	1		NSt	10 024 064	10 024 064	10 024 064
-	connecting rod	1		NSt	10 021 417	10 021 848	10 021 848
-	hexagonal nut	1		NSt	10 021 404	10 021 404	10 021 404
-	<b>damping washer</b>	<b>1</b>	<b>W</b>	<b>KG</b>	<b>10 022 115</b>	<b>10 022 115</b>	<b>10 022 115</b>
547	blocking pipe	1		LM	10 024 054	10 024 054	10 024 054
548	arresting sleeve	1		LM	10 001 784	10 001 784	10 001 784
549	measuring unit ring (only for K6)	1		LM	10 008 538	10 008 538	10 008 538

## 4.2.2 Assembly unit for HON 402 DNE 50 to DNE 100

item no.	designation	quant.	W	material	part number		
					DNE 50	DNE 80	DNE 100
<b>526</b>	<b>sealing ring</b>	<b>2</b>	<b>W</b>	<b>LM</b>	<b>00 018 694</b>	<b>00 018 694</b>	<b>00 018 694</b>
527	switch valve HON 919	1		-	10 022 971	10 022 971	10 022 971
528	diaphragm plate, at option:						
528	for K 4	1		LM	10 008 551	10 008 551	10 008 551
528	for K 5	1		LM	10 008 552	10 008 552	10 008 552
528	for K 6	1		LM	10 008 553	10 008 553	10 008 553
<b>529</b>	<b>diaphragm, at option:</b>						
<b>529</b>	<b>for K 4</b>	<b>1</b>	<b>W</b>	<b>KG</b>	<b>10 008 545</b>	<b>10 008 545</b>	<b>10 008 545</b>
<b>529</b>	<b>for K 5</b>	<b>1</b>	<b>W</b>	<b>KG</b>	<b>10 008 547</b>	<b>10 008 547</b>	<b>10 008 547</b>
<b>529</b>	<b>for K 6</b>	<b>1</b>	<b>W</b>	<b>KG</b>	<b>10 008 549</b>	<b>10 008 549</b>	<b>10 008 549</b>
530	adapter	1		St	00 030 113	00 030 113	00 030 113
530	adapter (without diaphragm leak shut-off)	2		St	00 030 113	00 030 113	00 030 113
531	union nut	1		St	00 030 804	00 030 804	00 030 804
531	union nut (without diaphragm leak shut-off)	2		St	00 030 804	00 030 804	00 030 804
532	cutting ring	1		St	00 030 904	00 030 904	00 030 904
532	cutting ring (without diaphragm leak shut-off)	2		St	00 030 904	00 030 904	00 030 904
533	switch bushing	1		NSt	10 008 616	10 008 616	10 008 616
<b>534</b>	<b>O ring</b>	<b>1</b>	<b>W</b>	<b>KG</b>	<b>00 020 413</b>	<b>00 020 413</b>	<b>00 020 413</b>
535	SAV connection flange	1		St	10 008 500	10 008 502	10 008 502
<b>536</b>	<b>O ring</b>	<b>1</b>	<b>W</b>	<b>KG</b>	<b>00 020 383</b>	<b>00 020 383</b>	<b>00 020 383</b>
537	ring segment	2		St	10 007 589	10 007 589	10 007 589
<b>538</b>	<b>O ring</b>	<b>1</b>	<b>W</b>	<b>FPM</b>	<b>00 020 752</b>	<b>00 020 752</b>	<b>00 020 752</b>
539	nut	1		St	10 008 614	10 008 614	10 008 614
540	circlip	1		FSt	00 019 127	00 019 127	00 019 127
541	ring segment	2		St	10 008 612	10 008 612	10 008 612
<b>542</b>	<b>O ring</b>	<b>1</b>	<b>W</b>	<b>KG</b>	<b>00 020 596</b>	<b>00 020 266</b>	<b>00 020 268</b>
543	valve stem, complete, consisting of:	1		NSt	10 024 062	10 024 063	10 024 063
-	valve stem, pre-assembled	1		NSt	10 024 064	10 024 064	10 024 064
-	connecting rod	1		NSt	10 021 417	10 021 848	10 021 848
-	hexagonal nut	1		NSt	10 021 404	10 021 404	10 021 404
-	<b>damping washer</b>	<b>1</b>	<b>W</b>	<b>KG</b>	<b>10 022 115</b>	<b>10 022 115</b>	<b>10 022 115</b>
547	blocking pipe	1		LM	10 024 054	10 024 054	10 024 054
548	arresting sleeve	1		LM	10 001 784	10 001 784	10 001 784
549	measuring unit ring (only for K6)	1		LM	10 008 538	10 008 538	10 008 538

# Remote release and manual release with current supply





### 3. Special maintenance notices

#### Control devices

Before removing from the body the SAV must be released. SAV's that are provided with an underpressure release mechanism (standard version) will close automatically.

#### Note

If the switch mechanism is to be dismantled after an underpressure shut-off, the valve stem (443, 543) must be pushed back at least up to the engaged position. A conversion from K4 to K5, K6 or K5, K6 to K4 is not possible on site due to the need for an exact zero adjustment via the compensation disc (413, 513).

#### Valve stem (443, 543)

It is important that the valve stem can be moved easily. In case of damage to material be detected at the valve stem shoulder (e. g. wearout of material or ridges) the valve stem must be renewed. When fitting a new valve stem to control devices of series 1989 and earlier, the guide cylinder (416, 516) and closing spring (417, 517) have to be replaced at the same time. The pressure relief mechanism will then no longer be active.

Prior to inserting the valve stem (443, 543) into the guide cylinder (416, 516) the relief balls (in old designs) must be wedged apart from above by using assembly bolt W4.

#### Spring retainer ( 404, 504)

The touching faces between the spring retainer and the diaphragm plate (428, 528) and the spring retainer and guiding sleeve (405, 505) must be kept free of grease.

#### Relief springs

For control devices with a delivery date prior to July 1986 new relief springs part no. HON 10 008 640 should be fitted when maintaining the valve.

#### Valve plate (420, 520)

When inserting the O ring (442, 542) into the groove of the valve plate, proceed as follows:

- Place the greased O ring onto the location groove and press in at several evenly spaced spots around the circumference.
- Then press the O ring into the groove completely .

#### Compensating disc (413, 513)

This disc builds a group together with the head work (409), flange (412) and connecting flange of SAV (435). The compensation disc is used for exact zero adjustment. After changing the diaphragm the same disc is to be used again. Note that body parts also must be the same.

#### Note

If the disc (413, 513) has to be replaced, it is important to transmit the thickness to the new disc (part no. HON 00014135). Both sides of the discs should touch each other for this process. The thickness protruding from the new disc is cut away with a knife. The compensating disc consists of aluminium foil layers with a size of 0.1 mm.

#### Bush (433, 533)

If the switch bushing is damaged (e.g. material wear) it must be renewed.

#### 3.1 Torque

The nuts ( 411, 511) must be tightened with a torque wrench to  $M_A = 10 \text{ Nm}$

## 4.3.2 Accessories

### Manual release

item no.	designation	quant.	W	material	part number
300	adapter	1		St	00 031 213
301	push button valve HON 912	1			10 005 070
302	sealing ring	3		LM	00 018 694
303	union nut	2		St	00 030 804
304	cutting ring	2		St	00 030 904
305	adapter	3		St	00 030 113

### Remote release with current supply

300	adapter	1		St	00 031 213
306	3/2 - way solenoid, at option:				
-	24 V	1			00 024 505
-	220 V	1			00 024 506
307	reduction connection	1		St	00 031 893

### Remote release and manual release with current supply

300	adapter	1		St	00 031 213
301	push button valve HON 912	1			10 005 070
302	sealing ring	3		LM	00 018 694
303	union nut	1		St	00 030 804
304	cutting ring	1		St	00 030 904
305	adapter	2		St	00 030 113
306	3/2 - way solenoid, at option:				
-	24 V	1			00 024 505
-	220 V	1			00 024 506
308	adapter	1		St	00 030 038

### Electrical remote transmission

310	proximity initiator	1			00 024 046
311	isolator device, at option:				
311	24 V	1			00 024 400
311	220 V	1			00 024 402

## 1. General

The technical specifications, description, and dimensions for the control device **HON 674** are contained in the control device information publications, e.g. 330.00.

The HON publication "**General operating instructions for gas pressure regulators and safety devices**" gives information on installation, commissioning, and notices on fault finding.

For planning through to maintenance of gas pressure regulating systems the applicable national regulations must be observed:

**Germany:** DVGW work sheets G 600, G 459/II, G 490/I, G 491, and G 495

The time intervals for monitoring and maintenance depend largely on the operating conditions and the type of gas media used. Therefore, no fixed intervals are being stated. It is recommended to keep to the maintenance intervals given in the DVGW work sheet G 495.

During maintenance the components must be cleaned and checked carefully. This is still required even if irregularities are found during operation or functional tests. The checks must extend to diaphragms and seals and all moveable parts in particular. Damaged parts must be renewed.

The item numbers given in the special operating and maintenance notices correspond to those in the spare part drawing and spare part list.


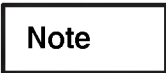
It is recommended to keep components marked "**W**" in the spare part drawings and spare part lists in stock for maintenance purposes. These components are summarized on a separate sheet.

These control devices are being used in the following devices with their corresponding operating and maintenance instructions:

device type	Applicable operating and maintenance instruction
HON 330	330.20
HON 332	332.20
HON 402	402.20
HON 408	408.20

### 1.1 Safety notices

Safety notices are marked with the following signal words or symbols:

Marking	used for:
	danger to property or environment
	important additional information

**For More Information**

To learn more about Honeywell's  
Advanced Gas Solutions, visit  
[www.honeywellprocess.com](http://www.honeywellprocess.com) or contact  
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**GERMANY****Honeywell Process Solutions**

Honeywell Gas Technologies GmbH

Osterholzstrasse 45

34123 Kassel, Germany

Tel: +49 (0)561 5007-0

Fax: +49 (0)561 5007-107

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