

# Installation and Operation Manual



**PPR / PPL Series  
Pneumatic Positioner**

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## 1. Safety Instructions

These safety instructions are intended to prevent hazardous situations and/or equipment damage. These instructions indicate the level of potential hazard.



**WARNING:** Identifies a potentially hazardous situation or practice that may lead to serious personal injury or death.



**CAUTION:** Indicates general precaution that could lead to minor personal injury or damage to equipment.

- This device was shipped from the factory in a proper condition to be safely installed and operated in a hazard-free manner. The notes and warnings in this document and on the actuator should be maintained and followed to ensure safe operation of the device.
- Take all necessary precautions to prevent damage to the positioner due to rough handling, impact, or improper storage.
- Do not use abrasive compounds to clean the actuator, or scrape metal surfaces with any objects.
- The system controlling the positioner must have proper safeguards to prevent damage to equipment, or injury to personnel should failure of system components occur.
- A qualified person in terms of this document is one who is familiar with the installation, commissioning and operation of the positioner and associated equipment, and who has appropriate qualifications, which may include:
  - Is trained in the operation and maintenance of electric equipment and system in accordance with established safety practices.
  - Is trained or authorized to energize, de-energize, ground, tag and lock electric circuits and equipment in accordance with established safety practices.
  - In cases where the actuator is installed in a potentially explosive (hazardous) location, is trained in the installation, commissioning, operation and maintenance of equipment in hazardous locations.
- The positioner must be installed, commissioned, operated and repaired by qualified personnel.
- All installation, commissioning, operation and maintenance must be performed under strict observation of all applicable codes, standards and safety regulations.
- Reference is specifically made here to observe all applicable safety regulations for positioners installed in potentially explosive (hazardous) locations.

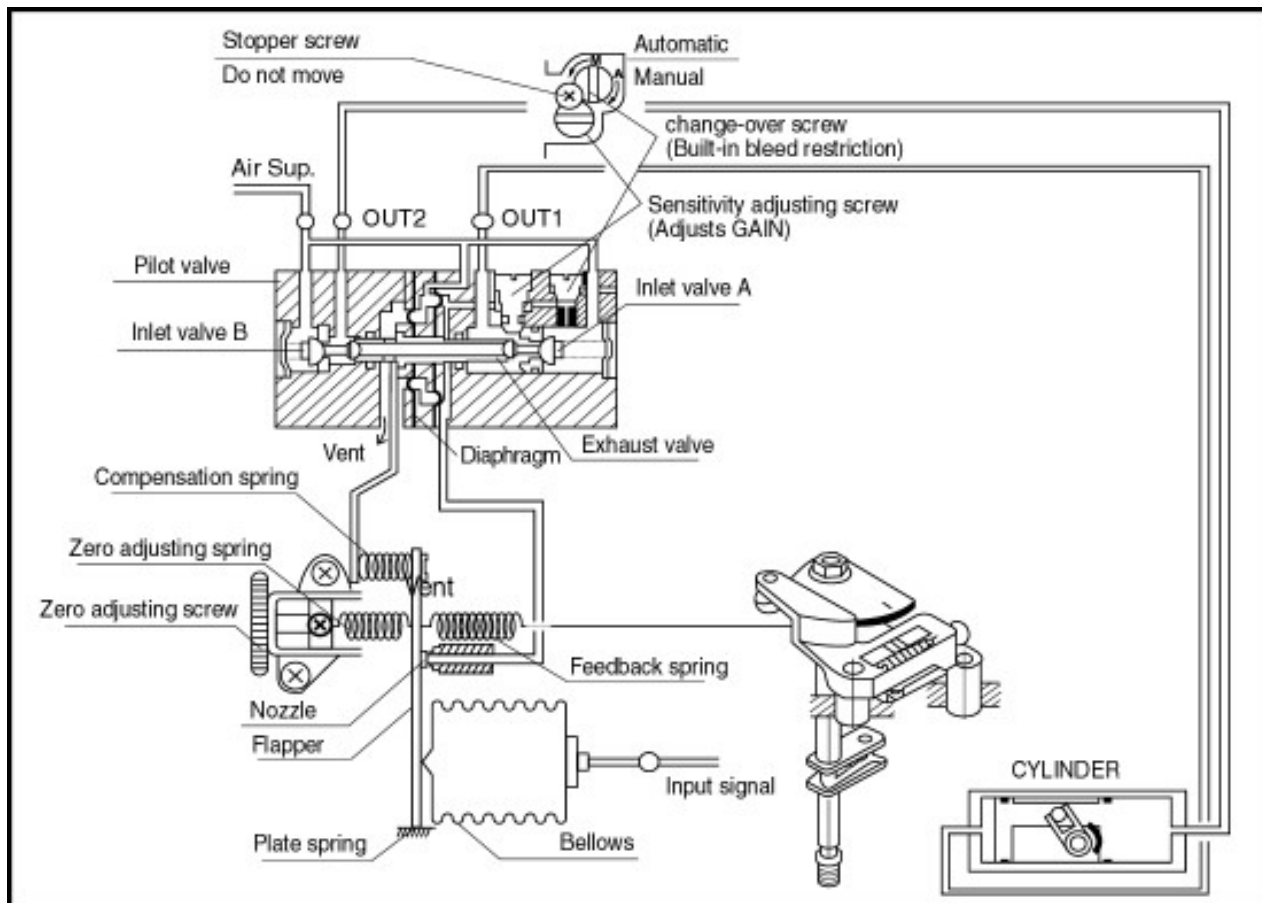
## 2. Description

The PPR series are pneumatic positioners controlled with a 3-15psi signal for operation of quarter-turn valves.

## 3. Principle of Operation

As the input signal pressure (3-15psi) from the controller increases, the plate spring of the bellows works as a pivot. As the flapper receives the rotary torque in the counterclockwise direction, the clearance between the nozzle and the flapper will increase, and the back pressure of the nozzle will decrease. As a result, the exhaust valve of the pilot valve moves to the right, and the output pressure of OUT1 increases (as OUT 2 decreases) to move the cylinder actuator.

The movement of the actuator in turn rotates the feedback shaft, and the feedback spring lengthens or shortens by the movement of the feedback cam connected to the feedback shaft. The actuator stays in the position where the spring force is balanced with the force generated by the input current in the bellows. The compensation spring is for direct feedback of the motion of the exhaust valve and is connected to the flapper to enhance the stability of the loop. The zero point is adjusted by changing the zero-adjustment spring tension.

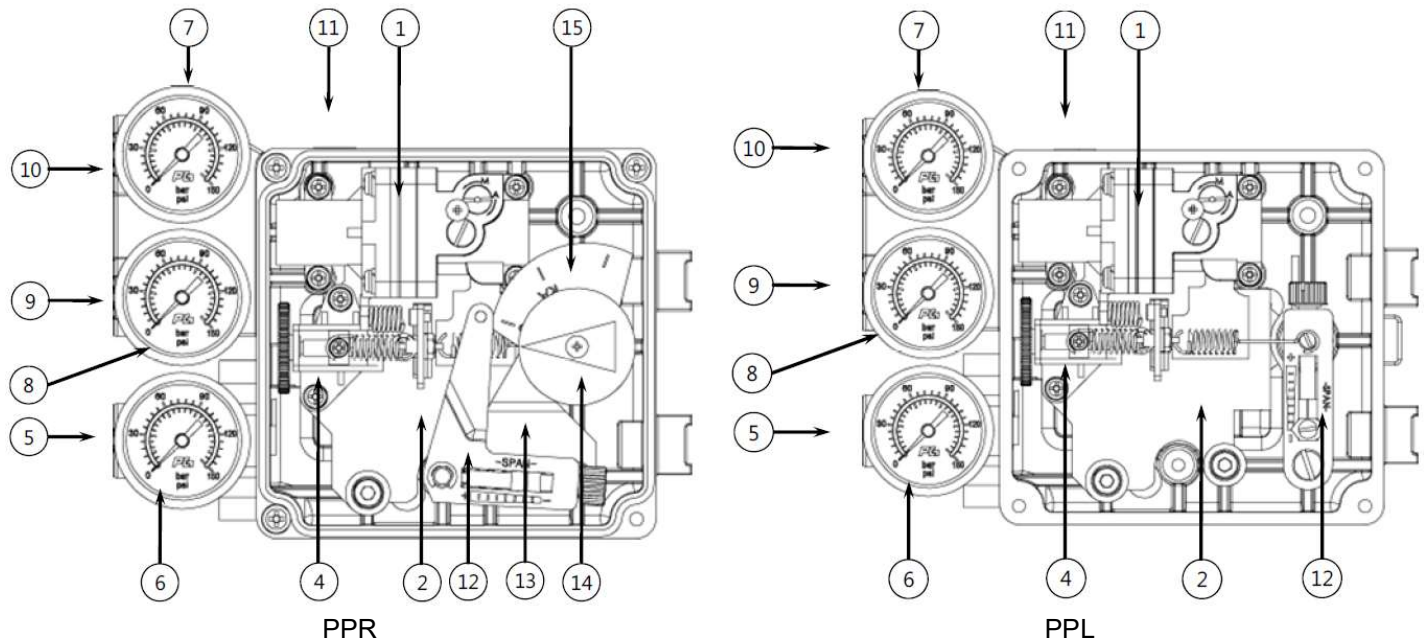


## 4. Specifications

	PPR		PPL	
Type	Rotary Type (Cam Feedback)		Linear Type (Lever Feedback)	
Action	Single Acting	Double Acting	Single Acting	Double Acting
Input Signal	3 – 15psi (Note. 1)			
Air Supply Pressure	20 - 100 PSI (1.4 – 7.0 bar), free of oil, water and moisture			
Standard Stroke	60° – 100° (Note 2)		10 – 80mm (Note 3)	
Air Piping Connection	1/4" NPT			
Ambient Temperature	-4°F to 158°F (-20°C to 70°C)			
Pressure Gauge	Stainless Steel			
Output Characteristics	Linear			
Linearity	Within ± 1.5 % F.S			
Sensitivity	Within ± 2.0 % F.S			
Hysteresis	Within ± 1.0 % F.S			
Repeatability	Within ± 0.5 % F.S			
Air Consumption	0.18 CFM (Sup. 20PSI)			
Flow Capacity	2.83 CFM (Sup. 20PSI)			
Material	Aluminum Die Casting Body			
Weight	5.5 lbs (2.5 kg)		4.6 lbs (2.1 kg)	

NOTE: 1) 1/2 split range can be adjusted for 3-9psi or 9-15psi input  
 2) Stroke can be adjusted to 0° - 60° or 0° - 100°  
 3) Feedback lever for up to 150mm is available

## 5. Internal View



1	Pilot Valve	6	SIGNAL Air Gauge	11	OUT2 Port
2	Bellows	7	OUT1 Air Gauge	12	Span Adjust
3	Shaft	8	SUPPLY Air Gauge	13	Cam
4	Zero Adjust	9	SUPPLY Port	14	Indicator
5	SIGNAL Port	10	OUT1 Port	15	RA/DA Plate

## 6. Installation

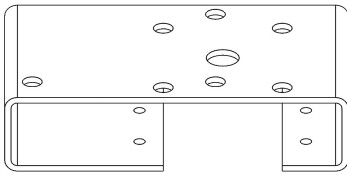


Remove all input signals and air pressure from valve and other surrounding equipment before installing.

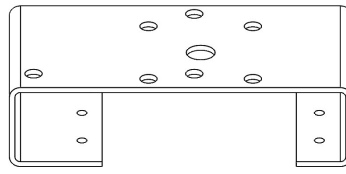
### 6.1. Mounting PPR Positioner

#### Mounting NAMUR Type

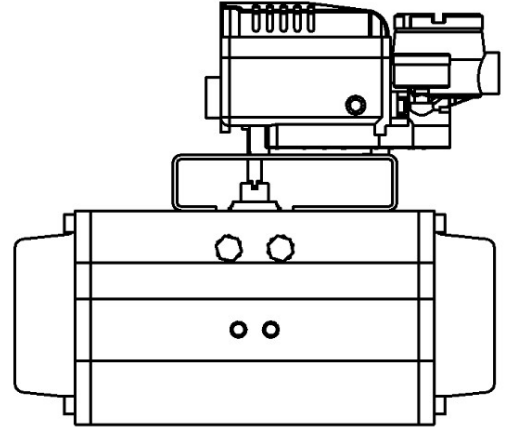
The PPR positioner has the NAMUR shaft as standard which can be directly mounted to the top pinion (VDI/VDE 3845) of the pneumatic rotary actuator.



NAMUR Bracket  
(80 x 30 x 20)

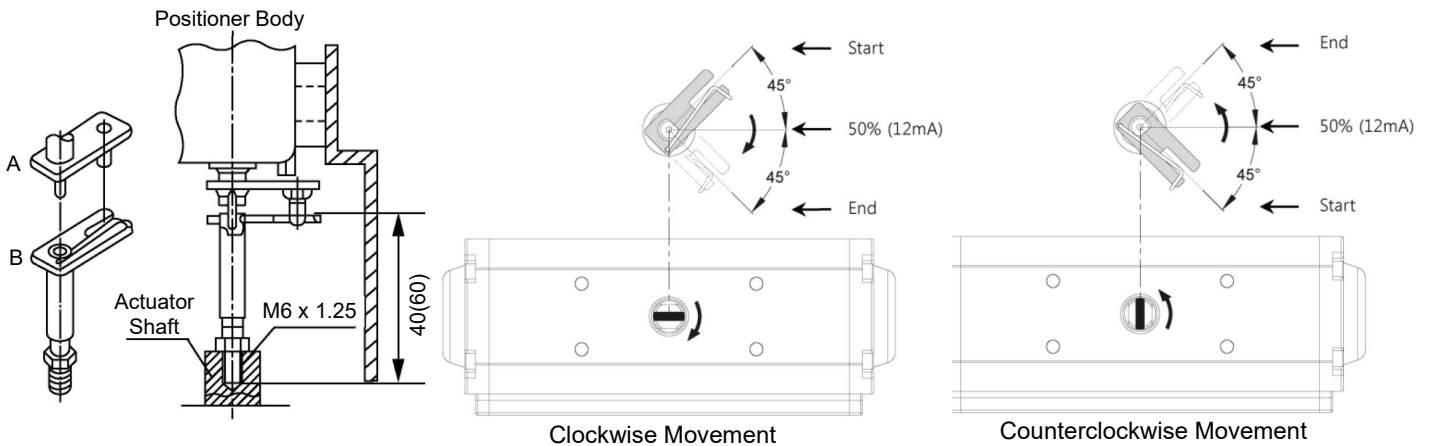


NAMUR Bracket  
(130 x 30 x 30)



#### Mounting Fork Lever Type

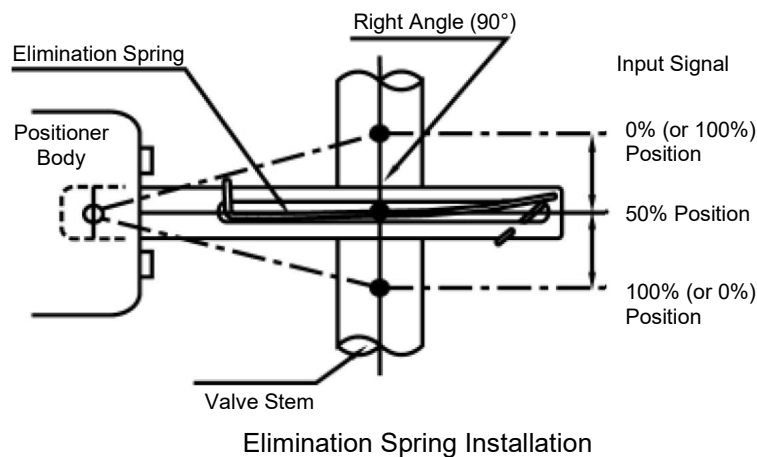
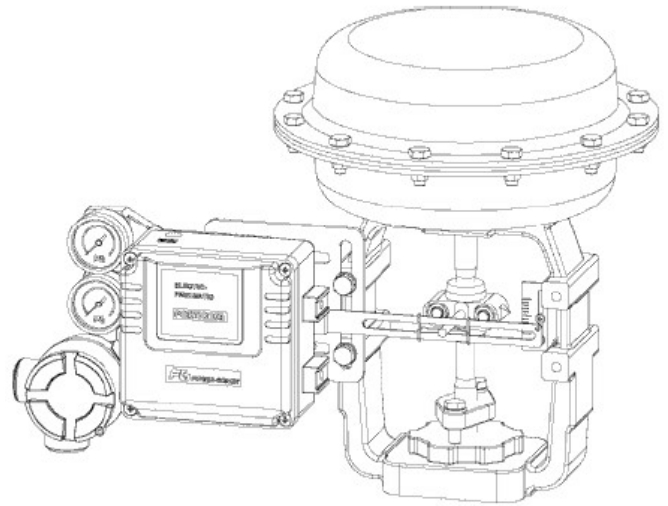
Mount the PPR positioner to the actuator with bracket as shown. Ensure the feedback lever shaft "A" is placed in the orifice for the fork lever "B" and that they are in alignment with a rotary actuator output shaft.



## 6.2. Mounting PPL Positioner

### Mounting and Attaching Feedback Lever

- 1) Mount the PPL positioner to the control valve as shown.
- 2) Fix the PPL positioner and the feedback lever to the control valve stem at the position where the angle between the valve stem is at 90 degrees when the input signal is set to 9 psi (50%). Ensure the elimination spring is installed.
- 3) Feedback lever A is for stroke between 10-40mm. Feedback lever B is for stroke between 10-80mm. For stroke up to 150mm, connect feedback lever A and feedback lever B together.
- 4) The operation angle of the PPL is between 10° and 30°.

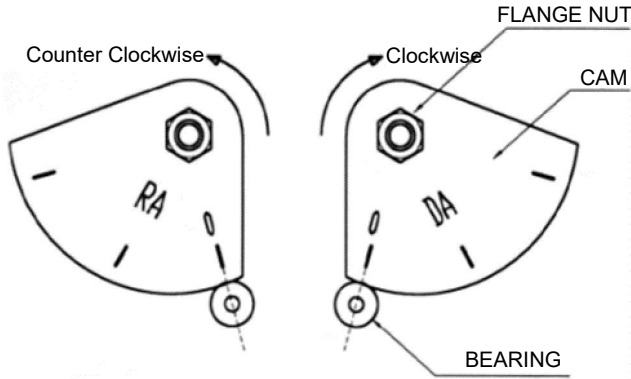


## 7. Cam and Indicator Adjustment

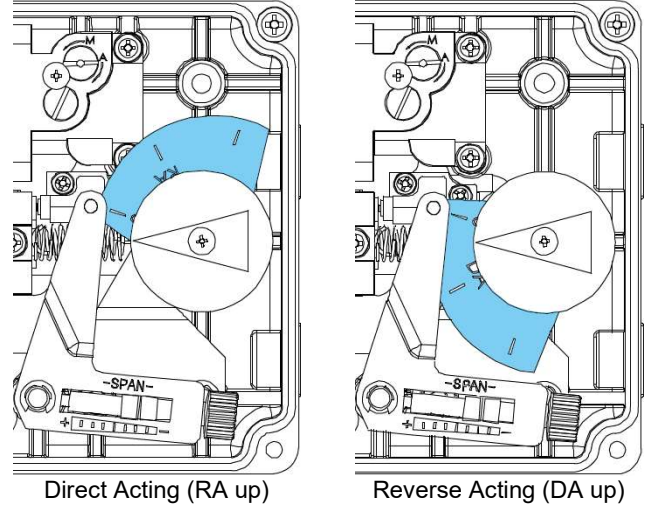


**WARNING:** When adjusting or replacing cams, ensure the air supply to the positioner is shut off to avoid the positioner suddenly reacting and causing possible damage or injury.

- 1) Loosen the flange nut on the cam. Match the part of the cam with "0" marked on it with the center of bearing as shown. The span adjusting arm unit should now be aligned.



NOTE: Direct Acting (RA up) is the standard factory setting.



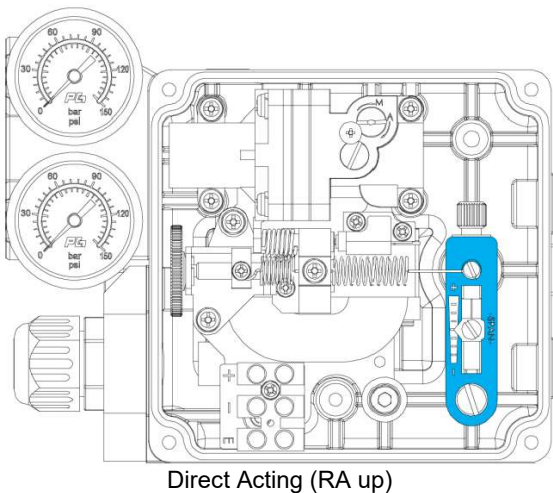
- 2) Tighten the flange nut of the cam after setting the cam.
- 3) After cam installation, proceed to adjust zero and span. Once this is complete, secure the indicator with the bolt (M6) to the feedback shaft according to the actuator type (RA or DA). The position for the indicator should be arranged in the scale (0-90 degrees) shown on the cover.

## 8. Position Span Adjuster

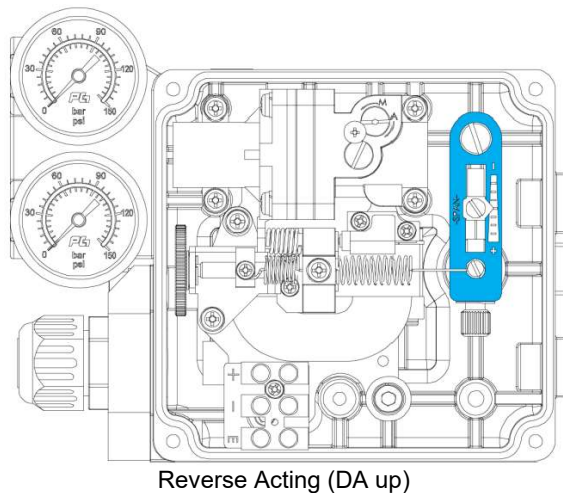


**WARNING:** When adjusting or replacing span adjuster, ensure the air supply to the positioner is shut off to avoid the positioner suddenly reacting and causing possible damage or injury.

Span adjuster is set to Direct acting as standard factory setting. For Reverse Acting, it is necessary to move the span adjuster as shown below.



Direct Acting (RA up)

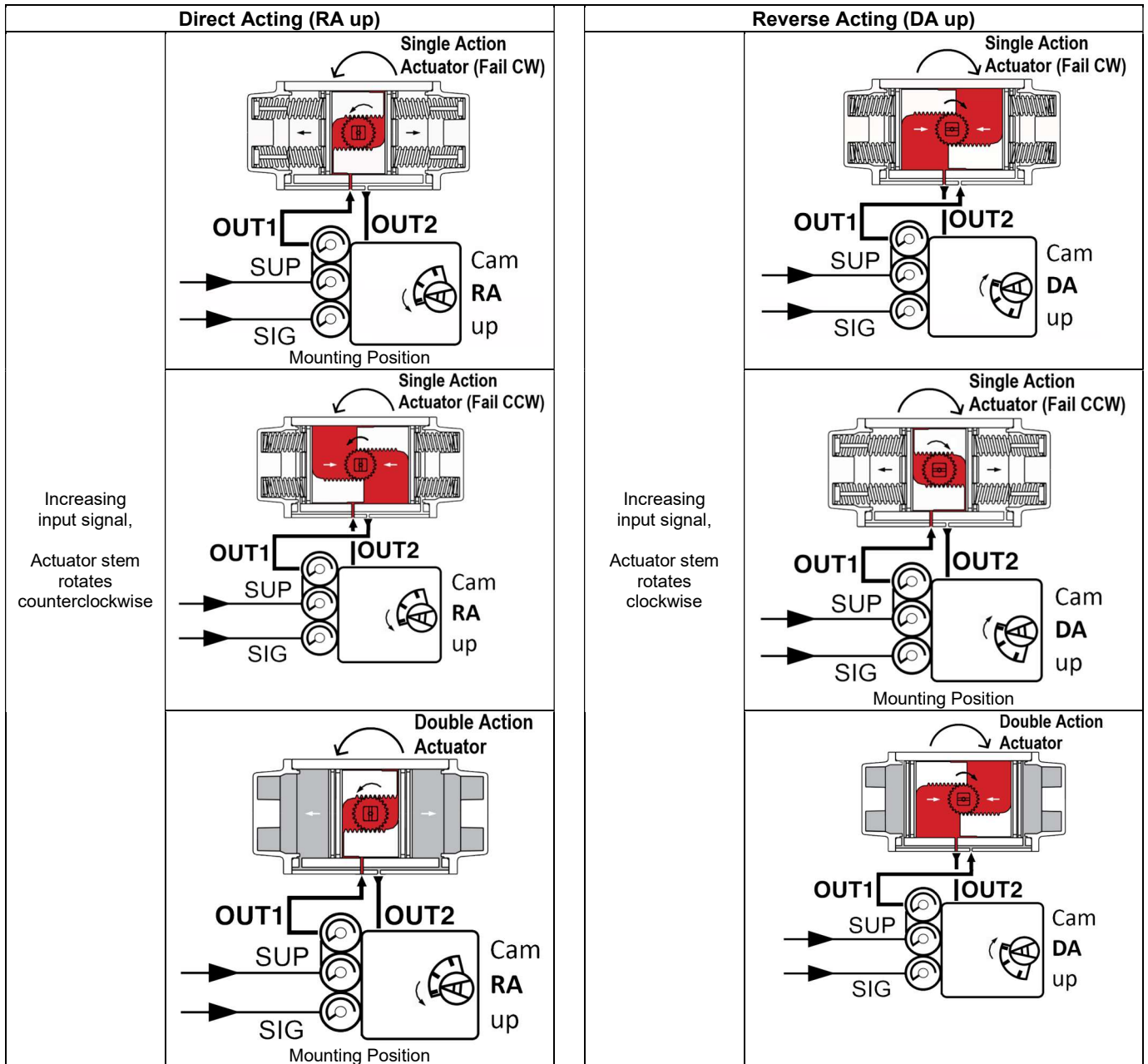


Reverse Acting (DA up)

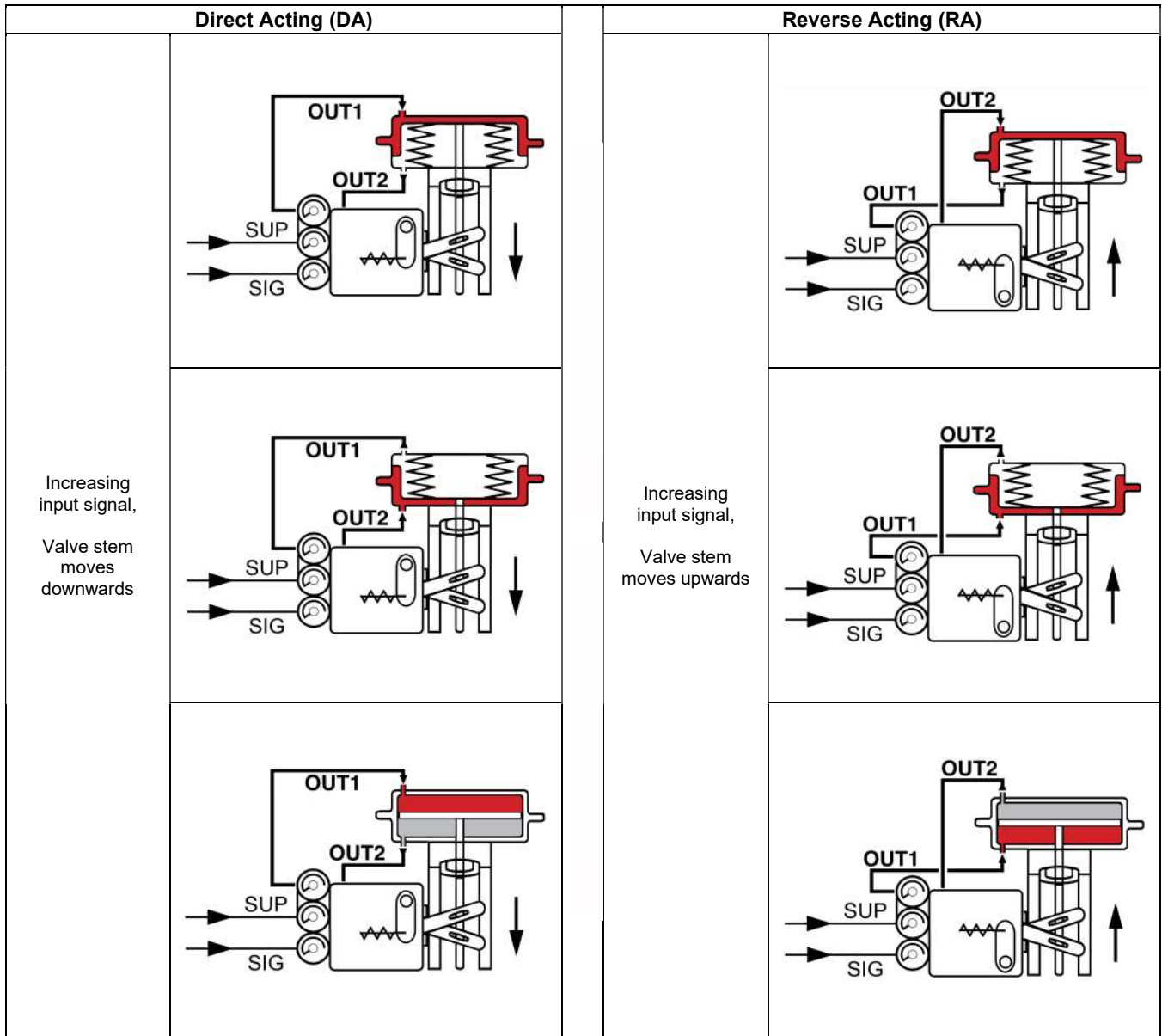


9. Air Connections

9.1. PPR Positioner



9.2. PPL Positioner

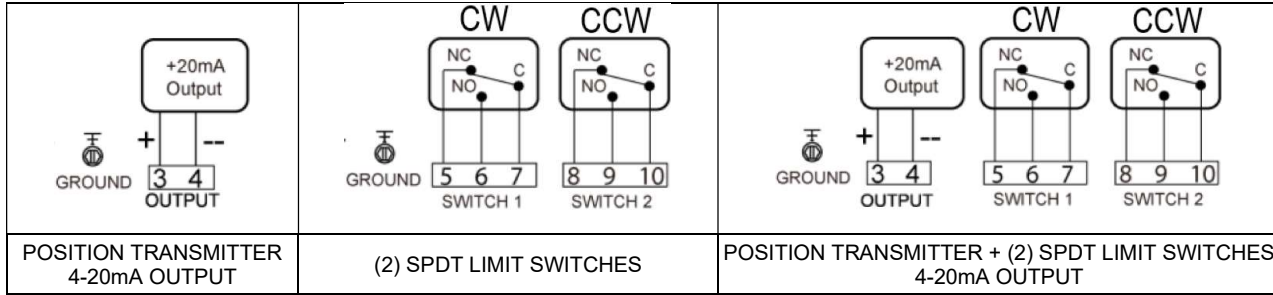


## 10. Electrical Connections



- Always check that the electrical load is within the range stated on the nameplate. Failure to remain within the electrical ratings may result in damage to, or premature failure of the electrical switches, sensors or transmitter electronics.
- Ensure correct polarity of + and – connections.

## 11. General Wiring



## 12. Limit Switches

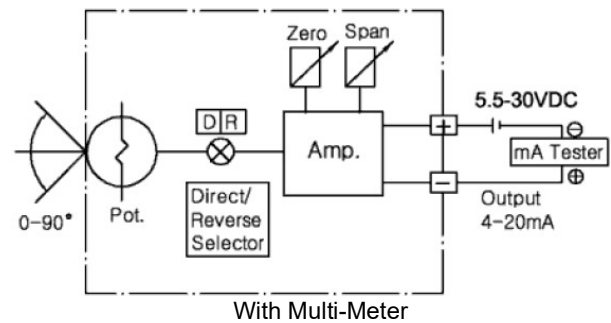
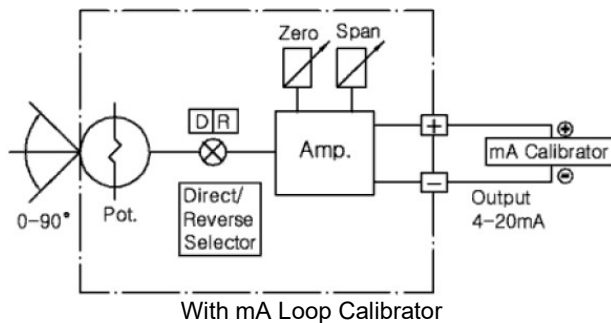
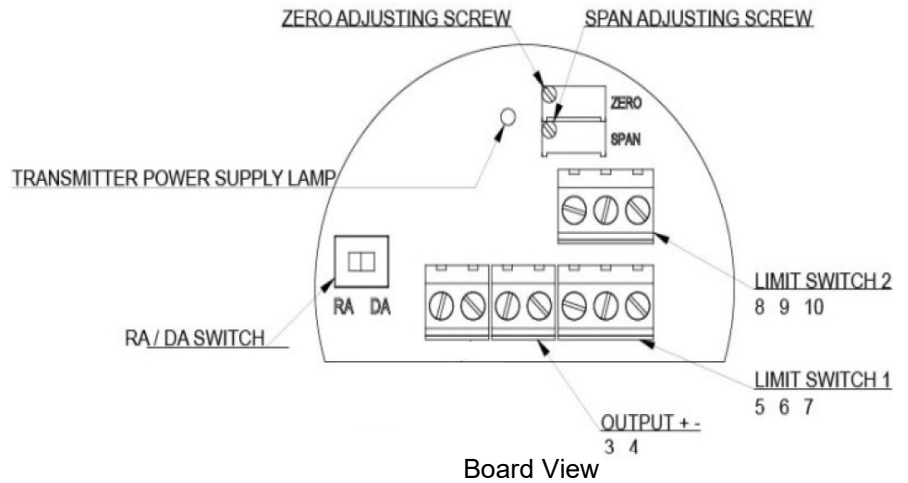
### Specifications

<b>Contacts:</b>	SPDT Form C
<b>AC Rating:</b>	16A 1/2HP 125/250 VAC
<b>DC Rating:</b>	0.6A 125VDC / 0.3A 250VDC
<b>Adjustment:</b>	Cams with set screw

## 13. Position Transmitter

### Specifications

<b>Power Supply Rating:</b>	5.5 – 30 VDC Loop-Powered
<b>Recommended Power Supply:</b>	24 VDC
<b>Output Signal:</b>	4-20 mA
<b>Operating Temperature:</b>	-4° to 158°F
<b>Load Impedance:</b>	0-600 Ohms
<b>Max. Output:</b>	30 mA DC
<b>Linearity:</b>	± 1.0 %
<b>Hysteresis:</b>	1.0 % of full scale
<b>Repeatability:</b>	± 0.5 % of full scale
<b>Adjustment:</b>	Zero and Span in Terminal Box



### 13.1. Transmitter Calibration

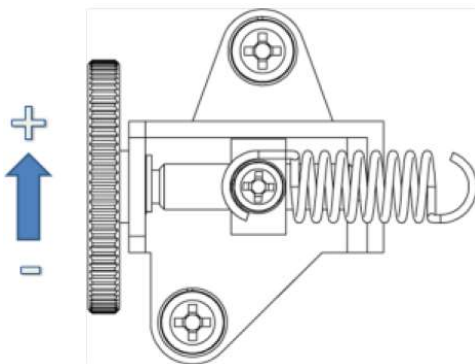
- 1) Select RA or DA on the board in the terminal box. RA (Reverse Acting) is standard factory setting.
- 2) Supply 4mA input signal and turn the zero adjusting screw on the board clockwise or counterclockwise until the output signal equals 4mA.
- 3) Supply 20mA input signal and turn the span adjusting screw on the board clockwise or counterclockwise until the output signal equals 20mA.
- 4) Repeat adjusting zero and span until the output approaches the input signal.



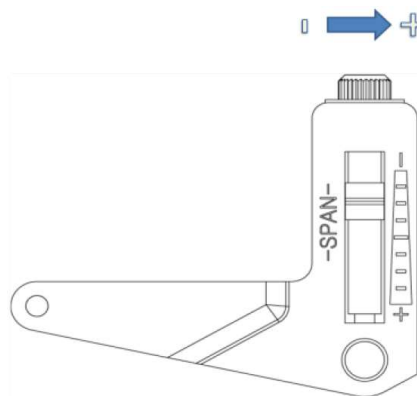
- Be sure the Zero and Span of the positioner is set correctly before adjusting the Zero and Span of the position transmitter.
- Be sure that 5.5V to 30V DC is supplied when using calibrating with multimeter.
- Be sure loop calibrator is sourcing.
- Be sure the transmitter power supply lamp is on.

### 14. Zero and Span Setting

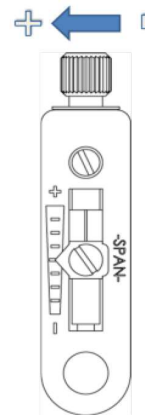
- 1) Check all air connections.
  - 2) Set input signal to 3 psi while positioner is at the 0% position, or stroke starting point. Turn the zero-adjustment knob clockwise or counter-clockwise to set the 0% position.
  - 3) Check the stroke of the actuator by setting the signal to 15 psi. If the stroke does not meet the 100% position, turn the span adjustment screw clockwise or counterclockwise to set the 100% position.
  - 4) Set input signal back to 3 psi and adjust the zero-adjustment screw until 0% position is reached.
  - 5) Repeat the process until the desired set points are reached.
- Adjust into the 0% and 100% position to avoid stopping by the actuator's mechanical stops.



Zero Adjuster



Span Adjuster (PPR)



Span Adjuster (PPL)

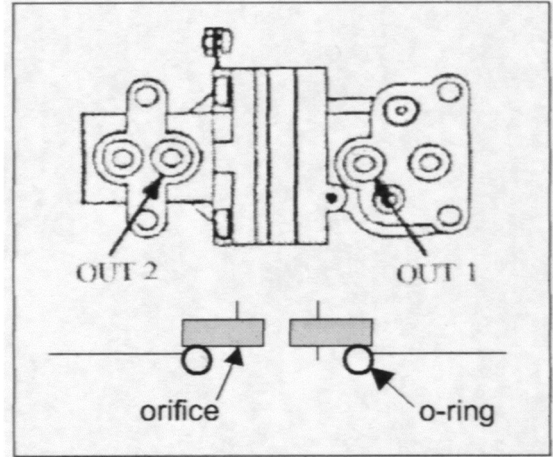
### 15. Optional Restricted Pilot Valve Orifice



**WARNING:** Before removing the pilot valve, disconnect the positioner from the signal and compressed air source.

For improved control using smaller actuators, a restricted pilot valve orifice kit is included with the positioner. To install, the pilot valve must be removed from the positioner.

- 1) Remove the four screws holding the pilot in the positioner body.
- 2) Hold the compensation spring in place while the pilot valve is removed.
- 3) Flip the valve to view the bottom side.
- 4) Remove the o-rings from OUT 1 and OUT 2 ports.
- 5) Place the orifice plates in the OUT 1 and OUT 2 ports and replace with new o-rings.
- 6) Reinstall the pilot valve ensuring the compensation spring is in place.

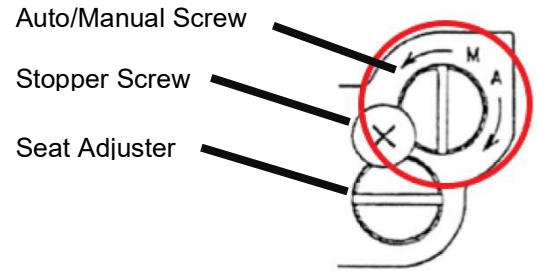


### 16. Auto / Manual Operation

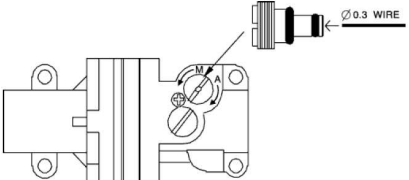
For manual operation using an external air regulator, set the Auto / Manual switch on the pilot valve to M. This will bypass the 3-15psi input signal.



DO NOT change the seat adjuster. This sets the sensitivity and is preset at the factory. If hunting occurs, insert small pilot valve orifices.

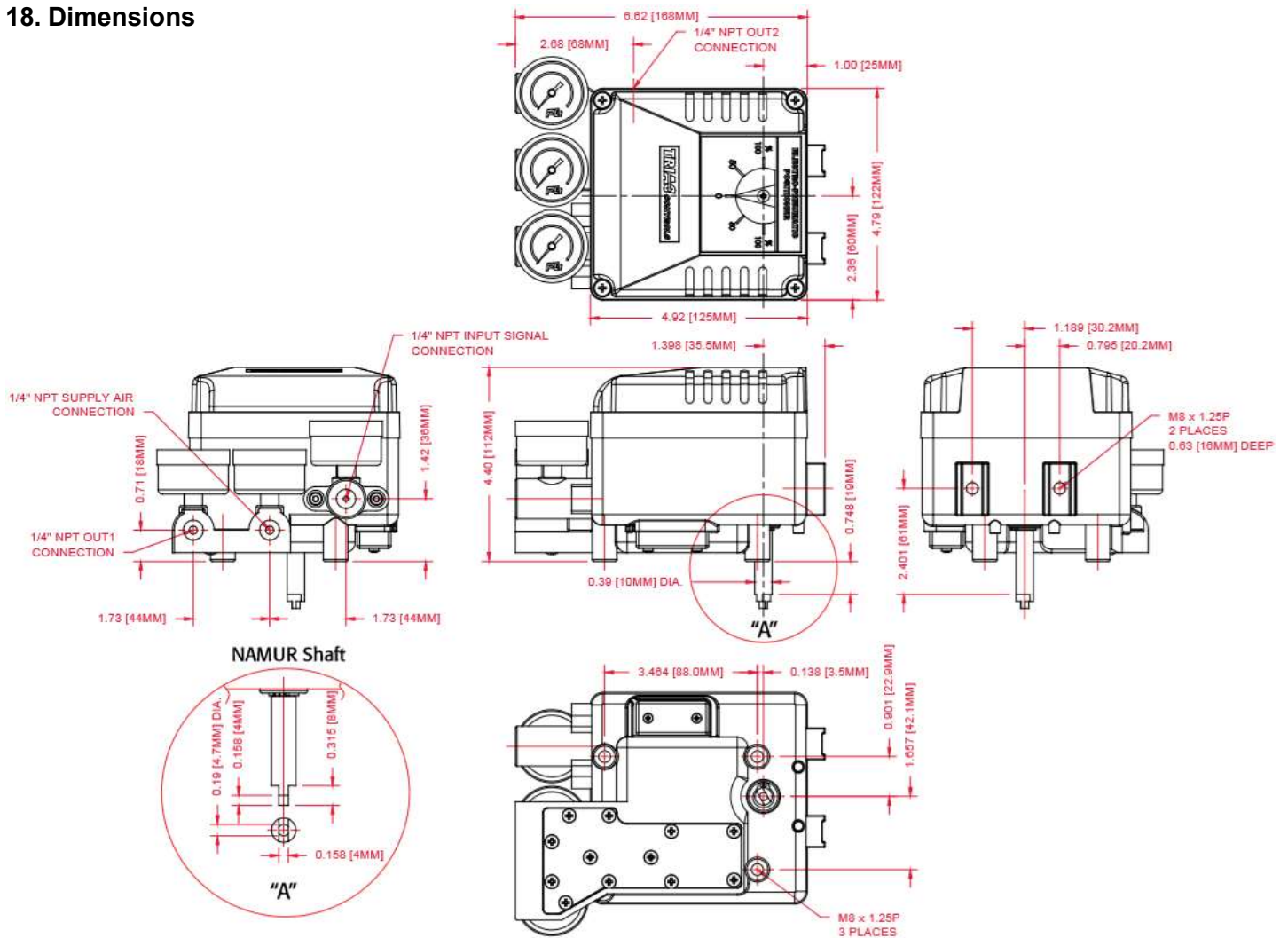


### 17. Troubleshooting

Trouble	Solution
Valve is hunting.	The actuator is small. Install the small orifice kit in the pilot valve.
	Ensure the position shaft is tightly inserted into the actuator output shaft.
Valve is always open regardless of input signal.	The pilot valve Auto/Manual screw orifice is clogged. Disconnect supply air and clean orifice with a wire (one is provided attached inside the positioner cover). 

Trouble	Solution
Valve is always open or closed with input signal.	Air connections or cam are not correct. Verify air connections and cam orientation.
Linearity is poor.	<ul style="list-style-type: none"> <li>• Check if positioner and mounting bracket are installed properly and tightly.</li> <li>• Check if zero and span are set properly.</li> </ul>
Hysteresis is poor.	Check if mounting bracket is installed tightly.
Valve moves too slowly.	Actuator is too large. Use an air volume booster

### 18. Dimensions



A-T Controls product, when properly selected, is designed to perform its intended function safely during its useful life. However, the purchaser or user of A-T Controls products should be aware that A-T Controls products might be used in numerous applications under a wide variety of industrial service conditions. Although A-T Controls can provide general guidelines, it cannot provide specific data and warnings for all possible applications. The purchaser / user must therefore assume the ultimate responsibility for the proper sizing and selection, installation, operation, and maintenance of A-T Controls products. The user should read and understand the installation operation maintenance (IOM) instructions included with the product and train its employees and contractors in the safe use of A-T Controls products in connection with the specific application.

While the information and specifications contained in this literature are believed to be accurate, they are supplied for informative purposes only. Because A-T Controls is continually improving and upgrading its product design, the specifications, dimensions and information contained in this literature are subject to change without notice. Should any question arise concerning these specifications, the purchaser/user should contact A-T Controls.

For product specifications go to <http://download.a-tcontrols.com/>

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