

The 400 series glue valves are solenoid-operated for precise glue patterns at high machine speeds. The compact size permits installation into space-restricted areas. The valves feature a purge/test switch and a carbide-tipped plunger assembly for long service life.

**Applications**

Folding cartons, envelopes, mailers, and other requirements in the paper converting and graphics industries

**Technical Data**

Coil data ..... 12 VDC, 20 ohm,  
7.2 W  
Max. fluid pressure ..... 500 psi (35 bar)  
Viscosity ..... 300–2500 cps  
Min. pattern length ..... 0.20 in. (5 mm)  
at 1000 ft/min  
(304 m/min)  
Min. skip distance ..... 0.50 in. (13 mm)  
at 1000 ft/min  
(304 m/min)

**400EZ non-contact, nozzle seat**

704xx542	400EZ valve, 0.30 mm
704xx543	400EZ valve, 0.35 mm
704xx544	400EZ valve, 0.40 mm
704xx545	400EZ valve, 0.50 mm
704xx546	400EZ valve, 0.60 mm
704xx547	400EZ valve, 0.70 mm
704xx548	400EZ valve, 0.80 mm

**400E non-contact, internal seat**

704xx550	400E valve assembly less nozzle
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**400E nozzle options (item 17 on parts list)**

704xx571	Nozzle, 0.30 mm
704xx572	Nozzle, 0.40 mm
704xx573	Nozzle, 0.50 mm
704xx574	Nozzle, 0.60 mm
704xx575	Nozzle, 0.70 mm
704xx576	Nozzle, 0.80 mm

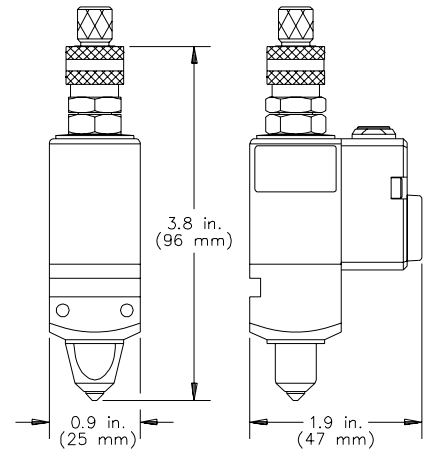
**400EC contact, internal seat**

704xx549	400EC valve assembly less nozzle
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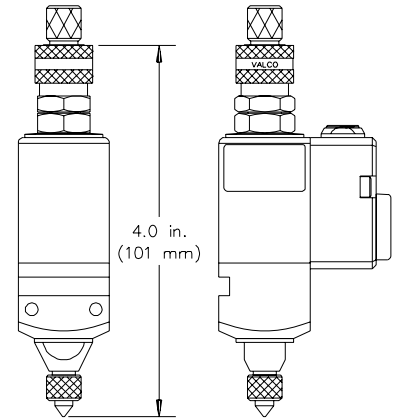
**400EC nozzle options (item 18 on parts list)**

<i>Ceramic:</i>	
704xx509	Nozzle, 0.40 mm
704xx402	Nozzle, 0.50 mm
704xx419	Nozzle, 0.60 mm
704xx401	Nozzle, 0.70 mm
<i>Stainless steel:</i>	
704xx449	Nozzle, 0.25 mm
704xx499	Nozzle, 0.30 mm
704xx010	Nozzle, 0.40 mm
704xx009	Nozzle, 0.50 mm
704xx008	Nozzle, 0.60 mm
704xx007	Nozzle, 0.70 mm
704xx332	Nozzle, 0.80 mm
704xx331	Nozzle, 1.00 mm

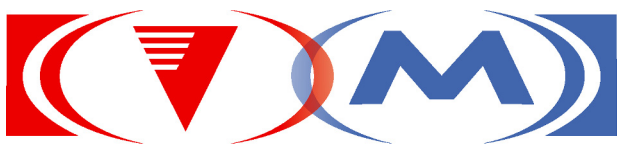
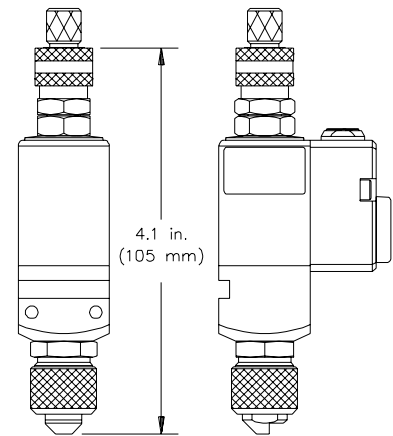
**400EZ Valve**



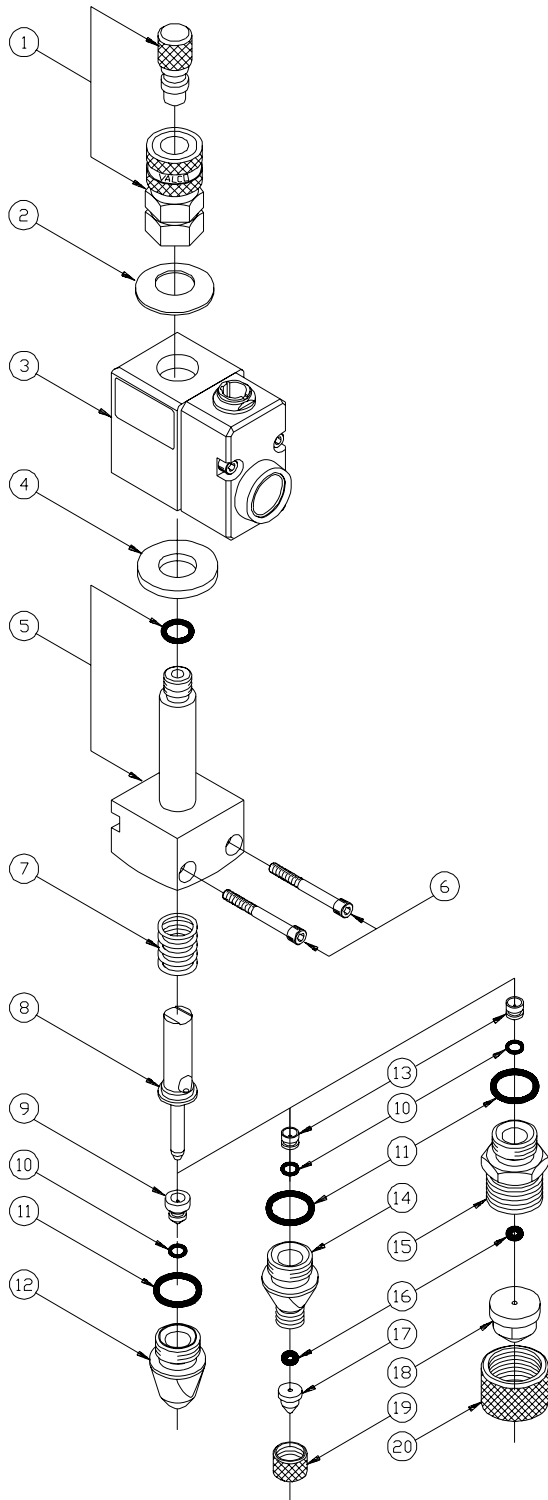
**400E Valve**



**400EC Valve**



**VALCO MELTON™**  
**400 Series Glue Valves**



## Replacement Parts

	400 valve sub-assembly (includes items 1–6)	704xx551
1	Quick-disconnect assembly	752xx028
1a	Male stopper	750xx013
2	Spring washer	793xx153
3	Solenoid assembly (includes item 4)	704xx562
4	Flux washer	704xx348
5	Valve body assembly (includes item 5a)	704xx563
5a	O-ring	745xx113
6	SHCS, M3 x 25 mm	798xx049
7	Spring	793xx727
8	Plunger	704xx554

## 400EZ Seat Options and Nozzle Body

9a	Seat assembly, 0.30 mm	704xx555
9b	Seat assembly, 0.35 mm	704xx556
9c	Seat assembly, 0.40 mm	704xx557
9d	Seat assembly, 0.50 mm	704xx558
9e	Seat assembly, 0.60 mm	704xx559
9f	Seat assembly, 0.70 mm	704xx560
9g	Seat assembly, 0.80 mm	704xx561
	(Seat assemblies include item 10.)	
10	O-ring	745xx527
11	O-ring	745xx340
12	Nozzle body assembly (includes item 11)	704xx553

## 400E and 400EC Seats, Adapters, and Retainers

	Nozzle adapter assembly 400E (includes items 13, 10, 11, 14, 16, and 19)	704xx566
	Nozzle adapter assembly 400EC (includes items 13, 10, 11, 15, 16, and 20)	704xx567
13	Seat insert assembly (includes item 10)	704xx565
14	Nozzle adapter, 400E	704xx568
15	Nozzle adapter, 400EC	704xx569
16	O-ring	745xx132
17	Nozzle (see options on front)	
18	Nozzle (see options on front)	
19	Retaining nut, 400E, M8 x 0.75	793xx728
20	Retaining nut, 400EC, M16 x 1	793xx710

## Tools and Repair Kits

	Maintenance kit, 400EZ	704xx581
	Maintenance kit, 400E/400EC	704xx582
	Maintenance kit, 400EZ, 24V	707xx597
	Seat extraction tool, 400E/400EC	781xx305
	Seat insertion tool, 400E/400EC	781xx306

Maintenance kits include lithium grease, flushing adapter, nozzle cleaning drills, cleaning brush, valve spring, and O-rings. The 704xx582 kit also includes seat extraction tools.

## Accessories

	Connector cable, 5 m (16 ft)	030xx583
	Connector cable, 10 m (32 ft)	030xx584
	Connector cable, 15 m (48 ft)	030xx585
	Connector cable, 6 m (19 ft) with phono plugs for VC100/VC200 controls	030xx603