

### Overview

This kit adds an additional hydraulic valve to the TracStar® 900 and 630, allowing the operator to control external hydraulic pipe stands from the fusion machine. This new hydraulic pipe stand valve will operate up to two hydraulic pipe stands. Hydraulic pipe stand part number is T9055701.

### Tools Required

- 1/2" through 1-3/16" Wrenches
- Drill
- 1/2" Drill Bit
- Bench Vice
- 5/16" Hex Wrench

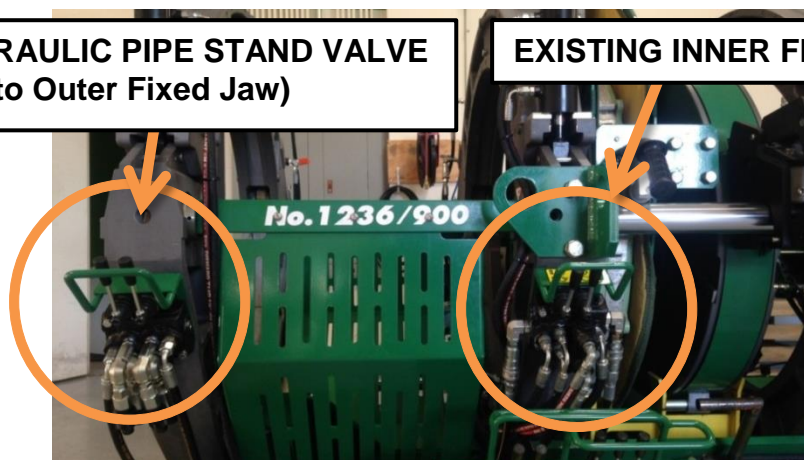
### Parts List

Item	Part Number	Qty	Description
1	MAB00038	3	5/16"-18NC X 2-1/4" LG HHCS
2	MAB00066	3	3/8"-16NC x 1-1/2" LG HHCS
3	MBE00006	3	5/16" REG SPLIT LOCK WASHER
4	MBE00007	6	3/8" REG SPLIT LOCK WASHER
5	MEF00306	1	2-SPOOL DIRECTIONAL VALVE, LESS HANDLES
6	MFC00082	4	8MSAE/6FSAE REDUCER
7	MFC00113	4	6MSAE/6FSAE ELBOW
8	MFC00134	6	6MSAE/6MSAE ADAPTER
9	MFC00171	2	8MSAE/8FSAE ELBOW
10	MFC00201	2	8MSAE/8MSAE ADAPTER
11	MFC00204	2	6FSAE/6FSAE COUPLING
12	MFH00045	2	1/2" FSAE QUICK DISC COUPLER
13	MFH00046	2	1/2" FSAE QUICK DISC NIPPLE
14	MFH00115	2	1/2" FSAE THREAD TOGETHER QUICK DISC COUPLER
15	MFH00116	2	1/2" FSAE THREAD TOGETHER QUICK DISC NIPPLE
16	MFQ00011	2	6MSL/6MSAE ADAPTER
17	SLBDDJE059	2	HOSE ASSEMBLY OAL 59"
18	T9021301	1	JAW VALVE GUARD WELDMENT
19	T9055902	1	EXTENSION HOSES
20	MEF00077	2	VALVE HAND LEVER
21	MAB00064	3	3/8"-16NC x 1" LG HHCS
22	MBA00007	3	3/8"-16NC FINISH HEX NUT STL PL
23	T9021401	1	SPACER PLATE

Kit includes this instruction sheet

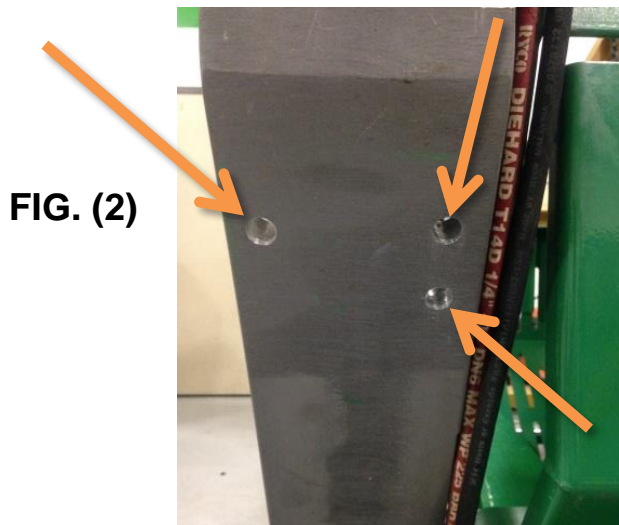
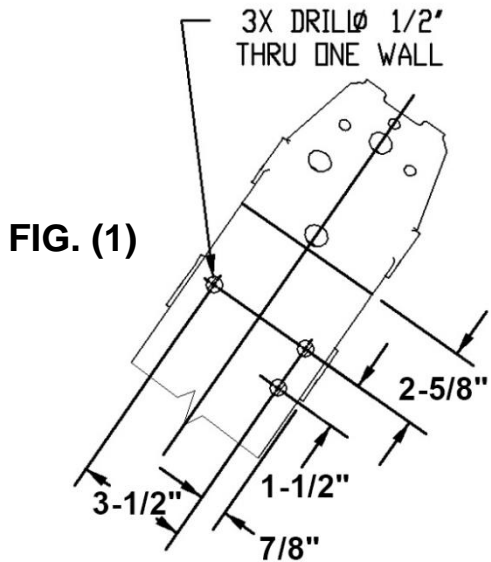
**NEW HYDRAULIC PIPE STAND VALVE  
(Mounted to Outer Fixed Jaw)**

**EXISTING INNER FIXED JAW VALVE**

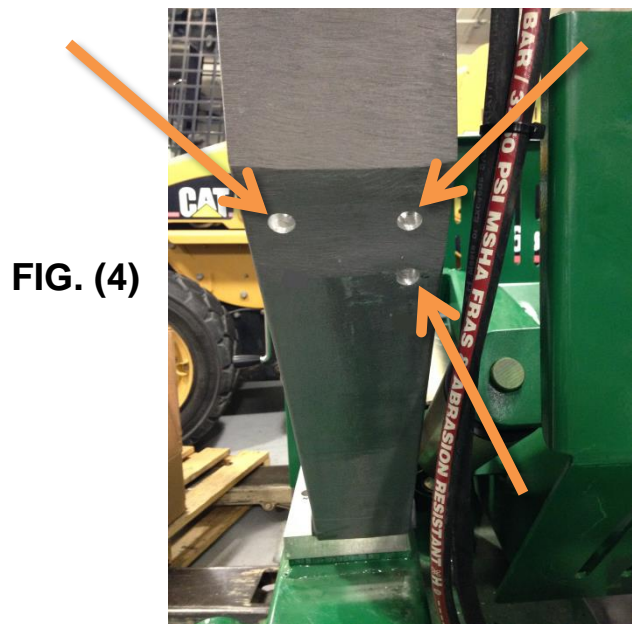
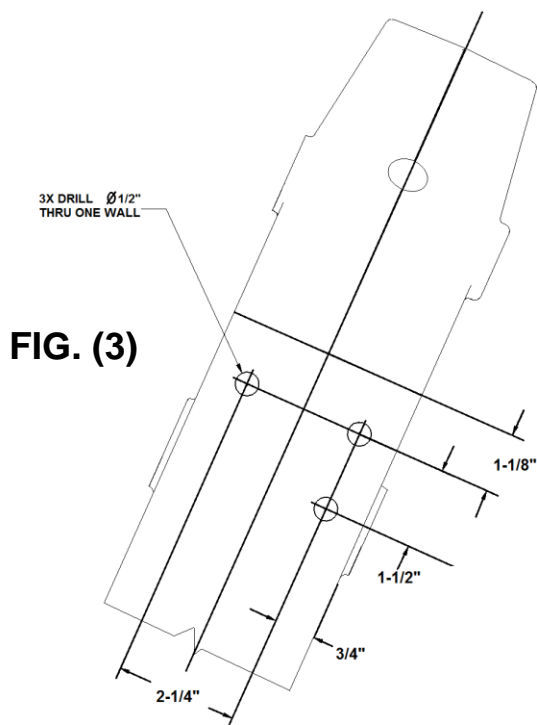


### Procedure:

1. Mark and drill three, 1/2" diameter holes on outer fixed jaw according to the figures below. Figures (1) and (2) show the hole pattern for the TracStar 900, and figures (3) and (4) show the pattern for the TracStar 630.



TracStar® 900



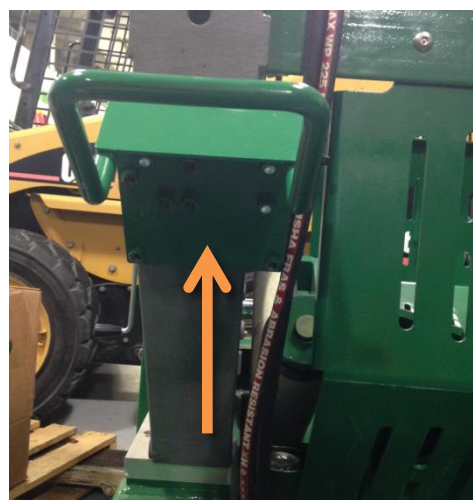
TracStar® 630

**For TracStar® 900**

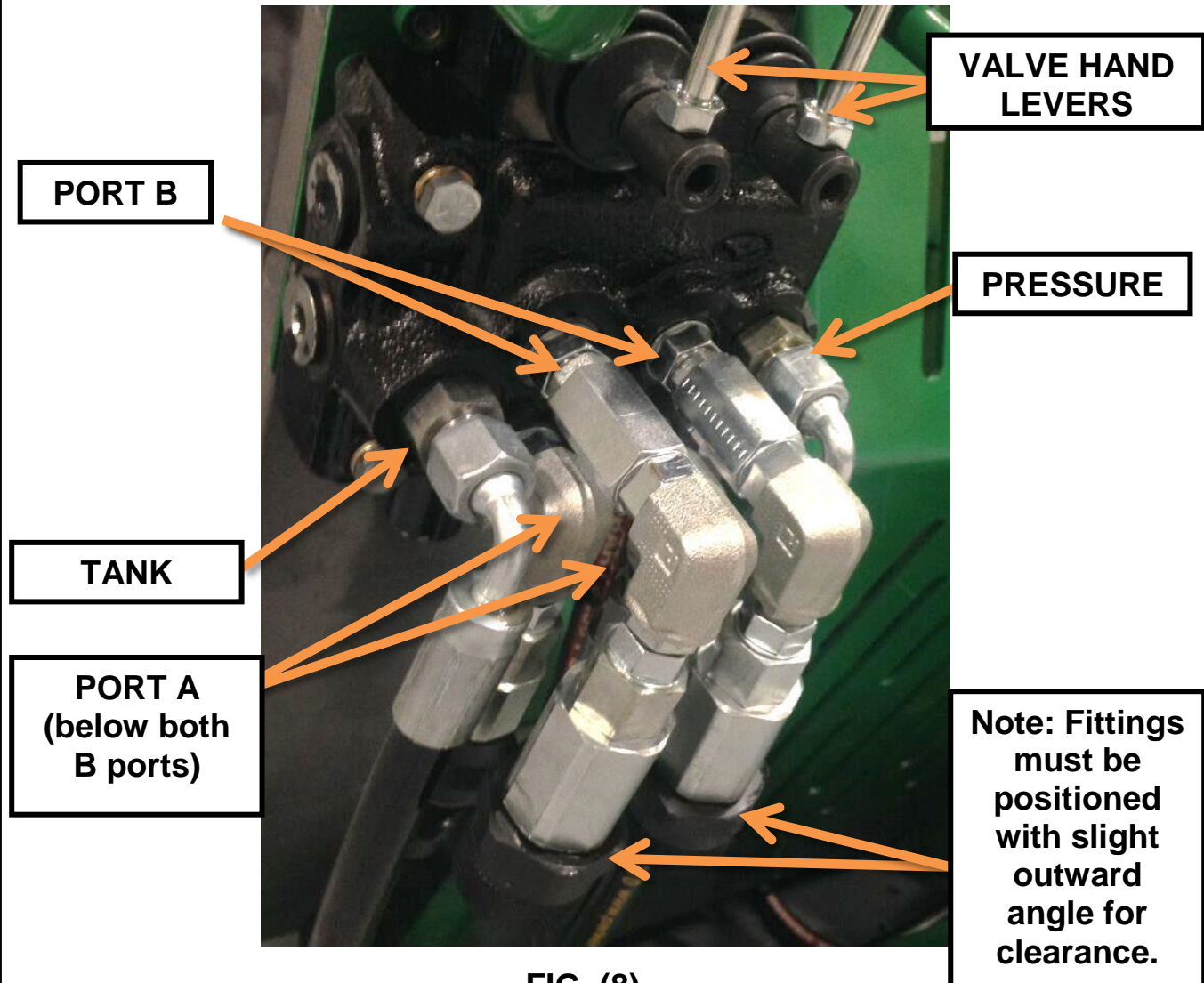
2. Mount Jaw Valve Guard Weldment (item 18) using supplied hardware, (item 2 and 4) per figure (5).

**FIG. (5)****For TracStar® 630**

3. Mount the spacer (item 23) using supplied hardware (items 2, 4 and 22) per figure (6). Mount Jaw Valve Guard Valve Weldment (item 18) using supplied hardware (items 21 and 4) per figure (7).

**FIG. (6)****FIG. (7)**

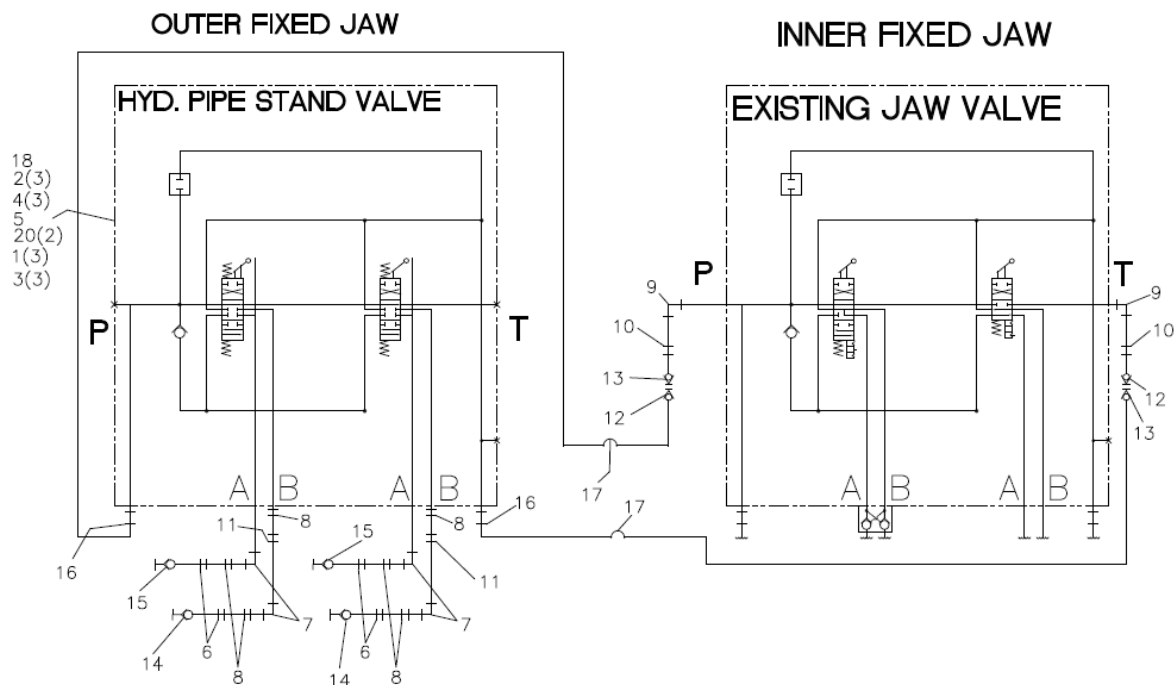
4. Install the hydraulic fittings into the P, T, A, and B ports of the hydraulic pipe stand valve (item 5) according to figure (8) and figure (10), paying close attention to the orientation of the "A" and "B" ports. With valve handles oriented upward, "B" ports will be on top and "A" ports will be on bottom. Item numbers on figure (10) correspond to parts list on page 1.
5. Install the valve hand levers (item 20) into the hydraulic pipe stand valve according to figure (8).

**HYDRAULIC PIPE STAND VALVE ON OUTER FIXED JAW****FIG. (8)**

6. Mount Hydraulic Pipe Stand Valve, with hand levers oriented upward, to Jaw Valve Guard Weldment using supplied hardware, (item 1 and 3).
7. Remove the side port plugs from the existing inner fixed jaw valve using the 5/16" hex wrench. Install the pressure and tank fittings to the existing inner fixed jaw valve according to figures (9) and (10).

8. Install the Hose Assemblies (item 17) from the pressure and tank fittings of the inner Fixed Jaw Valve to the pressure and tank fittings of the Hydraulic Pipe Stand Valve as indicated by figures (8), (9) and (10).

**INNER FIXED JAW VALVE****FIG. (9)**



**FIG. (10)**

9. Attach extension hoses (item 19) to A/B of hydraulic pipe stand valve ports and connect opposite ends together. Turn on machine and actuate each valve hand lever for 30 seconds in each direction to purge air in hoses. Check the hydraulic fluid reservoir level to determine if fluids need to be added after filling hoses.
10. Modification complete.

**NOTE:** Extension hose ends can now be connected to hydraulic pipe stands. Each hydraulic pipe stand valve lever operates a single hydraulic pipe stand.

## INSTRUCTION SHEET REVISION HISTORY LISTING

**PART NO:** T905590101  
**DESCRIPTION:** HYDRAULIC PIPE STAND VALVE/HOSE KIT  
**CHECK:** SRB      **APPRV'D:** JAL      **RELEASED:** 1/06/16

<u>CHK/APR</u>	<u>REV</u>	<u>DATE</u>	<u>BY</u>	<u>DESCRIPTION OF REVISION</u>
SRB/BLM	A	2/23/16	RLT	ADDED WELDMENT INSTALLATION INSTRUCTIONS FOR THE T630 FUSION MACHINE TO THIS DOCUMENT, INCLUDING ADDITIONAL PARTS.
SRB/JBC	B	9/26/16	RLT	REVISED ITEM #1 MAB00039 TO MAB00038 NEEDED SHORTER BOLT.