

Ball Valve Headwork Strip-down & Re-assembly

Installation, Operation and Maintenance Manual

Reference Number:	IOM 012	Date:	31 August 2011	Issue:	A
-------------------	---------	-------	----------------	--------	---



Bestobell Valves, President Park, President Way,
Sheffield, South Yorkshire, S4 7UR
Tel: +44 (0) 114 224 0000 Fax: +44 (0) 114 278 4974
info@bestobellvalves.com www.bestobellvalves.com

Bestobell Valves Inc, 270 Meadowlands Blvd
Washington, PA 15301
Tel: +1 724 746 3750 Fax: +1 724 746 0940
sales@confloflowusa.com www.bestobellvalves.com

Ball Valve Headwork Strip-down & Re-assembly

Reference Number:	IOM 012	Date:	31 August 2011	Issue:	A
-------------------	---------	-------	----------------	--------	---

WARNING!

BEFORE ANY INSTALLATION AND MAINTENANCE WORK CAN COMMENCE ENSURE THE VALVE AND SURROUNDING SYSTEM IS DRAINED OF PRESSURE AND ISOLATED.

Ball Valve Headwork Strip-down & Re-assembly

Reference Number:	IOM 012	Date:	31 August 2011	Issue:	A
-------------------	---------	-------	----------------	--------	---

Contents

Disclaimer	4
Introduction	5
Outline.....	5
Safety	5
Cleanliness.....	6
Service Intervals.....	7
Installation	7
Installation Overview	8
Preparation.....	9
Hardware Description.....	10
Features and Benefits	10
Installation and Maintenance.....	11
Spares Kit.....	11
Torque Table – Joining Bolts.....	12
Lever Operation Torques	12
Installation & Maintenance	13
Installation & Maintenance	13
Refit / Refurbishment Method.....	16
Refit / Refurbishment Method.....	16
Refit / Refurbishment Method.....	16
Refit / Refurbishment Method.....	16
Appendix 1 – Nordlock Washers	20
Contact Details.....	21
Service Record.....	22

Ball Valve Headwork Strip-down & Re-assembly

Reference Number:	IOM 012	Date:	31 August 2011	Issue:	A
-------------------	---------	-------	----------------	--------	---

Disclaimer

PLEASE NOTE:

If the valves produced by Bestobell Valves/LNG are refurbished by a third party organisation that is not approved by Bestobell Valves/LNG, then the safety and performance will not be guaranteed and the warranty may be invalid.

If unsure about the installation and operation procedures for this valve, please contact Bestobell Valves/LNG.

Bestobell Valves has produced this manual in order to provide engineering personnel with sufficient general information to enable the operation, installation and effective maintenance of the valve manufactured by Bestobell Valves.

In the interest of product development, the designs and specifications for our products are constantly under review and we therefore reserve the right to make changes and improvements without notice.

This manual and the copyright therein are the property of PRESIDENT ENGINEERING GROUP and all information that it contains is confidential.

This manual must not be reproduced or disclosed nor must any information taken there from be disclosed, without prior consent in writing of PRESIDENT ENGINEERING GROUP.

This document has been authorised for use by:

Name:	M. ROBINSON
Title:	ENGINEERING MANUAL
Signed:	<i>M. Robinson</i>
Date:	6/9/11

Ball Valve Headwork Strip-down & Re-assembly

Reference Number:	IOM 012	Date:	31 August 2011	Issue:	A
-------------------	---------	-------	----------------	--------	---

Introduction

Outline

This manual is broken down into separate sections:

- **Introduction**

This section provides information about important safety requirements as well as highlighting the precautions taken at Bestobell Valves to ensure the cleanliness of our products. Details regarding servicing are also introduced.

- **Installation**

This details the method of installing the valve on site, and includes information on storage, unpacking and inspection. Preparation of the valve and site is also discussed to allow ease of installation and operation.

- **Hardware Description**

Introduces the product as well as providing a more detailed description including operating conditions and suitable media. Any further requirements for the effective operation of the valve are also discussed.

- **Maintenance**

Provides information relating to the on-site maintenance of the supplied valve, as well as discussing common problems and solutions.

Safety

Read and understand these instructions before installing the valve. Improper installation, operation or maintenance by the owner or operator of this valve can result in personal injury.

Only use genuine Bestobell Valves spares to ensure safe and optimum performance.

Prior to the installation of the valve into the system and any maintenance work, ensure the system is de-pressurised and isolated for the duration of the installation and during any subsequent maintenance.

The valve must be installed within a system that has adequate draining and venting provisions.

In cryogenic applications the area of pipe-work to receive the valve must be allowed to reach ambient temperature.

It is essential that the installers and operators are conversant with all of the safety issues relating to the medium within the system, and are fully trained to an adequate standard.

Ball Valve Headwork Strip-down & Re-assembly

Reference Number:	IOM 012	Date:	31 August 2011	Issue:	A
-------------------	---------	-------	----------------	--------	---

Wear safety glasses and gloves during any installation or operation of the valve.

Valves must only be used in a circuit protected by suitable equipment.

The valve should be inspected for wear as part of a regular system maintenance programme.

Cryogenic burns can occur if the valve is handled during or after the valve has operated.

Minor leaks from the outlet side of the valve, if allowed to build up in a confined area, can be hazardous. This can be avoided by dissipating into the atmosphere or a well ventilated area.

If valve is to be installed in hazardous climatic conditions or seismic areas, please inform Bestobell Valves Ltd.

Identify the intended flow direction and match the valve orientation with its flow direction arrow.

Ensure that all end connections to the valve are in line and that the pipe work is supported to reduce unwanted stresses, loading and vibration on the valve and system pipe work.

Ensure that all joining materials / components used during the installation of the valve are compatible, and will not cause any deterioration to the valve structure.

When using on CO₂, the internal atmosphere must be dry and moisture free as any bronze components could be affected by carbonic acid.

DO NOT check leaks with hands.

Cleanliness

Immediately after assembly in a controlled clean room, the valve is sealed in an airtight plastic bag to maintain cleanliness. As such, it is essential to maintain this cleanliness throughout all stages of installation. Particular care should be taken not to contaminate the internals of the valve with grease, moisture, grinding dust, weld/brazing spatter etc.

Clean practices will save time later with reduced 'flushing' and maintenance.

Ball Valve Headwork Strip-down & Re-assembly

Reference Number:	IOM 012	Date:	31 August 2011	Issue:	A
-------------------	---------	-------	----------------	--------	---

Service Intervals

Bestobell Valves recommends that a major service is carried out on its valves in line with the procedures contained in this manual every 2 years.

In addition to this, a regular inspection should take place to ensure correct operational condition.

Regular inspections are suggested on a monthly basis and maintenance work should be carried out in line with this service manual.

In addition to the scheduled servicing, the valve gland packing should be replaced after 40 000 operations in cryogenic conditions.

It is recommended that the Service Record Sheet enclosed be fully completed at every service interval.

Installation

Personnel carrying out Assembly / Joining / Welding / Inspection must be adequately trained and hold the necessary approvals.

Valves should be installed in a vertical position and not less than 30° from horizontal. (for angles less than 30°, longer extension may be required, please contact Bestobell Valves)

Ensure that environmental conditions (atmospheric pollution) are compatible with the valve materials.

(NOTE: Ensure there is enough space around the valves installed position to allow the removal and refit of the headwork / valve)

Ball Valve Headwork Strip-down & Re-assembly

Reference Number:	IOM 012	Date:	31 August 2011	Issue:	A
-------------------	---------	-------	----------------	--------	---

Installation Overview

The quality of performance in service is a function of the care taken to ensure good installation. A careful study of these instructions is therefore recommended, as properly installed equipment will normally operate for long periods without problems.

The most critical point in the lifetime of a valve is the time of installation, therefore, proper care at this stage and during any maintenance will increase the probability of trouble free valve service.

It is important to maintain cleanliness throughout all stages of the installation, with particular care being taken not to contaminate the internals of the valve with grease, moisture, grinding dust, weld / brazing spatter or other foreign matter.

Clean practices will save time later with reduced 'flushing' and maintenance.

STORAGE:

The equipment packing cases are **NOT** waterproof and should be stored in a weatherproof location before use.

UNPACKING:

It is recommended that before any item is unpacked, it should be moved as close as possible to its installed position. This will minimise the possibility of damage during handling.

It is further recommended that each item should only be unpacked immediately before it is required.

Before installation the engineer should check for:

- Damaged Packaging
- Bent or Distorted Items
- Scratches, Dents or Damage

Particular attention should be paid to the sealing faces on the end connection flanges.

TOOLS REQUIRED:

No special tooling is required for the installation of this valve.

Ball Valve Headwork Strip-down & Re-assembly

Reference Number:	IOM 012	Date:	31 August 2011	Issue:	A
-------------------	---------	-------	----------------	--------	---

Preparation

WARNING!

BEFORE ANY INSTALLATION AND MAINTENANCE WORK CAN COMMENCE ENSURE THE VALVE AND SURROUNDING SYSTEM IS DRAINED OF PRESSURE AND ISOLATED.

Remove the valve centre section before installation to protect the internals of the valve from particulate contamination.

Also ensure that enough room is left above / around the valve for the headwork once this is replaced after installation.

Identify the intended flow direction and ensure the valves flow direction matches this.

Ensure that all end connections to the valve are in line and that the pipe work is supported to reduce unwanted stresses, loading and vibration on the valve and system pipe work.

Ensure that all joining materials / components used during the installation of the valve are compatible, and will not cause any deterioration to the valve structure.

Ball Valve Headwork Strip-down & Re-assembly

Reference Number:	IOM 012	Date:	31 August 2011	Issue:	A
-------------------	---------	-------	----------------	--------	---

Hardware Description

All materials used are selected for their suitability to function at cryogenic temperatures. All valves are degreased for oxygen duty, assembled in clean room conditions, and sealed in robust polythene bags prior to despatch.

Maximum Working Pressure: 50 Bar (725 psi).
Temperature Range: +65°C to -196°C or + 150°F to -320°F

Only suitable for operation with media: - O₂, N₂, Ar, CO₂, He, Kr, Ne, H₂, C₂H₄ and N₂O.

When using on CO₂, the internal atmosphere must be dry and moisture free as bronze could be affected by carbonic acid.

A stainless steel three-piece ball valve designed specifically for cryogenic applications. Available with socket weld and butt weld ends. A bronze body version is also available.

The valve can be operated either manually by a lever or an electric or pneumatic actuator can be fitted.

Features and Benefits

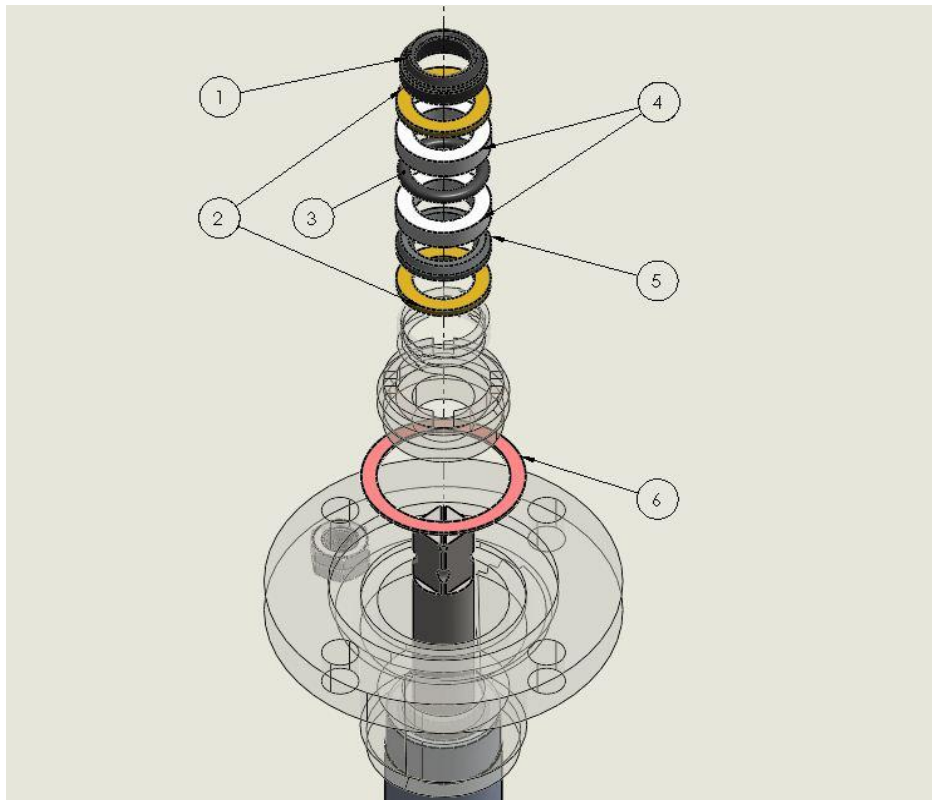
- Spring loaded gland seal giving low torque levels under both ambient and cryogenic conditions.
- Precision investment cast body with a smooth surface finish.
- One piece anti blow-out stem.
- Relief hole to prevent trapping of liquefied gases.
- Designed to prevent incorrect, and hence dangerous, re-assembly after stripping for maintenance.
- Removable centre section designed to industry standard dimensions, allowing the interchange of assemblies in existing installations.
- Suitable for retro fitting of electric, or pneumatic, actuators allowing fast, remote automatic operation.
- Fast, easy maintenance of PTFE components.

Ball Valve Headwork Strip-down & Re-assembly

Reference Number:	IOM 012	Date:	31 August 2011	Issue:	A
-------------------	---------	-------	----------------	--------	---

Installation and Maintenance

Spares Kit



Reference	Description	Spares Kit
1	Wiper Seal	Contact Bestobell Valves Technical Sales
2	Plain Washer	
3	'O' Seal	
4	Top Chevron	
5	Bottom Chevron	
6	Gasket	
7	Wiper Seal	
	Seal to Ball	

Ball Valve Headwork Strip-down & Re-assembly

Reference Number:	IOM 012	Date:	31 August 2011	Issue:	A
-------------------	---------	-------	----------------	--------	---

Torque Table – Joining Bolts

Valve Size		Bolt Torque
Full Bore (FB)	Standard Bore (RB)	
10	15	9 NM (6.7 lb.ft)
20	25	16 NM (12 lb.ft)
32	40	33 NM (24 lb.ft)
40	50	55 NM (41 lb.ft)
65	80	270 NM (200 lb.ft)

- Apply torques progressively and in sequence.
- Only use PTFE based lubricants.
- Torque specified is for lubricated Stainless Steel fasteners.
- On Cryogenic applications, ONLY use specified Stainless Steel fasteners.
- **NOTE:** For 65mm full and 80mm standard bore ball valves, see Appendix 1 for the assembly instructions when the flanges are fitted with Nordlock washers.

Lever Operation Torques

Valve Size	Maximum Torque
DN15 (RB)	17.5 NM (13 lb.ft)
DN25 (RB)	23 NM (17 lb.ft)
DN40 (RB)	40 NM (30 lb.ft)
DN50 (RB)	62 NM (46 lb.ft)
DN80 (RB)	102 NM (75 lb.ft)

Ball Valve Headwork Strip-down & Re-assembly

Reference Number:	IOM 012	Date:	31 August 2011	Issue:	A
-------------------	---------	-------	----------------	--------	---

Installation Method

STEP 1:

Welded End Connections:

If welding of pipe work to end covers is to take place, it is recommended that the valve centre section is removed. To remove the centre section, ensure the valve is in the open position and remove the body connector bolts. Then carefully remove the centre section from the end covers. Ensure all parts removed are protected from weld spatter and other debris.

Weld the end covers into the pipeline, ensuring that the correct separation is achieved between the end covers and that the pipe work and bolt holes are aligned correctly. After completion, check the welded end connections, ensure the gasket surfaces are clean and system pipe work is thoroughly flushed. Replace the centre section of the valve carefully; ensuring that the gasket faces are not damaged. Replace the connector bolts, locking washers and nuts. Tighten sequentially to the torque values shown in the table.

Note: Please ensure that the relief hole in the ball is facing upstream when the valve is in the closed position. Also ensure when the valve is installed in the pipeline that the flow arrow is pointing downstream.

Ensure all end connections to the valve are in line and that pipe work is supported to reduce unwanted stresses / loading and vibration on the valve and system pipe work.

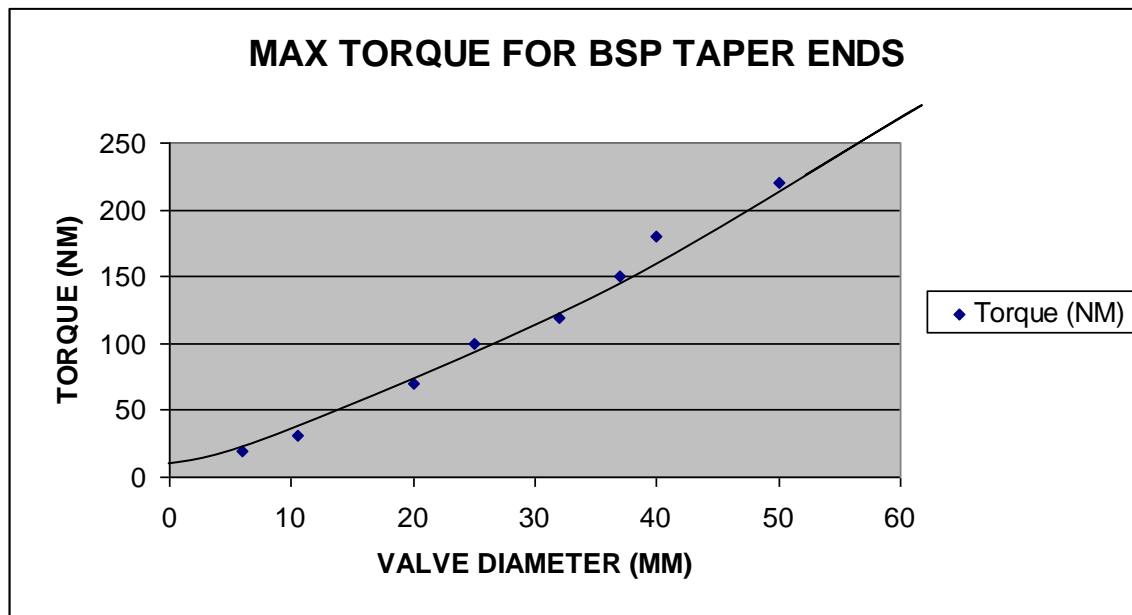
Ensure that all joining materials / components used during the installation of the valve are compatible and will not cause any deterioration to the valve structure.

Ball Valve Headwork Strip-down & Re-assembly

Reference Number:	IOM 012	Date:	31 August 2011	Issue:	A
-------------------	---------	-------	----------------	--------	---

Taper Threaded End Connections:

For valves with taper threaded end connections a good quality PTFE thread tape may be used. Firstly, tighten the end connections by hand to reduce the risk of cross threads before finally tightening with a suitable torque wrench. (See torque graph for female taper threads).



Flanged End Connections:

Tighten the flange fasteners progressively and in sequence, at the same time as checking the alignment of mating flanges.

STEP 2 (Re-fitting the Centre Section):

After completion, check the welded end connections, ensure the gasket surfaces are clean and system pipe work is thoroughly flushed. Replace the centre section of the valve carefully; ensuring gasket faces are not damaged. Replace the connector bolts, locking washers and nuts. Tighten sequentially to the torque values shown in the table.

Ball Valve Headwork Strip-down & Re-assembly

Reference Number:	IOM 012	Date:	31 August 2011	Issue:	A
-------------------	---------	-------	----------------	--------	---

STEP 3 (Testing):

Before introducing pressure to the valve, carry out a thorough inspection of all connections: welded and/or threaded. Once pressure is introduced to the valve, a method appropriate to the medium being carried by the system should be employed to test for leaks.

Never use hands to test for leaks!

Step 4 (Operation):

Check that the valve fully opens and closes smoothly by hand. If difficulty is experienced, refer to the troubleshooting section of this manual.

Note: If unsure about the installation and operation of this valve please contact Bestobell Valves before you continue.

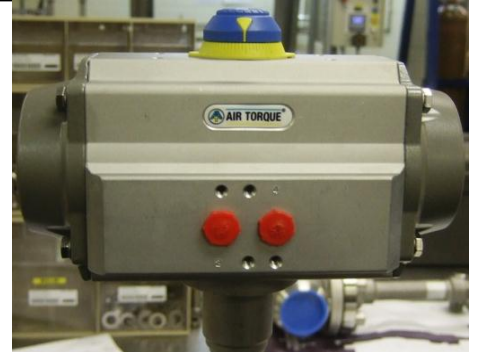
Ball Valve Headwork Strip-down & Re-assembly

Reference Number:	IOM 012	Date:	31 August 2011	Issue:	A
-------------------	---------	-------	----------------	--------	---

Refit / Refurbishment Method

STEP 1:

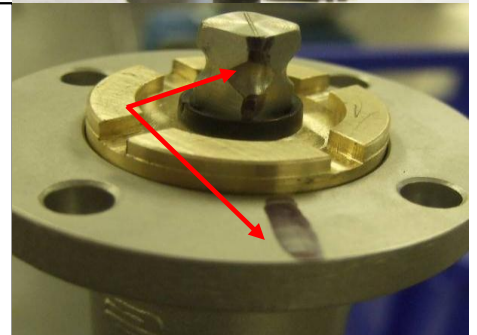
Remove the actuator fitted to the valve.



STEP 2:

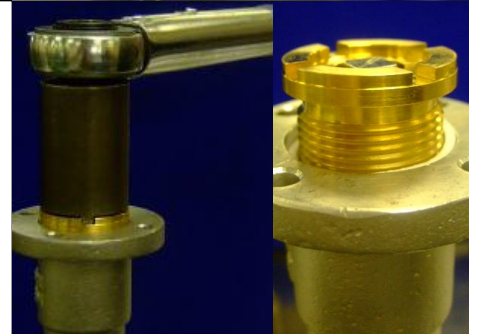
Mark the stem and the body (as shown).

This is to be used as a point of reference, this should help ensure the stem and ball remain in the correct orientation when the valve is re-assembled.



STEP 3:

Unscrew the gland follower from the body.



Ball Valve Headwork Strip-down & Re-assembly

Reference Number:

IOM 012

Date:

31 August 2011

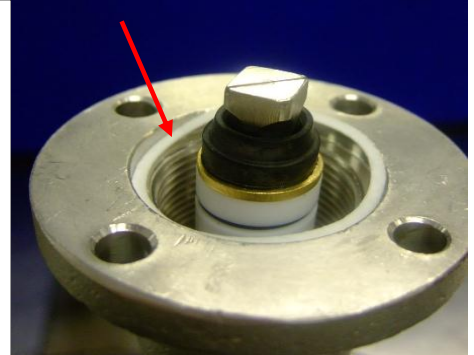
Issue:

A

STEP 4:

Remove all packings, including wiper seals, brass washers and the gasket, taking care not to damage the stem or gland area.

Discard old packings and gasket.

**STEP 5:**

Remove the spring, clean the spring and replace it.

**STEP 6:**

From the replacement kit, take the Plain Washer and slide it over the Stem.

**STEP 7:**

From the replacement kit, take the Bottom Chevron and slide it over the Stem.



Ball Valve Headwork Strip-down & Re-assembly

Reference Number:

IOM 012

Date:

31 August 2011

Issue:

A

STEP 8:

From the replacement kit slide the Top Chevron over the stem.

**STEP 9:**

From the replacement kit slide the O Seal down the Stem.

**STEP 10:**

From the replacement kit, slide the second Top Chevron down the Stem.

**STEP 11:**

From the replacement kit, slide the second Plain Washer down the Stem.



Ball Valve Headwork Strip-down & Re-assembly

Reference Number: IOM 012 Date: 31 August 2011 Issue: A

STEP 12:

Finally, from the replacement kit, slide the Wiper Seal after the Plain Washer and place the Gasket in the groove.



STEP 13:

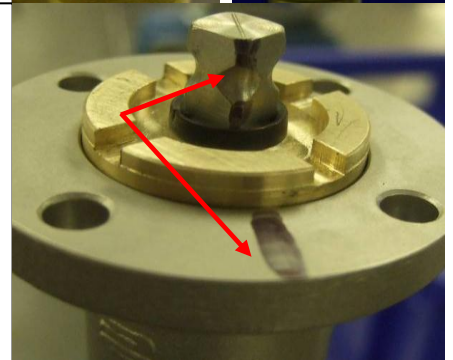
Screw the Gland Follower into the top of the Body.

Valve Size	Gland Follower Tightening Torque
DN15 (1/2") – DN25 (1")	50 NM (37 lb.ft)
DN40 (1 1/2") – DN50 (2")	70 NM (52 lb.ft)



STEP 14:

Ensure the lines marked at the start of the process are aligned before the actuator is replaced.



STEP 15:

Replace Actuator.

Tighten the actuator securing screws to 9NM.



Ball Valve Headwork Strip-down & Re-assembly

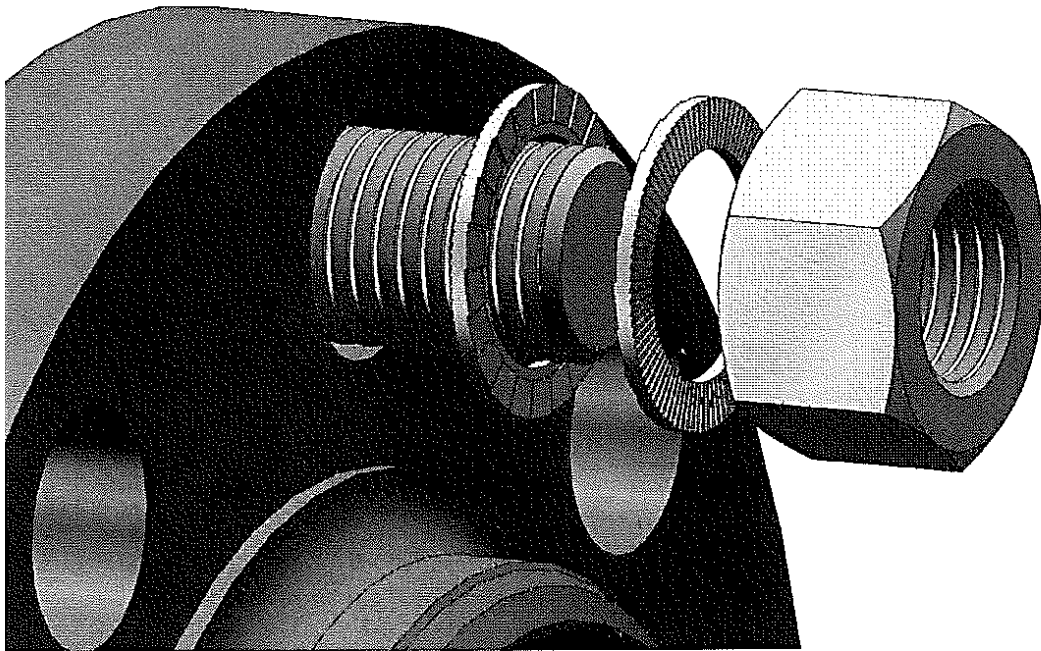
Reference Number:	IOM 012	Date:	31 August 2011	Issue:	A
-------------------	---------	-------	----------------	--------	---

Appendix 1 – Nordlock Washers

Assemble the Nordlock washers in pairs, as shown, so that the angled serrations lock together. Screw nuts onto the studs loosely and ensure the valve body, gaskets and flanges are in the correct position.

The nuts should then be progressively tightened to the torque specified in the table on page 19.

A periodic check should be carried out on fasteners once every 6 months to ensure that the nuts are tight to the specified torque.



Ball Valve Headwork Strip-down & Re-assembly

Reference Number:	IOM 012	Date:	31 August 2011	Issue:	A
-------------------	---------	-------	----------------	--------	---

Contact Details

For further maintenance instructions and spares contact:

United Kingdom Enquiries:

Bestobell Valves/LNG
President Park,
President Way,
Sheffield,
South Yorkshire,
S4 7UR,
England.

Tel: +44(0)114 2240263

Fax: +44(0)114 2784974

Email: info@bestobell-lng.com / sales@bestobellvalves.com

Web: www.bestobell-lng.com / www.bestobellvalves.com

United States Enquiries:

Bestobell Valves Inc
270 Meadowlands Blvd,
Washington,
PA 15301.

Tel: +1 724 746 3750

Fax: +1 724 746 0940

Email: sales@conflowusa.com

Web: www.bestobellvalves.com

