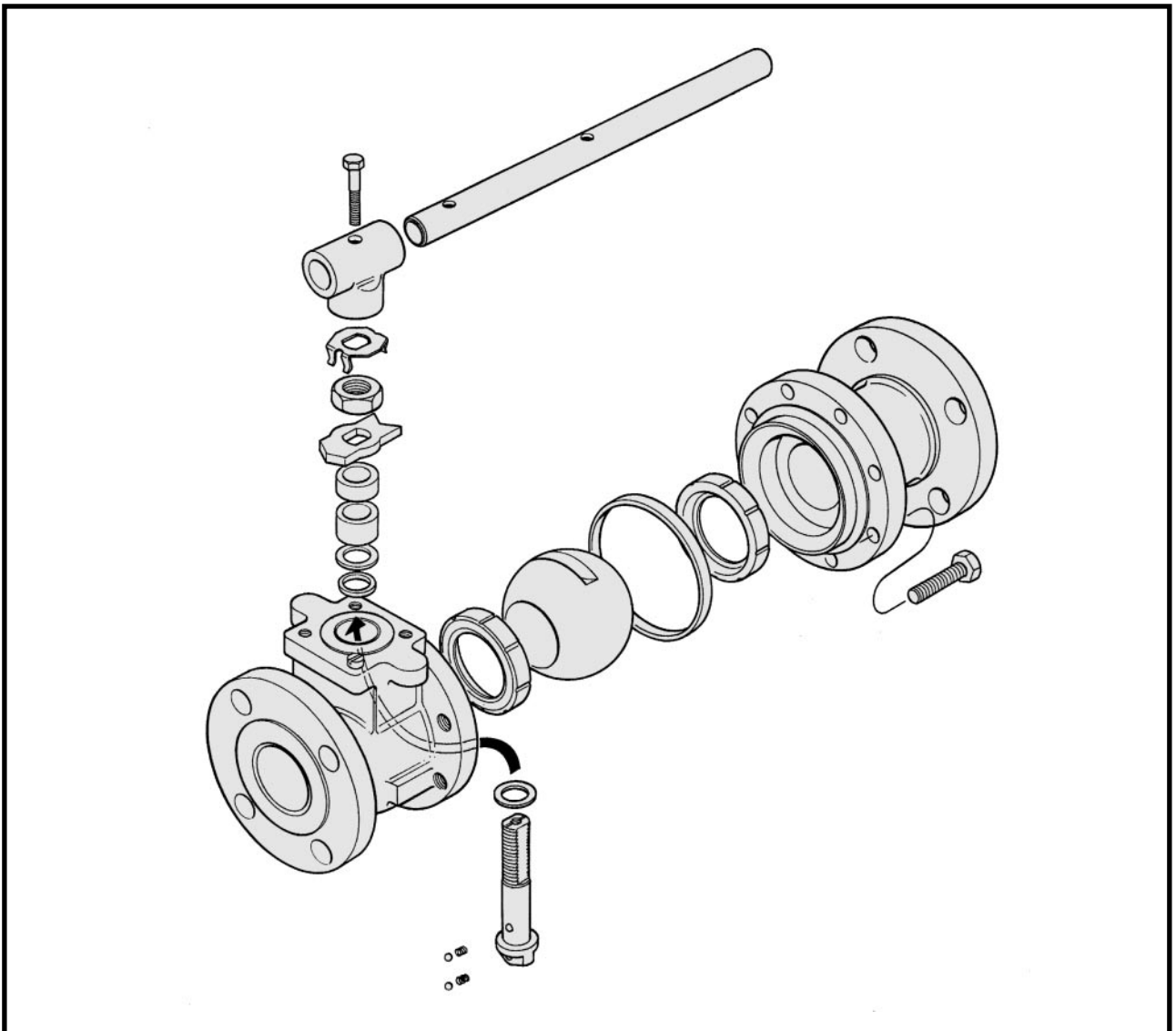




Installation, Operating & Maintenance Instructions

Full Bore 819 / 829 Series



FM 00707

1 STORAGE AND PRESERVATION

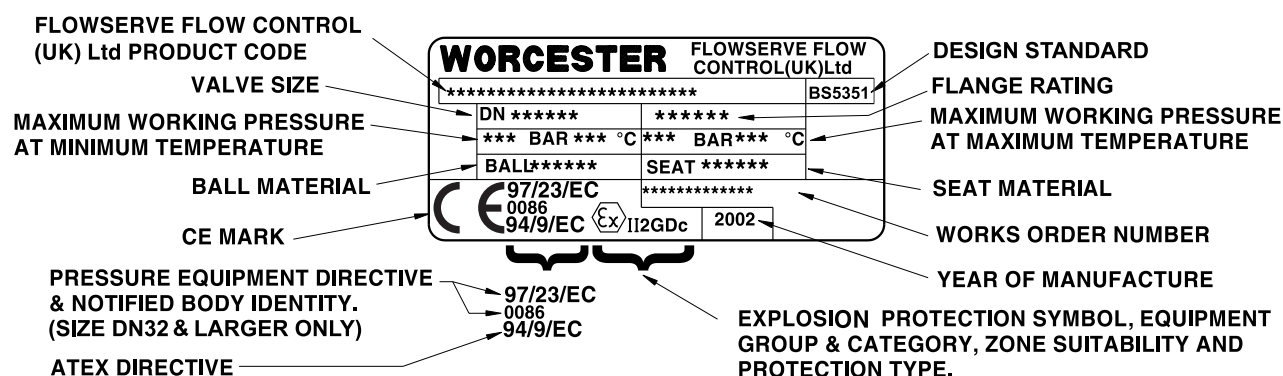
All valves are despatched in the open position and it is recommended that they are left in this position during storage. All protective packaging should remain in position until the valve is to be installed.

Valves should be stored in a clean, dry environment.

Carbon steel valves are manganese phosphated and coated with a de-watering oil. This coating is non-toxic and is quite safe on edible or potable products.

2 VALVE MARKINGS

Each valve has the following identification information plate attached to the side of the body:



2.1 Pressure Equipment Directive: If the identity plate carries the Pressure Equipment Directive number '97/23/EC' and the Notified Body identity number '0086' beside the 'CE' mark, the product complies with the Pressure Equipment Directive 97/23/EC and the Pressure Equipment Regulations 1999 (SI 1999/2001). Without these numbers, the product is classified as 'SEP' (Sound Engineering Practice) and may only be used within the limitations defined in tables 6, 7, 8 & 9 of Schedule 3 of the Pressure Equipment Regulations.

2.2 ATEX Directive: If the identity plate carries the ATEX Directive number '94/9/EC' followed by the Explosion Protection Symbol and codes identifying the equipment group and category, the zone suitability and protection type beside the CE mark, the product complies with the ATEX Directive and The Equipment and Protective Systems for Use in Potentially Explosive Atmospheres Regulations 1996.

Definition of identity plate marking above:

'II' = Equipment Group; '2' = Equipment Category; 'G' = Gas Zone suitability (Zones 1 & 2); 'D' = Dust Zone suitability (Zones 21 & 22); 'c' = type of protection i.e. constructional safety (prEN 13463-5).

Surface Temperature: As per EN 13463-1:2001(E) paragraph 14.2.g, the temperature class or maximum surface temperature cannot be marked on the product as it is dependant on the operating conditions. However the maximum allowable operating temperature for the product is marked on the identification plate.

2.3 Should the valve soft trim materials be changed during the course of its operational life it is necessary for this change to be reflected on the identification plate i.e. material change may impact pressure and temperature limitations.

Refer to Flowserve Flow Control (UK) Ltd. Technical Sales for details.

2.4 Material traceability markings are hard marked on the valve body and connector.

3 HEALTH AND SAFETY

When installing or maintaining valves:

- a) Conduct a risk assessment and eliminate or reduce hazards to an acceptable level.
- b) Work in accordance with Safe Systems of Work.
- c) Observe all site Health and Safety Rules in particular Permit to Work and Hot Work procedures.
- d) Wear all necessary Personal Protective Equipment.
- e) Never remove or maintain a valve or joint unless the line has been fully de-pressurised, drained and where necessary, purged of toxic / explosive / flammable media. Always operate the valve to the open position to ensure that no trapped pressure exists within the cavity.
- f) Never handle valves that have been used on harmful substances unless they have been completely decontaminated and certified safe to handle.
- g) Never use a valve on a duty which exceeds its prescribed operating parameters. Refer to Flowserve Flow Control (UK) Ltd Technical Sales for performance curves or further information.
- h) Never modify or alter valves unless the manufacturer has been consulted or recommends such changes.
- i) The valves wrenches are only designed for use in operating the valves and must not be used to carry them by. Failure to observe this warning may result in operator injury.
- j) Due to the large physical size and weight of some sizes of this product, always use correct lifting methods and equipment when installing, removing and maintaining the product, and that it is correctly supported in its final operating location.
- k) Due to the variety of duties on which this product can be employed, it is the end users responsibility to ensure the compatibility of the media with the materials of construction of the product for each specific application (i.e.corrosion and erosion which may affect the integrity of the pressure containing envelope).
- l) Before equipment is installed in areas which may be subject to seismic activity or extreme climatic conditions consult Flowserve Flow Control (UK) Ltd. Technical Sales.
- m) End Flanges: The end flange design of this product has been verified by either 1998/2001 ASME Boiler and Pressure Vessel Code Section VIII Division 1 calculation method, by Finite Element Analysis in accordance 1998/2001 ASME Boiler and Pressure Vessel Code Section VIII Division 2 - Alternative Rules, or by experimental testing as defined in pr EN 12516-3 Valves Design Strength - Part 3 Experimental Method.

3 HEALTH AND SAFETY (cont.)

Gaskets: The gaskets used in all methods are Spiral Wound to BS4865 for PN rated flanges, and ASME B16.20 for Class rated flanges. These have Gasket Factors and Design Stresses of 2.5 and 10000psi respectively for Carbon Steel gaskets, and 3.0 and 10000psi for Stainless Steel gaskets as defined in the 1998/2001 ASME Boiler and Pressure Vessel Code Section VIII Division 1.

If gaskets are used with higher Gasket Factors and Design Stresses than those stated above, please consult Flowserve Flow Control (UK) Ltd Technical Sales.

Bolting: End flanges have been verified by the methods stated above, using bolt design stress values based on those for ASTM A193 B8 Cl.2 (i.e. 25000/20000psi - dependant on the bolt size) for Stainless Steel valves, and ASTM A320 L7 (25000psi) for Carbon Steel valves as defined in 1998/2001 ASME Boiler and Pressure Vessel Code Section II - Materials - Part D - Properties.

- n) Lethal Service. In accordance with the design verification code (1998/2001 ASME Boiler and Pressure Vessel Code Section VIII Division 1) a casting quality factor of 1.0 is allowable for all products except those intended for 'lethal service'. All products for such service must have had non-destructive examination carried out in accordance with Appendix 7 of the code. Refer to Flowserve Flow Control (UK) Ltd Technical Sales.
- o) If the processes or environments that the products are used in are likely to cause temperatures (high or low) that may cause injury to personnel if touched, then adequate insulation/protection must be fitted.
- p) If the equipment is to be used on unstable gas duty, ensure that the operational parameters as indicated on the product identification plate cannot be exceeded.
- q) This equipment should be protected by other devices to prevent over-pressurisation. (i.e. caused by external fire etc).
- r) This equipment must be installed in a system that is designed to prevent excessive forces acting on the flanges, connections, etc.

4 PREPARATION FOR INSTALLATION

When dispatched, valves contain a mineral oil which aids the bedding in of the valve. This may be removed if found unsuitable. Special variants may contain other lubricants or be dry built.

Some valves contain a Silica gel bag inside the ball cavity to absorb humidity during storage. These must be removed before installation, as must all other protective packaging.

It is important to ensure that the gland nut locking clip is retained at all times. If, during installation, it is noted that the locking clip is not in place, the gland nut must be adjusted to the correct torque and a new locking clip fitted.

Significant problems can arise with any valve installed in an unclean pipeline. Ensure that the pipeline has been flushed free of dirt, weld spatter, etc. before installation. The working area should be clean and clear of any debris which could contaminate the valve.

5 INSTALLATION INSTRUCTIONS

- a) Standard valves may be installed in either direction. Valves with a upstream relief hole (Q190) are unidirectional and must be fitted with the flow arrow pointing downstream.
- b) Installation of flanged valves should follow prevailing site standards. Where such standards do not exist the following should be used as a guideline.
 - i) Flanged joints require compressive loading onto the gasket material as the normal line pressure forces tend to separate the joint. There should be no misalignment between the valve and mating faces.
 - ii) Pipework should have the correct gap to allow for the valve face to face length plus assembled gasket material thickness.
 - iii) Ensure the pipeline and flange faces are clean and free of any debris which may be detrimental to flange sealing.
 - iv) Bolting should be of the correct size, length and material for the duty.
 - v) Locate the valve between the pipe ends and slide in the gaskets. It may be necessary to lever the mating flanges gently apart to allow for easy fitting of the gasket. Care should be taken to prevent damage to the sealing surfaces. Correct lifting equipment must be used when handling valves for operator safety.
 - vi) Assemble all bolts and loosely tighten. Diametrically and evenly tighten the bolts to the correct torque required for the specific gasket material.
- c) It is recommended that the valves are left in the open position during fitting.

6 OPERATION

6.1 USE

Worcester ball valves provide bubble tight shut off when used in accordance with the published pressure/temperature chart.

It is not good practice to leave a standard ball valve in the partially (throttled) position as this may cause damage and seat life may be reduced. Flow control ball valves are available which contain seats designed for this purpose.

Any media which may solidify, crystallise or polymerise should not be allowed to stand in the ball cavity since this is detrimental to valve performance and life.

6.2 MANUAL OPERATION

The basic type of wrench which is fitted to 15-50mm($\frac{1}{2}$ "-2") valves is of sheet steel with integral stop. The larger sizes of valves have a cast wrench head and tubular handle secured to the stem by a wrench bolt.

Worcester valves have $\frac{1}{4}$ turn operation, closing in a clockwise direction. It is possible to see when the valve is open or closed by the position of the wrench: When the wrench is in line with the pipeline, the valve is open; when the wrench is across the pipeline, the valve is closed. Similarly, if the wrench is removed the flats of the stem will also indicate valve position.

When operating the valve the use of excessive side loading on the wrench should be avoided.

6.3 REMOTE OPERATION

Where automation of valves is required, Worcester can supply pneumatic and electric actuators to cover a wide range of operating torques.

Operation will be in accordance with installation, operation and maintenance instructions for the relevant actuator.

7 MAINTENANCE

7.1 GENERAL

With self wipe ball / seats and patented pressure equalising slots, Worcester valves have long, trouble free lives and maintenance is seldom needed. The following checks will help extend life further and reduce plant problems:

Routine checks / maintenance:

- i) Every 25000 cycles or 3 months: Check for any signs of leakage (see 7.2, 7.3 & 7.4 below) and that all fasteners (including the gland nut) and joints are tightened to their correct torque value (see final section of this I.O.M.).
- ii) Infrequent operation: The valve should not be left standing without operation for more than 1 month. After this period the valve should be operated through three full cycles.

7.2 IN-LINE LEAKAGE

Check that the valve is fully closed. If it is, then any leakage will be due to damage to the body, connector, insert, seat or ball sealing surfaces and it will be necessary to dismantle the valve to repair it. (See section 9).

7.3 STEM LEAKAGE

Remove the wrench assembly as detailed in section 9 or the actuator as detailed in the relevant actuator I.O.M., followed by the gland nut locking clip, and retighten to the recommended torque. If the leakage persists then it will be necessary to dismantle the valve to establish the cause and/or replace gland packings and thrust seals.

7.4 BODY/INSERT/CONNECTOR JOINT LEAKAGE

BODY/CONNECTOR: Check the interface bolting is tightened to the recommended torque values and tighten if necessary. If leakage still occurs it will be necessary to remove the valve from line and split the valve at the interface joint to replace the body seal and to establish whether the seal faces of the body and connector have been damaged. (See section 9).

BODY/INSERT: If leakage occurs here, it will be necessary to remove the valve from line. Remove the insert and establish whether the body and insert seal faces have been damaged. Replace the body seal, refit and tighten the insert to to the recommended torque value. (See section 9)

8 REPAIR KITS

Repair kits are available for all Worcester valves. Details of their contents are found in the Instruction sheet supplied with the kit.

If other parts are required, it is usually recommended that the complete valve is replaced, although piece parts are available. Parts from different sized / rated valves must not be interchanged.

Only Worcester authorised spare parts should be used. This includes basic components such as fastenings. If the valve is altered in any way, without the consent of Flowserve Flow Control (UK) Ltd. then Flowserve Flow Control (UK) Ltd. will accept no responsibility.

9 REFURBISHMENT INSTRUCTIONS

Prior to commencing any work on the valve or removing it from line, refer to the 'Health & Safety' Instructions.

NEVER remove or maintain a valve or joint unless the line has been fully de-pressurised, drained and where necessary, purged of toxic / explosive / flammable media.

9.1 SIZE 15mm - 40mm (1/2" - 1 1/2") - ONE PIECE VALVES

9.1.1 DISMANTLING

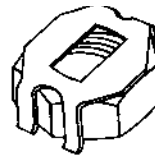
- a) Ensuring that it is correctly supported, remove the valve from the pipeline by extracting the flange bolting from each end.
- b) With the valve securely clamped and in the open position, undo the insert using the appropriate drive adaptor. It will be necessary to use a heavy mallet on the tommy bar of the insert tool to break the metal to metal seal.
- c) Remove the insert to allow access to the cavity.
- d) Remove the body seal and discard. Close the valve and using a soft drift through the body port, tap out the ball and insert seat.
- e) Turn the stem back to the open position and, using a suitable hook, pull out the body seat being careful not to damage the seat sealing face of the valve body.
- f) To dismantle the stem assembly remove:
 - Wrench Nut
 - Wrench Nut Spring/Star Washer } If fitted
 - Wrench
 - Gland Nut Locking Clip
 - Gland Nut
 - Disc Springs
 - Gland
- g) Withdraw the stem from inside the body (N.B. with 15mm (1/2") valves the gland packing must be removed and the wrench flats of the stem must be aligned across the valve to allow withdrawal of the stem). The gland packing, thrust seal and thrust seal protector can now be removed from their recesses, being careful not to damage the seal faces.
- h) All components not replaced by items in the repair kit should be thoroughly cleaned and stored in a clean secure area. All sealing faces on the body, insert and ball must be checked for corrosion, erosion and scratches. If damage is found or there is any doubt, replace the component.
- i) Cleaning the valve parts should be carried out using a suitable degreasing agent. Hard deposits can be removed using wire wool. Care should be taken on all seal faces to avoid damaging them.

9.1.2 REBUILDING

- a) Before rebuilding, ensure the repair kit and/or components used are suitable for the valve requirement. When rebuilding, cleanliness is essential for long valve life. Both the thrust seal protector and seats may be lightly lubricated with a light oil to aid bedding in. Ensure that the lubricant is compatible with the pipeline media.
- b) Fit a new thrust seal protector and thrust seal on to the stem shoulder and insert the stem through the valve body from inside the valve cavity.
(On 15mm (½") valves, tweezers will make the job easier).
- c) Fit the new gland packings into the body recess and the gland and new disc springs (with their outer edges touching) on to the stem.
- d) Fit the gland nut and preventing the stem from turning, tighten it down to the recommended torque.
- e) Operate the stem several times and re-adjust the gland nut to the specified figure. The locking clip must then be fitted correctly, either across the corners or on the flats of the nut. Always tighten the gland nut to the next position to correctly locate the clip (see below). Over-tightening the gland nut will only reduce the life of the stem assembly.



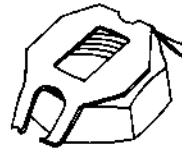
Correct



Correct



Incorrect



Incorrect

- f) Fit the wrench, spring washer and wrench nut to the stem (if required) and operate the stem to the valve open position.
- g) Fit the body seat into the valve cavity past the stem drive tang, and position it into the seat housing.
- h) Turn the stem to the valve closed position and slide the ball into the body, locating on the stem drive tang.
- i) Locate the insert end seat into the cavity and the body seal into its housing.
- j) Open the valve, and tighten the insert into the valve body to the specified torque using the correct drive adaptor. It is important that on stainless steel valves an anti-scuffing compound such as Rocol 'Copperslip' is used on the insert threads. It is advisable, though not mandatory to use it on carbon steel valves as well.
- k) If practical, leak tightness and operating torque should be checked prior to refitting the valve in line.

9.2 SIZE 50mm - 200mm (2" - 8") - TWO PIECE VALVES

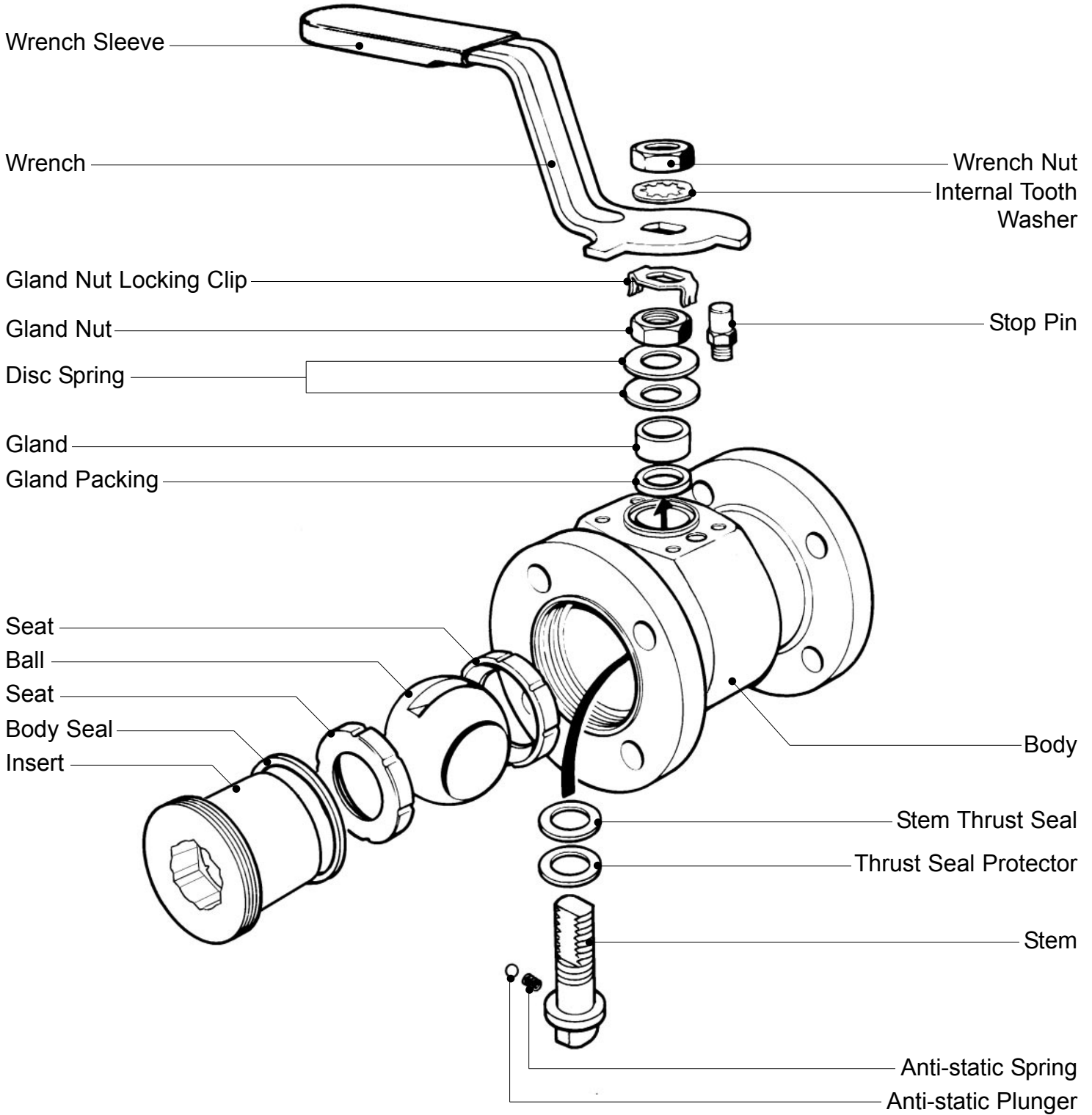
9.2.1 DISMANTLING

- a) Ensuring that it is correctly supported, remove the valve from the pipeline by extracting the flange bolting from each end. Large pipelines have a tendency to spring the flanges together making removal difficult. If necessary, remove or loosen elbows, couplings or pipe supports to get extra manoeuvrability.
- b) With the valve securely clamped and in the open position, undo the fastenings retaining the two body parts.
- c) Tap one of the flanges sharply with a mallet to break the joint and separate.
- d) With the valve in the closed position remove the ball. If there is a large build up of solid scale or media in the cavity it may be necessary to tap it out using a soft drift.
- e) Using a suitable hook to get under the seat face, remove the seats from the body and the body connector. Care must be taken to avoid damaging the seal faces.
- f) Remove the body seal from the interface housing.
- g) To dismantle the stem assembly remove:
 - T-Bar Wrench
 - Locking Clip
 - Gland Nut
 - Stop Plate
 - Gland
- h) Tap the stem down into the valve cavity and withdraw. The gland packing, location washer, secondary stem seal and thrust seal can now be removed.
- i) All components not replaced by items in the repair kit should be thoroughly cleaned and stored in a clean secure area. All sealing faces on the body, insert and ball must be checked for corrosion, erosion and scratches. If damage is found or there is any doubt, replace the component.
- j) Cleaning the valve parts should be carried out using a suitable degreasing agent. Hard deposits can be removed using wire wool. Care should be taken on all seal faces to avoid damaging them.

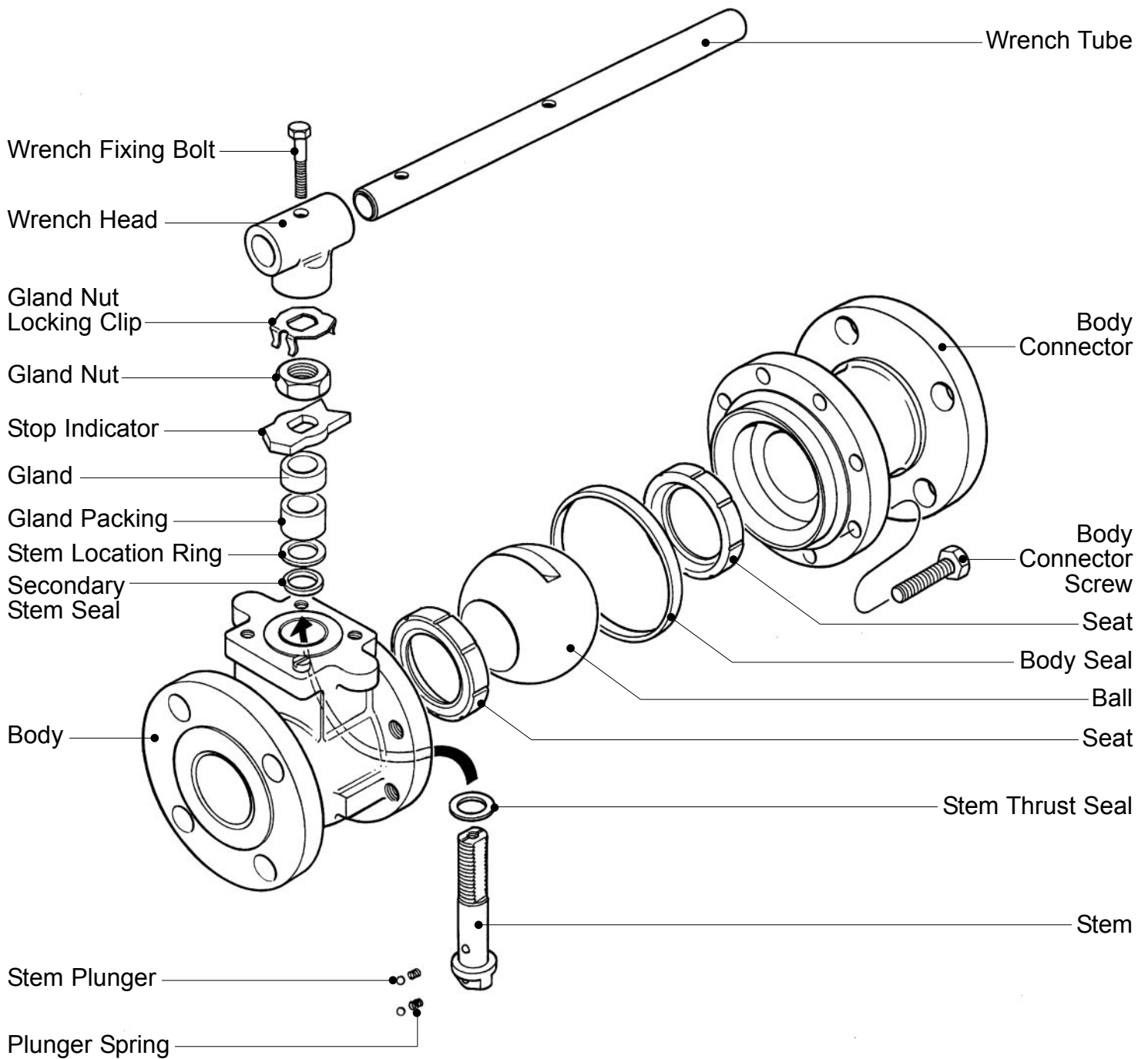
9.2.2 REBUILDING

- a) Before rebuilding ensure the repair kit and/or components used are suitable for the valve requirement. When rebuilding, cleanliness is essential for long life. The seats may be lightly lubricated with a light oil to aid bedding in. Ensure that the lubricant is compatible with the pipeline media.
- b) Fit a new thrust seal onto the stem shoulder and insert the stem through the valve body from inside the valve cavity.
- c) Place the secondary stem seal into the bottom of the gland housing, followed by the location ring, gland packing, gland and stop plate followed by the gland nut. With self locking gland nuts, Rocol 'Copperslip' or a similar anti-scuffing agent should be applied to the stem thread.
- d) Tighten the gland nut until the specified stem assembly torque or gland nut tightening torque has been achieved. Over tightening of the gland nut will only reduce the life of the stem assembly and can seriously increase torque. A locking clip should be fitted following the procedure 9.1.2 Section (e).
- e) Ensure the valve is in the closed position.
- f) Secure the valve in the vertical position, and place the seat in the body housing.
- g) Locate the body seal into the interface housing.
- h) Slide the ball into the body, locating the stem drive tang, and operate to the valve open position.
- i) Locate the connector seat in its housing.
- j) Fit the body connector to the body, being careful not to damage the body seal. Ensure the connector flange is correctly orientated to the body flange. Lower the connector down squarely and tap it fully home with a soft mallet.
- k) Replace interface fastenings and tighten evenly to the recommended torque. For stainless steel fastenings Rocol 'Copperslip' or an alternative should be applied to the threads.
- l) If practical, leak tightness and operating torque should be checked prior to refitting in line.

ONE PIECE VALVES 15 - 40mm (1/2" - 1 1/2")



TWO PIECE VALVES 50 - 200mm (2" - 8")



VALVE ASSEMBLY TORQUES

DEFINITIONS

Insert Torque - The torque required to fully tighten the insert of one piece valves.

Interface Fastening Torques -The torques applied to the body interface fastenings to ensure the segments of the two piece valves are correctly assembled.

Stem Assembly Torques -The torque required to operate the assembled stem before the ball and seats are fitted to the valve.

Gland Nut Torques -The tightening torques to be applied to the gland nuts to achieve the above figures. **Note:** these figures can only be used with valves fitted with locking clips and **must not** be used for tightening self locking gland nuts.

SIZE	INSERT TORQUES (Nm)	INTERFACE FASTENING TORQUES (Nm)	GLAND NUT TORQUES (Nm)		STEM ASSEMBLY TORQUES (Nm)
			GRAPHITE BUILD	PTFE BUILD	
15mm (½")	65 - 75		5 - 7	6 - 9	3 - 5
20mm (¾")	70 - 80		6 - 10	8 - 12	4 - 6
25mm (1")	70 - 80		6 - 10	8 - 12	4 - 6
32mm (1¼")	80 - 90		8 - 12	13 - 18	6 - 8
40mm (1½")	90 - 100		8 - 12	13 - 18	6 - 8
50mm (2")		55 - 65	21 - 26	19 - 24	8 - 11
65mm (2½")		55 - 65	27 - 32		18 - 22
80mm (3") 819 Series		55 - 65	27 - 32		18 - 22
80mm (3") 829 Series		85 - 95	35 - 40		20 - 26
100mm (4") 819 Series		85 - 95	35 - 40		20 - 26
100mm (4") 829 Series		85 - 95	47 - 53		23 - 28
150mm (6") 819 Series		85 - 95	47 - 53		23 - 28
150mm (6") 829 Series		135 - 145	63 - 68		29 - 35
200mm (8") 819 Series		135 - 145	63 - 68		29 - 35
200mm (8") 829 Series		200 - 210	90 - 98		35 - 40



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