



INITIAL RELEASE E.O.:		E.O. 29049	PART NUMBER		55501374	REV.	B
REV.	DESCRIPTION			INCRP BY	DATE		
B	E.O. 32703			<i>DD</i>	2/17/05		

INSTRUCTIONS FOR REPAIR OF HANDLE-TYPE 16 SERIES DIAPHRAGM PACKLESS VALVES

WARNING: THIS PROCEDURE MAY ADVERSELY AFFECT THE CLEANLINESS FOR THE VALVE AND SHOULD BE PERFORMED ONLY BY PERSON THOROUGHLY FAMILIAR WITH THE VALVE'S END USE.

1. MAKE SURE VALVE IS FULLY OPEN. DISASSEMBLE THE VALVE. REMOVE HANDLE, BONNET NUT, UPPER STEM AND BUTTON. REMOVE OLD DIAPHRAGMS AND LOWER STEM & SPRING SUBASSEMBLY. ENSURE THAT NO FOREIGN MATTER CONTAMINATES INSIDE OF THE VALVE.
2. INSERT NEW LOWER STEM & SPRING SUBASSEMBLY INTO SEAT CHAMBER.
3. ASSEMBLE NEW DIAPHRAGMS.
4. PLACE NEW DIAPHRAGMS INTO VALVE, MAKING SURE DOME ON EACH DIAPHRAGM IS UP.
5. DISASSEMBLE BONNET NUT AND UPPER STEM ASSEMBLY. APPLY A SMALL AMOUNT OF FLUOROCARBON GREASE ON THREAD AND BOTTOM OF UPPER STEM AND REASSEMBLE. PLACE THE GUIDE PIN INTO BONNET NUT ALSO.
6. APPLY A SMALL AMOUNT OF FLUOROCARBON GREASE ON EVERY SURFACE OF BUTTON INCLUDING THE SLOT. REASSEMBLE BUTTON WITH BONNET NUT & UPPER STEM ASSEMBLY. MAKE SURE FLAT SIDE FOR BUTTON FACE THE CHAMBER OF BONNET NUT. ALSO MAKE SURE THAT GUIDE PIN IS IN THE SLOT.
7. REPLACE THE WHOLE BONNET NUT, UPPER STEM & BUTTON ASSEMBLY ON THE VALVE. TORQUE BONNET NUT TO: 80 FT-LBS. SST BODIES & 40 FT-LBS BRASS BODIES
8. PUT THE HANDLE BACK ON THE UPPER STEM. TIGHTEN THE HANDLE SET SCREW.
9. REF. P/N ES-REPAIR-16

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES

TOLERANCES ON

FRACTIONS	DECIMALS	ANGLES
±1/64	.XX = ±.01	±1/2°
	.XXX = ±.005	

MACH. SURF. FLAT WITHIN .001 IN/IN
 CONCENTRICITY MACH. SURF.; TIR WITHIN 1/2 SUM OF DIAS. TOLERANCES
 REMOVE ALL BURRS
 BREAK SHARP EDGES .015 X 45°. MACHINE FILLETS .01R
 MACHINE FINISH 63 MICRO INCH.
 INTERPRET PER ASME Y14.5M-1994

DO NOT SCALE DRAWING

MATERIAL

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SCALE				----	SHEET 1 OF 1		