

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

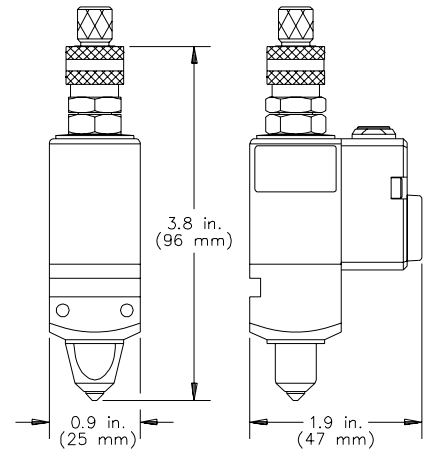
400EC contact, internal seat

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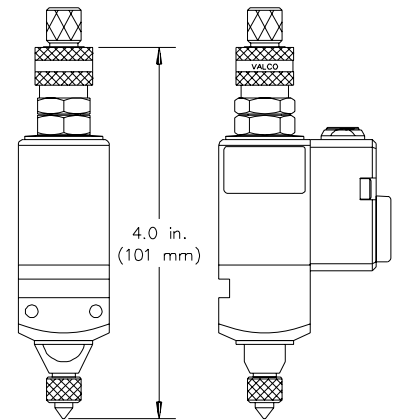
400EC nozzle options (item 18 on parts list)

<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

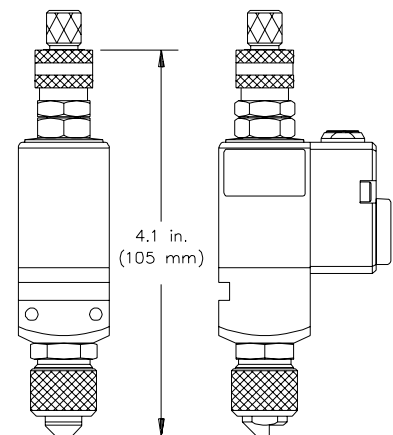
400EZ Valve



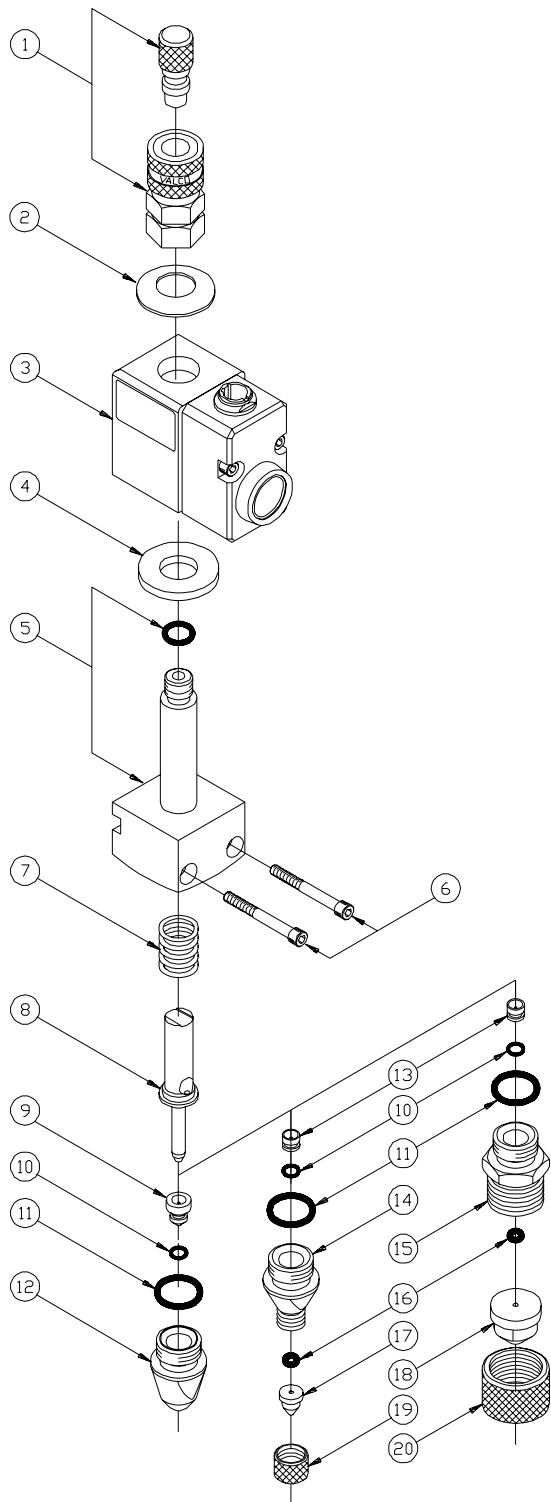
400E Valve



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

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Applications

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Technical Data

Coil data	12 VDC, 20 ohm, 7.2 W
Coil data	24 VDC, 80 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)

400ECT contact, internal seat, Viton

704xx814	400ECT valve assembly less nozzle, 12VDC
704xx815	400ECT valve assembly less nozzle, 24VDC

400ECT contact, internal seat, EP

707xx385	400ECT valve assembly less nozzle, 12VDC
707xx754	400ECT valve assembly less nozzle, 24VDC

400ECT nozzle options (item 18 on parts list)

Ceramic:

704xx509	Nozzle, 0.40 mm
704xx402	Nozzle, 0.50 mm
704xx419	Nozzle, 0.60 mm
704xx401	Nozzle, 0.70 mm

Stainless steel:

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

400Ezt non-contact, nozzle seat, 12VDC, Viton O-rings

707xx591	400Ezt valve, 0.25 mm
704xx797	400Ezt valve, 0.30 mm
704xx801	400Ezt valve, 0.35 mm
704xx802	400Ezt valve, 0.40 mm
704xx803	400Ezt valve, 0.50 mm
704xx804	400Ezt valve, 0.60 mm
704xx805	400Ezt valve, 0.70 mm
704xx806	400Ezt valve, 0.80 mm

400Ezt non-contact, nozzle seat, 24VDC, Viton O-rings

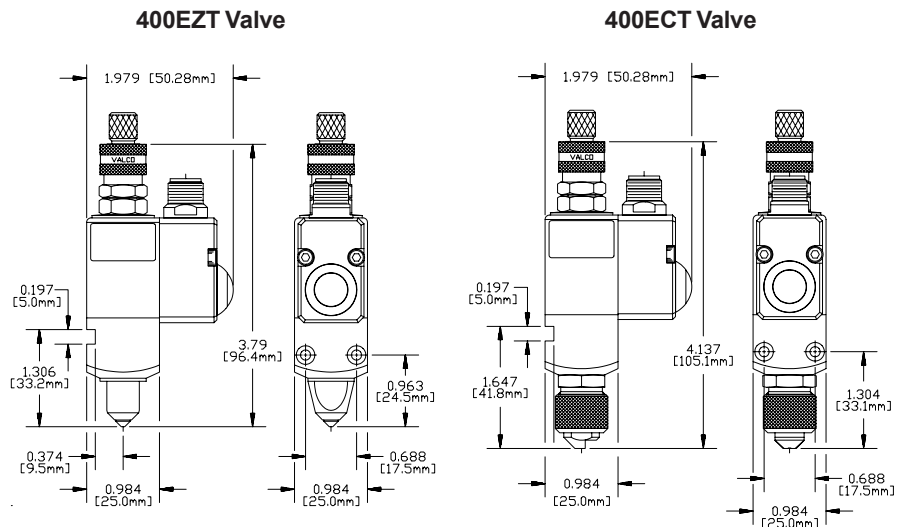
704xx807	400Ezt valve, 0.30 mm
704xx808	400Ezt valve, 0.35 mm
704xx809	400Ezt valve, 0.40 mm
704xx810	400Ezt valve, 0.50 mm
704xx811	400Ezt valve, 0.60 mm
704xx812	400Ezt valve, 0.70 mm
704xx813	400Ezt valve, 0.80 mm

400Ezt non-contact, nozzle seat, 12VDC, EP O-rings

707xx761	400Ezt valve, 0.25 mm
707xx762	400Ezt valve, 0.30 mm
707xx763	400Ezt valve, 0.35 mm
707xx764	400Ezt valve, 0.40 mm
707xx765	400Ezt valve, 0.50 mm
707xx766	400Ezt valve, 0.60 mm
707xx767	400Ezt valve, 0.70 mm
707xx768	400Ezt valve, 0.80 mm

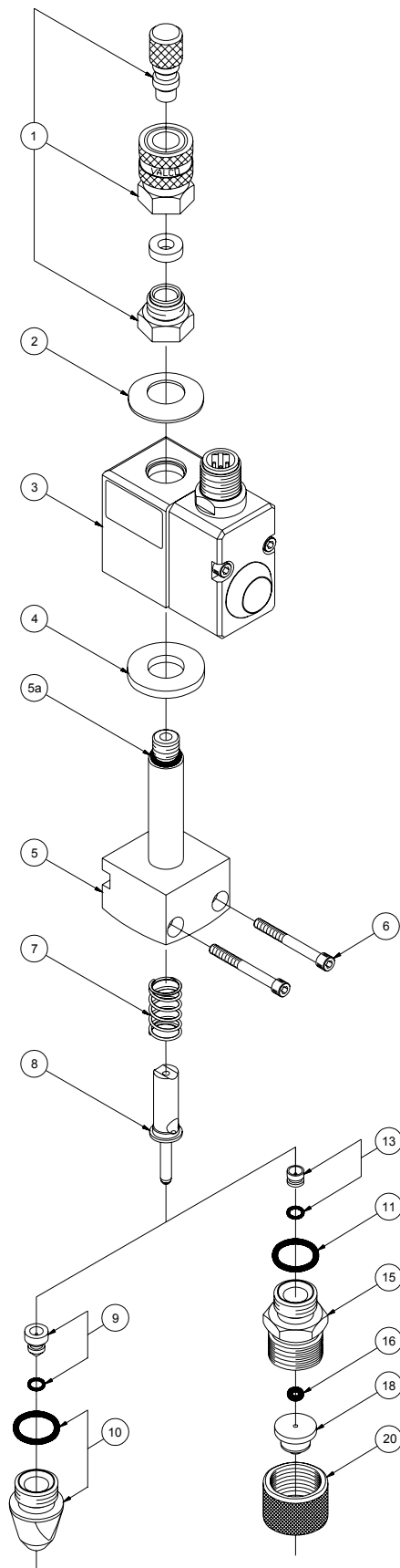
400Ezt non-contact, nozzle seat, 24VDC, EP O-rings

707xx772	400Ezt valve, 0.30 mm
707xx773	400Ezt valve, 0.35 mm
707xx774	400Ezt valve, 0.40 mm
707xx775	400Ezt valve, 0.50 mm
707xx776	400Ezt valve, 0.60 mm
707xx777	400Ezt valve, 0.70 mm
707xx778	400Ezt valve, 0.80 mm



VALCO MELTON™

400 Ezt/Ect Series Glue Valves



Replacement Parts

		Viton Assys.	EP Assys.
	400E valve sub-assembly (includes items 1-6), 12VDC	704xx798	707xx386
	400E valve sub-assembly (includes items 1-6), 24VDC	704xx800	707xx622
1	Quick-disconnect assembly	752xx028	752xx040
1a	Male stopper	750xx013	750xx013
2	Spring washer	793xx153	793xx153
3	Solenoid assembly (includes item 4) 24VDC	704xx799	704xx799
	Solenoid assembly (includes item 4) 12VDC	704xx796	704xx796
4	Flux washer	704xx348	704xx348
5	Valve body assembly (includes item 5a)	704xx563	704xx563
5a	O-ring	745xx113	745xx113
6	SHCS, M3 x 25 mm	798xx049	798xx049
7	Spring, 12VDC	793xx727	793xx727
	Spring, 24VDC	793xx271	793xx271
8	Plunger	704xx554	704xx554

400EZT Seat Options and Nozzle Body

9a	Seat assembly, 0.25 mm	707xx110	707xx110
9b	Seat assembly, 0.30 mm	707xx073	707xx073
9c	Seat assembly, 0.35 mm	707xx074	707xx074
9d	Seat assembly, 0.40 mm	707xx075	707xx075
9e	Seat assembly, 0.50 mm	707xx076	707xx076
9f	Seat assembly, 0.60 mm	707xx077	707xx077
9g	Seat assembly, 0.70 mm	707xx078	707xx078
9h	Seat assembly, 0.80 mm (Seat assemblies includes O-ring 745xx527)	707xx079	707xx079
10	Nozzle body assembly (includes O-ring)	704xx553	707xx619
	400ECT Seats, Adapters, and Retainers Nozzle adapter assembly 400ECT (includes items 13, 11, 15, 16, and 20)	704xx567	707xx384
11	O-ring	745xx340	746xx089
13	Seat insert assembly (includes O-ring)	707xx085	707xx387
	O-ring for above	745xx527	746xx088
15	Nozzle adapter, 400ECT	704xx569	704xx569
16	O-ring	745xx132	746xx087
18	Nozzle (see options on front)		
20	Retaining nut, 400EC, M16 x 1	793xx710	793xx710

Note: Valve and maintenance kits are supplied with Viton seals.

Tools and Repair Kits

	Viton Assys.	EP Assys.
Maintenance kit, 400EZ	704xx581	707xx636
Maintenance kit, 400EC	704xx582	707xx635
Repair Kit, 400 12V (Includes Items 1, 2, 5a, 6, 7, 11, 16 and the O-rings for 9 and 13)	707xx441	707xx259
Repair Kit, 400 24V (Includes Items 1, 2, 5a, 6, 7, 11, 16 and the O-rings for 9 and 13)	707xx442	707xx260
Seal Kit		707xx510
Seat extraction tool, 400EC	781xx305	781xx305
Seat insertion tool, 400EC	781xx306	781xx306

Maintenance kits include lithium grease, flushing adapter, nozzle cleaning drills, cleaning brush, valve spring, screws, swivel fitting (plug) and O-rings. Kits 704xx582 and 707xx635 also include seat extraction tool.

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Valco Cincinnati Incorporated
411 Circle Freeway Drive
Cincinnati, Ohio 45246, USA
TEL: (1) 513-874-6550
FAX: (1) 513-874-3612

Melton S.L.U.
Pol. Industrial Agustinos
calle G, n. 34
31160 Orcoyen, Navarra, Spain
TEL: (34) 948-321-580
FAX: (34) 948-326-584

Valco Cincinnati, Ltd.
Unit 7-8
Hortonwood 32
Telford TF1 7YN England
TEL: (44) 1952-677911
FAX: (44) 1952-677945

Valco Cincinnati GmbH
Storkower Strasse 6
D-15749 Gallun, Germany
TEL: (49) 33764 8700
FAX: (49) 33764 87070