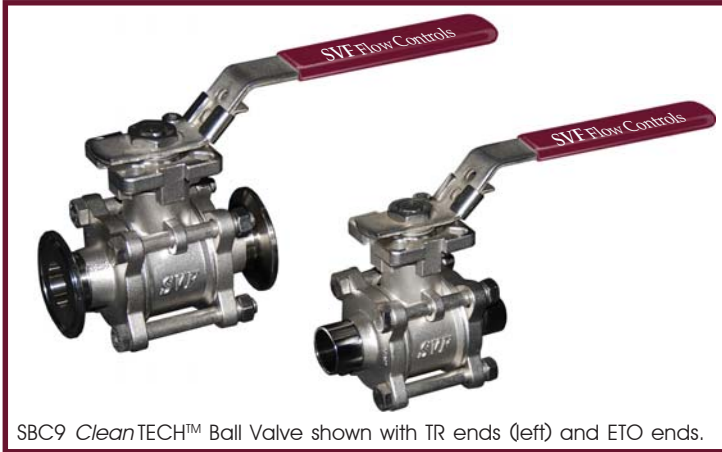


INSTALLATION, OPERATION & MAINTENANCE FOR SVF SERIES SBC9 BALL VALVES



SBC9 CleanTECH™ Ball Valve shown with TR ends (left) and ETO ends.

GENERAL

SVF Ball valves have been designed and engineered to provide long lasting and trouble free service when used in accordance with the instructions and specifications herein.

The following instructions refer only to all SVF Standard Series SBC9 CleanTECH Ball Valve.

Keep protective cover in place until moment of installation. Valve performance depends upon prevention of damage to ball surface. Upon removal of cover, make sure that the valve is completely open and free of obstruction.

If requested, valves can be shipped from the factory containing a silicon based lubricant which aids in the assembly of the valve. This may be removed with a solvent if found intolerable.

!!!CAUTION! Safety Precautions!!!

Before removing valve from pipeline NOTE that:

Media flowing through a valve may be corrosive, toxic, flammable, a contaminant or harmful nature. Where there is evidence of harmful fluids having flowed through the valve, the utmost care must be taken. It is suggested that the following minimal safety precautions be taken when handling valves.

1. Always wear eye shields.
2. Always wear gloves and overalls.
3. Wear protective footwear.
4. Wear protective headgear.
5. Ensure that running water is readily accessible.
6. Have a suitable fire extinguisher ready if media is flammable.
7. Be sure that you are aware of the fluid that has been passing through the valve before opening or dismantling any valve. Require MSDS information.

By checking line gauges ensure that no pressure is present at the valve.

Ensure that any media is released by operating valve slowly to half open position. Ideally, the valve should be decontaminated when the ball is in the half open position.

These valves, when installed, have body connectors which form an integral part of the pipeline and the valve cannot be removed from the pipeline without being dismantled.

Valves and accessories must not be used as a sole support of piping or human weight. Safety accessories such as safety relief (overpressure) valves are the responsibility of the system designer.

It is the user/system designer's responsibility to use insulation in high temperature applications. Refer to OSHA documents for more details.

What do you need today?™





INSTALLATION, OPERATION & MAINTENANCE FOR SVF SERIES SBC9 BALL VALVES

INSTALLATION

The valve may be installed for flow or vacuum in either direction. Carefully exclude pipe sealants from the valve cavity. When installing, use standard gaskets suitable for the specific service. Tighten flange bolts or studs evenly.

OPERATION

SVF valves provide tight shut off when used under normal conditions and in accordance with SVF's published pressure/temperature chart. If these valves are used in a partially open (throttled) position seat life may be reduced.

SVF valves have ¼ 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 handle. When the wrench is inline with the pipeline, the valve is open.

Any media which might solidify, crystallize or polymerize should not be allowed to stand in the ball valve cavities unless regular maintenance is provided. If minimal maintenance is required, SVF offers steam jacketed ball valves.

TORQUE REQUIREMENTS

Torque ratings are subject to variations depending on the length of time between cycles and the media in the system.

Breakaway torque is that force which must be exerted to cause the ball to begin to open. Operating torque requirements will vary depending on the length of time between cycles, media in the system, line pressure, and type of valve seat.

MAINTENANCE

With self-wiping ball/seats, SVF valves have a long, trouble free life, and maintenance is seldom required. But, when necessary, valves may be refurbished, using a small number of components, none of which require machining.

SVF valves are designed for easy service and assembly in the field. The following checks will help to extend valve life, or reduce plant problems.

SVF ball valves utilize live-loaded stem seals featuring Belleville Washers (disk springs) that maintain constant pressure on the Stem Seal area even under a wide range of pressure and temperature fluctuations. If stem leakage is evident proceed as follows:

STEM LEAKAGE

Examine the disk springs (Belleville Washers) for damage. If in good condition tighten the gland nut until disk springs are firmly compressed, then back nut off 1/16th of a turn. If damaged, dismantle the stem down to the gland, fit new disk springs with their outer edges touching, replace and retighten using gland nut. Further maintenance necessitates dismantling of the valve.

LEAKAGE AT BODY JOINT

Check for tightness at the body connector bolts. If loose, tighten body bolts. Excessive force will damage the bolts. (See Table A below)

If there is still leakage it will be necessary to dismantle the valve and replace the body seals.

IN-LINE LEAKAGE

Check that the valve is fully closed. If leakage occurs while the valve is in the closed position, a seat or ball sealant surface may be damaged and it will be necessary to disassemble the valve.

NOTE: Stem leakage and leakage at body joint, if not cured by simple means described above, necessitate dismantling valve. If there is no stem leakage the stem assembly should not be touched.



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REBUILDING

Before rebuilding, check that all the correct components are available and that they are fit for reassembly. When rebuilding, cleanliness is essential to allow long valve life and provide cost effective maintenance. CAUTION: NO BODY OR STEM SEALS ARE REUSABLE. Care must be taken to avoid scratching the seats and seals during installation.

NOTE: Caution must be taken with valves that have been in hazardous media. They must be decontaminated before disassembly, by relieving the line pressure and flushing the line with the valve in the partially open position. Protective clothing, face shields, gloves, etc., MUST BE USED for this operation.

A DISASSEMBLY OF VALVE (Removed from line)

- 1.) Remove the End Connectors (#2) by removing the Body Bolts (#5) and Body Bolt Nuts (#22).
- 2.) Once the End Connectors (#2) have been separated from the Body (#1), remove the Body Seals (#7) and Seats (#4).
- 3.) Make sure the Ball is in the closed position, thus the Ball (#3) can be taken out easily from the Body (#1)

B REMOVING STEM ASSEMBLY - 1/2" ~ 3"

- 1.) Remove Handle (#17) by removing Handle Nut (#16).
- 2.) Remove the Handle Gland (#15), Tab Lock (#14), Stem Nut (#13), Belleville Washers (#12), Gland (#11), Bushing (#10) and Stem Seals (#9).
- 3.) Push the Stem (#6) down into the body cavity to remove, once removed take off the Thrust Washer (#8).

B-1 REMOVING STEM ASSEMBLY - 4"

- 1.) Loosen Set Screw (#26) on Handle Adapter (#27) to remove from the Stem (#6).
- 2.) Remove the Triangle Stopper (#25), Tab Lock (#14), Stem Nut (#13), Belleville Washers (#12), Gland (#11), Bushing (#10) & Stem Seals (#9).
- 3.) Push the Stem (#6) down into the body cavity to remove. Once removed take off the Thrust Washer (#8).

C INSPECTION

- 1.) The ball and the surfaces of the seats should be free of pit marks and scratches. Light marring from the action of the ball against the seats is normal and will not affect the operation of the valve.
- 2.) The stem, thrust bearing, stem seal, and surrounding body should be free of pit marks and scratches.

D REASSEMBLY

- 1.) Apply an adequate amount of lubricant, compatible with the media being handled, around the Ball (#3), Seats (#5), Body Seal (#6), Stem (#4), and Thrust Washer (#21).
- 2.) For stem reassembly, disassembly procedure should be followed in reverse order.
- 3.) When stem assembly is complete, tighten Stem Nut according to the values in Table A.
- 4.) With the Stem (#6) in the closed position, insert the Ball (#3) into Body (#1) so that stem slot engages with the tang at the base of the stem.
- 5.) Make sure Body Seals (#7) rests squarely on center seal surface of the body.
- 6.) Insert seats in body. Make sure seats rest firmly on back surface of each recess.
- 7.) Merge the End Connectors (#2) with the body (#1).
- 8.) Insert and tighten Body Bolts/Nuts (#5 & #22) diagonally, in accordance to the cross pattern procedure shown in the following page.
- 9.) In the final assembly step ensure that Body Bolts/Nuts (#5 & #22) are tightened according to torques values in Table A.

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TORQUE SPECS

Certain precautions need to be followed when tightening bolts down to their corresponding torques to help prevent bolt galling. There are two passes each bolt has to undergo during the process, first pass and the final pass. Once every bolt has met the first pass requirement, the final pass can be initiated. When tightening down bolts it is necessary to follow the corresponding bolt pattern shown below.

TABLE A: TORQUE REQUIREMENTS (in-lbs)

SBC9 Valve Size	Body Bolts			Stem Nut Torque
	Bolt Pattern	First Pass	Final Pass	
1/2"	4	42	70	80
3/4"	4	60	100	100
1"	4	60	100	100
1-1/2"	4	168	280	160
2"	4	168	280	200
2-1/2"	4	348	580	200
3"	6	348	580	200
4"	6	480	800	270

REPAIR KITS

Repair Kits are available from SVF Flow Controls, Inc. Table B below shows what the kits consist of. When ordering a Repair Kit, please be sure to specify the type, size and seating material of the valve.

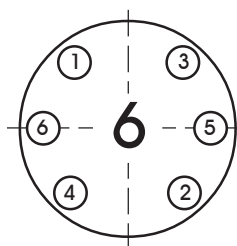
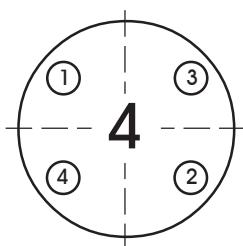
When repairing a valve use only SVF Flow Controls, Inc. authorized spare parts including; bolts and nuts, etc. In addition to maintenance kits, spare parts are available from SVF Flow Controls, Inc. (Balls and stems). If additional parts are required (body and ends) it is normally recommended that the complete valve be replaced.

Components from a different valve series should not be used with the repair of any other valve. If the valve is altered in any way, no liability can be accepted by SVF Flow Controls, Inc.

TABLE B: GENERAL REPAIR KIT

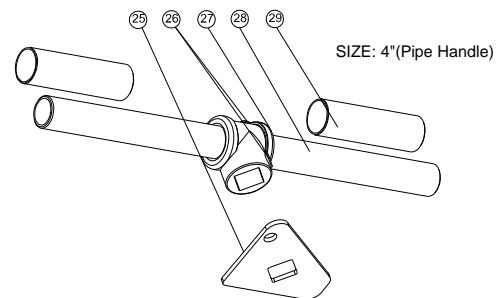
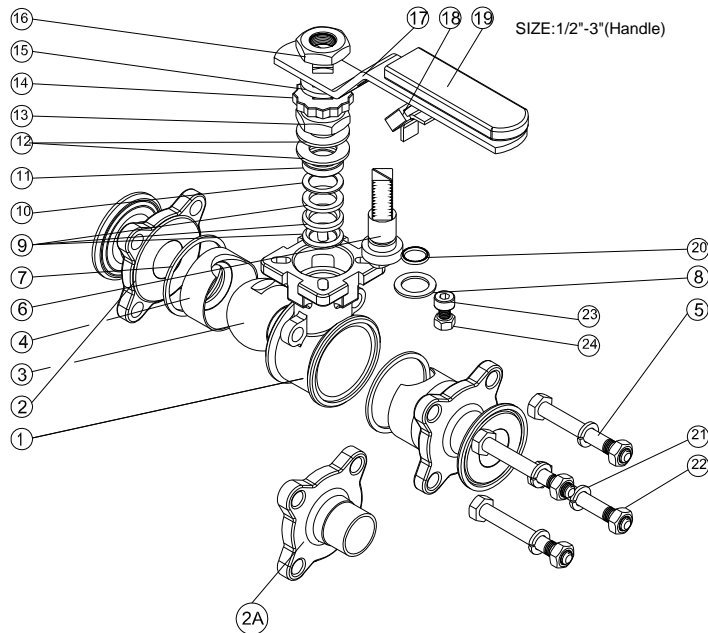
Part	Quantity
Thrust Washer	1
Stem Seals	2
Belleville Washers	2
Seats	2
Body Seals	2

CleanTECH™ SERIES BOLT PATTERNS - BOLT TIGHTENING SEQUENCE



MATERIALS OF CONSTRUCTION FOR SVF SERIES SBC9 BALL VALVES - SIZES 1/2" - 4"

Item #	Part Name	Materials	Recommended Spare	Wetted
1	Body	316L Stainless Steel A351-CF8M	-	X
2	End Connector (Tri-Clamp)	316L Stainless Steel A351-CF8M	-	X
2A	End Connector (ETO)	316L Stainless Steel A351-CF3M	-	X
3	Ball	316L Stainless Steel A351-CF8M	-	X
4	Ball Seat	TFM1600™	X	X
5	Body Bolt	A193-B8	-	-
6	Stem	316L Stainless Steel A351-CF8M	-	X
7	Body Seal	TFM1600™	X	X
8	Thrust Washer	TFM1600™	X	X
9	Stem Seal	TFM1600™	X	-
10	Bushing	50%SS+50%PTFE	X	-
11	Gland	Stainless Steel	X	-
12	Belleville Washer	Stainless Steel	X	-
13	Stem Nut	Stainless Steel	-	-
14	Tab Lock	Stainless Steel	-	-
15	Handle Gland	Stainless Steel	-	-
16	Handle Nut (1/2"-3")	Stainless Steel	-	-
17	Handle (1/2"-3")	Stainless Steel	-	-
18	Locking Device (1/2"-3")	Stainless Steel	-	-
19	Handle Sleeve (1/2"-3")	Vinyl Plastic	-	-
20	O-ring	Viton	X	X
21	Bolt Washer	Stainless Steel		
22	Body Bolt Nut	Stainless Steel		
23	Stop Bolt	Stainless Steel		
24	Stop Nut	Stainless Steel		
25	Triangle Stopper (4")	Stainless Steel		
26	Set Screw (4")	Stainless Steel		
27	Handle Adapter (4")	Stainless Steel		
28	Pipe Handle (4")	A53 + Zn Plated		
29	Pipe Handle Sleeve (4")	Vinyl Plastic		





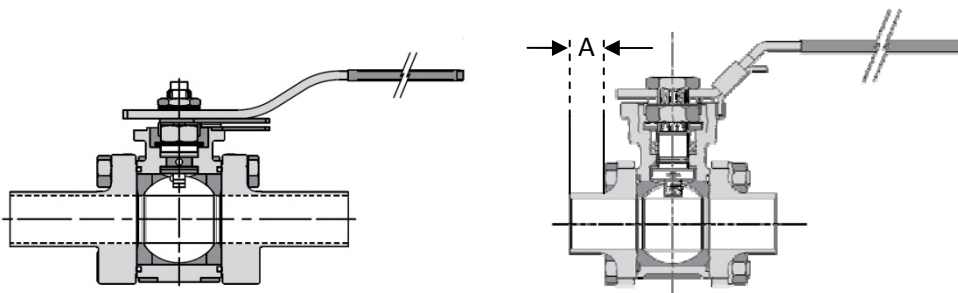
CleanTECH™ Series - ETO Ends and Orbital Welding

Nº. 1031

Prior to the introduction of the Series SB9/SBC9 in our CleanTECH™ product group, we studied the orbital welding techniques that are used when installing weld end valves.

The results of that research indicate that the product, as supplied to our marketplace, has an appropriate Extended Tube OD (ETO) length to be used with an orbital welder.

The ETO ends on the SB9/SBC9 CleanTECH™ valves are shorter than the ETO end dimensions on our CleanFLOW™ SB7 valves, but they are of a length that can be welded with an orbital system. Below you will find a table containing the dimensions (Dimension A) of the ETO tube on the SB9/SBC9 valve series.



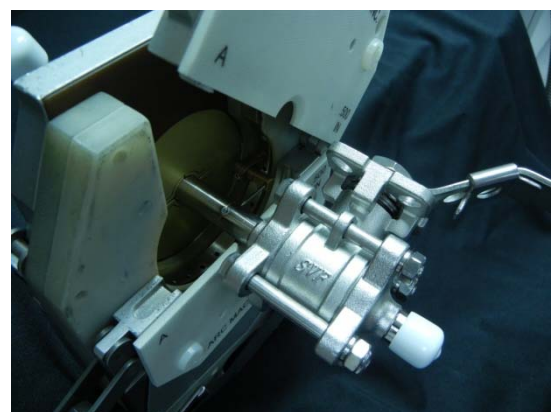
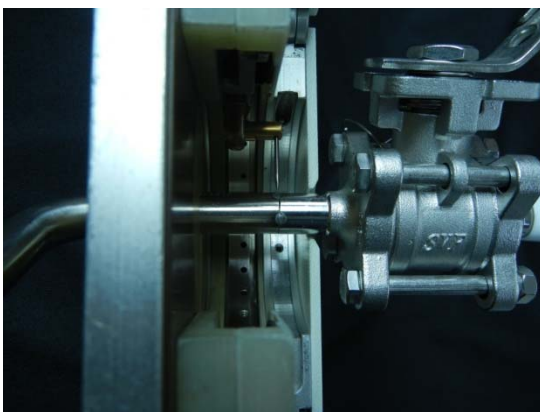
CleanFLOW™ ETO Ends

CleanTECH™ ETO Ends

Valve Size	Dimension A
1/2"	0.57"
3/4"	0.58"
1"	0.58"
1-1/2"	0.59"
2"	0.71"
3"	0.90"
4"	1.02"

Examples of devices that can be used to weld these CleanTECH™ valves would be those that are equivalent to the ARC Machines models M8 and M9. (Photo below, right)

The pictures below show a 1/2" SBC9 CleanTECH™ valve mounted on an AMI Model 8 preparing for orbital welding.



Photos courtesy of Arc Machines, Inc.

If you have any questions in regards to SBC9 orbital welding techniques please contact Brett Lewis from [Arc Machines Inc.](http://www.ArcMachines.com)