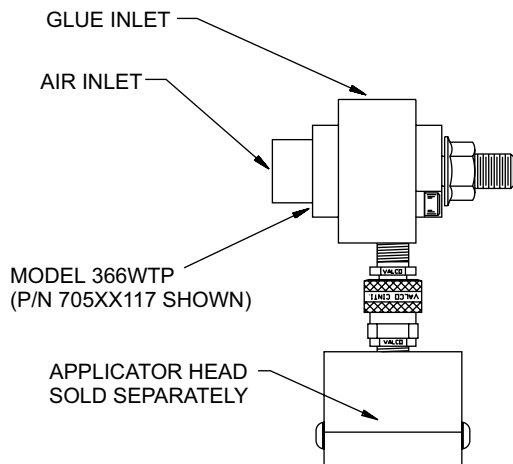
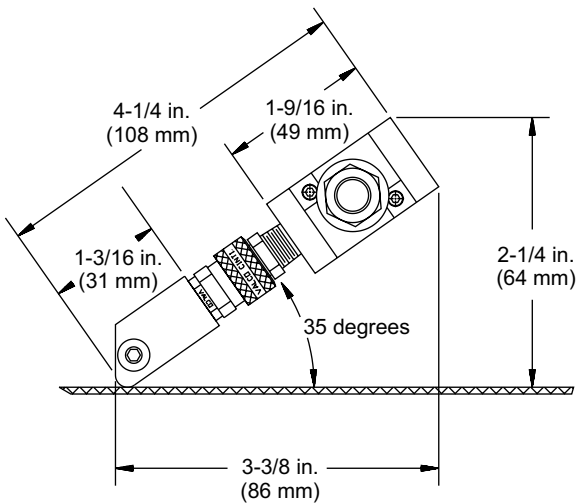
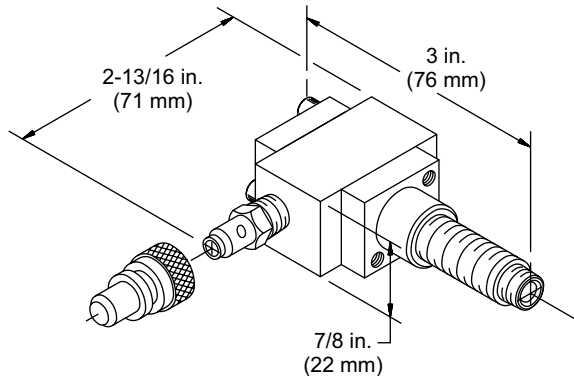


# 366 Glue Valve

multi-application, contact extrusion valve



The patented **366 valve** is a stainless-steel extrusion valve for multiple cold-glue applications. The innovative design provides a reliable and extremely high cycle life. The compact valve can be used alone or in parallel with other valves. Multiple applicator heads allow glue patterns up to 6 in. (150 mm). The contact extrusion valve accommodates a wide viscosity range up to 2000 cps. The 366 valve is mounted with quick-connect fittings for easy installation and maintenance. Nozzles are available in tungsten carbide, ceramic, rust-free tool steel, or plastic. The economically priced valve also has a metric version (366M).

## Applications

Packaging, case sealing, corrugated lap gluing, palletizing, laminating, tray making, bag sealing, labeling

## Technical Data

Height (with applicator head) .....	4.2 in. (107 mm)
Width .....	0.875 in. (22.5 mm)
Operating solenoid valve .....	3-way valve
Control air pressure .....	90 psi (6 bar)
Max. cycle rate .....	3500/min
Max. fluid pressure .....	60 psi (4 bar)
Max. viscosity .....	2000 cps

## COMMON GENERAL PURPOSE VALVE ASSEMBLIES

All Model 366 general purpose valves have a prefix code of 705xx. Determine the last three digits of the part number from the following list. Choices include: mounting style, standard or low-pressure pilot inlet, and fitting.

### "G" MOUNT STYLE (1/2-20 MOUNT/1/8 NPT AIR INLET)

Stud Length/ Pilot Inlet	1 1/2 in. (38 mm) STD	1 1/2 in. (38 mm) LP	2 3/4 in. (70 mm) STD	2 3/4 in. (70 mm) LP	4 in. (102 mm) STD	4 in. (70 mm) LP
Swivel Fitting	111	112	113	114	115	116
Rotary Fitting	211	212	213	214	215	216
Fixed Swivel	311	312	313	314	315	316
Rotary Fitting w/ Chained Stopper	711	712	713	714	715	716

### "P" MOUNT STYLE (3/8-16 MOUNT / 1/8 NPT AIR INLET)

	Standard Pilot Inlet	Low Pressure Pilot inlet
Swivel Fitting	117	118
Rotary Fitting	217	218
Fixed Swivel	317	318
Rotary Fitting w/ Chained Stopper	717	718

## SPECIFIC PURPOSE VALVE ASSEMBLIES

The following valves are assembled for specific machines and applications.

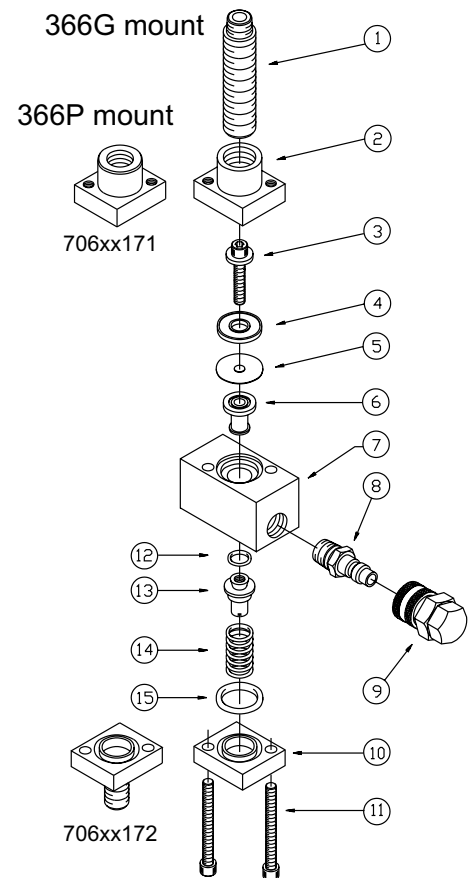
705xx025	366WTP, Glue valve with swivel fitting and 3/8-16 wing_nut. One of two style valves used on <a href="#">labelers</a> .
705xx026	366WTPF, Glue valve with fixed swivel and 3/8-16 wing nut. One of two style valves used on <a href="#">labelers</a> .
705xx024	Glue valve assembled for V-75 (Flexoseal) top-down glue station. Includes fittings and quick disconnects.
705xx043	Glue valve assembled for VO-700 (Flexoseal) bottom-up glue station. Includes fittings and quick disconnects.
705xx016	S366RT, Glue valve with integral rotary fitting and special air inlet. For <a href="#">General and Universal tapers</a> .
705xx023	Glue valve assembled for use with <a href="#">578xx651</a> and <a href="#">578xx652</a> spring-loaded brackets

### Combi-glue station valves and modules

706xx052	Valve module, top-down, fourth-panel side or bottom-up tab side. <b>Includes 706xx051 (366) valve assembly</b>
706xx053	Valve module, top-down, tab side or bottom-up fourth-panel side. <b>Includes 706xx051 (366) valve assembly</b>

(The valve assemblies listed above are typical assemblies. Custom assemblies can be ordered. Contact your Valco Cincinnati sales representative for more information.)

## REPLACEMENT PARTS



1	"G" mounting stud (366WGT valve only) Length 1-1/2 in. with 1/8-in. NPT .....	701xx498
	Length 2-3/4 in. with 1/8-in. NPT .....	701xx525
	Length 4 in. with 1/8-in. MPT ..	701xx526
2	Pilot inlet 366G mount valves .....	706xx170
	366P mount valves .....	706xx171
3	Stem screw diaphragm restrainer assembly .....	706xx177
4	Diaphragm .....	706xx100
5	Diaphragm protector .....	706xx101
6	Stem top .....	706xx175
7	Valve body .....	706xx166
8	Male swivel .....	750xx009
	Non-rotating swivel .....	750xx011
9	Female stopper .....	750xx005
10	Lower retainer 366G mount valves .....	706xx173
	366P mount valves .....	706xx172
11	Assembly screws (2) 366G mount valves .....	798xx043
	366P mount valves .....	798xx041
12	O-ring .....	745xx098
13	Stem bottom .....	706xx176
14	Valve spring .....	706xx102
15	Lower retainer O-ring .....	745xx066

## Maintaining Valves

### 366 Glue Valve Disassembly/Assembly

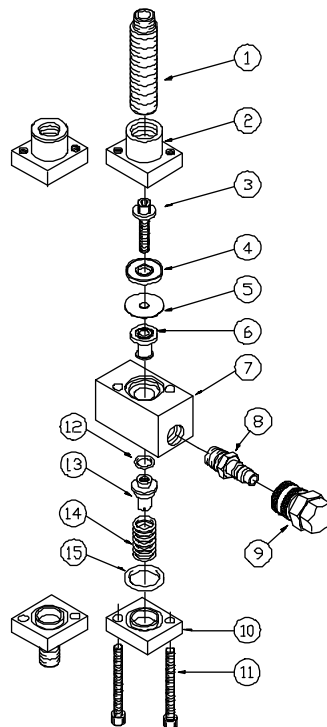
#### Disassembly

1. Have a valve seal kit ready in the event that defective or worn parts are found.
2. Place the valve on a work bench or other solid, flat surface.
3. Loosen the assembly screws (11), the lower retainer (10), and the pilot inlet (2).
4. Remove the stem bottom (13) from the stem screw (3).
5. Remove and disassemble all parts from the stem screw (3).
6. Rinse all parts in clean water.
7. Inspect parts and replace all of the parts if any of the parts are worn or defective.

#### Assembly

1. Place the diaphragm (4) on the stem screw (3) and hold in position.
2. Place the diaphragm protector (5) on the stem screw (3).
3. Screw the stem top (6) onto the stem screw (3) and tighten with your fingers.
4. Install these parts into the valve body (7).
5. Place the O-ring (12) over the stem bottom (13) and screw the stem bottom onto the stem screw (3) for a firm (not tight) fit.
6. Place the pilot inlet (2) onto the valve body.
7. Use assembly screws (11) to install the spring (14), lower retainer (10), and O-ring (15) onto valve body.
8. Replace the valve on the applicator assembly.

**Note!** Always check the mounting stud (1) to ensure that dried glue is not present and the opening is clear.



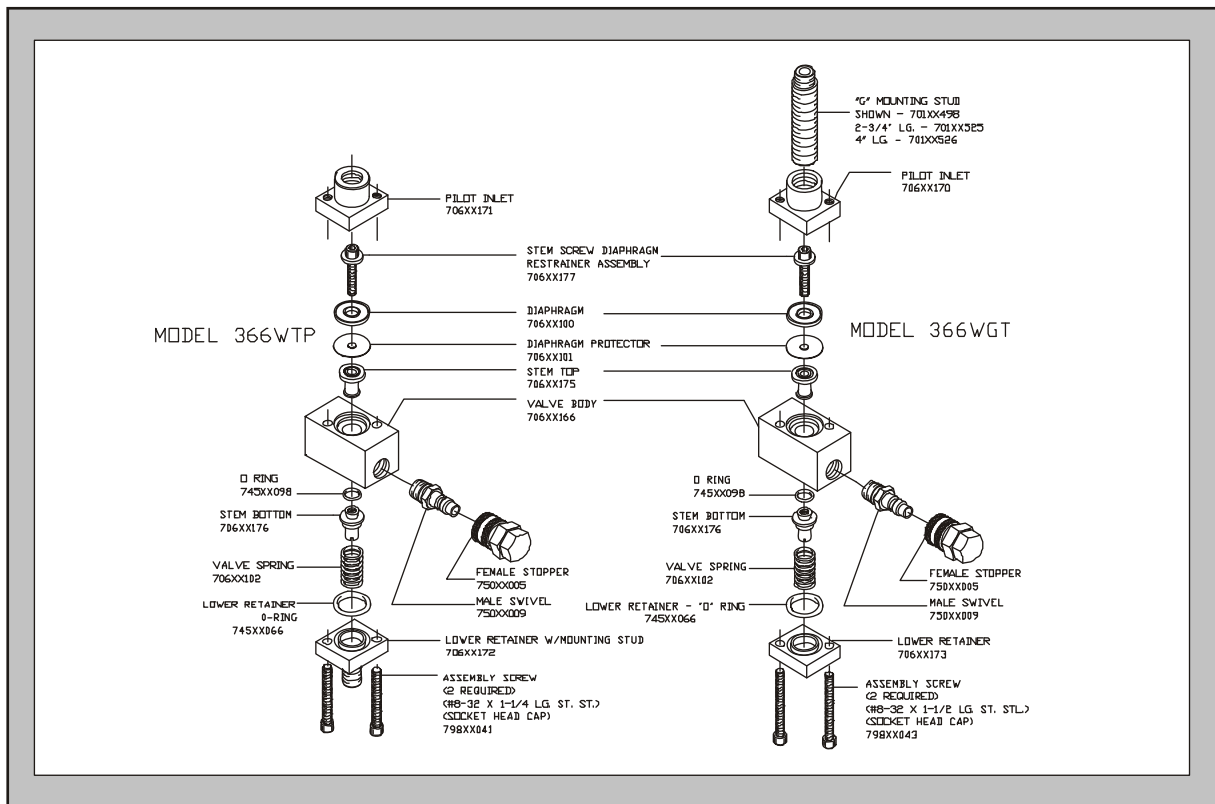
366 Glue Valve



## MODEL 366 GLUE VALVE

### Model 366 Valve Components

NOTE: Internal components are available in packages of ten at a discounted price.



#### Model 366 Internal Components and Packages

PN	DESCRIPTION	PKG 10
706xx177	Stem screw assembly with diaphragm retainer	706xx198
706xx100	Diaphragm	706xx144
706xx101	Diaphragm protector	706xx145
706xx204	Diaphragm protector, Teflon	NA
706xx102	Valve spring	706xx146
745xx098	O-ring seat	745xx187
745xx327	O-ring seat, Teflon	NA
745xx066	O-ring for lower retainer	745xx068
706xx175	Stem top	706xx197
706xx176	Stem bottom	706xx199



## MODEL 366 GLUE VALVE

Model 366 Valve Components	
PN	DESCRIPTION
Model 366 valve body options	
706xx166	Valve body, for swivel fitting, 1/8 NPT
706xx164	Valve body with integral rotary, 1/4 NPT
706xx194	Valve body with integral rotary, for <a href="#">tapers</a> .
706xx180	Valve body with left-side inlet, for <a href="#">New Way</a>
706xx168	Valve body with right-side inlet, for <a href="#">New Way</a>
706xx162	Valve body with mounting holes, for <a href="#">Schroeder</a> .
Model 366 lower reatianer options	
706xx172	Lower retainer with 3/8-16 mounting stud
706xx173	Lower retainer, no stud, for "G"-mount valves.
706xx193	Lower retainer, no stud, for <a href="#">tapers</a>
706xx192	Lower retainer with mounting holes for <a href="#">Schroeder</a>
Model 366 pilot inlet options	
706xx171	Pilot inlet, 1/8 NPT
706xx170	Pilot inlet, 1/2-20 female THD. For "G"-mount style.
706xx190	Pilot inlet, for <a href="#">tapers</a> (RT style)
706xx182	Pilot inlet for <a href="#">Schroeder</a> .
706xx139	Pilot inlet, low pressure, 1/8 NPT for "P"-mount-style valves. Assembly includes: 1-706xx184 Pilot i nlet, top 1-706xx187 Pilot i nlet, bottom 1-701xx406 Diaphragm 1-706xx186 Disc 4-798xx005 Assembly screw, 6-32 x 1/2
706xx140	Pilot inlet, low pressure, 1/2-20 female. For "G"-mount stud. Assembly includes: 1-706xx185 Pilot i nlet, top 1-706xx187 Pilot i nlet, bottom 1-701xx406 Diaphragm 1-706xx186 Disc 4-798xx005 Assembly screw, 6-32 x 1/2
Model 366 mounting stud options	
701xx498	"G"-mount stud with 1/8 NPT, 1 1/2-in. length
701xx525	"G"-mount stud with 1/8 NPT, 2 3/4-in. length
701xx526	"G"-mount stud with 1/2" NPT, 4-in. length
Model 366 assemnly screws	
798xx041	Assembly screw, 8-32 x 1 1/4, for WTP style
798xx043	Assembly screw, 8-32 x 1 1/2, for WGT style
798xx870	Assembly screw, 8-32 x 1 1/8, for RTP and LP-WTP style.
798xx869	Assembly screw, 8-32 x 1 3/8, for RT ( <a href="#">tapers</a> ) and LP-WGT style.



**MODEL 366  
GLUE VALVE**

## Model 366 Valve - Seal Kits and Repair Kits

Model 366 Valve Seal Kits / Repair Kits	
PN	DESCRIPTION
706xx178	366 VSK Viton, Valve seal kit, includes: 4-706xx102 Spring 4-706xx100 Diaphragm 4-706xx101 Diaphragm protector 4-745xx098 O-ring seat 4-745xx066 Lower retainer, O-ring -Viton
706xx205	366 VSK Teflon, Valve seal kit with Teflon protector and O-ring seat. Same as above except: 4-706xx204 Diaphragm protector, Teflon 4-745xx327 O-ring seat, Teflon
706xx215	366 VSK Ethylene propylene, Valve seal kit with Teflon protector and EP O-ring seat. Same as above except: 4-745xx326 O-ring seat, Ethylene propylene
706xx219	366 VSK Kalrez, Valve seal kit with Teflon protector and Kalrez O-ring seat. Same as above except: 4-746xx131 O-ring seat, Kalraz
706xx143	366SPKT, Spare Parts Kit, includes: 1-706xx178 Valve seal kit, 366 VSK 1-706xx177 Stem screw assembly 1-706xx176 Stem bottom 1-706xx175 Stem top 2-798xx043 Assembly screw, 8-32 x 1 1/2 2-798xx041 Assembly screw, 8-32 x 1 1/4 1-794xx852 Hex key, 9/64
706xx179	LP366VSK, Valve seal kit for valves with the low-pressure pilot inlet, includes: 1-706xx178 Valve seal kit, 366VSK 4-701xx406 Diaphragm, low-pressure pilot inlet
706xx142	LP366SPKT, Spare parts kit for valves with the low-pressure pilot inlet, includes: 1-706xx143 Spare parts kit, 366 SPKT 4-701xx406 Diaphragm, low-pressure pilot inlet
706xx150	366ERK, Emergency repair kit, includes: (see note below) 1-706xx100 Diaphragm 1-706xx101 Diaphragm protector 1-706xx102 Spring 1-745xx098 O-ring seat 1-745xx066 Lower retainer, O-ring -Viton

NOTE: The 706xx150 (366ERK) is a no-charge item only provided with complete systems.



### Model 366 Maintenance and System Kits

The following kit is available to enable customers to easily convert to the new-style fittings. It should be included with every Flexoseal rebuild program.

Model 366 Fittings Maintenance Kit	
PN	DESCRIPTION
750xx039	Fittings/maintenance kit, includes: 1-794xx044 Carrying case 1-667xx001 Flushing adapter 1-667xx031 Head angle gauge 1-795xx903 Grease 1-795xx020 Grease gun assembly 10-750xx009 Male swivel 10-750xx005 Female stopper 10-750xx001 Female swivel 5-750xx011 Male swivel, fixed 5-750xx015 Female swivel 5-750xx013 Male stopper

The following maintenance kits are no charge items which should be specified only when the valves are ordered with complete gluing systems. Maintenance kits include a valve repair kit (ERK) and the appropriate service manuals.

Model 366 System Maintenance Kits	
PN	DESCRIPTION
795xx520	366 maintenance kit, General system
795xx573	366 maintenance kit, Burt labeler
795xx569	366 maintenance kit, Standard Knapp labeler
795xx574	366 maintenance kit, New Way labeler
795xx570	366 maintenance kit, Stackpole labeler
795xx571	366 maintenance kit, General taper
795xx572	366 maintenance kit, Universal taper
795xx505	366 maintenance kit, Flexoseal