

## ASSEMBLY INSTRUCTIONS FOR TWO-WAY VALVE INTO SPACER BAR

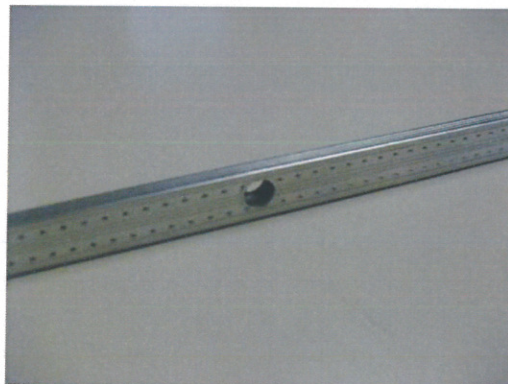
### Material needed:

- Workbench with vice
- Drill with 6.1 mm bit
- 1 compliant two-way valve tested by our valve tester code 9736
- 1 collared bush 6.5 mm high for 6.5 mm spacer bar or 1 collared bush 8.0 mm high for 8.0 mm spacer bar
- 1 silicone tube 50 mm long
- Technical data sheet
- Spacer frame of **9.5 mm minimum width**

**Warning:** assembly must occur before putting the molecular sieves into spacer frame.

### Instructions:

- 1) At a 22 mm distance from the upper corner of the frame (see technical data sheet), drill the spacer bar in the middle making a 6.2 mm through hole without deforming the surfaces (remove any burr on both sides):



- 2) Insert silicone tube into the collared bush letting it protrude of minimum 5 mm per side:

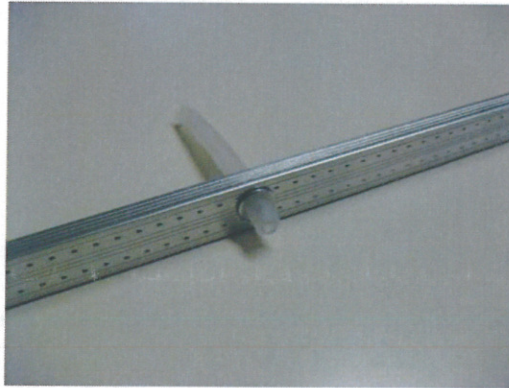


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REA. Bologna: N. 236672  
Export Code: B0009788

- 3) Insert the kit of collared bush and silicone tube into IG unit with collared bush inside, that is in the micro-drilled side of spacer bar:



- 4) Insert the two-way valve into silicone tube:



- 5) Gently pull the silicone tube to near the valve to spacer bar:




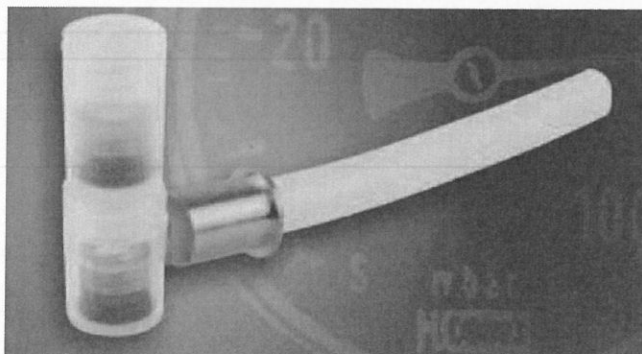
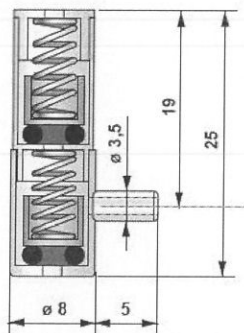
**WARNING: BE SURE THE TWO-WAY VALVE HAS BEEN ASSEMBLED PROPERLY BEFORE SEALING THE IG UNIT.**

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<b>SCPVTW</b>	<b>PRODUCT CHART</b>	
Rev. 00 del 01/04/2010	<b>TWO-WAY VALVE</b>	



Item code		
Code 0736065 (valve for 6,5 mm spacers) Code 0736080 (valve for 8,0 mm spacers)		
Batch number		
Segnature for Quality Control:		
Check made by:	Production date	Batch number
Quality Control Department	04/12/2015	107073
Properties		
In standard pressure conditions, TWO-WAY valve is generally closed; when pressure difference between inside and outside I.G. unit exceeds of about 80 mbar, the valve opens adjusting the two pressures.		
Product control features		
Ref.	Test method	Test instrument
1.0	Valve assembly check	VISUAL
	Valve opening check In Out	PRESSURE CHECK INSTRUMENT 80 mbar +/-10 mbar
	Packaging in bags with  <b>PRODUCTION DATE and BATCH NUMBER</b>	

### 2.0 Quality

CONTROL DATA SHEET SUMS UP TEST RESULTS OCCURED DURING ALL PROCESSINGS.

### 3.0 Storage

KEEP THE VALVE CLOSED IN ITS ORIGINAL PACKAGING IN CLEAN AND DRY PLACE AT A TEMPERATURE OF MAXIMUM 20° C.

UNDER SUCH CONDITIONS, THE VALVE HAS AN ASSEMBLING EXPIRY DATE OF 6 MONTHS FROM PRODUCTION DATE.

ONCE THE PACKAGE IS OPENED, ALL VALVES MUST BE USED IN A SHORT TIME.

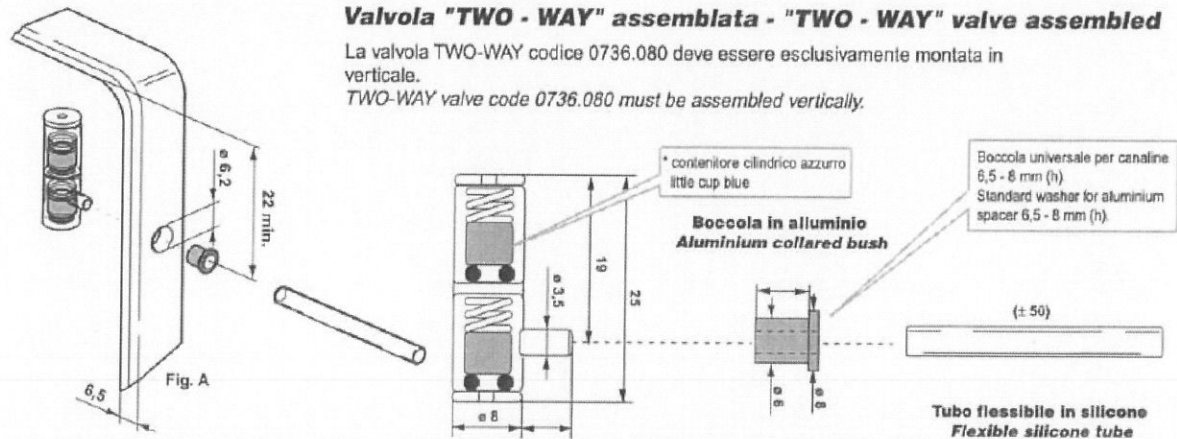
**AL7-Meipa Srl**  
**Quality Control Department**

## VALVOLA "TWO - WAY" • "TWO - WAY" VALVE

### Valvola "TWO - WAY" assemblata - "TWO - WAY" valve assembled

La valvola TWO-WAY codice 0736.080 deve essere esclusivamente montata in verticale.

*TWO-WAY valve code 0736.080 must be assembled vertically.*

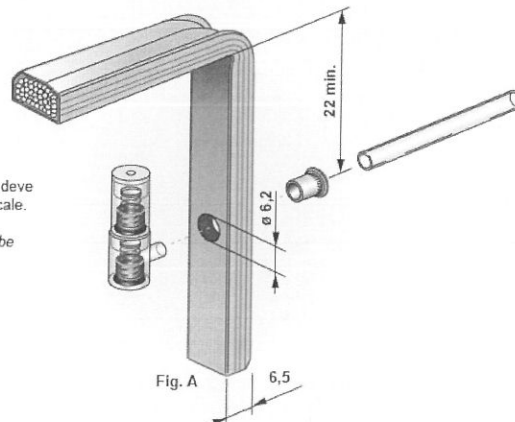


Prima di utilizzare la valvola "TWO - WAY" codice 0736.080 verificare che sia completa di tutti i particolari come indicato nel disegno con le molle in posizione corretta all'interno del contenitore cilindrico azzurro\*. N.B. In caso di utilizzo di uno spaziatore non piegato, come mostrato in figura A, occorre fare il foro alla quota appropriata per evitare la giunzione ad angolo.

*Before using the "TWO - WAY" valve, code 0736.080, verify that it is complete of all its parts as indicated in the drawing, with the springs in the correct position inside the little cup blue\*. NOTE: If a non bendable spacer is used as shown in fig. A, the hole for the valve must be drilled at a distance to avoid the corner joint.*

La valvola TWO-WAY codice 0736.080 deve essere esclusivamente montata in verticale.

*TWO-WAY valve code 0736.080 must be assembled vertically.*



### NOTE

**TWO-WAY VALVE** is installed in spacer profile by a 6,2 mm hole. Once I.G. unit is sealed, Two-Way valve becomes an integral part of the same.

### Item code

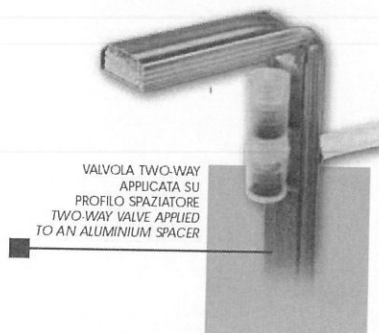
Code 0736065 (valve for 6,5 mm spacers)

Code 0736080 (valve for 8,0 mm spacers)

### Properties

Dimensions  
SEE PICTURE ABOVE

OPENING /CLOSING OF TWO-WAY VALVE AT 80 mbar +/- 10 mbar



ASSEMBLY INSTRUCTIONS / WARNINGS	
1.0	Minimum spacer width where to install Two-Way valve = 9,5 mm
1.1	Test two-way valve by our TESTER item code 9736
1.2	Two-Way valve works VERTICALLY only (in all stages: installation in IG unit, transport of IG unit, final application of IGU at destination, etc.), which means it does not work if installed in inclined or parallel to ground IG units nor when IG units are transported/ assembled horizontally.
1.3	Once I.G. unit is sealed, cut the tube at secondary sealing (generally polysulphide)
1.4	Once Two-Way valve is installed, glass thickness of I.G. unit must be calculated, as Two-Way valve adjusts pressure inside insulating glass only. Two-Way valve does not exempt from making correct calculation of glass thickness nor from using the related safety coefficients linked to final application.
1.5	Two-Way valve closure depends on the design made by the customer and/or the insulating glass designer, who have for sure considered life cycle of insulating glass, installation, functionality, etc... Valve tube can be closed by supplied cones. We remind you that if you close the tube, the valve does not adjust pressure differences any longer.
<b>DO NOT put in ARGON by Two-Way valve</b> <b>DO NOT use glue to fix Two-Way valve</b>	

Certification
IFT ROSENHEIM Certification - Test report No. 601 22579/2 e


### Storage

KEEP THE VALVE CLOSED IN ITS ORIGINAL PACKAGING IN CLEAN AND DRY PLACE AT A TEMPERATURE OF MAXIMUM 20° C.  
UNDER SUCH CONDITIONS, THE VALVE HAS AN ASSEMBLING EXPIRY DATE OF 6 MONTHS FROM PRODUCTION DATE.  
ONCE THE PACKAGE IS OPENED, ALL VALVES MUST BE USED IN A SHORT TIME.

The present data are based on tests performed on our standard production. They are proposed as technical advices. Nevertheless, AL7 MEIPA Srl recommends to check their suitability to every specific application and the related calculation of insulating glass.

AL7-MEIPA Srl declines any liability for damages, direct or indirect, caused by an illegitimate use of the product and cannot be held responsible for any possible breaking or malfunctioning of the finished product.

**AL7-Meipa Srl**  
**Quality Control Department**

AQTWV	Frequently Asked Questions	 AL7 - MEIPA Srl
Rev. 01 Date 01/01/2014	<h2>TWO-WAY VALVES</h2>	

**1) Does Two-Way valve work for many years inside I.G. unit? If yes, how long?**

Two-way valve works whenever nominal pressure difference between inside and outside insulating glass is reached: about 80 mbar. Life cycle must be calculated by the glass designer, because once I.G. unit is installed, it is rarely subjected to pressure differences. In any case, please refer to EN 13474-3.

**2) Which altitude does Two-Way valve start "working" at?**

Two-Way valve working is connected with mbar difference between inside and outside insulating glass. As a matter of fact, pressure varies according to altitude (about 10 mbar every 100 m) and weather.

**3) Does Two-Way valve suit any existing pressure? What does the actual pressure of Two-Way valve "80 mbar +/- 10 mbar" refer to? Does it come from practical results in I.G. field?**

80 mbar corresponds to the difference in pressure between inside and outside insulating glass, which makes the valve open and work. Such value has a tolerance of +/- 10 mbar. The insulating glass must be always calculated as per point no. 16 listed hereunder and EN 13474-3.

**4) Must Two-Way valve tube be cut once I.G. unit is sealed?**

Yes, it must be cut at secondary seal (generally polysulphide).

**5) Must Two-Way valve tube be closed once I.G. unit is sealed? If so, how?**

Two-Way valve tube closure depends on the design made by the customer and/or the insulating glass designer, who have for sure considered life cycle, installation, functionality, etc. of insulating glass. Valve tube can be closed by the supplied **plugs**. **However, we remind you that if you close the tube, the valve does not work any longer (it does not adjust pressure differences any longer).**

**6) If Two-Way valve is not closed, may air (and consequently humidity) come in and molecular sieves become saturated?**

Once insulating glass is sealed, the valve is normally closed, unless insulating glass is subjected to pressure changes (e.g. further transport of insulating glass set inside house-hold appliance).

**7) What kind of spacer bars can Two-Way valve be installed in?**

It can be installed in all kinds of spacer bars. Please, read assembling instructions.

**8) What is the spacer minimum width where Two-Way valve can be installed in?**

Two-Way valve can be installed in spacers of 9,5 mm minimum width.

**9) And what about the maximum one?**

There are no limits for maximum width.

**10) Can Two-Way valve be indifferently installed horizontally or vertically in I.G. unit?**

**THE TWO-WAY VALVE WORKS IN VERTICAL POSITION ONLY** (in all stages: installation in I.G. unit, transport of I.G. unit, final application of I.G. unit at destination, etc.), which means it does not work if installed in inclined or parallel to ground I.G. units or when I.G. units are transported to &/or assembled at destination horizontally.

**11) Where exactly (up or down)?**

No matter where, but ALWAYS VERTICALLY and never in inclined or parallel to ground glasses.

**12) Is Two-Way valve visible from the outside of I.G. unit?**

Yes, it is.

**13) Can glue or silicone be used to fix Two-Way valve?**

Absolutely NOT.

**14) Is it possible to install Two-Way valve in a I.G. unit with a secondary seal of silicone? Do you have any statement concerning the compatibility with silicones?**

The valve is equipped with a silicone tube. We do not actually know what kind of sealing silicone you would like to use; therefore, we cannot guarantee any compatibility between the silicone of the valve tube and that one you are using to seal. Before application, we suggest to check if your sealing silicone is compatible with other plastic materials.

**15) Can Two-Way valve be set in TRIPLE-GLAZED UNITS?**

**ALWAYS CONSIDER THE PEAK PRESSURE RESULTING FROM PRESSURE COUPLING OF SINGLE CAVITIES. USE ONE TWO-WAY VALVE PER CAVITY.**

**16) Can Two-Way valve be set in I.G. units filled with argon?**

Yes, it can. Be careful that the two-way valve adjusts pressure making the argon coming out of I.G. unit but obviously it does not make argon enter the I.G. unit, it makes only air enter the I.G. unit. In any case, it is recommended to define life cycle of I.G. unit first.

**17) Must glass thickness be calculated before installing Two-Way valve?**

Yes, it must, because Two-Way valve serves the only purpose of adjusting pressure inside insulating glass. As a matter of fact, Two-Way valve does not exempt from making correct calculation of glass thickness or from using the related safety coefficients linked to final application.