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Model J3.1 Owner's Manual

# Sealweld® ACTIV-8® Gun



By Sealweld Corporation

We trust you will find the lessons detailed in this program useful when maintaining the valves at your facility.  
Should you have any questions regarding any of these procedures, or if you know of any successful  
procedures you would like to share, please contact us at:

### **Sealweld Corporation**

# 106, 4116-64 Ave. S.E., Calgary, Alberta, Canada T2C 2B3  
Telephone: 1-403-236-0043 Fax: 1-403-236-5487  
TOLL FREE 1-800-661-8465 in North America  
Email: [info@sealweld.com](mailto:info@sealweld.com)  
Web Site: [www.sealweld.com](http://www.sealweld.com)

### **Sealweld (USA), Inc.**

6450 Skyview drive, Houston, Texas, USA 77041  
Telephone: 1-713-466-7373 Fax: 1-713-466-7778  
TOLL FREE 1-800-624-4301 in North America  
Email: [info@sealweld.com](mailto:info@sealweld.com)  
Web Site: [www.sealweld.com](http://www.sealweld.com)

### **ValvePro® Technical Support**

Telephone: 1-403-236-0043 Fax: 1-403-236-5487  
Email: [support@valvepro.com](mailto:support@valvepro.com)  
Web Site: [www.valvepro.com](http://www.valvepro.com)

The information in this handbook is intended as a guide only.  
Always consult the valve manufacturers recommended maintenance procedures.  
No warranty is written or implied.

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# Read This First

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## Sealweld® ACTIV-8® Owner's Manual



*ACTIV-8® Model J-4.0*

The Sealweld® ACTIV-8® Sealant Injection Gun is the result of adapting the popular and proven Uni-Seal sealant injection pump to load from a (10) ten pound pail rather than from a (1) one pound cartridge. The Uni-Seal pump has an extremely fast rate of delivery, (one (1) pound in approximately 73 seconds). However the limited (1) one pound barrel capacity required frequent shut-down to refill, preventing the gun from being used to its full capacity.



*Total-Lube # 911 Valve Lubricant / Sealant One Pound Cartridge*

By increasing the sealant capacity of the Uni-Seal pump by a factor of (10) ten, the ACTIV-8® gun becomes the most productive portable high-pressure gun in the industry.

This increased productivity will quickly recover the cost of the gun in man-hours saved, due to both much faster delivery of sealant to the valve, and to elimination of down-time due to air-locking experienced by some makes of air-operated lubricant guns. Down-time frequently results in tying up of individuals not directly involved in lubrication operations, and sometimes can occur at critical times in a facility's operation.



*Sealweld® On-site Training*

The Sealweld® ACTIV-8® and all its components are guaranteed to be free of defects and are pressure-tested prior to delivery. Sealweld Corporation will replace all parts free of charge, which fail in the first year of operation, under normal use. See Warranty Information.

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*ALWAYS WEAR SAFETY GLASSES WHEN OPERATING THIS GUN.*

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# Safety Considerations

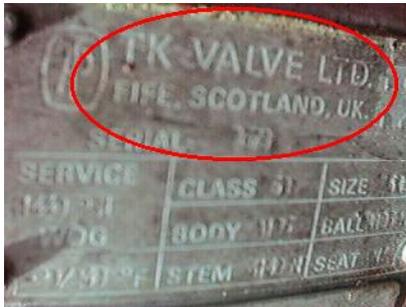
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## Sealweld® ACTIV-8® Safety Considerations

The Sealweld® ACTIV-8® is a power assisted sealant injection gun designed for injecting sealants, lubricants and valve cleaners into pressurized pipeline valves.

ALWAYS read and follow the valve manufacturer's recommendations before servicing a pressurized valve. If you have any questions, contact the valve manufacturer or either Sealweld® office. When calling have the following information available:

- Valve Manufacturers Name (and address if possible).
- Model Number, Size & Pressure Rating.



*Nameplate*

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*This information is usually found on the nameplate or on the body casting.*

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*Air Regulator and Filter*

The ACTIV-8® is designed for use with compressed air from 60 PSI minimum to a maximum of 125 PSI and operates ideally at 120 PSI. The motor draws approximately (20) twenty cubic feet per minute when running at full capacity. You can get by with a relatively small air tank (receiver) because the time required to refill the sealant barrel will usually allow the compressor to refill the air tank.

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*ALWAYS WEAR EYE PROTECTION WHEN OPERATING THE ACTIV-8®.*

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ALWAYS be aware of the amount of energy this gun will generate and the mechanical limitations of the valve and fittings you are servicing.

Test the gun before attempting to service a valve. Repair or replace all worn, missing or broken parts of the gun before operating. While a small amount of leakage from the release valve and buttonhead coupler located at the end of the sealant hose is unavoidable, you should be concerned with all other sources of leakage. DO NOT attempt repairs on the hydraulic motor.

For motor repair see any of the many OTC Repair Depots. During the first year the gun must be returned to Sealweld® for Warranty Repairs. After the first year you may have the gun repaired by Sealweld®, our many distributors or any OTC Repair Depot. Replace the air filter element, drain water from the filter bowl and lubricate the motor as recommended. Follow the suggested annual repair schedule and the motor should provide years of trouble-free operation.

# Loading Instructions

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## How to Load a Sealweld® ACTIV-8® Gun

Inspect the pail groove cut in the top of the elevator plate (#8A) and clean out as required.



*Pail Groove*

Place the OTC pump (#16A2) pedal in NEUTRAL position.

Put pail guard on new pail of lubricant, making sure the lips of the guard are opposite the seam on the pail. Tighten the pail guard wing nuts completely.



*Pail Guard*

Place pail with guard on elevator plate (#8A) making sure the bottom rim of the can fits properly in the pail groove. Open vent valve (#12).



*Vent Valve*

Turn the release valve on the jack (#7A) clock-wise to close the valve. Begin jacking the jack with jack handle (#7D) to raise the elevator plate (#8A) and pail of grease onto the loading plate (#9). Once the lubricant begins to load into the loading plate (#9), catch the lubricant escaping from vent valve (#12) with the pail lid or similar object. When lubricant appears and no longer has air bubbles, stop jacking and close vent valve (#12).



*OFF/RELEASE*

Put OTC pump (#16A2) foot pedal in OFF / RELEASE position to begin filling the sealant barrel (#19B) with lubricant. Begin stroking the jack (#7A) and watch loading tube gauge (#13) as the lubricant enters the loading tube assembly. It will take approximately (1) one minute to refill the sealant barrel (#19B); the time may vary depending on the lubricant viscosity and temperature. Once the sealant barrel (#19B) is full you are ready to begin injecting lubricant into the valve.



*Loading Tube Gauge*

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**NOTE:** Watch the Loading Tube Gauge (#13), it will rise and fall as you pump. Once the gauge stops falling the sealant barrel (#19B) is completely full and you should then release the pressure.

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# How to Test an ACTIV-8<sup>®</sup> Sealant Injection Gun

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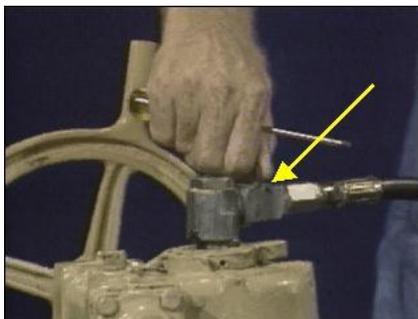
## Testing the Sealweld<sup>®</sup> ACTIV-8<sup>®</sup> Gun

With sealant barrel (#19B) loaded, attach air supply to air nipple (#15A).



*Air Nipple*

Close release valve (#23G) on high pressure hose assembly and move OTC pump (#16A2) switch to ON / PUMP position.



*Release Valve*



*ON / PUMP*

Watch sealant gauge (#23C) climb to approximately 10,000 PSI and begin to stall.



*15,000 PSI Gauge*

Leave OTC pump (#16A2) switch to NEUTRAL position and sealant gauge (#23C) pressure should remain stable at about 10,000 PSI.

The largest leak source is usually release valve (#23G). If testing with sealants leakage is minimal, if testing with light greases leakage can be quite substantial. Tighten the screw at bottom of release valve (#23G) and / or replace as necessary.

Check pressure on loading tube gauge (#13). If the loading system is over-pressurized, excess pressure will be automatically vented through relief valve (#14F).



*Relief Valve*

When using very viscous or cold sealants over-pressuring may create difficulties. If venting through relief valve (#14F) becomes a problem, you may eliminate pressure by opening vent valve (#12) until gauge (#13) reads zero. Sometimes heavy material will keep relief valve (#14F) from closing after it passes through the valve.

Relieve pressure in the loading tube by opening vent valve (#12), then remove relief valve (#14F) and clean with solvent so that it will re-seat.

If for any reason the check valve in the head (#18) of the gun were to fail and sealant discharge pressure were allowed to enter the loading tube assembly it would be discharged through relief valve (#14F). If this happens immediately disconnect air supply at air nipple (#15A) and move the OTC pump (#16A2) switch to the OFF / RELEASE position, relieve all gun pressure, disassemble and clean head (#18) or return to Sealweld® for service.



### *OFF/ RELEASE*

Check the top of the loading plate (#9) for evidence of leakage from relief valve (#14F) and for signs of leakage from the pail. If the pail has been damaged or if loading plate O-ring (#9A) has been nicked, sealant buildup will appear on top of the loading plate (#9). Should this happen, replace the pail and / or O-ring (#9A) and continue.

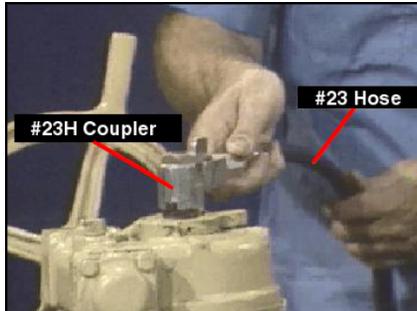
Check the O-rings (#11B) located on the upper (#11D) and lower (#11A) loading tubes on either side of the loading tube elbow (#11C) for leaks and replace loading tube O-rings (#11B) if necessary once pressure has been eliminated.



### *Loading-Tube O-rings*

Check loading head (#18) at loading tube (#11D) connection and at sealant barrel (#19B) connection for signs of leakage.

Follow high pressure hose (#23E) from the head (#18) to coupler (#23H), watch for leaks, weeps and bulges in the hose assembly.



### *Sealant Hose*

Inspect the sealant barrel end cap (#19D), hydraulic elbow (#17D) and OTC hydraulic hose (#17C) for leaks, weeps and bulges in the hydraulic system. Remove pressure from system, tighten and / or replace as necessary.

All sources of leakage (except release valve (#23G)) must be eliminated before the gun can operate safely.

Contaminants such as dirt and sand must not be allowed to enter the sealant system or these contaminants may find their way into the valve being serviced.

Occasionally sealant will enter the gauges (#23C and #13) bourdon tube and the gauges will fail to return to zero. If this occurs make sure all pressure sources have been eliminated, then remove the defective gauge and replace. To ensure longer service life for these gauges, before replacing gauge, dig a small cavity by removing a quantity of sealant out of the tee (#23B) or lower loading tube (#11A). Fill this cavity with a light-weight hydraulic fluid then install the new gauge.



*Loading Tube Gauge*



*High Pressure Gauge*

If your ACTIV-8® Sealant Injection Gun fails to operate properly consult this manual, your local Sealweld® Distributor or either Sealweld® Offices in Calgary or Houston via our toll free 1-800 lines.

# Operating Instructions

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## How to Operate a Sealweld® ACTIV-8® Gun

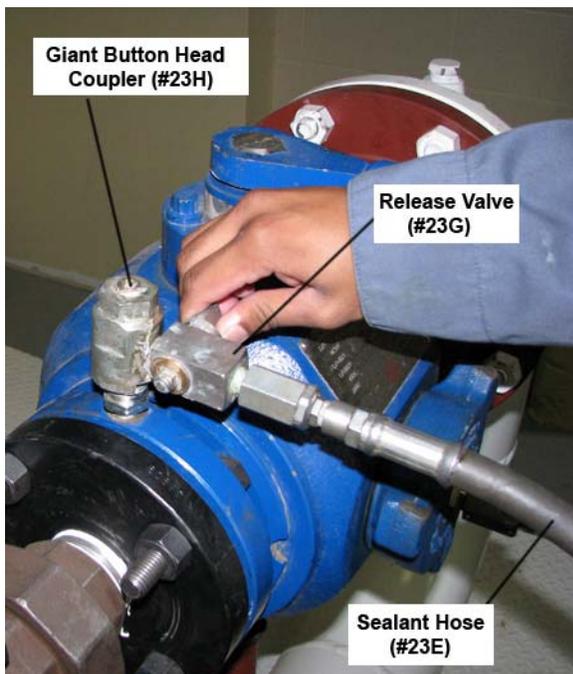
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*READ ALL INSTRUCTIONS BEFORE OPERATING.*

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### Injection Procedures

Attach Giant Button Head Coupler (#23H) to sealant injection fitting on the valve to be serviced. Open release valve (#23G) on sealant hose (#23E).



*Sealant Coupler*

Start gun by stepping on OTC Pump (#16A2) foot pedal in ON / PUMP position.



*ON / PUMP*

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*SWITCH MUST BE HELD DOWN FOR THE MOTOR TO RUN AND WILL STOP WHEN RELEASED*

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Watch sealant gauge (#23C) for an indication of product flowing into the valve. Damaged injection fittings may not seal properly with sealant coupler (#23H); if this is the case reposition the sealant coupler (#23H) until a seal is achieved. If the sealant coupler (#23H) continues leaking, inspect the fitting and install a LEAK-LOCK adapter if required.

It should take (1) one or (2) two minutes to pump all the lubricant out of the sealant barrel (#19B). This may vary depending on inlet air pressure, the pressure inside the valve being serviced, the lubricant / sealant viscosity and temperature. Restrictions inside the sealant fitting or internal sealant passages may also affect sealant flow. In the case of plugged sealant fittings, the sealant gauge (#23C) will climb rapidly and not fall when pumping stops. Consult Sealweld Corporation valve maintenance manuals for specific advice on remedies for plugged fittings.



*Pressure Gauge # 23C*

When the sealant barrel (#19B) is empty, the piston assembly will reach the top of the barrel and the motor will slow or appear to stall. The sealant gauge (#23C) will simultaneously drop to (0 PSI) zero. When this

happens move the OTC pump (#16A2) foot pedal to the OFF / RELEASE position. Begin jacking the jack (#7A) with jack handle (#7D) to raise the elevator plate (#8A) and pail of grease into the loading plate (#9).



*OFF / RELEASE*

After refilling the sealant barrel (#19B) two (2) or three (3) times, the jack swing bar (#8G) will need to be swung into place under the center of the elevator plate (#8A) in order to empty the rest of the pail. While holding the elevator plate (#8A) in position with one hand, turn the jack (#7A) release counter-clockwise using the jack handle (#7D). The jack pull down bar (#7G) and jack springs (#7F) will lower the jack extender down and out of the way. Place the swing bar (#8G) into position on the elevator plate (#8A) and close the jack (#7A) release. Continue to jack (#7A) until the extender comes in contact with the swing bar (#8G). Proceed to load the gun and then continue to service the valve.

## How to Move To Another Valve

When finished servicing a particular valve ALWAYS turn the OTC pump (#16A2) OFF / RELEASE to relieve sealant pressure before removing the coupler (#23H) from the valve. Disconnect air supply from inlet air nipple (#15A) and remove sealant coupler (#23H) from valve being serviced.



*OFF / RELEASE*



*Air Nipple # 15A*

Coil the high pressure hose (#23E) around the handle (#2A) and attach the sealant coupler (#23H) to fitting (#2C). Move to another valve.

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# Refilling Instructions

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## How To Refill a Sealweld® ACTIV-8® Gun

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*READ ALL INSTRUCTIONS BEFORE REFILLING THE ACTIV-8® SEALANT INJECTION GUN.*

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### How to Remove the Pail

Open jack (#7A) by-pass valve by turning the valve counter clock-wise. The jack (#7A) pull down bar (#7G) and jack springs (#7F) will lower the jack extender down and out of the way. Swing the swing bar (#8G) out of the way. The OTC pump (#16A2) foot pedal MUST be in the NEUTRAL position to prevent air from entering the sealant barrel (#19B) while blowing off the old pail. Disconnect air supply from air nipple (#15A).



*NEUTRAL*



*Air Nipple #15A*

Push air hose end coupler over modified air nipple (#14A). This air nipple has been modified to prevent a connection.

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*NOTE: Use only quick short shots of air, KEEP HANDS CLEAR, WEAR PROTECTIVE GLASSES to keep grease from spraying eyes.*

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*Modified Air Nipple # 14A*

After pail is off loading plate (#9), depress the elevator plate (#8A) to its lowest position if not already in this position. Remove pail guard from the pail and attach to a new pail of lubricant making sure the lips of the pail guard are not aligned with the seam on the pail.



*Pail Guard*

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*NOTE: If air is accidentally introduced to the blow-down assembly before lowering the elevator plate, the pail will be pressurized. If this occurs, the pressure should be relieved through vent valve (#12). Be sure to hold the pail lid or similar object in front of the (#12) valve as the pressure will blow both air and grease out of the valve rapidly. Be sure to WEAR EYE PROTECTION.*

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## **How to Change Product**

When changing products always purge the old material out of the sealant barrel (#19B) and sealant hose assembly before attaching the button head coupler (#23H) to the next valve. Load about half of the barrel (#19B) with the new lubricant type and pump the old material out of the hose assembly and into the old pail to avoid wasting any material. You may need to repeat this step two (2) times to purge the old material from sealant barrel (#19B) and sealant hose assembly.

# Troubleshooting Hints

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## Minor Repairs to the Sealweld® ACTIV-8®

The major moving part of the Sealweld® ACTIV-8® Sealant Injection Gun is the piston assembly in the sealant barrel (#19B). We recommend replacing the nylon (#20C) and leather (#20G) piston cups on an annual basis to prevent the possibility of sealant contaminating the hydraulic system. If this occurs, we do not recommend that you attempt repairs on the OTC pump (#16A2). OTC pump (#16A2) repairs should only be attempted by trained service personnel. For repairs contact your nearest OTC repair depot, your local Sealweld® distributor or either Sealweld® office.



*OTC Pump*

## How to Extend Motor Life

Use the air filter (#15H) / lubricator (#15J) assembly system provided. Replace air filter elements as necessary, drain water from the filter bowl on a regular basis. Adjust the flow screw on lubricator unit (#15J) so that the motor receives approximately (1) one drop of oil per minute of operation. Use a clean non-detergent #10 S.A.E. weight oil. Tighten loose or leaking hydraulic fittings and replace hoses which have been damaged.

Use minor repair kit R-A8-25 to replace the following parts on an annual basis (or as necessary):

- nylon piston cup (#20C) - 1 each
- leather piston cup (#20G) - 1 each
- piston O-ring (#20E) - 1 each
- barrel gasket (#19A) - 1 each
- barrel O-ring (#19C) - 1 each
- loading-tube O-rings (#11B) - 2 each
- loading-plate O-ring (#9A) - 1 each
- relief valve (#14F) - 1 each

Other parts to consider for annual replacement include:

- hydraulic fluid for OTC Pump
- air filter element

## Replacing the Replacement Parts

Run the OTC pump (#16A2) until the sealant barrel (#19B) is empty and OTC pump (#16A2) begins to stall. Move OTC pump (#16A2) foot pedal to OFF / RELEASE position, check gauges (#13) (#23C) to MAKE SURE all pressure has been removed from system.

Open jack (#7A) by-pass valve by turning the valve counter clock-wise. The jack pull down bar (#7G) and jack springs (#7F) will lower the jack extender down and out of the way. Swing the swing bar (#8G) out of the way. Switch the OTC pump (#16A2) foot pedal into the NEUTRAL position to prevent air from entering the sealant barrel (#19B) while blowing off the old pail. Disconnect air supply from air nipple (#15A).

Push air hose end coupler over modified air nipple (#14A).

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*NOTE: Use only quick short shots of air, KEEP HANDS CLEAR, WEAR PROTECTIVE GLASSES to keep grease from spraying eyes.*

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After pail is off loading plate (#9), depress the elevator plate (#8A) to its lowest position if not already in this position.

Remove sealant barrel (#19B) from frame by removing "U" Bolts (#22B). Head (#18) and barrel assembly with top loading tube (#11D) attached will slip out of loading tube elbow (#11C) by pulling laterally. The loading tube elbow (#11C) is held in place by loading tube O-rings (#11B).



### *Loading-Tube O-rings*

Remove loading tube elbow (#11C) and replace both loading tube O-rings (#11B) on upper (#11D) and lower (#11A) loading tubes. Before re-installing the elbow (#11C), coat the inside with a lubricant or grease such as Eterna-Lube 1000. Place elbow (#11C) back in position.

Remove head assembly (#18) from sealant barrel (#19B) by unscrewing.



### *Remove Head Assembly*

Place sealant barrel (#19B) in a vise in an upright position (hose down, open barrel up).

Make sure OTC pump (#16A2) foot pedal is in OFF / RELEASE position. Push piston assembly to the bottom of the sealant barrel (#19B) with a wooden handle or similar object which will not score the sealant barrel (#19B).

Move OTC pump (#16A2) foot pedal to the NEUTRAL position. Disconnect end cap (#19D) from sealant barrel (#19B). Leave the end cap (#19D) in an upright position to prevent leakage of hydraulic fluid.



### *NEUTRAL*

Remove piston assembly from sealant barrel (#19B). Disassemble the piston by attaching piston wrench # R-A8-20G to piston end nut (#20F) and an Allen wrench to set piston screw (#20A). Clean all parts and install new cups (#20C and #20G). Make sure cups are facing opposite directions. Replace piston O-ring (#20E). Apply a small amount of Locktite # 242 to set piston screw (#20A) before reassembling and tightening.



### *Piston Assembly – R-A8-20*

Inspect the old nylon piston cup (#20C) and leather piston cup (#20G) and piston O-ring (#20E) for damage. Severe damage such as a nick or groove could be caused by scoring on the inside of the sealant barrel (#19B). If sealant is present on the hydraulic side of the piston your hydraulic system could be contaminated.

Should contamination be suspected, change the hydraulic fluid in the reservoir. Inspect and replace hydraulic hose (#17C) as required. Fill the OTC pump reservoir with hydraulic fluid and then reinsert the breather plug.



### *Hydraulic Hose*

Replace the barrel O-ring (#19C) in end cap (#19D) and re-attach sealant barrel (#19B). Make sure to use Teflon tape on the barrel threads to help prevent oil from leaking past barrel o-ring (#19C). The entire sealant barrel (#19B) should be full with hydraulic fluid before placing the piston assembly into the sealant barrel (#19B). This will reduce air pocket buildup within the sealant barrel (#19B).

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*ALWAYS WEAR EYE PROTECTION WHEN OPERATING AND REPAIRING THE ACTIV-8®.*

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Using the OTC pump (#16A2), pump the hydraulic oil to the top of the sealant barrel (#19B). Wrap the top of the sealant barrel (#19B) with rags or paper towel to help prevent hydraulic oil from spilling or splashing. Place the repaired piston assembly into sealant barrel (#19B), ALWAYS insert piston from the top end with the piston end nut down (#20F) (the leather cup end goes in first). Make sure that you haven't caught any of the rag or paper towel underneath the piston. As you push the piston assembly into the sealant barrel (#19B), switch the OTC pump (#16A2) foot pedal into the release position to insert the piston assembly into the sealant barrel (#19B).

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*Before driving the piston to the bottom of the Sealant Barrel (#19B), ALWAYS make sure the OTC pump (#16A2) is in the "off" position to relieve pressure and return the hydraulic fluid back to the reservoir.*

---

With the OTC pump (#16A2) in the "off" position, use a modified barrel end cap with air nipple screwed on firmly at the top of sealant barrel (#19B), attach air hose coupling to nipple and proceed to drive the piston to the bottom of the sealant barrel (#19B). There will be a distinct click as the piston strikes the end cap (#19D) at the bottom of the sealant barrel (#19B). If you do not have a modified barrel end cap, use a broom handle to push the piston to the bottom of the sealant barrel (#19B).

### ***Piston Break-In Procedure***

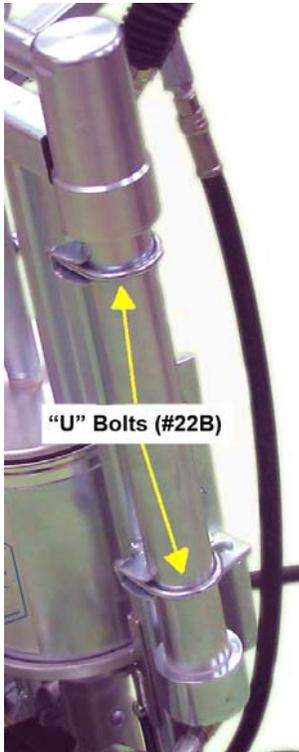
After installing new piston cups it is recommended to run the piston up and down several times. This can be done by engaging the OTC pump (#16A2) until the piston is seen at the top of the sealant barrel (#19B), push the piston back down and repeat the procedure several times. Leave the piston at the top of the sealant barrel (#19B) when complete. Be careful not to pump the piston out of the sealant barrel (#19B).



*Piston Assembly – R-A8-20*

Replace barrel gasket (#19A) before tightening head assembly (#18) to sealant barrel (#19B).

Attach head (#18) and sealant barrel (#19B) assembly to the frame with “U” bolts (#22B), washers and Nylock locknuts by sliding the top loading tube (#11D) into loading tube elbow (#11C). Make sure that loading tube O-ring (#11B) is not nicked or damaged. Tighten the “U” bolt Nylock locknuts.



*Barrel Mounting*

Replace loading-plate O-ring (#9A).



*Loading-Plate O-ring*

Replace relief valve (#14F). Use a backup wrench on the tee when removing and replacing the relief valve (#14F). Tighten all threaded connections and replace all missing fasteners. When completed, refill the sealant barrel (#19B) with lubricant and test gun as detailed in How To Operate a Sealweld® ACTIV-8® Gun.

# Parts List

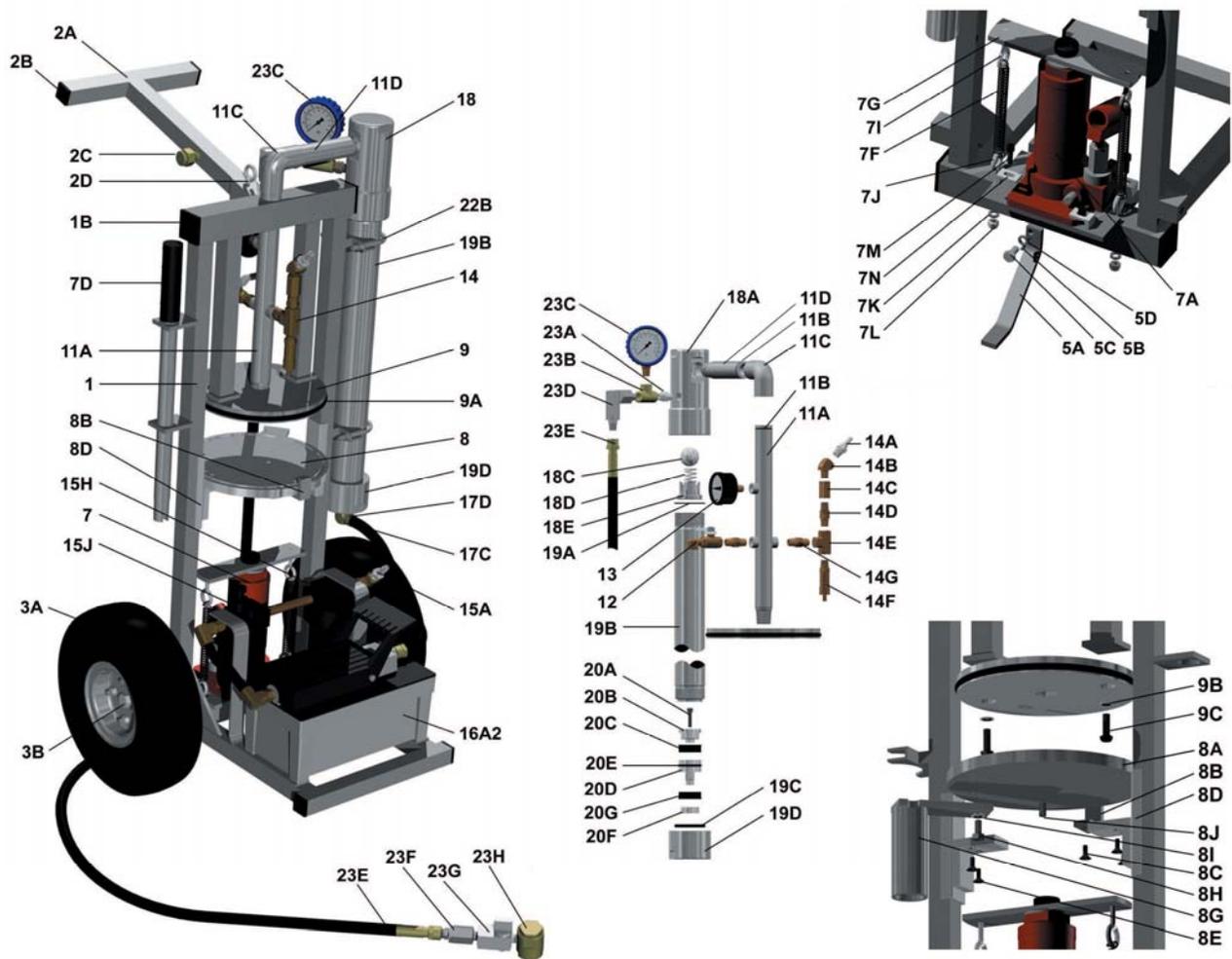
## How To Order ACTIV-8® Parts

Illustration #	Description	Order Part #	Qty. Req'd
1	ACTIV-8® Frame (bare)	R-A8-01	1
1B	1-1/2" Frame Plugs	R-A8-01B	4
	T-Handle Assembly	R-A8-02	
2A	T-Handle (bare)	R-A8-02A	1
2B	1" Frame Plugs	R-A8-02B	4
2C	Capped Sealant Fitting ¼" Carbon Steel	F-SC1/4-BH-CS	1
2D	T-Handle Large Eye Hook	R-A8-53	1
	Washer – ¼"	R-A8-32	1
	¼" Nylock Lock Nut	R-A8-33	1
3A	Pneumatic Wheel	R-A8-03P1	2
3B	½" x 3-1/4" New Style Axle	R-A8-03P5	2
	Kick Stand Assembly	R-A8-05	
5A	Kick Stand	R-A8-05A	1
5B	Kick Stand Set Screw	R-A8-05B	1
5C	Kick Stand Bolt	R-A8-34	1
5D	Washer – ¼"	R-A8-32	2
	¼" Nylock Lock Nut	R-A8-33	1
7	Jack Assembly	R-A8-07	
7A	Jack	R-A8-07A	1
	Jack Collar	R-A8-07AC	1
	Jack Handle with Grip Assembly	R-A8-07B	1
7D	Jack Handle with Grip	R-A8-07B2	1
	Washer – ¼"	R-A8-32	1
	Jack Bracket Bolt	R-A8-50A	1
7F	Jack Pull Down Springs	R-A8-07C	2
7G	Jack Pull-Down Bar	R-A8-07D	1

Illustration #	Description	Order Part #	Qty. Req'd
7I	Upper Eye Bolts	R-A8-29	2
7J	Lower Eye Bolts	R-A8-30	2
7K	Washer – ¼"	R-A8-32	2
7L	¼" Nylock Lock Nut	R-A8-33	2
7M	Jack Bracket Bolts	R-A8-50A	4
7N	Jack Bracket	R-A8-50B	4
8	Elevator Plate Assembly	R-A8-08	
8A	Elevator Plate	R-A8-08A	1
8B	Elevator Plate Back-Stop	R-A8-08B	1
8C	Back Stop Bolt	R-A8-37	1
8D	Slide Rails	R-A8-08C	2
8E	Slide Rail Screw	R-A8-52	4
	Jack Extension Assembly	R-A8-08D	
8G	Swing Bar	R-A8-08D1	1
	Dowel Pin – 1/8" x ½"	R-A8-08E	1
8H	Swing Bar Bolt – 5/16"	R-A8-39	1
8I	Washer – ¼"	R-A8-32	1
8J	Swing Bar Stop Bolt	R-A8-39A	1
9	Loading Plate	R-A8-09	1
9A	Loading Plate O-Ring - Nitrile	R-A8-09A	1
9B	Bonded Seal – 5/16"	R-A8-09D	2
9C	Loading Plate Cap Screws – 5/16" x 1"	R-A8-09C	2
11A	Lower Loading Tube	R-A8-11A	1
11B	Loading Tube O-Rings - Nitrile	R-A811B	2
11C	Loading Tube Elbow	R-A811C	1
11D	Upper Loading Tube	R-A811D	1
12	Vent Valve Assembly	R-A8-12A	1
13	Loading Tube Gauge – 200 PSI	R-A8-13	1
14	Blow Down Assembly	R-A8-14	
14A	Modified Air Nipple	R-A8-14A	1
14B	Elbow – 45 Degree – LP – M x F	R-A8-14B	1
14C	Collar – Low Pressure – F x F	R-A8-14C	1
14D	Check Valve	R-A8-14D	1
14E	Low Pressure Tee	R-A8-14E	1
14F	Relief Valve – 200 PSI	R-A8-14F	1
14G	Low Pressure Nipple – ¼"	R-A8-14G	1
	Filter / Lubricator Assembly	R-A8-15	
15A	Air Nipple	R-A8-15A	1
	Air Swivel Elbow	R-A8-15F3	1
	Low Pressure Hose	R-A8-15F4	1
	Elbow – 90 Degree – LP – F x F	R-A8-15F7	2

Illustration #	Description	Order Part #	Qty. Req'd
	Pipe Nipple – LP – 3" – ¼" NPT	R-A8-15F8	1
	Pipe Nipple – LP – 2" – ¼" NPT	R-A8-15F9	2
	Pipe Bracket Screws	R-A8-15G	4
	Pipe Bracket Nylock Lock Nuts	R-A8-15G2	4
	Lubricator/Filter Pipe Brackets	R-A8-15G3	2
15H	Large Air Filter Unit	R-A8-15H	1
15J	Large Lubricator– ¼"	R-A8-15J	1
	Lubricator/Filter Bracket Set	R-A8-15K	1
16A2	Air / Hydraulic Motor – OTC Pump	R-A8-16A2	1
	Bolts for Metal Pump Box	R-A8-31	4
	Washers – ¼"	R-A8-32	4
17C	OTC Hydraulic Hose	R-A8-17C	1
17D	Elbow – 90 Degree ¼" M x ¼" F	R-A8-17D	1
18	Head Assembly	R-A8-18	
18A	Head - Bare	R-A8-18A	1
18C	Steel Flag Ball for Head – 1-1/4"	R-A8-18C	1
18D	Spring for Head	R-A8-18D	1
18E	Flow Wolf Cage for Head	R-A8-18E	1
	Sealant Barrel Assembly	R-A8-19	
19A	Barrel Gasket	R-A8-19A	1
19B	Sealant Barrel	R-A8-19B	1
19C	Barrel O-Ring - Nitrile	R-A8-19C	1
19D	Barrel End Cap	R-A8-19D	1
	Piston Assembly	R-A8-20	
20A	Piston Screw	R-A8-20A	1
20B	Piston Stop	R-A8-20B	1
20C	Nylon Piston Cup	R-A8-20C	1
20D	Piston Body	R-A8-20D	1
20E	Piston O-Ring	R-A8-20E	1
20F	Piston End Nut	R-A8-20F	1
20G	Leather Piston Cup	R-HG08H	1
	Head and Barrel Assembly	R-A8-21	
22B	"U" Bolts	R-A8-22B	2
	Washers – ¼"	R-A8-32	4
	3/8" – "U" Bolt - Nylock Nuts	R-A8-45	4
	High-Pressure Hose Assembly	H-A-HOSE	
23A	Adapter – ¼" M x ¼" M	H-AD-4M4M	1
23B	High-Pressure Tee – ¼" F x ¼" F	H-T-444	1
23C	HP Gauge Assembly - 15,000 PSI	H-GD-01C	1
23D	"L" Swivel – 1/4 " M x ½" – 27M	H-SV-L1	1
23E	HP 10 foot Hose – 3/8" – 10,000 PSI	H-HS-120HP	1

Illustration #	Description	Order Part #	Qty. Req'd
23F	Straight Swivel 1/4" M x 1/4" – 27 M	H-SV-ST1	1
23G	Release Valve 1/4" M x 1/4" F	H-RVAB	1
23H	Sealweld Giant Buttonhead Coupler	H-CPSG-2	1
	Pail Guard	R-A8-24	1
	Pail Guard Wing Nuts – 5/16"	R-A8-48	2
	MINOR REPAIR KIT	R-A8-25	



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# Warranty Information

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## Sealweld® ACTIV-8® Warranty

Sealweld® warrants its products only against defects in materials and workmanship.

Sealweld Corporation's liability and customer's exclusive remedy under this warranty extends for a period of one (1) year from the date of Sealweld Corporation's shipment and is expressly limited to repayment of purchase price, repair or replacement, at Sealweld Corporation's option, during said period, upon proof satisfactory to Sealweld® and upon customers returning and prepaying all charges on such products to factory or warehouse designated by Sealweld®. Warranty excludes normal wear items such as packings, seals and filters. Also excluded is equipment subject to corrosion, contamination, negligence, accident, or units, which have been altered in any way.

This Warranty is made expressly in lieu of all other warranties, express, implied or statutory, with respect to quality, merchantability, or fitness for a particular purpose.

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## Contact Information

### Sealweld Corporation – Canada

# 106, 4116 – 64 Ave. S.E.  
Calgary, Alberta  
CANADA T2C 2B3  
TOLL FREE 1-800-661-8465  
PHONE 1-403-236-0043  
FAX 1-403-236-5487  
EMAIL [info@sealweld.com](mailto:info@sealweld.com)  
URL <http://www.sealweld.com>



### Sealweld (USA), Inc.

6450 Skyview Drive  
Houston, Texas  
USA 77041  
TOLL FREE 1-800-624-4301  
PHONE 1-713-466-7373  
FAX 1-713-466-7778  
EMAIL [info@sealweld.com](mailto:info@sealweld.com)  
URL <http://www.sealweld.com>



### ValvePro® Technical Support

TOLL FREE 1-800-661-8465  
PHONE 1-403-236-0043  
FAX 1-403-236-5487  
EMAIL [support@valvepro.com](mailto:support@valvepro.com)  
URL <http://www.valvepro.com>



# About This Manual

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## Trademarks and Patents

We trust you will find the lessons detailed in this program useful when maintaining the valves at your facility. Should you have any questions regarding any of these procedures, or if you know of any successful procedures you would like to share, please contact us.

The Sealweld® ACTIV-8® Owner's Manual is written from the maintenance departments point of view and in the language of service people responsible for safe and efficient operation of lubricated plug, ball and gate valves.

The information in this manual is intended as a guide only. Always consult the valve manufacturer's recommended maintenance procedures. No warranty is written or implied.

Use of product and / or company names is for reference only.

The Sealweld® ACTIV-8® Owner's Manual is one of the software solutions in the Sealweld® ValvePro® series. Use the components that suit your needs and approach fugitive leakage reduction from the most cost effective approach.

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