



VAT Gate Valve Overhaul Procedure 10846-UE24(VAT)

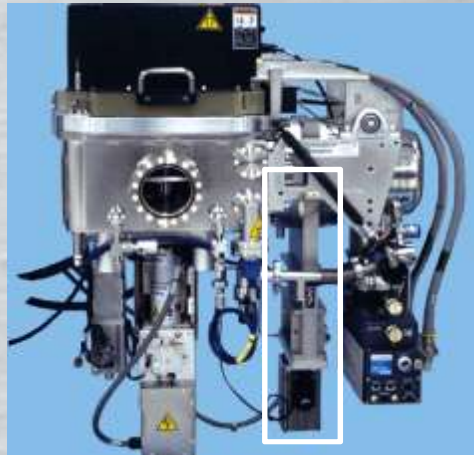




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➤ Basic Information

Picture



Factory P/N : 10846-UE24(VAT)

Function : Gate valve

Port Size : ICF-200

Port 方向 : 180

Driver : CDA

Driver界面 : N/A

Key parts : Metal seal

Bellow type : Welded

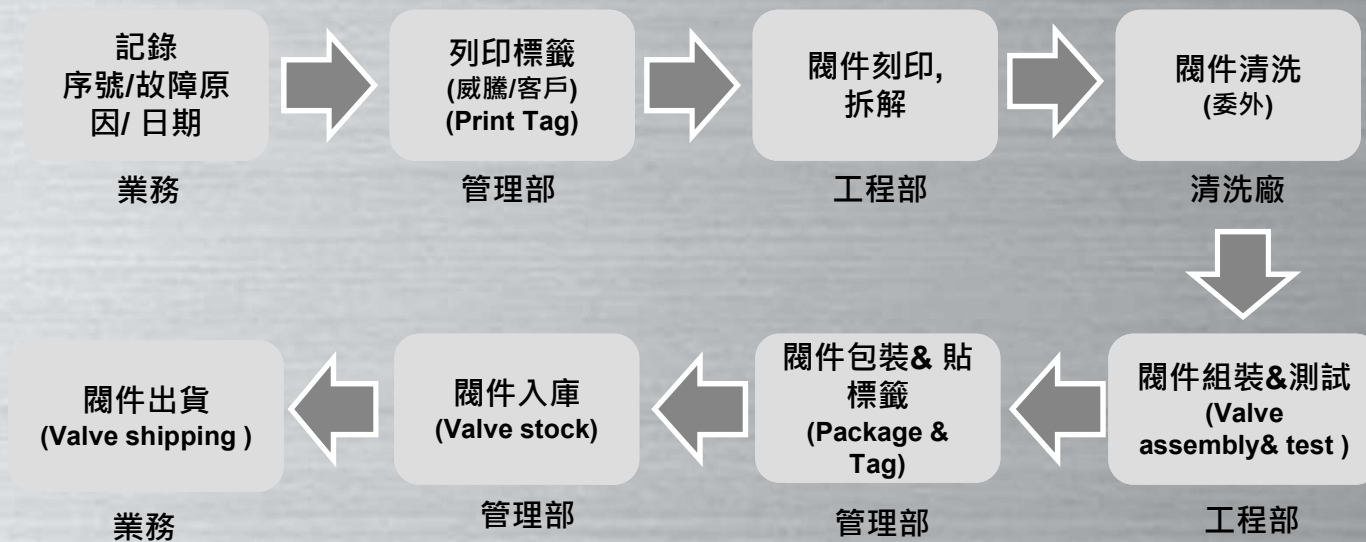
Seal type : 燒結 O-RING

Application : AMAT ENDURA



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➤ Overhaul process flow



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1. Laser mark & valve disassembly

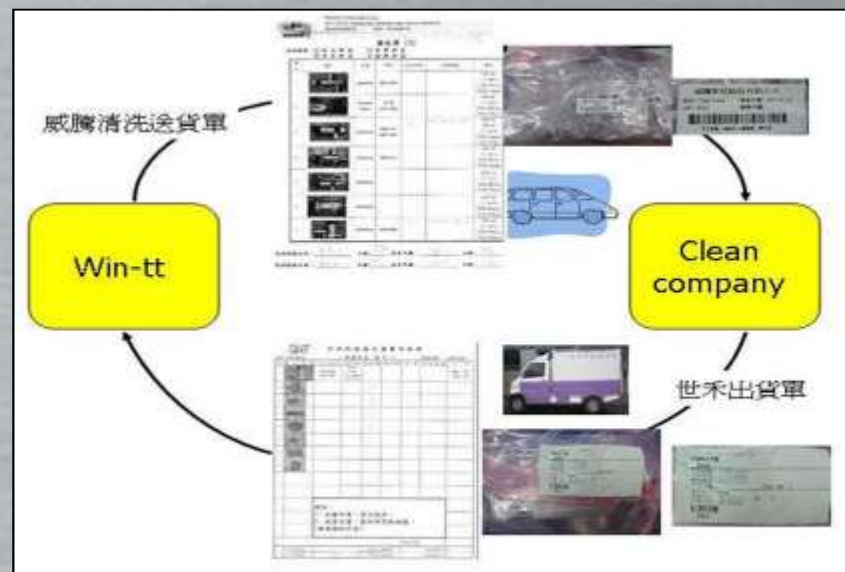


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2. Parts clean by outsourcing



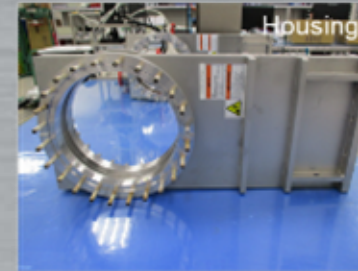
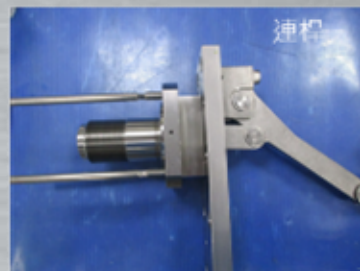
送洗物件



送洗流程

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3. Parts Replacement

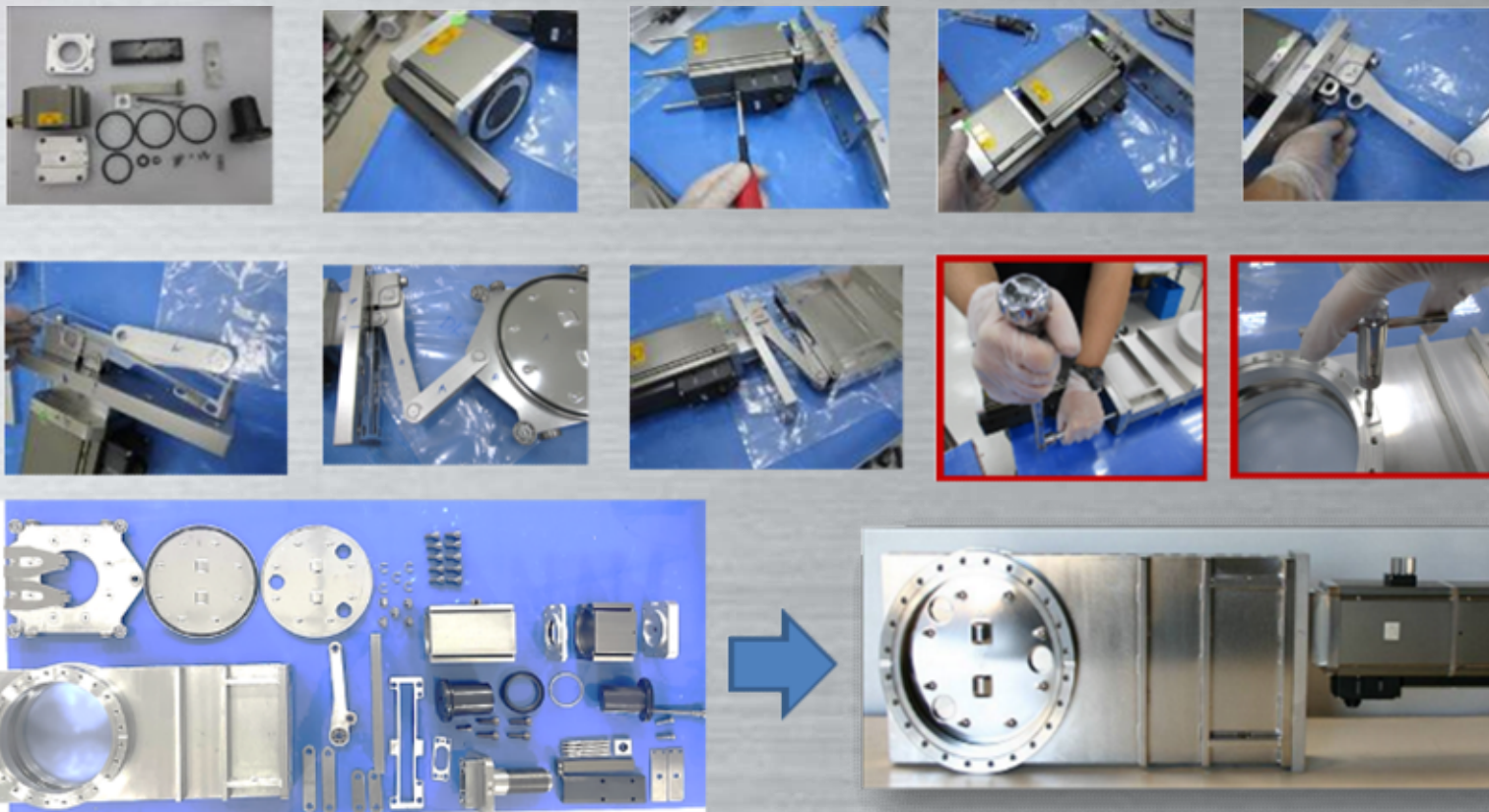


品名	規格	材質	數量	Remark
鋼珠	8.5mm	NA	16	Replace
Bearing	6201IH(SS6201)	NA	8	If necessary
Metal seal	63217-01	無氧銅 大	1	Replace
Metal seal	65313-01	無氧銅 小	1	Replace
Viton O-ring	AS-311	VITON	1	Replace
Viton O-ring	AS-332	VITON	1	Replace
Viton O-ring	AS-335	VITON	3	Replace
Viton O-ring	AS-113	VITON	1	Replace
Viton O-ring	AS-204	VITON	1	Replace
Viton O-ring	AS-329	VITON	1	Replace
Bellow Assembly	OD46.0248*FL167.2	316L/WBL-486	1	Replace
面盤組	NA	316L	1	If necessary

1. All of O-ring
2. Metal Seal * 2
3. 鋼珠 * 16
4. CDA port * 2
5. Gate Plate (面盤) (If necessary)
6. Bellows assembly
7. Sensor (If necessary)
8. Bearing * 8 (If necessary)
9. Housing 攻牙

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4. Valve Assembly



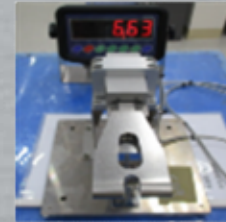
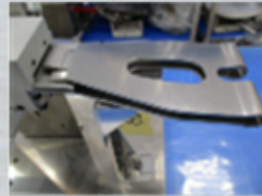
- 鎖 Metal Seal 螺絲扭力扳的磅數為: 40 NT-m
- Housing 每一個螺絲孔需用攻牙器檢查過

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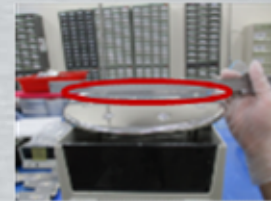
5. Valve final test:

➤ Parts Inspection:

1. 面盤組:



夾力必需大於6 kg

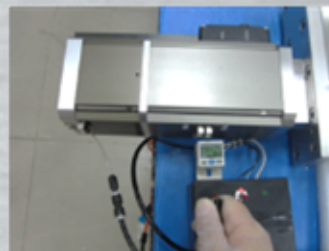


面盤必需平整 (不能有空隙)



Seal 高度必需大於4.5mm

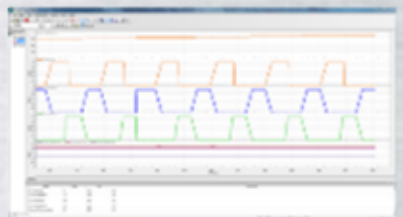
2. Cylinder



飽壓: Over 100 PSI

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Cycle test & Mid Position check



Close

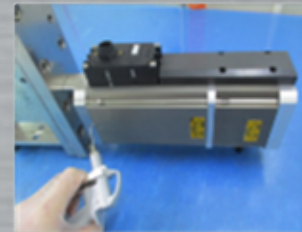
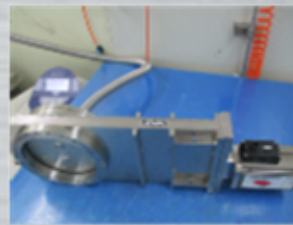
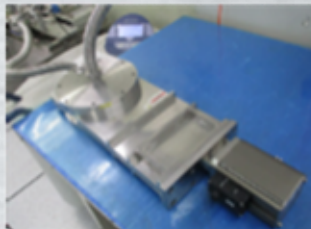


Open



MID

Vacuum test by He detector





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6. E-Check list

電子檢點表(查詢)
單筆內容

產品編號: GAT-107

申請者: 謝政穎

申請日期: 2021-08-03

版別: 1

版次: 8

數值

序次	測試分類	單位	Data Name	分析資料	上限	下限	內容	Remark
13	Time	Sec	T-OPTE	Y	2		1.Open test time,CDA 55PSI	N/A
14	Time	Sec	T-CLTE	Y	2		1.Close test time,CDA 55PSI	N/A
17	Vacuum test	1.0e ⁻⁴ Torr-L/S	P-LEAO	Y	50		1.外部測漏測試Vacuum leakage check <5E-9 torr-L/sec	N/A
18	Vacuum test	1.0e ⁻⁴ Torr-L/S	P-LEAI	Y	50		1.內部測漏測試Vacuum leakage check <5E-9 torr-L/sec	N/A

Check

序次	分類	內容
1	Condition check	To use "游標卡尺" check "將動盤" 平整度, (不能有空隙)
2	Condition check	valve plate 溝槽深度需<2.8mm
3	Condition check	清潔磁缸及上層磁油
4	Position Check	主軸上下必須鎖付C型扣(上/下各2個,共4個)
5	氣壓缸保潔測試	維持CDA為100 PSI,持續測試1分鐘
6	Size	氣缸面盤SEAL高度需在4.45-4.55mm
7	Condition check	用40NM扭力鎖緊磁缸蓋密封
8	Position Check	Open/Close sensor定位
9	Position Check	Medium sensor定位
10	Condition check	零件是否齊全
11	Parts replacement	更換CDA傳感器
12	Condition check	檢查所有的真空密封表面
15	Time	Valve close to open time need < 2 sec.
16	Cycle test	CDA壓力為55PSI,Open to close test 500 times

Chart

序次	內容
1	Close/ Open/ MID cycle test 200 times, motion time need within 2 sec.