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College Park, MD 20740-3835

M-b-348

October 4, 2004

TO: All Regional Food and Drug Directors
Attn: Regional Milk Specialists

FROM: Milk Safety Branch (HFS-626)

SUBJECT: Waukesha Cherry-Burrell W75RS PMO Double Seat Mix-Proof Valve
1"- 4" inch (Spill-Free Design)

In accordance with M-I-00-2, *Milk and Milk Product Equipment-A Guideline for Evaluating Construction*, the Food and Drug Administration's (FDA) Central Region Milk Specialists and CFSAN's Milk Safety Team have evaluated this Mix-Proof Valve and have validated the technical information reviewed and submitted by the Atlantic-Midwest Dairy Equipment Review Committee (AMDERC) addressing the Waukesha Cherry-Burrell W75RS PMO Double Seat Mix-Proof Valve 1"- 4" inch (Spill-Free Design). When constructed, installed and operated as described in this memorandum, this Mix-Proof Valve has been found to meet the applicable provisions of the *Grade "A" Pasteurized Milk Ordinance* (PMO), when used to separate cleaning product solution and milk and milk products.

Waukesha Cherry-Burrell W75RS PMO Double Seat Mix-Proof Valve 1"- 4" inch (Spill-Free Design) is a single-bodied double seat valve designed to comply with Item 15p. PROTECTION FROM CONTAMINATION, 15p(B) of the PMO. The valve may be used as part of a fail-safe system to separate milk and milk products from tanks or circuits containing cleaning and/or sanitizing solution.

Compliance with the PMO is based upon construction, installation, and operation as described in the manufacturer's Operation and Maintenance Manual, October 2004, publication #95-03076.

The technical information that was reviewed addressing the Waukesha Cherry-Burrell W75RS Double Seat Mix-Proof Valve 1"- 4" inch (Spill-Free Design) constitutes the AMDERC's Engineering Design and Technical Construction File (EDTCF). The Table of Contents for this file is attached. The material in the EDTCF is the property of the manufacturer and may be shown at their discretion. For additional information regarding this equipment and to request copies of the documents, please contact:

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Waukesha Cherry Burrell
611 Sugar Creek Road
Delavan, WI 53115
Phone: (262) 728-1900
Fax: (262) 728-4904

FDA's review and acceptance of this piece of equipment does not constitute agency endorsement or approval. Any representation on a label or in printed literature citing or indicating "FDA Approval" is false and misleading.

An electronic version of this memorandum is available for distribution to Regional Milk Specialists, State Milk Regulatory Agencies and State Milk Sanitation Rating Officers in your region. The electronic version should be widely distributed to representatives of the dairy industry and other interested parties and will also be available on the FDA Web Site at <http://www.cfsan.fda.gov> at a later date.

If you would like an electronic version of this document prior to it being available on the CFSAN Web Site, please e-mail your request to Robert.Hennes@cfsan.fda.gov.

Donald R. Goldsmith
Regional Milk Specialist
FDA Central Region

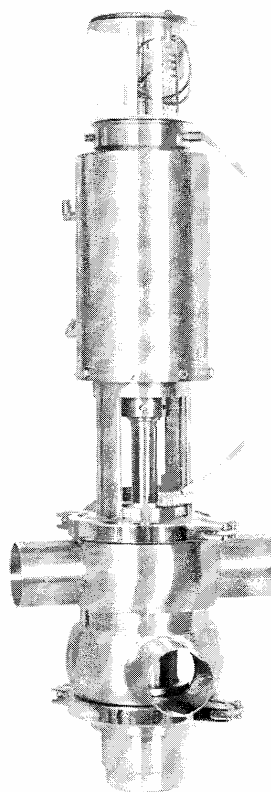
Jonathan M. Gardner
Milk Sanitation Officer
FDA/MST

Attachments:

Valve Literature
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Test Procedures



Operation and Maintenance Manual
W75RS PMO Double Seat Mix Proof Valves
Spill-Free Design



**Engineering Design and Technical Construction File (EDTCF)
Waukesha Cherry-Burrell Mix-Proof Valve, Model W75RS
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2. Previous Correspondence Letters and Review Reports
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 - Sectional Drawing: W75RS
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4. Essential Requirements for Design
5. 3A Symbol Authorization
6. Verification of Compliance to Other Standards
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11. Wiring Diagram

Test Procedures

Stem Gauge

First confirm proper location of lower valve stem. Place test gauge (Figure 11, item A) as shown on lower shoulder of stem. The shoulder should line up with the gauge.

Corrective Action: Check stem assembly, ensuring lower stem is fully turned in.

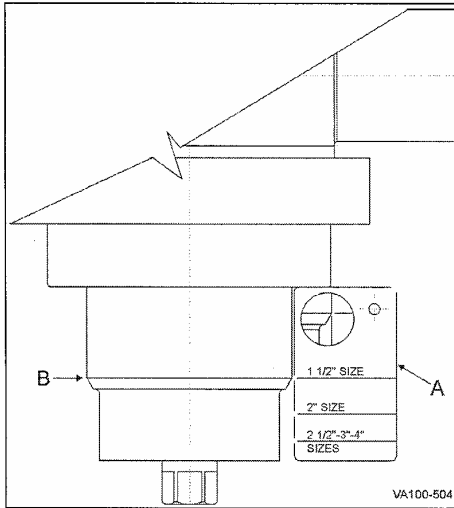


Figure 11 - Test Gauge and Stem Alignment

Confirm yoke area proximity switch location for detection of upper stem movement within 1/16". Insert test gauge sideways between detection cap and switch with valve in the closed position.

Proximity switch (Figure 12, item C) should contact gauge (item D) without compressing detection cap (item E).

Corrective Action: Loosen proximity switch bolt and adjust position.

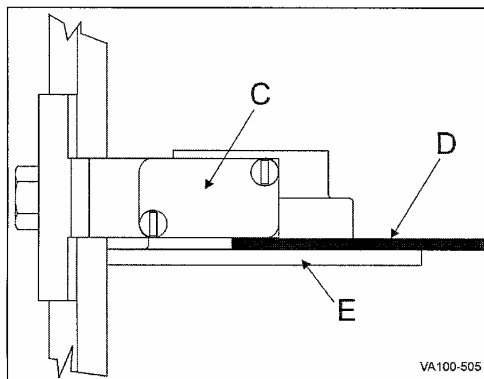


Figure 12 - Proximity Switch Location

Positive Fail-Safe Detection Test

Perform test to verify fully closed fail-safe position. Both upper and lower valve plugs are position-detectable via proximity switches. Valve plug feedback proximity switches are to be set for the fully opened and fully closed positions of the valve. See Figure 6 on page 13 for port and corresponding chambers. See Figure 11 and Figure 12 on page 16 to confirm stem and switch positions using stem gauge.

Decommission system, drain lines and lock out pumps.

1. With valve fully closed, confirm proximity switches conform to Table 1. Verify switch status on PLC control system.
2. Pressurize chamber B to open valve. Confirm proximity switches conform to Table 1.
3. Vent chamber B to close valve.
4. Activate upper seat lift either through the control system or manually by supplying air to air port in chamber C.
5. When upper seat lifts, confirm proximity switches conform to Table 1. Verify switch status on PLC control system.
6. Vent air in chamber C to deactivate seat lift.
7. Activate lower seat push either through the control system or manually by supplying air to chamber A on valve actuator.
8. When lower seat is pushed, confirm proximity switches conform to Table 1. Verify switch status on PLC control system.
9. Vent air in chamber A to deactivate seat lift.
10. Disconnect air from valve actuator placing valve in fail-safe position. Verify proximity switches register valve is fully closed.

Corrective Action

If double seat mix-proof valve fails to respond as indicated above, an immediate check of valve assembly and wiring is required to locate and correct the cause.

- First, check proximity switch adjustment.
- Check for correct assembly and adjustment of valve.