

Installation of Shutoff Valves- Single or Dual Port

NOTES:

- **Do not open the sealed bag until the valve is ready to be brazed**
 - **Refer to the Authority Having Jurisdiction (AHJ) for the appropriate installation methods**
 - **The instructions below are guidelines. Specific procedures per the AHJ must be followed.**
 - **Cross-Connection of gases could lead to serious injury or be fatal. A cross-connection test must be performed by a qualified individual to ensure that there is not a cross-connection between various medical gas and vacuum piping systems.**
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- A.) Ensure the piping to be brazed is clean and free of burrs with square cut ends
 - B.) Visually examine the tube ends to ensure they have not become contaminated and are free of obstructions or debris
 - C.) Ensure that the space around the joints to be brazed are free from materials which may catch fire
 - D.) Do not use flux
 - E.) Filler metals shall comply with ANSI / AWS A5.8 *Specification for Brazing Filler Metal*
 - F.) Shutoff valves shall be installed with the handles, in the open position, pointing toward the medical gas outlet (or inlet, in the case of vacuum) side of the piping infrastructure
 - G.) Wrap a wet rag around the tube extensions of the joint to be brazed to prevent overheating and potential damage to the valve
 - H.) While being brazed, the joints shall be continuously purged with oil-free dry Nitrogen NF and a discharge opening shall be on the opposite side of the joint from where the purge gas is being introduced. The flow of purge Nitrogen NF shall be continuous until the last joint brazed is cool to the touch.
 - I.) Test the piping system for leaks
 - J.) Ensure that the gas lines are not cross-connected
 - K.) After the installer performed tests, initial pressure test, cross connection test, and piping purge tests are performed, any gauge (if applicable) may be affixed to the medical gas outlet side (or inlet, in the case of vacuum) of the valve. Ensure that there is a check valve located between the gauge port and the pressure / vacuum gauge.