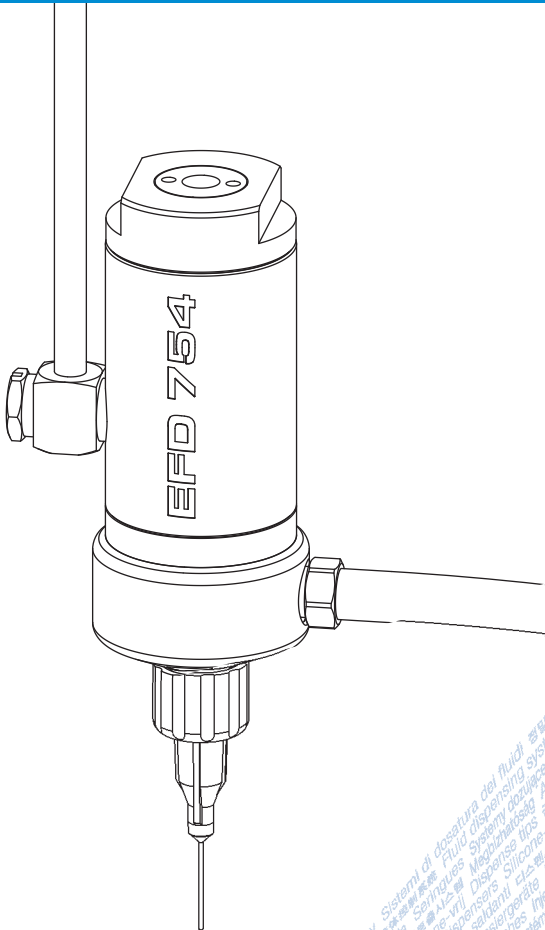


# 754V-SS Dispense Valve

## Maintenance & Parts Guide



**IMPORTANT!**  
Save this Sheet.

Forward to  
Maintenance or  
Tool Crib Supervisors

Electronic pdf files of Nordson  
EFD manuals are also available  
at [www.nordsonefd.com](http://www.nordsonefd.com)



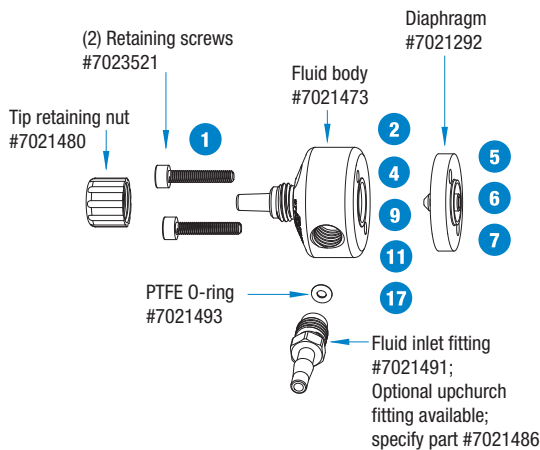
# Valve Disassembly and Reassembly Procedures

## Fluid Body

1. Remove the two retainer screws.
2. To reinstall the fluid body, align fluid body holes with diaphragm and air cylinder body holes and reinsert retainer screws. Torque to 1.58 Nm (14 inch pounds).

## Diaphragm

3. Back out stroke control two turns counterclockwise from the closed position.
4. Remove fluid body.
5. Unscrew diaphragm (counterclockwise) and remove it from the piston rod.
6. Thread on the new diaphragm and tighten slowly until diaphragm bottoms against piston shaft.
7. Align the holes of the diaphragm with the appropriate holes in the air cylinder body by inserting a flat tip screwdriver through the hole in the stroke control and engage piston rod slot.
8. Rotate rod, piston and diaphragm assembly clockwise until holes are aligned.
9. Reinstall fluid body and torque retainer screws to value specified in step 2.
10. Turn stroke control clockwise until closed, and then reopen to desired stroke.



## Piston O-ring

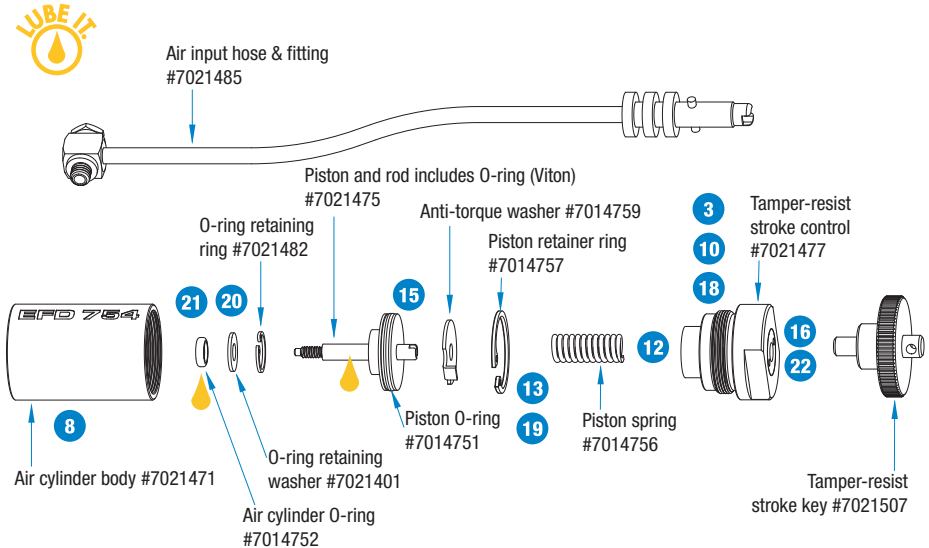
11. Remove fluid body and diaphragm.
12. Remove stroke control and spring by turning counterclockwise.
13. Remove the piston retainer ring and anti-torque washer.
14. Remove the piston.
15. Lubricate O-ring, piston shaft and air cylinder wall with Magnalube-G.
16. Reinstall components in reverse order of disassembly.

## Cylinder O-ring

17. Remove fluid body and diaphragm.
18. Remove stroke control knob and spring by turning counterclockwise.
19. Remove the piston retainer ring, anti-torque washer and piston.
20. Remove air cylinder retaining ring, washer and O-ring.
21. Lubricate O-ring with Magnalube-G.
22. Reinstall components in reverse order.

### Tools required:

- 2.5 mm hex wrench
- 1/8" flat-tip screwdriver
- 6" adjustable wrench
- 6" needle-nose pliers
- snap-ring pliers



# Troubleshooting Guide

## No fluid flow

- If valve operating air pressure is too low, the valve will not open. Increase air pressure to 70 psi (4.8 bar) minimum.
- The reservoir air pressure may not be high enough. Increase pressure.
- The dispensing tip may be clogged. Replace tip.
- The stroke adjustment may be closed. Open stroke adjustment.
- Fluid may have solidified in the valve. Clean the fluid body.

## Fluid drools after the valve closes, eventually stopping

- This is caused when air is trapped in the outlet section of the fluid body or the fluid has entrapped air. The air will expand after the valve closes, causing extrusion until the air reaches atmospheric pressure.  
Purge the valve by dispensing at a steady flow until clear. If a small tip is used, it may be necessary to remove the tip while purging to obtain sufficient flow to carry the air down through the tip adapter.
- If the fluid has entrapped air, the material must be degassed before dispensing.

## Fluid drips at a steady rate after the valve closes

- A steady drip can be caused by excessive reservoir pressure. Check to be sure the reservoir pressure is not above 70 psi (4.8 bar).
- A steady drip also indicates failure of the diaphragm to close fully due to particle build-up or wear. In either case, replace the sealing head in accordance with the maintenance instructions.

## Fluid leaks out between fluid body and diaphragm

- Fluid leakage between the fluid body and diaphragm indicates the annular sealing ridge on the fluid body is damaged or the

fluid body is distorted due to excessive torque on the retaining screws. In either case, replace the fluid body.

## Fluid flows out of the drain hole

- Fluid flowing out of the drain hole indicates a ruptured diaphragm. Replace in accordance with the maintenance instructions.

## Valve responds slowly when opening and closing

- Valve response is related to control air hose length and size. The valve is supplied with 5-feet of 3/32" ID tubing attached. Any additional length or size change will affect response time. Check to be sure the length and size have not been changed.

## Inconsistent deposits

- Inconsistent deposits can result if the air pressure controlling the valve and/or supplying the reservoir is fluctuating or if the valve operating pressure is less than 70 psi (4.8 bar). Check to be sure air pressures are constant and the valve operating pressure is 70 psi (4.8 bar).
- The time the valve is open must be constant. Check to be sure the valve controller is providing a consistent output.

---

USA & Canada: 800.556.3484 or +1.401.434.7000  
Europe: 0800 585733 or +44 (0) 1582 666334  
India: +91 80 4021 3600  
Asia: +86 (21) 3866 9006  
technical@nordsonefd.com www.nordsonefd.com

The Wave Design is a trademark of Nordson Corporation.  
©2013 Nordson Corporation 7026836-EN v072313