

MOUNTING AND OPERATING INSTRUCTIONS



EB 01a

Translation of the original manual



Control valve BR 01a • DIN and ANSI version
to combine with actuators

March 2023 edition



Note regarding this installation and operating manual

This Installation and Operating Manual (EB) provides guidance for safe assembly and operation.

The notes and instructions in this EB are binding when handling PFEIFFER devices. The figures and illustrations in this EB are examples and must therefore be considered as such.

- ⇒ For safe and correct use, read this EB carefully prior to use and keep it for later reference.
- ⇒ In the case of questions that go beyond the scope of this EB, please contact the After Sales Service at PFEIFFER Chemie-Armaturenbau GmbH.
- ⇒ This manual only applies to the valve itself, the respective additional manual applies for the mounted actuator.

Definition of signal words

DANGER

Hazardous situations that lead to death or serious injuries

WARNING

Situations that can lead to death or serious injuries

NOTE

Property damage and malfunctions

Info

Additional information

Tip

Recommended action

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1 Safety instructions and safety measures

Intended use

The BR 01a valve is equipped with a manual gear or in combination with an actuator and intended for the regulation of the volume flow, pressure and temperature of fluid, gaseous or vaporous media.

- The valve and its actuator are designed for precisely defined conditions (e.g. operating pressure, utilised medium, temperature).

Therefore the operator must make sure that the valve is only used when the conditions of use comply with the design criteria defined in the order.

If the operator would like to use the valve in other applications or environments, they must contact PFEIFFER.

- Manual valves are only intended for use, after installation in a pipe system, to cut off the media (mainly corrosive), let it flow through or regulate it within the permitted pressure and temperature limits.
- Automated valves are only intended for use, after installation in a pipe system and after connecting the actuator to the control, to cut off the media (mainly corrosive), let it flow through or regulate it within the permitted pressure and temperature limits.
- The data sheet contains the permissible pressure and temperature range for these valves ► TB 01a.
- The safety regulations that apply to the pipe system in which the valves are installed and to the control system to which the actuator is connected also apply to the valves.

This manual only provides safety instructions that are to be observed additionally for valves.

There may be additional safety instructions in the manuals for the actuator assemblies.

- It is assumed that this chapter is observed when using the valve as intended.

Reasonably foreseeable erroneous use and unintended use

The valve is not suited for the following areas of use:

- Use outside of the technical data and the limits defined by the design.
- Use outside of the limited defined by the peripheral devices installed on the valve.

Furthermore, the following activities are considered unintended use:

- Use of third-party spare parts.
- Performance of maintenance and repair work that is not described.

Qualification of operating personnel

The valve may only be disassembled, dismantled, assembled and commissioned by qualified specialist personnel trained in pressurised pipes who are familiar with the assembly, commissioning and operation of this product.

- Specialist personnel in terms of this installation and operating manual are persons who, on the basis of their vocational education, knowledge and experience and knowledge of the relevant standards, are capable of evaluating the assigned tasks and identifying possible hazards.

Personal protective equipment

Depending on the utilized medium, PFEIFFER recommends the following protective equipment:

- Protective garments, protective gloves and eye protection when using hot, cold, aggressive and/or corrosive media.
- Hearing protection when working near the valves.
- Request additional protective equipment from the plant operator.

Prohibition of modifications

Changes to the product are not permitted without consulting PFEIFFER. Non-compliance invalidates the warranty and product guarantee. PFEIFFER shall not be held liable for any resulting property damage or personal injury.

Protective devices

In the case of a power supply failure, the automated valve automatically switches to a certain fail-safe position, see "Fail-safe positions" in Chapter "3 Design and principle of operation".

- The fail-safe position corresponds to the effective direction and is indicated on the type plate of SAMSON actuators, see the actuator documentation.
- The valve is to be included in the equipotential bonding of the plant.

Warning of residual risks

To prevent personal injury or property damage, the operator and operating personnel must use suitable measures to prevent the hazards that can result from the flow medium and operating pressure as well as the signal pressure and moving parts of the valve.

- Therefore, the operator and operating personnel must observe all the hazard information, warning information and information in this installation and operating manual.

Obligation of the operator to exercise diligence

The operator is responsible for proper operation as well as compliance with the safety regulations.

- The operator is responsible for providing operating personnel with this installation and operating manual as well as the applicable documents and to provide instructions on proper operation.
- Furthermore, the operator must ensure that operating personnel and third parties are not endangered.

It is not the responsibility of PFEIFFER and therefore when using the valve ensure that:

- The valve is only used as intended as described in this chapter.

- A actuator unit that is subsequently installed on the valve is adapted to the valve and is correctly adjusted in the end positions, and in particular in the closed position of the valve.
- The pipe system and control system are properly installed and regularly checked. The wall thickness of the valve body is measured such that an additional load of the usual magnitude is taken into account for a pipe system installed properly in this way.
- The valve is connected properly to these systems.
- The customary flow rates in continuous operation are not exceeded in this pipe system.
- PFEIFFER is contacted in the case of abnormal operating conditions, such as vibrations, hydraulic shock, cavitation and also small amounts of solid matter in the medium, especially abrasive matter.

Obligation of operating personnel to exercise diligence

Operating personnel must be familiar with this installation and operating manual and the applicable documents and comply with the indicated hazard information, warning information and other information. Furthermore, operating personnel must be familiar with the applicable regulations concerning occupational safety and accident prevention and observe them.

Applicable standards and directives

- The valves fulfil the requirements of the European Pressure Equipment Directive 2014/68/EU and the European Machinery Directive 2006/42/EC.
In the case of valves provided with a CE marking, the Declaration of Conformity provides information about the conformity assessment procedure that was used.
The corresponding declarations of conformity are available in the Annex of this EB, see chapter "14 Certificates".
- According to an ignition hazard assessment according to DIN EN ISO 80079-36, PFEIFFER valves do not have any own potential ignition sources and therefore are not subject to Directive 2014/34/EU.
CE marking based on this standard is not permitted. The inclusion of valves in the equipotential bonding of a plant applies independently of the directive for all metal parts in potentially explosive areas.
Valves with plastic lining (PFA, PTFE) through which chargeable media flows during operation, must be provided with an electrostatically dissipative plastic lining whose surface resistance does not exceed a value of 1 G Ω (10⁹ Ω) in accordance with DIN EN ISO 80079-36.

1.1 Notes regarding possible severe personnel injury

DANGER

Hazards and ineffectiveness of the warranty!

In the case of non-compliance with the following hazard and warning information, hazards may arise and the warranty provided by PFEIFFER may become invalid.

- ⇒ Observe the following hazards and warning information.
- ⇒ Contact PFEIFFER in the case of questions:

Hazards and damage due to unsuitable valves!

Valves whose permissible pressure/temperature range (= "rating") is not sufficient for the operating conditions can pose a danger to the user and cause damage to the pipe system.

- ⇒ Only operate valves whose permissible pressure/temperature range (= "rating") are sufficient for the operating conditions, see the data sheet ► TB 01a)

Risk of bursting of the pressure equipment!

Valves and pipes are pressure equipment. Improper opening can cause the bursting of valve components.

- ⇒ Observe the maximum permissible pressure the valve and plant.
- ⇒ Before working on the valve, depressurise the concerned plant parts and the valve.
- ⇒ Before removing the valve from the pipe, completely release the pressure in the pipe so that the medium does not escape uncontrolled from the line.
- ⇒ Empty the medium from the concerned plant parts and valve. (Wear protective equipment).

1.2 Notes regarding possible personnel injury

WARNING

Hazards due to incorrect valve use!

The incorrect use of the valve can represent a hazard for the user and cause damage to the pipe system that are then no longer the responsibility of PFEIFFER.

- ⇒ The lining selected for the parts of the valve that come into contact with the media must be suitable for the utilised media, pressures and temperatures.

Danger of burning due to hot or cold components and pipes!

Depending on the utilised medium, valve components and pipes can become very hot or very cold and cause burns upon contact.

- ⇒ Valves must be protected against contact in the case of operating temperatures >+50°C or <-20°C together with the pipe connections.

! WARNING**Danger of crushing due to moving parts!**

The valve contains moving parts (actuator and plug stem) that can lead to crushing if reaching into it.

- ⇒ Do not reach into the yoke during operation.
- ⇒ When working on the valve, interrupt and lock pneumatic energy and the control signal.

Danger of injury during the switching operation if performing test runs on valves not installed in the pipe!

- ⇒ Do not reach into the valve. This can result in serious injuries.

Danger of injury due to venting the actuator!

During operation, when regulating or opening and closing the valve, the actuator can be ventilated.

- ⇒ Install the valve such that the actuator does not ventilate at eye level.
- ⇒ Use suitable silencers and plugs.
- ⇒ Wear eye protection and, if necessary, hearing protection when working near the valve.

Danger of injury due to prestressed springs!

Valves that are equipped with preloaded actuator springs are under mechanical tension. These valves, in combination with the pneumatic SAMSON actuators, can be identified by the elongated screws on the bottom of the actuator.

- ⇒ Before working on the actuator, release the compression from the preloaded springs, see the corresponding actuator documentation.

Danger of injury due to residual medium in the valve!

When a valve must be removed from a pipe, medium can escape from the pipe or the valve.

- ⇒ In the case of media that is harmful to health or hazardous, the pipe must be completely emptied before a valve can be removed.
- ⇒ Pay attention to the afterflow of residuals or residuals that remain in dead spots.

Danger of injury due to the releasing of body screw connections!

If the body screw connections must be released, medium can escape from the valve.

- ⇒ The screw connections on the connection of the body and bonnet flange may only be released or loosened after the valve has been removed.
- ⇒ During reassembly, tighten the screws according to Table 15-1 in Chapter "15.1.1 Tightening torques" using a torque wrench.

Dangers due to use as an end fitting!

During normal operation, in particular with gaseous, hot and/or hazardous media, spraying medium can cause hazards. It must be kept in mind that the media is usually hazardous!

- ⇒ A blind flange must be assembled on the free connecting pieces or the valve must be secured against unauthorized actuation.
- ⇒ If a valve used as an end fitting in a pressurised line is opened, this may only be done with extreme caution so that the escaping medium does not cause any damage.

! WARNING**Deviation of the breakaway and actuating forces due to non-actuation of the valve!**

Depending on the period of time of non-actuation, the breakaway and actuation forces can deviate considerably from the actuating power data in the data sheet.

It is recommended to actuate the valve at regular intervals.

- ⇒ In consideration of the design, actuation must take place during the year.
- ⇒ Indicate the duration of non-actuation when making an enquiry, so that this condition is taken into consideration in the actuator design.
- ⇒ In the case of retrofitted actuators by the operator, the correct actuator design as regards the duration of non-actuation is no longer the responsibility of PFEIFFER.

1.3 Notes regarding possible property damage

! NOTE**Damage to the valve due to contamination!**

Contamination (e.g. solid particles) in the pipes can damage the valve.

- ⇒ The plant operator is responsible for cleaning the pipes in the plant.
- ⇒ Rinse the pipes prior to commissioning.
- ⇒ Observe the maximum permissible pressure the valve and plant.

Damage to the valve due to unsuitable medium properties!

The valve is designed for a medium with certain properties.

Other media can damage the valve.

- ⇒ Only use a medium that corresponds to the design criteria.

Damage to the valve and leakage due to excessively high or low tightening torques!

The valve components must be tightened with specific torques.

Deviating torques can lead to valve leakage or damage.

- ⇒ Excessively tightened components are subject to increased wear.
- ⇒ Insufficiently tightened components can cause leakage.
- ⇒ Observe the tightening torques, see Table 15-1 in Chapter "15.1.1 Tightening torques".

Damage to the valve due to unsuitable tools!

Unsuitable tools can damage the valve.

- ⇒ Suitable tools are required to work on the valve, see Chapter "15.1.3 Tools".

! NOTE

Damage to the valve due to unsuitable lubricants!

Unsuitable lubricants can corrode and damage the surface.

⇒ The valve material requires suitable lubricants, see Chapter "15.1.2 Lubricants".

1.4 Warning notes on the device

Warning of moving parts

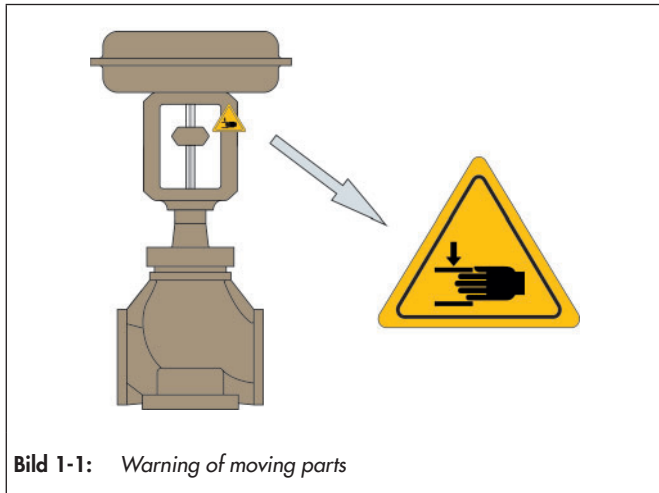


Bild 1-1: Warning of moving parts

There is a danger of crushing due to the lifting movements of the actuator and plug stem when reaching into the yoke as long as the pneumatic power is connected to the actuator.

2 Markings on the device

Each valve using has the following marking.

Table 2-1: Marking on the type plate and on the body of the valve

Pos.	For	Marking	Remark
1	Manufacturer	PFEIFFER	Address see Chapter "15.3 Service"
2	Valve type	BR (and number value)	e.g. BR 01a = Series 01a, see the PFEIFFER catalogue
3	Body material	e.g. EN-JS 1049	No. of the material standard according to DIN EN 1563 (previous: GGG 40.3)
4	Size	DN (and number value)	Number value in [mm], e.g. DN50 / number value in [inches], e.g. NPS2
5	Maximum pressure	PN (and number value)	Number value in [bar], e.g. PN10 / number value in [inches], e.g. c150 at room temperature
6	Max. permissible operating temperature	TS (and number value)	PS are TS are related values here at the max. permissible operating temperature with the max. permissible operating overpressure, see the Pressure-Temperature Diagram on the data sheet ▶ TB 01a
	Max. permissible operating pressure	PS (and number value)	
7	Test pressure	PT (and number value)	The test pressure must be observed depending on the device
8	Manufacturer number from 2018	e.g. 381234/001/001	<p>38 1234 /001 /001</p> <p>Valve no. within the item</p> <p>Item in the order</p> <p>Order</p> <p>Year of manufacture (38=2018, 39=2019, 30=2020, 31=2021 etc.)</p>
	Manufacturer number 2009 to 2017	e.g. 211234/001/001	<p>21 1234 /001 /001</p> <p>Valve no. within the item</p> <p>Item in the order</p> <p>Order</p> <p>Year of manufacture (29=2009, 20=2010, 21=2011, 22=2012 etc.)</p>
	Manufacturer number until 2008	e.g. 2071234/001/001	<p>207 1234 /001 /001</p> <p>Valve no. within the item</p> <p>Item in the order</p> <p>Order</p> <p>Year of manufacture (205=2005, 206=2006, 207=2007 etc.)</p>
9	Seat diameter	e.g. 24 mm	Number value in [mm]
10	Year of manufacture	e.g. 2018	The year of manufacture is affixed on the valve
11	Plug version	e.g. V-port plug	Marking for "Parabolic plug" or "T-port plug"
12	Lining	e.g. PTFE	Marking for BR 01a "PTFE"
13	Characteristic curve	e.g. =%	Marking for "linear" or "equal percentage"
14	Travel	e.g. 30 mm	Number value in [mm]
15	Kvs	e.g. 25	Number value in [m ³ /h]
16	DataMatrix code		
17	Conformity	CE	Conformity is certified separately by PFEIFFER
	Code No.	0035	"Notified body" according to EU Directive = TÜV Rheinland Service GmbH
18	Flow direction	➔	Attention: see the note in Chapter "5.4 Installing the valve in the pipe"
19	Test point number	e.g. F123201-1	Specified by the customer
20	Materials		Materials outside of the standard in the case of parts in contact with the media

i Info

Markings on the body and the type plate must be permanent so that the valve remains identifiable.

2.1 Type plates

2.1.1 Valve type plate

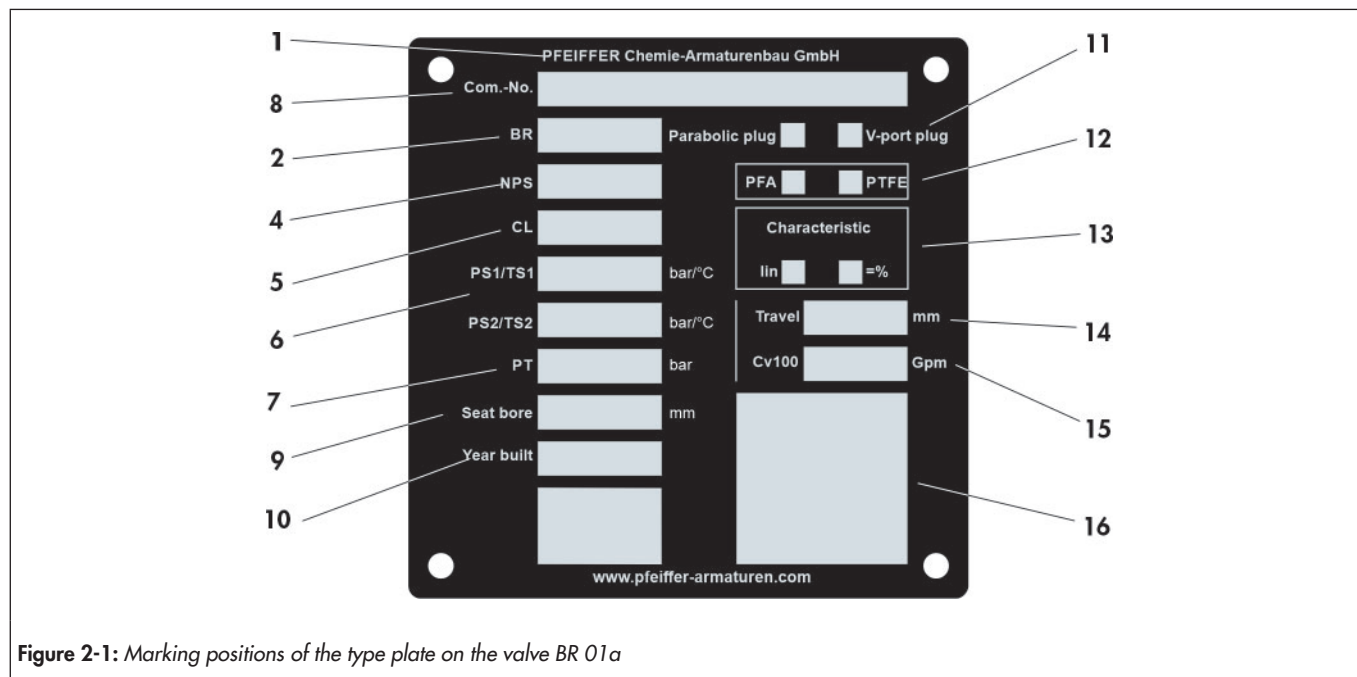


Figure 2-1: Marking positions of the type plate on the valve BR 01a

2.1.2 Actuator type plate

See the corresponding actuator documentation.

2.2 Material marking

The valves are marked on the body with material specification, see Table 2-1.

Further specifications can be requested from PFEIFFER.

3 Design and principle of operation

Function and principle of operation

The medium flows through the valve against the closing direction.

The position of the plug determines the cross-sectional area between the plug (13) and the seat (4).

The plug is connected via the stem (16) to the actuator stem.

The PTFE bellows (15) seal the area between the valve body (1) and the stem (16).

The graphite packing (26) or PTFE V-ring packing (33) is used for additional stem sealing.

In conjunction with the test connection (24), they allow you to check the bellows (15) e.g. by connecting a suction line or inert gas line.

The plug (13) is easy to replace thanks to the groove-spring connection with the bellows in the form of a PTFE cord (14).

The bottom flange (10) with inlay (7), PTFE washer (6) and spacer (5) house the exchangeable valve seat (4).

! NOTE

Damage to the valve due to cavitation!

The valve can be damaged due to cavitation.

⇒ *At the onset of cavitation or with differential pressures above 3 bar and a differential pressure ratio of $p_2 < \Delta p$, PFEIFFER recommends using a guided plug!*

⇒ *It is also recommended to use fittings made of ceramic or resistant special metals.*

Lined valves are not suitable for operation with cavitation.

Contact PFEIFFER in the case of questions.

Fail-safe positions

Depending on the mounting of the pneumatic actuator, the valve has two fail-safe positions that are activated when the pressure is released as well when the supply air fails:

– Valve with spring-close actuator [STAF]:

If the air supply fails, the valve is closed. The valve opens when the signal pressure increases, acting against the force of the springs.

– Valve with spring-open actuator [STEF]:

If the air supply fails, the valve is opened. The valve closes when the signal pressure increases, acting against the force of the springs.

Changing the fail-safe position

The fail-safe position of the actuator can be reversed if required. To do so, see the installation and operating manual for the respective pneumatic actuator.

Operating elements and functions

The BR 01a valve can be selected in the following versions:

- With a pneumatic SAMSON actuating drive.

- With a manual SAMSON actuator.
- With actuators from other manufacturers.

3.1 Variants

- Valve body warmed with a heating jacket.
- Lining with special compounds, e.g. PTFE-conductive.
- For eroding media, valve plug and valve seat also made of special material (e.g. tantalum, HC4, titanium or Al_2O_3).
- Bellows, stem made of special material (e.g. Hastelloy).
- Further components made of special material.
- Designed for high-permeation media.
- Suitable for crystallising media.
- Low-temperature version for $-40^\circ C$.

3.2 Additional fittings

Strainer

PFEIFFER recommends installing a strainer in front of the valve body. A strainer prevents the solid content in the medium from damaging the valve.

Bypass and shut-off valves

PFEIFFER recommends installing a shut-off valve in front of the strainer as well as behind the valve and to create a bypass. By means of the bypass, the entire plant does not have to be decommissioned during maintenance and repair work on the valve.

Insulation

The valves can be insulated to reduce the passage of heat energy.

Observe the notes in Chapter "5 Assembly".

Test connection

In the version with bellows sealing, a test connection (e.g. $\frac{1}{4}$ " thread) can be used on the upper flange to check the tightness of the bellows.

Grip protection

Under conditions of use that require a high level of safety (e.g. if the valve is freely accessible to untrained specialist personnel), PFEIFFER offers a safety guard to prevent the risk of crushing due to moving parts (actuating drive and plug stem).

The risk assessment of the plant by the operator will indicate if the installation of this protective device is required for the safe operation of the valve in the plant.

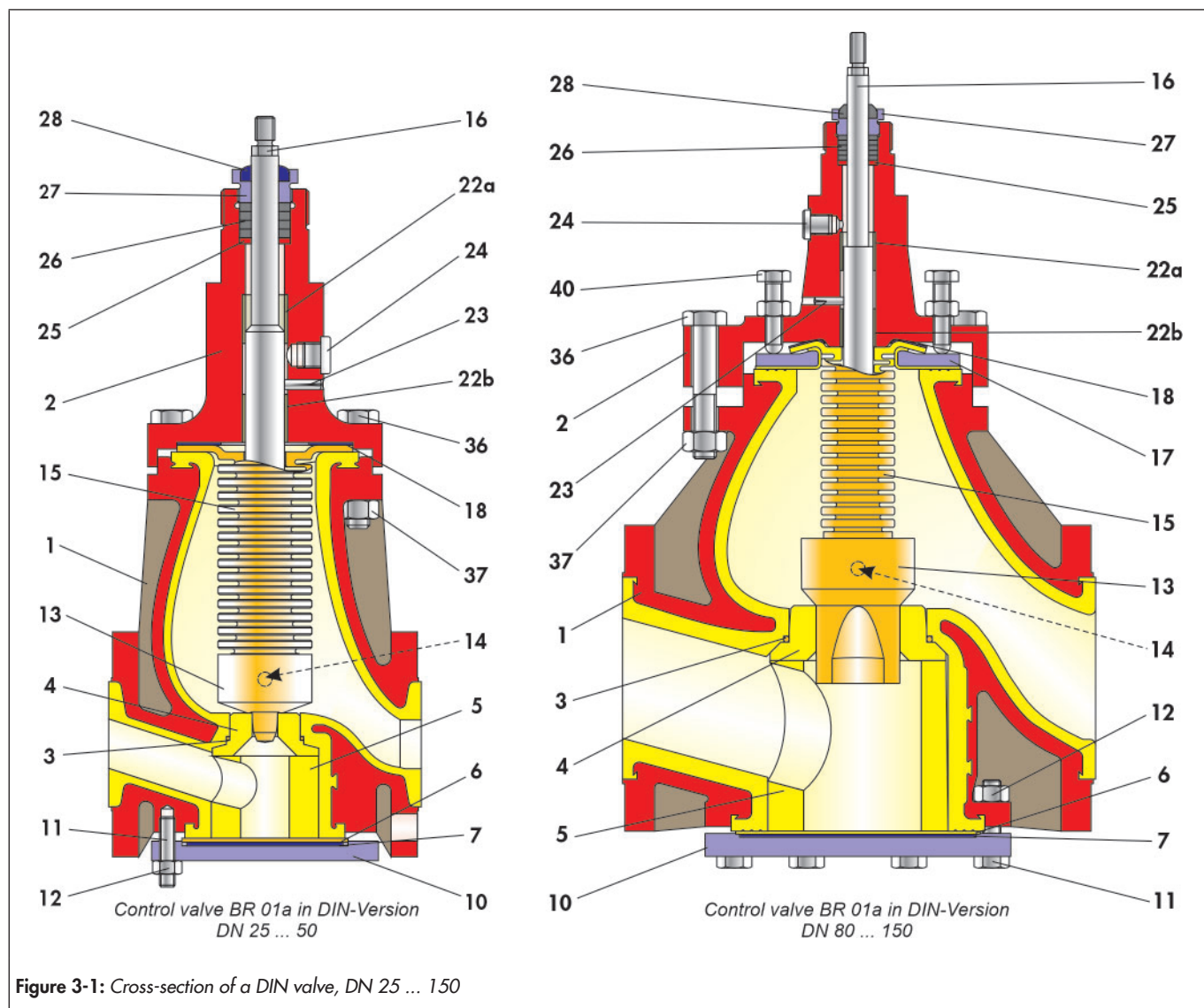


Figure 3-1: Cross-section of a DIN valve, DN 25 ... 150

Table 3-1: Parts list

Item	Designation
1	Valve body
2	Bonnet flange
3	O-ring
4	Seat
5	Spacer
6	Washer
7	Inlay
10	Bottom flange
11	Screw/ stud bolt
12	Nut
13	Plug
14	Cord
15	Bellows
16	Stem

Item	Designation
17	Bordered flange
18	Washer
22	Bushing
23	Grooved pin
24	Locking screw
25	Washer
26	Packing
27	Stuffing box
28	Wiper ring
36	Screw
37	Nut
38	Yoke (not marked)
39	Groove nut (not marked)
40	Support bolts

3.3 Attachments

The following accessories are available either individually or in combinations:

- Positioner
- Limit switch
- Solenoid valves
- Supply air regulator/filter
- Pressure gauge mounting blocks
- Pneumatic volume booster

Other additional equipment is possible according to specifications on request.

3.4 Technical data

The type plates of the valve and actuator give information about the valve version, see Chapter “2 Markings on the device”.

Info

Detailed information is available on the data sheet ► TB 01a.

3.5 Assembling the valve

The current DIN-compliant version of the BR 01a valve has design differences in the stem sealing in comparison to the current ANSI version, so that they cannot be documented in one construction manual.

- **Chapter 3.5.1** describes the assembly of the **DIN valve, DN 25 to 150**.
- **Chapter 3.5.2** describes the assembly of the **DIN valve, DN 200**.
- **Chapter 3.5.3** describes the assembly of the **ANSI valve, NPS 1 to 3** and the **DIN valve, DN 25 to 80** [Edition 2022].
- **Chapter 3.5.4** describes the assembly of the **ANSI valve, NPS 4 to 6**.
- **Chapter 3.5.5** describes the assembly of the **ANSI valve, NPS 8**.

Before assembly

To assemble the valve, all parts must be prepared, e.g. the parts are carefully cleaned and placed on a soft mat (rubber mat or other). Keep in mind that plastic parts are almost always very soft and very delicate, and in particular the sealing surfaces may not be damaged.

Info

The position and arrangement of the individual parts shown in the drawings must be observed during assembly.

NOTE

Damage to the valve due to cold welding of the screws in the body!

PFEIFFER recommends a heavy-duty grease paste (e.g. Gleitmo 805, manufacturer Fuchs) to prevent the cold-welding of the screws in the bodies.

⇒ Do not use this product for valves with use of oxygen. A suitable lubricant must be selected for grease-free valves, especially for use with oxygen.

Damage to the parts of the stem sealing in contact with media due to unsuitable grease.

⇒ When assembling the stem, bellows, plug, bonnet flange and all other parts of the stem sealing in contact with media, only use water-free grease (e.g. halocarbon grease).

3.5.1 Assembling the DIN valve, DN 25 to 150

3.5.1.1 Assembling the valve body

- ⇒ Place the valve body (1) with the cover-side flange on a clean, soft surface at working height so that the bearing area of the seat is easy to reach.
- ⇒ Clean the PTFE lining of the body with detergent.
- ⇒ Lay the PTFE O-ring (3) into the groove of the body.

Tip

Depending on the temperature, it may be necessary to shrink the O-ring with cold spray or by cooling it down in the refrigerator.

- ⇒ Insert the seat (4) into the body.
- ⇒ Press the spacer (5) into the seat (4) in the body.

NOTE

Reduction in flow rate due to improper assembly!

- ⇒ Make sure that the passage opening in the spacer (5) aligns with the inlet opening of the valve.
- ⇒ The upper edge of the pressure piece must be flat with the sealing surface of the housing flange.

- ⇒ With a 5 mm drill bit, drill diagonally approx. 10 mm deep into the spacer (5) from the sealing surface.
- ⇒ Secure the spacer against twisting with a piece of PTFE cord (14) inserted into this borehole.
- ⇒ Lay the PTFE washer (6) on the spacer in the body.
- ⇒ Place the elastomer inlay (7) on the PTFE washer.
- ⇒ Carefully place the bottom flange (10) on the body.
- ⇒ Fit the washer (6) and inlay (7) centrally in the bottom flange.
- ⇒ Insert the screws (11) and align using the nuts (12). Tighten the screws evenly in a criss-cross pattern.

NOTE

Damage to the valve due to incorrect tightening torques!

⇒ The permissible torques for assembly and for retightening the connection of the bottom flange can be found in Table 15-1 in Chapter "15.1.1 Tightening torques".

3.5.1.2 Assembling the stem

– When assembling the stem, bellows, plug and all other parts of the stem sealing in contact with media, only use water-free grease (e.g. halocarbon grease).

⇒ Grease the single-section stem (16) on the bottom thread.

Info

In some versions, the stem consists of three individual parts, whereby the guide is preassembled by a snap ring with the stem.

⇒ Screw the bellows (15) with a preassembled washer and bushing onto the greased thread of the stem (16).

Tip

Due to the sliding property of the PTFE, we recommend using an emery cloth to prevent the bellows from sliding when screwing it onto the stem.

Assembling the stem unit DN 25 to 50

Info

To make it easy to push on the plug stem, a small notch is made in the bellows to let air escape.

- ⇒ Push the plug (13) onto the bellows (15).
- ⇒ Secure the connection between the plug and bellows with a PTFE cord (14) inserted as far as possible.
- ⇒ Grease the groove of the stem thoroughly.

Assembling the stem unit DN 80 to 150

- ⇒ Grease the metal side of the bordered flange (17) to minimise rust.
- ⇒ Slide the bordered flange (17) over the bellows (15) until it stops.

Info

To make it easy to push on the plug stem, a small notch is made in the bellows to let air escape.

- ⇒ Push the plug (13) onto the bellows (15).
- ⇒ Secure the connection between the plug and bellows with a PTFE cord (14) inserted as far as possible.
- ⇒ Grease the groove of the stem thoroughly.

3.5.1.3 Assembling the bonnet flange

- When assembling the bonnet flange and all other parts in contact with media, only use water-free grease (e.g. halocarbon grease).
- ⇒ Before assembly, grease the bonnet flange (2) from the inside.
- ⇒ Lightly screw in the support bolts (40) so they do not protrude on the inside of the cover.

Info

Fit valves with a nominal size of DN 25 to 50 without support bolts (40).

⇒ For continued assembly, clamp the bonnet flange with the stem guide facing down in a vice.

NOTE

Damage to the bonnet flange due to improper handling!

⇒ Do not damage the bonnet flange, especially the thread on the stem end.

- ⇒ Apply Loctite on the Glycodur bushings (22a and 22b).
- ⇒ Insert the Glycodur bushing (22a) with a suitable pin as far as possible into the stem guide.
- ⇒ Insert the Glycodur bushings (22b) with a suitable pin so they are flush with the inner surface of the cover.

Info

If the Glycodur bushings vary in length:

First insert the shorter bushing (22a) followed by the longer bushing (22b)

- ⇒ Strike the grooved pin (23).
- ⇒ Screw in the locking screw (24).
- ⇒ Insert the washer (18) into the provided recess in the bonnet flange.
- ⇒ Insert the preassembled stem unit, see Chapter 3.5.1.2, in the cover.

3.5.1.4 Assembling the valve

Standard stuffing box

⇒ Carefully place the preassembled valve body, see Chapter 3.5.1.1, on the preassembled bonnet flange, see Chapter 3.5.1.3.

Info

Air connection (24) in the bonnet flange and type plate on the valve body (1) point in the same direction.

⇒ Insert the screws (36) and align using the nuts (37). Tighten the screws evenly in a criss-cross pattern.

! NOTE**Change the position of the plug by tightening the screws!**

⇒ Make sure that the position of the plug remains central.

Damage to the plug, seat or guide due to clamping of the stem!

⇒ Press on the stem (16) during the screwdriving process to test its smooth movement.

Damage to the valve due to incorrect tightening torques!

⇒ The permissible torques for assembly and for retightening the connection of the bonnet flange can be found in Table 15-3 in Chapter "15.1.1 Tightening torques".

- ⇒ Tighten the support bolts (40) on valves DN 80 to 150, see Table 15-5 in Chapter "15.1.1 Tightening torques".
- ⇒ To continue the assembly, place the valve with the stem guide facing up on an even work surface.
- ⇒ Position the washer (25).
- ⇒ Insert the packing rings (26) with a special pin into the cover.

! NOTE**Improper seal due to incorrect positioning of the packing rings!**

⇒ Insert packing rings staggered so that the division of the packing rings does not align.

- ⇒ Press the wiper ring (28) into the stuffing box (27).
- ⇒ Screw the stuffing box (27) into the cover with the wiper ring (28).
- ⇒ Tighten the stuffing box by hand and loosen a half turn
- ⇒ Retighten the stuffing box.

! NOTE**Damage to the packing due to improper assembly!**

⇒ Press the stuffing box packing in cleanly; the pack must not bulge through the stuffing box.

With optional adjustable stuffing box

- ⇒ The final assembly of the valve takes place as described above.
- ⇒ Do not loosen then retighten the stuffing box (27), rather unscrew it completely and remove it from the valve.
- ⇒ Clean the removed stuffing box to ensure it is free of grease.
- ⇒ Apply Loctite 668 onto the thread of the stuffing box (27).
- ⇒ Screw the stuffing box (27) into the bonnet flange.

i Info

Do not tighten the stuffing box, the distance between the collar of the stuffing box and the bonnet flange must be 3 mm!

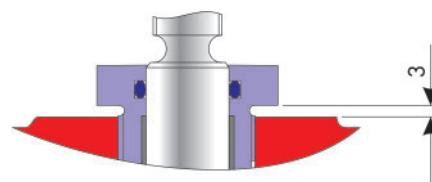


Figure 3-2: Adjustable stuffing box

⇒ Seal the stuffing box with a dot of red paint.

3.5.2 Assembling the DIN valve, DN 200

3.5.2.1 Assembling the valve body

- ⇒ Place the valve body (1) with the cover-side flange on a clean, soft surface at working height so that the bearing area of the seat is easy to reach.
- ⇒ Clean the PTFE lining of the body with detergent.
- ⇒ Lay the PTFE O-ring (3) into the groove of the body.

💡 Tip

Depending on the temperature, it may be necessary to shrink the O-ring with cold spray or by cooling it down in the refrigerator.

- ⇒ Insert seat (4) into the recess of the spacer (5) and fix with PTFE cord (14).
- ⇒ Insert spacer (5) with seat (4) into the body.

! NOTE**Reduction in flow rate due to improper assembly!**

- ⇒ Make sure that the passage opening in the spacer (5) aligns with the inlet opening of the valve.
- ⇒ The upper edge of the spacer must be flat with the sealing surface of the housing flange.

- ⇒ With a 5 mm drill bit, drill diagonally approx. 10 mm deep into the spacer (5) from the sealing surface.
- ⇒ Secure the spacer against twisting with a piece of PTFE cord (14) inserted into this borehole.
- ⇒ Lay the PTFE washer (6) on the spacer (5).
- ⇒ Place the thrust washer (8) on the PTFE washer (6).
- ⇒ Insert the spring washers (9). For the position of the spring washers, see Fig 3-3.
- ⇒ Carefully place the bottom flange (10) on the body.
- ⇒ Fit the washer (6), thrust washer (8) and spring washers (9) centrally in the bottom flange.
- ⇒ Tighten the screws (11) with the washer (43) in the valve body. Tighten the screws evenly in a criss-cross pattern.

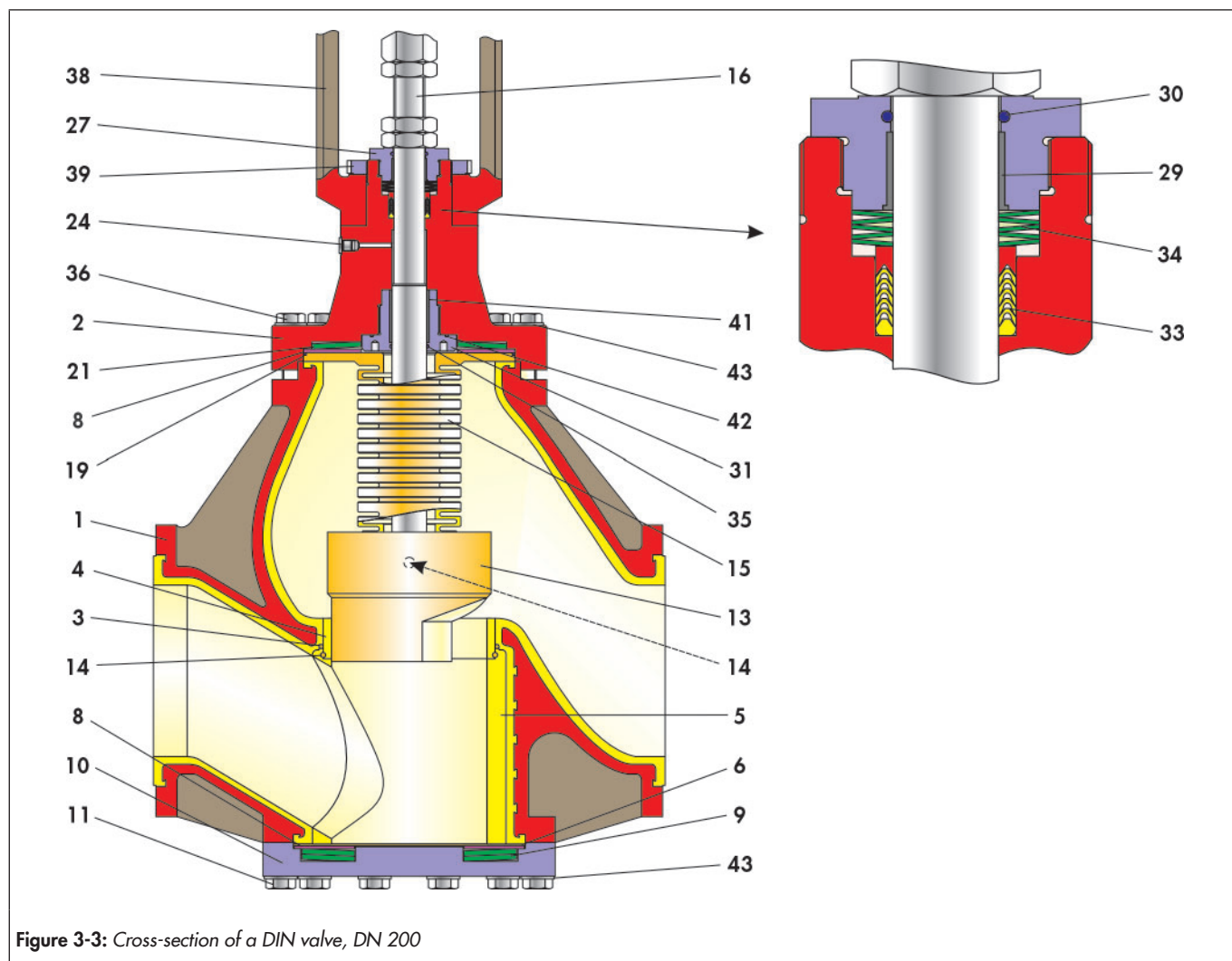


Figure 3-3: Cross-section of a DIN valve, DN 200

Table 3-2: Parts list

Item	Designation
1	Valve body
2	Bonnet flange
3	O-ring
4	Seat
5	Spacer
6	Washer
8	Thrust washer
9	Spring washer
10	Bottom flange
11	Screw
13	Plug
14	Cord
15	Bellows
16	Stem
19	O-ring

Item	Designation
21	Spring washer
24	Locking screw
27	Stuffing box
29	Bearing bushing
30	O-ring
31	Guide bushing
33	V-ring packing
34	Set of spring washers
35	O-ring
36	Screw
38	Yoke
39	Grooved nut
41	Bearing bushing
42	O-ring
43	Washer

NOTE**Damage to the valve due to incorrect tightening torques!**

- ⇒ The permissible torques for assembly and for retightening the connection of the bottom flange can be found in Table 15-2 in Chapter "15.1.1 Tightening torques".

3.5.2.2 Assembling the stem unit

- When assembling the stem, bellows, plug and all other parts of the stem sealing in contact with media, only use water-free grease (e.g. halocarbon grease).
- ⇒ The single-piece stem (16) is greased at the lower thread.
- ⇒ Screw the bellows (15) with a preassembled washer and bushing onto the greased thread of the stem (16).

Tip

Due to the sliding property of the PTFE, we recommend using an emery cloth to prevent the bellows from sliding when screwing it onto the stem.

Info

To make it easy to push on the plug stem, a small notch is made in the bellows to let air escape.

- ⇒ Push the plug (13) onto the bellows (15).
- ⇒ Secure the connection between the plug and bellows with a PTFE cord (14) inserted as far as possible.

3.5.2.3 Assembling the bonnet flange

- When assembling the bonnet flange and all other parts in contact with media, only use water-free grease (e.g. halocarbon grease).
- ⇒ Place the bonnet flange (2) on a clean surface at working height so that the stem guide is easy to reach.
- ⇒ Insert the distance bushing and V-rings and lock ring of the V-ring packing (33). For the arrangement of the packing rings, see Figure 3-3.
- ⇒ Insert the set of spring washers (34) into the provided hole. Arrangement of the spring washers, see Figure 3-3.
- ⇒ Insert the O-ring (30) into the inner groove of the stuffing box (27).
- ⇒ Press the upper bearing bushing (29) into the bottom part of the stuffing box (27).
- ⇒ Grease the stuffing box (27) on the thread.
- ⇒ Screw the stuffing box (27) into the upper thread of the bonnet flange (2), the outer groove of the stuffing box is still visible.

Info

Do not screw the stuffing box (27) into the bonnet flange as far as it will go.

- ⇒ Push the yoke (38) onto the bonnet flange and fasten with the grooved nut (39).
- ⇒ Clamp the bonnet flange (2) at the yoke in a vice with the flange opening facing upwards.

NOTE**Damage to the bonnet flange due to improper handling!**

- ⇒ Do not damage the bonnet flange, especially the thread on the stem end.
- ⇒ Press the lower bearing bushing (41) into the recesses of the guide bushing (31).
- ⇒ Insert the O-rings (35) and (42) into the corresponding recesses in the guide bushing.
- ⇒ Grease the guide bushing (31) on the thread.
- ⇒ Screw the guide bushing (31) into the bonnet flange (2) as far as it will go.

NOTE**Damage to the threaded bushing due to improper assembly!**

- ⇒ The guide bushing must not be inserted at a slanted angle when screw it into the bonnet flange.
- ⇒ Insert the spring washer (21), thrust washer (8) and O-ring (19) in the bonnet flange (2). For the arrangement of the components, see Figure 3-3.
- ⇒ Insert the preassembled stem unit, see Chapter 3.5.2.2, in the cover and press the flange of the bellows into the thread of the bonnet flange.
- ⇒ Screw in the locking screw (24).

3.5.2.4 Assembling the valve**Standard stuffing box**

- ⇒ Clamp the preassembled valve body, see Chapter 3.5.2.1, in a vice with the bonnet flange opening facing upwards.
- ⇒ Place the preassembled bonnet flange, see Chapter 3.5.2.3, onto the valve body carefully.

Info

Air connection (24) in the bonnet flange and type plate on the valve body (1) point in the same direction.

- ⇒ Tighten the screws (36) with washers (43) in the valve body. Tighten the screws evenly in a criss-cross pattern.

NOTE

Change the position of the plug by tightening the screws!

⇒ Make sure that the position of the plug remains central.

Damage to the stem due to twisting!

⇒ Before tightening the screw connection, pull the stem up as far as it will go.

Damage to the valve due to incorrect tightening torques!

⇒ The permissible torques for assembly and for retightening the connection of the bonnet flange can be found in Table 15-4 in Chapter "15.1.1 Tightening torques".

⇒ Tighten the stuffing box (27) after adjusting the valve.

With optional adjustable stuffing box

- ⇒ The final assembly of the valve takes place as described in Chapter 3.5.2.4.
- ⇒ Do not loosen then retighten the stuffing box (27), rather unscrew it completely and remove it from the valve.
- ⇒ Clean the removed stuffing box to ensure it is free of grease.
- ⇒ Apply Loctite 668 onto the thread of the stuffing box (27).
- ⇒ Screw the stuffing box (27) into the bonnet flange.

Info

Do not tighten the stuffing box, the distance between the collar of the stuffing box and the bonnet flange must be 3 mm!

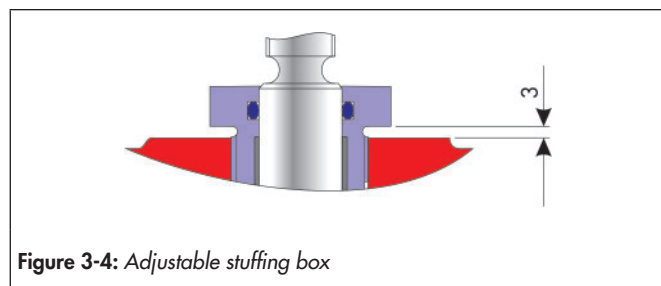


Figure 3-4: Adjustable stuffing box

⇒ Seal the stuffing box with a dot of red paint.

3.5.3 Assembling ANSI valve NPS 1 to 3 and DIN valve DN 25 to 80 [Edition 2022]

3.5.3.1 Assembling the valve body

- ⇒ Place the valve body (1) with the cover-side flange on a clean, soft surface at working height so that the bearing area of the seat is easy to reach.
- ⇒ Clean the PTFE lining of the body with detergent.
- ⇒ Lay the PTFE O-ring (3) into the groove of the body.

Tip

Depending on the temperature, it may be necessary to shrink the O-ring with cold spray or by cooling it down in the refrigerator.

- ⇒ Insert the seat (4) into the body.
- ⇒ Press the spacer (5) into the seat (4) in the body.

NOTE

Reduction in flow rate due to improper assembly!

⇒ Make sure that the passage opening in the spacer (5) aligns with the inlet opening of the valve.

⇒ The upper edge of the spacer must be flat with the sealing surface of the housing flange.

- ⇒ With a 5 mm drill bit, drill diagonally approx. 10 mm deep into the spacer (5) from the sealing surface.
- ⇒ Secure the spacer against twisting with a piece of PTFE cord (14) inserted into this borehole.
- ⇒ Lay the PTFE washer (6) on the spacer (5).
- ⇒ Place the thrust washer (8) on the PTFE washer (6).
- ⇒ Insert the spring washers (9). For the position of the spring washer, see Figure 3-5.
- ⇒ Carefully place the bottom flange (10) on the body.
- ⇒ Fit the washer (6), thrust washer (8) and spring washers (9) centrally in the bottom flange.
- ⇒ Screw the screws (11) into the valve body. Tighten the screws evenly in a criss-cross pattern.

NOTE

Damage to the valve due to incorrect tightening torques!

⇒ The permissible torques for assembly and for retightening the connection of the bottom flange can be found in Table 15-2 in Chapter "15.1.1 Tightening torques".

3.5.3.2 Assembling the stem unit

- When assembling the stem, bellows, plug and all other parts of the stem sealing in contact with media, only use water-free grease (e.g. halocarbon grease).
- ⇒ The single-piece stem (16) is greased at the lower thread.

Info

In some versions, the stem consists of three individual parts, whereby the guide is preassembled by a snap ring with the stem.

⇒ Screw the bellows (15) with a preassembled washer and bushing onto the greased thread of the stem (16).

Tip

Due to the sliding property of the PTFE, we recommend using an emery cloth to prevent the bellows from sliding when screwing it onto the stem.

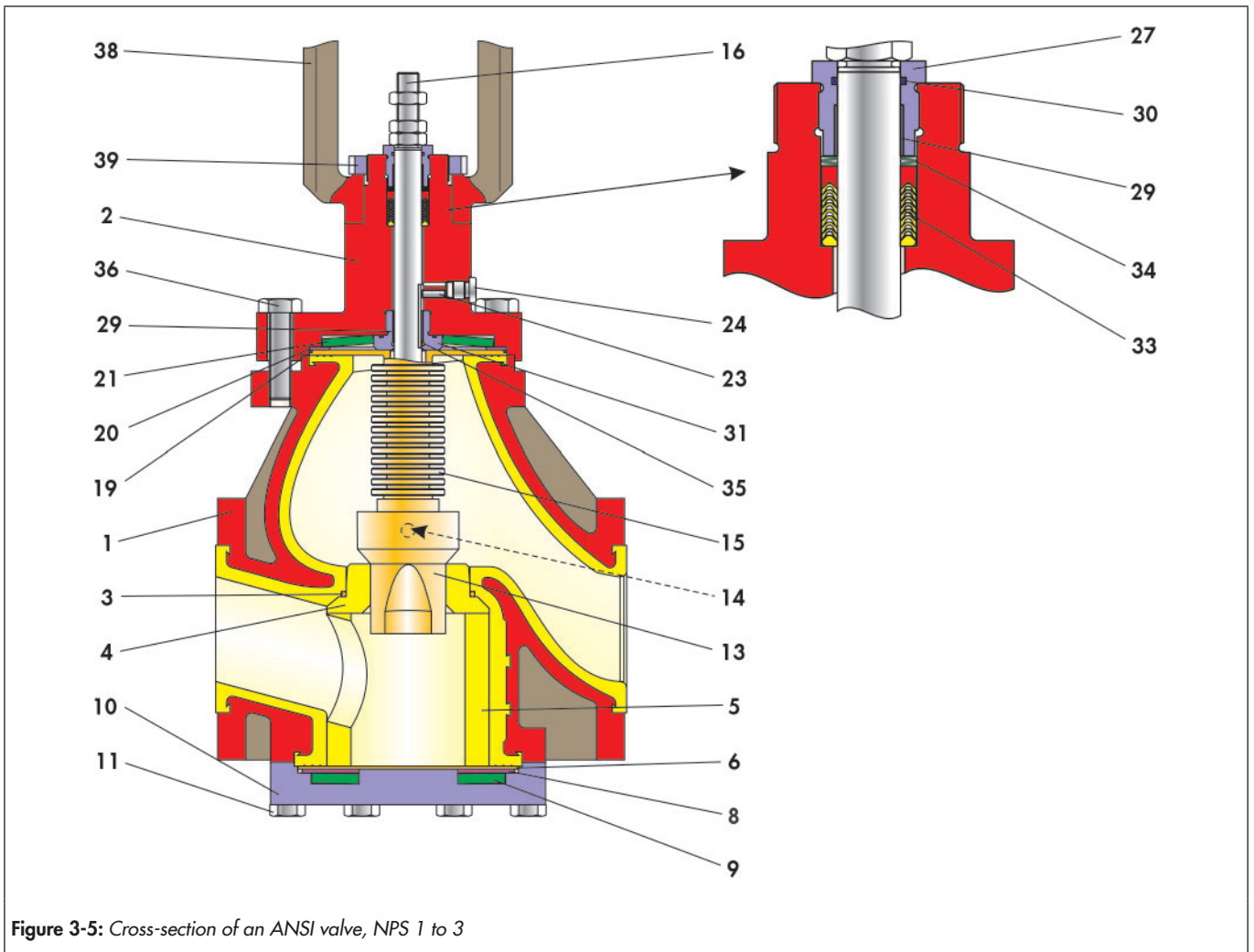


Figure 3-5: Cross-section of an ANSI valve, NPS 1 to 3

Table 3-3: Parts list

Item	Designation
1	Valve body
2	Bonnet flange
3	O-ring
4	Seat
5	Spacer
6	Washer
8	Thrust washer
9	Spring washer
10	Bottom flange
11	Screw
13	Plug
14	Cord
15	Bellows
16	Stem

Item	Designation
19	O-ring
20	Thrust washer
23	Grooved pin
24	Locking screw
27	Stuffing box
29	Bearing bushing
30	O-ring
31	Guide bushing
33	V-ring packing
34	Set of spring washers
35	O-ring
36	Screw
38	Yoke
39	Grooved nut

i Info

To make it easy to push on the plug stem, a small notch is made in the bellows to let air escape.

- ⇒ Push the plug (13) onto the bellows (15).
- ⇒ Secure the connection between the plug and bellows with a PTFE cord (14) inserted as far as possible.

3.5.3.3 Assembling the bonnet flange

- When assembling the bonnet flange and all other parts in contact with media, only use water-free grease (e.g. halocar-bon grease).

Bonnet flange assembly NPS1 to 2

- ⇒ Place the bonnet flange (2) on a clean surface at working height so that the stem guide is easy to reach.
- ⇒ Insert the distance bushing and V-rings and lock ring of the V-ring packing (33). For the arrangement of the packing rings, see Figure 3-5.
- ⇒ Insert the set of spring washers (34) into the provided hole. Arrangement of the spring washers, see Figure 3-5.
- ⇒ Insert the O-ring (30) into the inner groove of the stuffing box (27).
- ⇒ Press the upper bearing bushing (29) into the bottom part of the stuffing box (27).
- ⇒ Grease the stuffing box (27) on the thread.
- ⇒ Screw the stuffing box (27) into the upper thread of the bonnet flange (2), the outer groove of the stuffing box is still visible.

i Info

Do not screw the stuffing box (27) into the bonnet flange as far as it will go.

- ⇒ Clamp the bonnet flange (2) at the yoke in a vice with the flange opening facing upwards.
- ⇒ Press the lower bearing bushing (29) into the recesses of the threaded bushing (31).
- ⇒ Insert the O-ring (35) into the corresponding recess in the threaded bushing.
- ⇒ Grease the threaded bushing (31) on the thread.
- ⇒ Screw the threaded bushing (31) into the bonnet flange (2) as far as it will go.

! NOTE

Damage to the threaded bushing due to improper assembly!

- ⇒ *The threaded bushing must not be inserted at a slanted angle when screw it into the bonnet flange.*

- ⇒ Insert the spring washer (21), thrust washer (20) and O-ring (19) in the bonnet flange (2). For the arrangement of the components, see Figure 3-5.

- ⇒ Strike the grooved pin (23).
- ⇒ Insert the preassembled stem unit, see Chapter 3.5.3.2, in the bonnet flange and press the flange of the bellows into the thread of the bonnet flange.
- ⇒ Screw in the locking screw (24).

Bonnet flange assembly NPS3

- To assemble bonnet flange NPS3, follow the steps in “Bonnet flange assembly NPS1 to 2”.
- The only difference is that the bonnet flange described here has no integrated yoke.
- ⇒ Push the yoke (38) onto the bonnet flange and fasten with the grooved nut (39).

3.5.3.4 Assembling the valve

Standard stuffing box

- ⇒ Clamp the preassembled valve body, see Chapter 3.5.3.1, in a vice with the bonnet opening facing upwards.
- ⇒ Place the preassembled bonnet flange, see Chapter 3.5.3.3, onto the valve body carefully.

i Info

Air connection (24) in the bonnet flange and type plate on the valve body (1) point in the same direction.

- ⇒ Screw the screws (36) into the valve body. Tighten the screws evenly in a criss-cross pattern.

! NOTE

Change the position of the plug by tightening the screws!

- ⇒ *Make sure that the position of the plug remains central.*

Damage to the stem due to twisting!

- ⇒ *Before tightening the screw connection, pull the stem up as far as it will go.*

! NOTE

Damage to the valve due to incorrect tightening torques!

- ⇒ *The permissible torques for assembly and for retightening the connection of the bonnet flange can be found in Table 15-4 in Chapter “15.1.1 Tightening torques”.*

- ⇒ Tighten the stuffing box (27) after adjusting the valve.

With optional adjustable stuffing box

- ⇒ The final assembly of the valve takes place as already described in Chapter 3.5.3.4.
- ⇒ Do not loosen then retighten the stuffing box (27), rather unscrew it completely and remove it from the valve.
- ⇒ Clean the removed stuffing box to ensure it is free of grease.

- ⇒ Apply Loctite 668 onto the thread of the stuffing box (27).
- ⇒ Screw the stuffing box (27) into the bonnet flange.

i Info

Do not tighten the stuffing box, the distance between the collar of the stuffing box and the bonnet flange must be 3 mm!

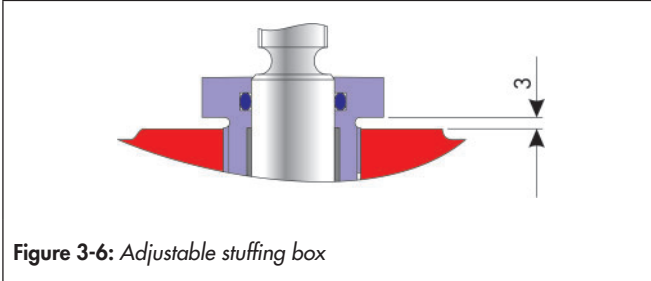


Figure 3-6: Adjustable stuffing box

- ⇒ Seal the stuffing box with a dot of red paint.

3.5.4 Assembling the ANSI valve, NPS4 to 6

3.5.4.1 Assembling the valve body

- ⇒ Place the valve body (1) with the cover-side flange on a clean, soft surface at working height so that the bearing area of the seat is easy to reach.
- ⇒ Clean the PTFE lining of the body with detergent.
- ⇒ Lay the PTFE O-ring (3) into the groove of the body.

💡 Tip

Depending on the temperature, it may be necessary to shrink the O-ring with cold spray or by cooling it down in the refrigerator.

- ⇒ Insert the seat (4) into the body.
- ⇒ Press the spacer (5) into the seat (4) in the body.

! NOTE

Reduction in flow rate due to improper assembly!

- ⇒ Make sure that the passage opening in the spacer (5) aligns with the inlet opening of the valve.
- ⇒ The upper edge of the spacer must be flat with the sealing surface of the housing flange.
- ⇒ With a 5 mm drill bit, drill diagonally approx. 10 mm deep into the spacer (5) from the sealing surface.
- ⇒ Secure the spacer against twisting with a piece of PTFE cord (14) inserted into this borehole.
- ⇒ Lay the PTFE washer (6) on the spacer in the body.
- ⇒ Place the elastomer inlay (7) on the PTFE washer.
- ⇒ Carefully place the bottom flange (10) on the body.
- ⇒ Fit the washer (6) and inlay (7) centrally in the bottom flange.
- ⇒ Insert the screws (11) and align using the nuts (12). Tighten the screws evenly in a criss-cross pattern.

! NOTE

Damage to the valve due to incorrect tightening torques!

- ⇒ The permissible torques for assembly and for retightening the connection of the bottom flange can be found in Table 15-1 in Chapter "15.1.1 Tightening torques".

3.5.4.2 Assembling the stem unit

- When assembling the stem, bellows, plug and all other parts of the stem sealing in contact with media, only use water-free grease (e.g. halocarbon grease).
- ⇒ Grease the single-section stem (16) on the bottom thread.

i Info

In some versions, the stem consists of three individual parts, whereby the guide is preassembled by a snap ring with the stem.

- ⇒ Screw the bellows (15) with a preassembled washer and bushing onto the greased thread of the stem (16).

💡 Tip

Due to the sliding property of the PTFE, we recommend using an emery cloth to prevent the bellows from sliding when screwing it onto the stem.

- ⇒ Grease the metal side of the bordered flange (17) to minimize rust.
- ⇒ Slide the bordered flange (17) over the bellows (15) until it stops.

i Info

To make it easy to push on the plug stem, a small notch is made in the bellows to let air escape.

- ⇒ Push the plug (13) onto the bellows (15).
- ⇒ Secure the connection between the plug and bellows with a PTFE cord (14) inserted as far as possible.
- ⇒ Grease the groove of the stem thoroughly.

3.5.4.3 Assembling the bonnet flange

- When assembling the bonnet flange and all other parts in contact with media, only use water-free grease (e.g. halocarbon grease).
- ⇒ Before assembly, grease the bonnet flange (2) from the inside.
- ⇒ Lightly screw in the support bolts (40) so they do not protrude on the inside of the cover.
- ⇒ For continued assembly, clamp the bonnet flange with the stem guide facing down in a vice.

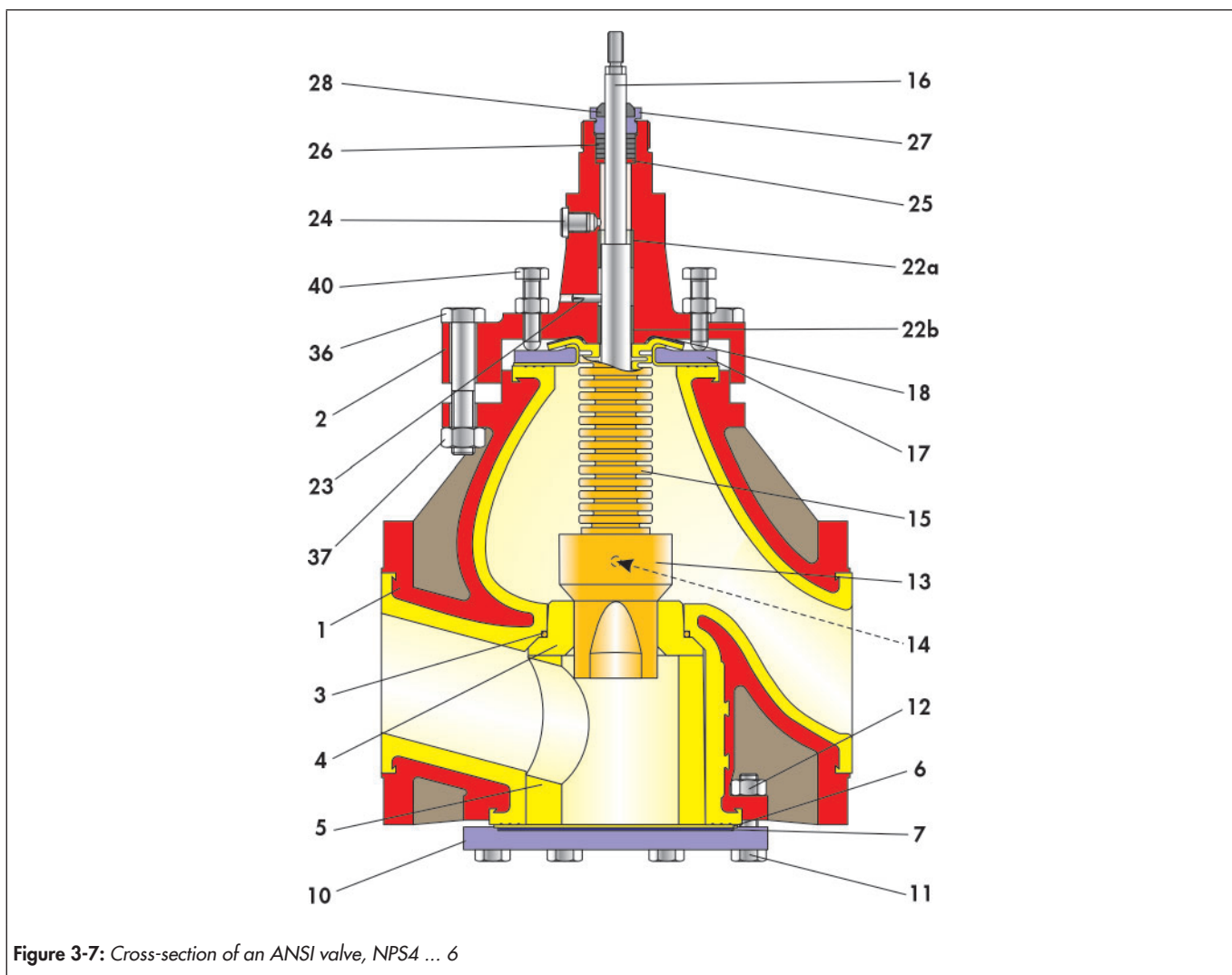


Figure 3-7: Cross-section of an ANSI valve, NPS4 ... 6

Table 3-4: Parts list

Item	Designation
1	Valve body
2	Bonnet flange
3	O-ring
4	Seat
5	Spacer
6	Washer
7	Inlay
10	Bottom flange
11	Screw/ stud bolt
12	Nut
13	Plug
14	Cord
15	Bellows
16	Stem

Item	Designation
17	Bordered flange
18	Washer
22	Bushing
23	Grooved pin
24	Locking screw
25	Washer
26	Packing
27	Stuffing box
28	Wiper ring
36	Screw
37	Nut
38	Yoke (not marked)
39	Groove nut (not marked)
40	Support bolts

NOTE**Damage to the bonnet flange due to improper handling!**

⇒ Do not damage the bonnet flange, especially the thread on the stem end.

- ⇒ Apply Loctite on the Glycodur bushings (22a and 22b).
- ⇒ Insert the Glycodur bushing (22a) with a suitable pin as far as possible into the stem guide.
- ⇒ Insert the Glycodur bushings (22b) with a suitable pin so they are flush with the inner surface of the cover.

i Info

If the Glycodur bushings vary in length:

First insert the shorter bushing (22a) followed by the longer bushing (22b)

- ⇒ Strike the grooved pin (23).
- ⇒ Screw in the locking screw (24).
- ⇒ Insert the washer (18) into the provided recess in the bonnet flange.
- ⇒ Insert the preassembled stem unit, see Chapter 3.5.4.2, in the cover.

3.5.4.4 Assembling the valve

Standard stuffing box

- ⇒ Carefully place the preassembled valve body, see Chapter 3.5.4.1, on the preassembled bonnet flange, see Chapter 3.5.4.3.

i Info

Air connection (24) in the bonnet flange and type plate on the valve body (1) point in the same direction.

- ⇒ Insert the screws (36) and align using the nuts (37). Tighten the screws evenly in a criss-cross pattern.

NOTE**Change the position of the plug by tightening the screws!**

⇒ Make sure that the position of the plug remains central.

Damage to the plug, seat or guide due to clamping of the stem!

⇒ Press on the stem (16) during the screwdriving process to test its smooth movement.

Damage to the valve due to incorrect tightening torques!

⇒ The permissible torques for assembly and for retightening the connection of the bonnet flange can be found in Table 15-3 in Chapter "15.1.1 Tightening torques".

- ⇒ Tighten the support bolts (40), see Table 15-5 in Chapter "15.1.1 Tightening torques".
- ⇒ To continue the assembly, place the valve with the stem guide facing up on an even work surface.

- ⇒ Position the washer (25).
- ⇒ Insert the packing rings (26) with a special pin into the cover.

NOTE**Improper seal due to incorrect positioning of the packing rings!**

⇒ Insert packing rings staggered so that the division of the packing rings does not align.

- ⇒ Press the wiper ring (28) into the stuffing box (27).
- ⇒ Grease the stuffing box (27) and screw into the cover.
- ⇒ Tighten the stuffing box by hand and loosen a half turn
- ⇒ Retighten the stuffing box.

NOTE**Damage to the packing due to improper assembly!**

⇒ Press the stuffing box packing in cleanly; the pack must not bulge through the stuffing box.

With optional adjustable stuffing box

- ⇒ The final assembly of the valve takes place as described above.
- ⇒ Do not loosen then retighten the stuffing box (27), rather unscrew it completely and remove it from the valve.
- ⇒ Clean the removed stuffing box to ensure it is free of grease.
- ⇒ Apply Loctite 668 onto the thread of the stuffing box (27).
- ⇒ Screw the stuffing (27) into the bonnet flange.

i Info

Do not tighten the stuffing box, the distance between the collar of the stuffing box and the bonnet flange must be 3 mm!

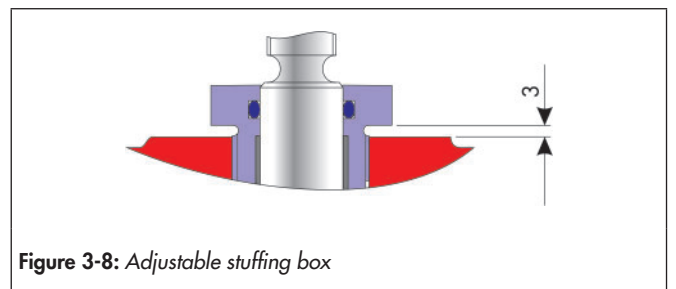


Figure 3-8: Adjustable stuffing box

- ⇒ Seal the stuffing box with a dot of red paint.

3.5.5 Assembling the ANSI valve, NPS8

3.5.5.1 Assembling the valve body

- ⇒ Place the valve body (1) with the cover-side flange on a clean, soft surface at working height so that the bearing area of the seat is easy to reach.

Design and principle of operation

- ⇒ Clean the PTFE lining of the body with detergent.
- ⇒ Lay the PTFE O-ring (3) into the groove of the body.

Tip

Depending on the temperature, it may be necessary to shrink the O-ring with cold spray or by cooling it down in the refrigerator.

- ⇒ Insert seat (4) into the recess of the spacer (5) and fix with PTFE cord (14).
- ⇒ Insert spacer (5) with seat (4) into the body.

NOTE

Reduction in flow rate due to improper assembly!

- ⇒ Make sure that the passage opening in the spacer (5) aligns with the inlet opening of the valve.
- ⇒ The upper edge of the spacer must be flat with the sealing surface of the housing flange.

- ⇒ With a 5 mm drill bit, drill diagonally approx. 10 mm deep into the spacer (5) from the sealing surface.
- ⇒ Secure the spacer against twisting with a piece of PTFE cord (14) inserted into this borehole.
- ⇒ Lay the PTFE washer (6) on the spacer (5).
- ⇒ Place the thrust washer (8) on the PTFE washer (6).
- ⇒ Insert the spring washers (9). For the position of the spring washers, see Figure 3-9.
- ⇒ Carefully place the bottom flange (10) on the body.
- ⇒ Fit the washer (6), thrust washer (8) and spring washers (9) centrally in the bottom flange.
- ⇒ Tighten the screws (11) with the washer (43) in the valve body. Tighten the screws evenly in a criss-cross pattern.

NOTE

Damage to the valve due to incorrect tightening torques!

- ⇒ The permissible torques for assembly and for retightening the connection of the bottom flange can be found in Table 15-2 in Chapter "15.1.1 Tightening torques".

3.5.5.2 Assembling the stem unit

- When assembling the stem, bellows, plug and all other parts of the stem sealing in contact with media, only use water-free grease (e.g. halocarbon grease).
- ⇒ The single-piece stem (16) is greased at the lower thread.
- ⇒ Screw the bellows (15) with a preassembled washer and bushing onto the greased thread of the stem (16).

Tip

Due to the sliding property of the PTFE, we recommend using an emery cloth to prevent the bellows from sliding when screwing it onto the stem.

Info

To make it easy to push on the plug stem, a small notch is made in the bellows to let air escape.

- ⇒ Push the plug (13) onto the bellows (15).
- ⇒ Secure the connection between the plug and bellows with a PTFE cord (14) inserted as far as possible.

3.5.5.3 Assembling the bonnet flange

- When assembling the bonnet flange and all other parts in contact with media, only use water-free grease (e.g. halocarbon grease).
- ⇒ Place the bonnet flange (2) on a clean surface at working height so that the stem guide is easy to reach.
- ⇒ Insert the distance bushing and V-rings and lock ring of the V-ring packing (33). For the arrangement of the packing rings, see Figure 3-9.
- ⇒ Insert the set of spring washers (34) into the provided hole. Arrangement of the spring washers, see Figure 3-9.
- ⇒ Insert the O-ring (30) into the inner groove of the stuffing box (27).
- ⇒ Press the upper bearing bushing (29) into the bottom part of the stuffing box (27).
- ⇒ Grease the stuffing box (27) on the thread.
- ⇒ Screw the stuffing box (27) into the upper thread of the bonnet flange (2), the outer groove of the stuffing box is still visible.

Info

Do not screw the stuffing box (27) into the bonnet flange as far as it will go.

- ⇒ Push the yoke (38) onto the bonnet flange and fasten with the grooved nut (39).
- ⇒ Clamp the bonnet flange (2) at the yoke in a vice with the flange opening facing upwards.

NOTE

Damage to the bonnet flange due to improper handling!

- ⇒ Do not damage the bonnet flange, especially the thread on the stem end.
- ⇒ Press the lower bearing bushing (41) into the recesses of the guide bushing (31).
- ⇒ Insert the O-rings (35) and (42) into the corresponding recesses in the guide bushing.
- ⇒ Grease the guide bushing (31) on the thread.
- ⇒ Screw the guide bushing (31) into the bonnet flange (2) as far as it will go.

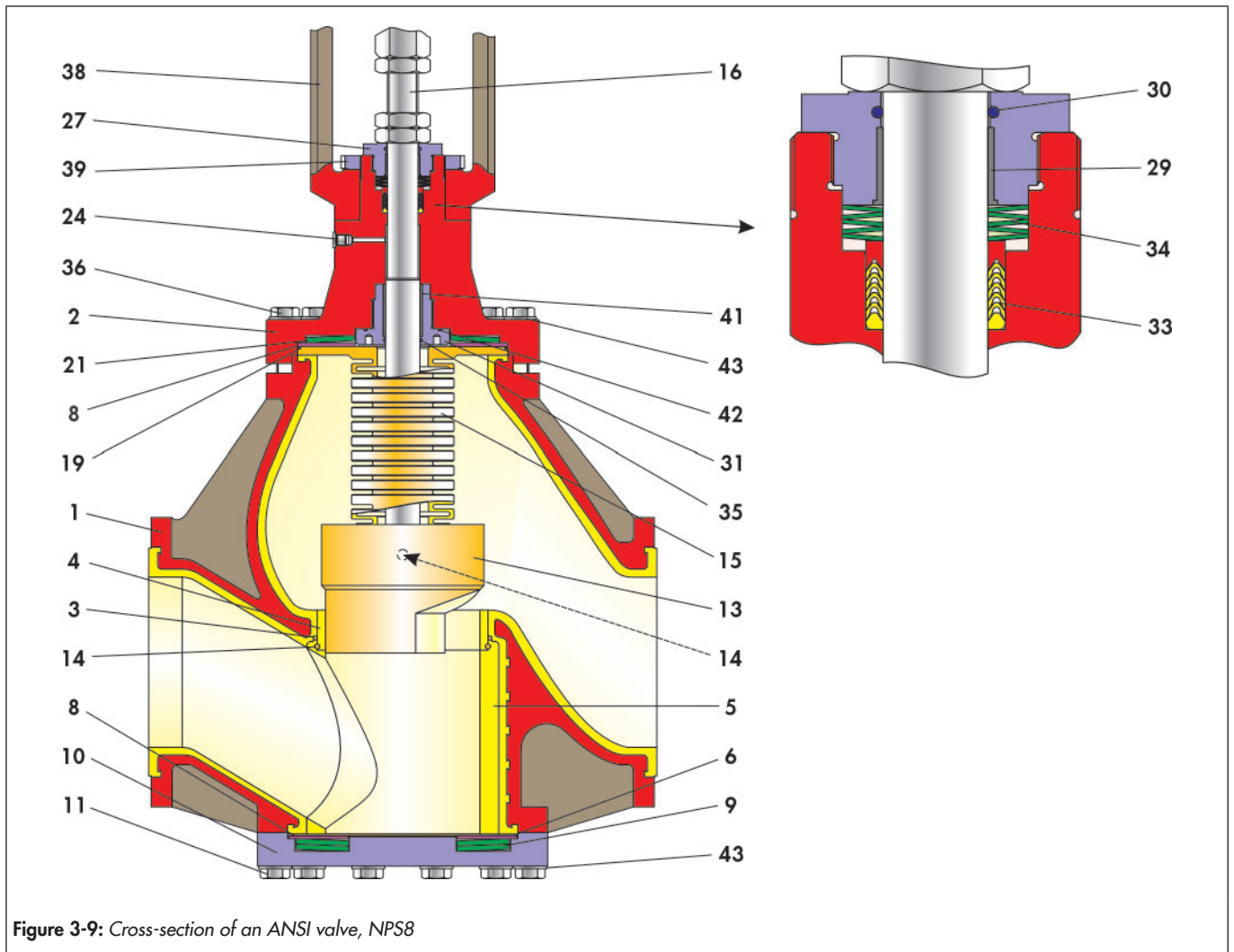


Figure 3-9: Cross-section of an ANSI valve, NPS8

Table 3-5: Parts list

Item	Designation
1	Valve body
2	Bonnet flange
3	O-ring
4	Seat
5	Spacer
6	Washer
8	Thrust washer
9	Spring washer
10	Bottom flange
11	Screw
13	Plug
14	Cord
15	Bellows
16	Stem
19	O-ring

Item	Designation
21	Spring washer
24	Locking screw
27	Stuffing box
29	Bearing bushing
30	O-ring
31	Guide bushing
33	V-ring packing
34	Set of spring washers
35	O-ring
36	Screw
38	Yoke
39	Grooved nut
41	Bearing bushing
42	O-ring
43	Washer

NOTE

Damage to the guide bushing due to improper assembly!

- ⇒ The guide bushing must not be inserted at a slanted angle when screw it into the bonnet flange.
-
- ⇒ Insert the spring washer (21), thrust washer (8) and O-ring (19) in the bonnet flange (2). For the arrangement of the components, see Figure 3-9.
 - ⇒ Insert the preassembled stem unit, see Chapter 3.5.5.2, in the cover and press the flange of the bellows into the thread of the bonnet flange.
 - ⇒ Screw in the locking screw (24).

3.5.5.4 Assembling the valve

Standard stuffing box

- ⇒ Clamp the preassembled valve body, see Chapter 3.5.5.1, in a vice with the bonnet flange opening facing upwards.
- ⇒ Place the preassembled bonnet flange, see Chapter 3.5.5.3, onto the valve body carefully.

i Info

Air connection (24) in the bonnet flange and type plate on the valve body (1) point in the same direction.

- ⇒ Tighten the screws (36) with washers (43) in the valve body. Tighten the screws evenly in a criss-cross pattern.

NOTE

Change the position of the plug by tightening the screws!

- ⇒ Make sure that the position of the plug remains central.

Damage to the stem due to twisting!

- ⇒ Before tightening the screw connection, pull the stem up as far as it will go.

Damage to the valve due to incorrect tightening torques!

- ⇒ The permissible torques for assembly and for retightening the connection of the bonnet flange can be found in Table 15-4 in Chapter "15.1.1 Tightening torques".

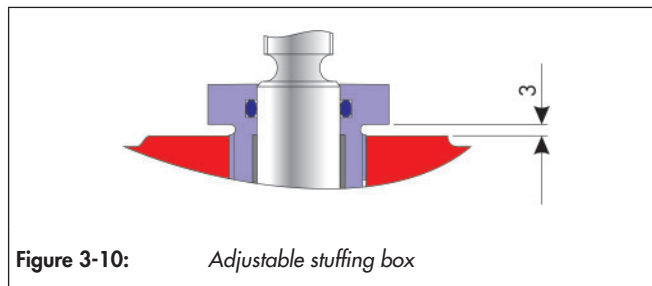
- ⇒ Tighten the stuffing box (27) after adjusting the valve.

With optional adjustable stuffing box

- ⇒ The final assembly of the valve takes place as described in Chapter 3.5.5.4.
- ⇒ Do not loosen then retighten the stuffing box (27), rather unscrew it completely and remove it from the valve.
- ⇒ Clean the removed stuffing box to ensure it is free of grease.
- ⇒ Apply Loctite 668 onto the thread of the stuffing box (27).
- ⇒ Screw the stuffing box (27) into the bonnet flange.

i Info

Do not tighten the stuffing box, the distance between the collar of the stuffing box and the bonnet flange must be 3 mm!



- ⇒ Seal the stuffing box with a dot of red paint.

4 Shipment and on-site transport

The work described in this chapter may only be performed by specialist personnel qualified to perform the corresponding task.

! NOTE

Damage to the valve due to improper transport and storage!

⇒ Valves with lining must be handled, transported and stored with care.

4.1 Accepting delivery

Perform the following steps after receiving the goods:

- ⇒ Check the scope of supply. Compare the delivered goods with the delivery note.
- ⇒ Check the supply for transport damage. Report transport damage to PFEIFFER and the transport company (see the delivery note).

4.2 Unpacking the valve

! NOTE

Damage to the plastic lining!

Protect the lined valve surfaces in particular prior to/during installation.

⇒ Transport the valve in its original packaging to the installation site and unpack it only there.

Perform the following steps before lifting and installing the valve:

- ⇒ Unpack the valve.
- ⇒ Dispose of the packaging properly.

! NOTE

Damage to the valve due to the ingress of foreign matter!

The protective caps on the valve inlet and outlet prevent foreign matter from entering the valve and damaging it. Only remove the protective caps prior to installation in the pipe.

4.3 Transporting and lifting the valve

! DANGER

Danger due to falling of suspended loads!

Do not stand under suspended loads.

! WARNING

Overturning of the lifting equipment and damage to the load lifting equipment by exceeding the lifting capacity!

- ⇒ Only used approved lifting equipment and load lifting equipment whose lifting capacity corresponds at least to the weight of the valve including the actuator.
- ⇒ Take the weights from the respective data sheet.

Danger of injury due to the tipping of the valve!

- ⇒ Observe the centre of gravity of the valve.
- ⇒ Secure the valve against tipping and twisting.

! NOTE

Damage to the valve due to improper fastening of the sling!

The welded-on lifting eyes on SAMSON actuators are used only for actuator assembling and disassembling as well as for lifting the actuator without the valve. This lifting eye is not intended for lifting the complete valve.

- ⇒ When lifting the valve, make sure that the entire load is carried by the sling that is fastened to the valve body.
- ⇒ Do not fasten the load-bearing sling to the actuator, hand wheel or other components.
- ⇒ Do not use the control air lines, accessories or other components with safety functions for suspension or damage them.

4.3.1 Transporting

The valve can be transported using lifting equipment such as a crane or a forklift.

- ⇒ Leave the valve on the pallet or in the transport container for transport.
- ⇒ Valves that weigh more than approx. 10 kg should be transported on a pallet (or supported similarly) (also to the installation site). The packaging should protect the scratch-sensitive plastic lining of the valve against damage.
- ⇒ Comply with the transport conditions.

Transport conditions

- ⇒ Protect the valve against external influences, such as impacts.
- ⇒ Do not damage the corrosion protection (paint, surface coating). Repair damage immediately.
- ⇒ Protect the valve against moisture and dirt.

4.3.2 Lifting

When installing the valve in the pipe, heavier valves can be lifting using lifting equipment such as a crane or forklift.

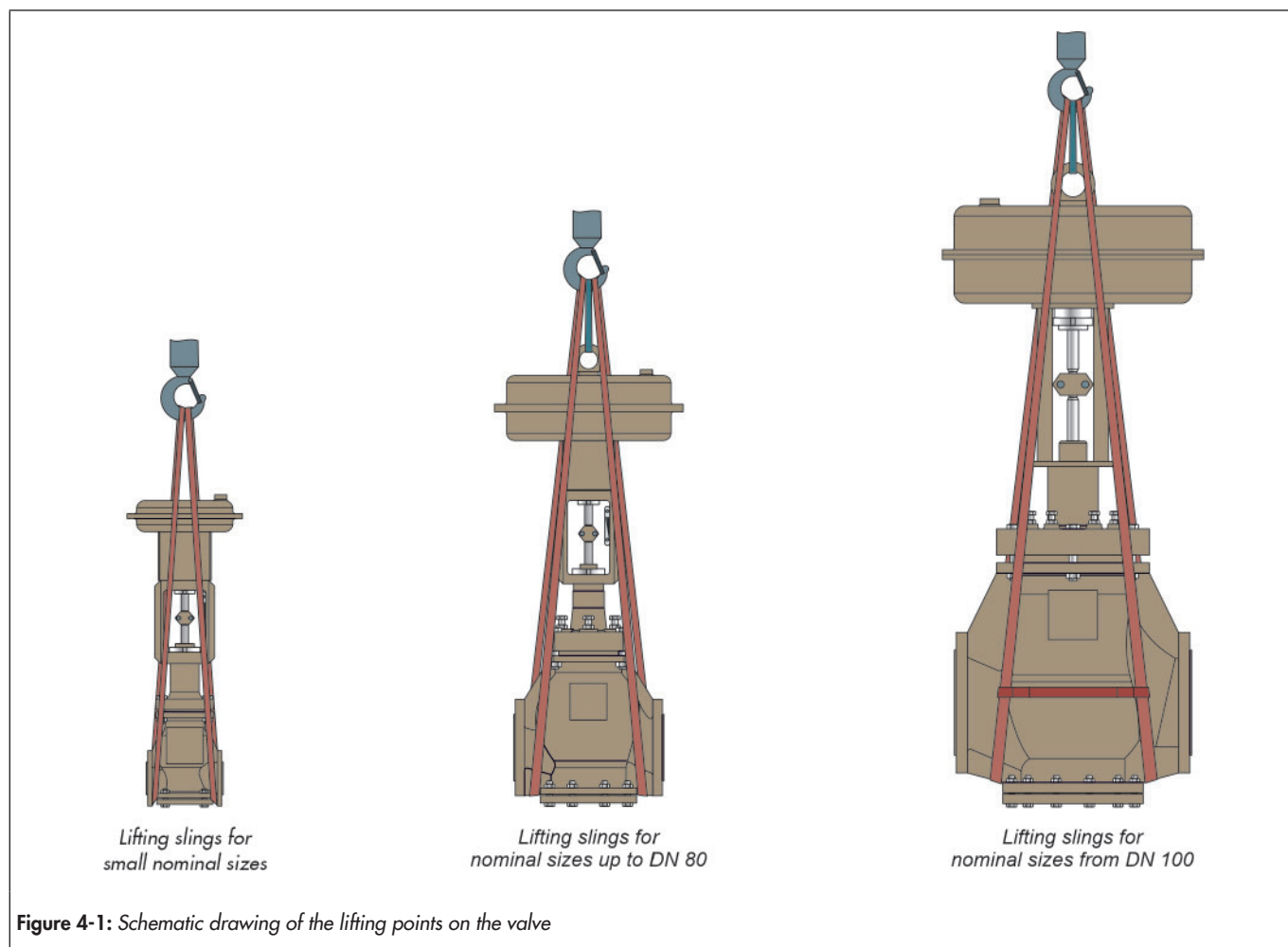


Figure 4-1: Schematic drawing of the lifting points on the valve

Conditions for lifting

- ⇒ Use a hook with a safety clamp as the suspension element so that the sling cannot slip off the hook during lifting and transport, see Figure 4-1.
- ⇒ Secure the sling against shifting and slipping off.
- ⇒ Fasten the sling such that it can be removed again after installation in the pipe.
- ⇒ Avoid swinging and tipping the valve.
- ⇒ In the case of interruptions in work, do not leave the lifting equipment suspended in the air for a long period of time.
- ⇒ Lift the valve aligned in the same direction in which it will be installed in the pipe.
- ⇒ Always lift the valve in the centre of gravity of the load to prevent uncontrolled tipping.
- ⇒ Also secure the valve to prevent it from tipping to the side.
- ⇒ Make sure that in the case of valves and actuators with lifting eyes that the additional sling between the lifting eye and the suspension element does not take on any load. This sling is used only to secure the load against turning over while lifting. Before lifting the valve, pretension this sling so it is taut.

⚠ DANGER

Danger due to incorrect lifting and transport!

The lifting points for the lifting slings shown in the schematic drawing serve as examples for most valve variants. On site the conditions for lifting and transporting the valve can change however.

- ⇒ The operator makes sure that the valve is lifted and transported safely.

Lifting the valve to DN 80

- ⇒ Fasten a lifting sling to each flange of the housing and on the suspension element (e.g. hook) of the crane or forklift, see Figure 4-1.
When doing so, ensure the safety, bearing capacity and length of the lifting slings
- ⇒ In the case of an actuator with a lifting eye: fasten additional lifting slings to the lifting eye on the actuator and on the suspension element.
- ⇒ Lift the valve carefully. Check if the load lifting equipment holds.

- ⇒ Move the valve at a constant speed to the installation site.
- ⇒ Install the valve in the pipe, see chapter 5.4.
- ⇒ After installation in the pipe: check that the flanges are firmly tightened and that the valve holds in the pipe.
- ⇒ Remove the lifting slings.

Lifting the valve from DN 100 upwards

- ⇒ Fasten a lifting sling to each flange of the housing and on the suspension element (e.g. hook) of the crane or forklift, see Figure 4-1.
- ⇒ When doing so, ensure the safety, bearing capacity and length of the lifting slings
- ⇒ Secure the slings attached to the body against slipping using a connector.
- ⇒ In the case of a actuator with a lifting eye: fasten additional lifting slings to the lifting eye on the actuator and on the suspension element.
- ⇒ Lift the valve carefully. Check if the load lifting equipment holds.
- ⇒ Move the valve at a constant speed to the installation site.
- ⇒ Install the valve in the pipe, see chapter 5.4.
- ⇒ After installation in the pipe: check that the flanges are firmly tightened and that the valve holds in the pipe.
- ⇒ Remove the lifting slings.

- ⇒ The valve must be stored in its protective packaging and/or with the protective caps on the connection ends.
The packaging should protect the scratch-sensitive plastic lining of the valve against damage.
- ⇒ Valves that weigh more than approx. 10 kg should be stored on a pallet (or supported similarly).
- ⇒ Valves are usually delivered in the fail-safe position. They must be stored in the position in which they were delivered. The actuating device must not be actuated.
- ⇒ Do not place any objects on the valve.
- ⇒ Do not stack the valves.

4.4 Storing the valve

NOTE

Damage to the valve due to improper storage!

- ⇒ Comply with the storage conditions.
- ⇒ Avoid long storage periods.
- ⇒ In the case of deviating storage conditions and a longer storage period, contact PFEIFFER.

Info

PFEIFFER recommends checking the valve and the storage conditions regularly during a longer storage period.

- ⇒ In the case of storage prior to installation, the valve should normally be stored in a closed room where it is protected against harmful influences such as impacts, dirt or moisture. PFEIFFER recommends a room temperature of $25^{\circ}\text{C} \pm 15^{\circ}\text{C}$.
- ⇒ In particular, the actuator and the ends of the valve to the pipe connection may not be damaged by mechanical or any other influences.
- ⇒ Prevent condensation in damp rooms. Use a desiccant or heater.

5 Installation

The work described in this chapter may only be performed by specialist personnel qualified to perform the corresponding task. The following instructions apply additionally for valves. Observe chapter "4.3 Transporting and lifting the valve" for transport to the installation site.

5.1 Installation conditions

Operator level

The operator level for the valve is the front view on all operating elements of the valve including the attachments from the perspective of operating personnel.

The plant operator must make sure that operating personnel can carry out all work after the device is installed safely and can access it easily from the operator level.

Pipe routing

The guidelines applicable on site apply for the installation of valves in the pipe.

Install the valves such that there is low vibration and no mechanical stress. Observe the sections "Installation orientation" and "Support and mounting" in this chapter.

Install the valve so there is enough space to replace the actuator and valve as well as to perform maintenance work.

Installation position

The valve can be installed in any installation position. PFEIFFER recommends however to install the valve in general so that the actuator points up in a vertical position.

In the following versions the valve with the actuator must be installed pointing upwards:

- Nominal sizes from DN 100 / NPS4
- Valves with insulating part.
- ⇒ In the case of deviations from this installation position, contact PFEIFFER.

Support and mounting

The plant manufacturer is responsible for the selection and implementation of a suitable support or mounting for the installed valve as well as the pipe.

NOTE

Damage to the valve due to improper support!

- ⇒ Support the valve in the piping only at the body.
- ⇒ Do not support at the end cap or bonnet flange.
- ⇒ Support must be vibration-free.

Venting

Vents are screwed into the exhaust air connections of pneumatic and electropneumatic devices to ensure that the generated exhaust air can be released to the outside (protection against overpressure in the device). Furthermore, vents allow the intake of air (protection against underpressure in the device).

- ⇒ Carry out venting on the side that faces away from the operator level.
- ⇒ When connecting the attachments, make sure that they can be accessed from the operator level safely and easily.

5.2 Preparing for assembly

Valves with lining must be handled, transported and stored with care, see Chapter "4 Shipment and on-site transport".

Perform the following steps after receiving the goods:

- ⇒ Check the scope of supply. Compare the delivered goods with the delivery note.
- ⇒ Check the supply for transport damage. Report transport damage to PFEIFFER and the transport company (see the delivery note).

Ensure the following conditions prior to assembly:

- The valve is clean.
- The valve data on the type plate (type, nominal size, material, nominal pressure and temperature range) matches the plant conditions (nominal size and nominal pressure of the pipe, medium temperature, etc.). For details about the type plate, see Chapter "2 Markings on the device".
- Desired or required additional fittings, see Chapter "3.2 Additional fittings", are installed or prepared as far as necessary before the assembly of the valve.

5.3 Assembling the valve and actuator

PFEIFFER valves are supplied in working order. In individual cases, the actuator and valve are delivered separately and must be assembled. The tasks are listed below that are necessary for assembly and prior to the commissioning of the valve.

WARNING

Danger and damage due to retrofitting an actuator unit!

The subsequent fitting of an actuator unit can pose a danger to the user and cause damage to the pipe system.

- ⇒ The travel torque, displacement and adjustment of the "OPEN" and "CLOSED" end stops must be adapted to the valve.

WARNING

Danger and damage due to use of an electrical actuator!

- ⇒ It must be made sure that the valve in the "CLOSED" position is turned off by the signal of the torque switch.
- ⇒ In the "OPEN" position, the valve must be turned off by the limit switch.
- ⇒ For further instructions, see the electrical actuator manual.

Danger and damage due to high external loads on an actuator unit!

Actuators are not "stepladders".

- ⇒ Loads may not be applied to the actuators as they can damage or destroy the valve.

Danger and damage due to heavy actuator units!

Actuators that are heavier than the weight of the valve can pose a danger to the user and cause damage to the pipe system.

- ⇒ These actuators must be supported if they generate a bending stress on the valve due to their size and/or installation situation.

NOTE

Damage to the valve due to incorrect travel adjustment!

If a SAMSON actuator is retrofitted, a preadjustment of the travel is necessary:

- ⇒ For details about travel adjustment, see Chapter "5.3.1 Travel adjustment with separately supplied SAMSON actuator".

The actuating device is adjusted to the operating data specified in the order:

- ⇒ The adjustment of the "OPEN" and "CLOSED" end stops is the responsibility of the user.

5.3.1 Travel adjustment with separately supplied SAMSON actuator

With a separately supplied valve and SAMSON actuator, the dimension "H" from the upper edge of the coupling nut to the upper edge of the yoke must be adjusted according to the table and is checked during assembly.

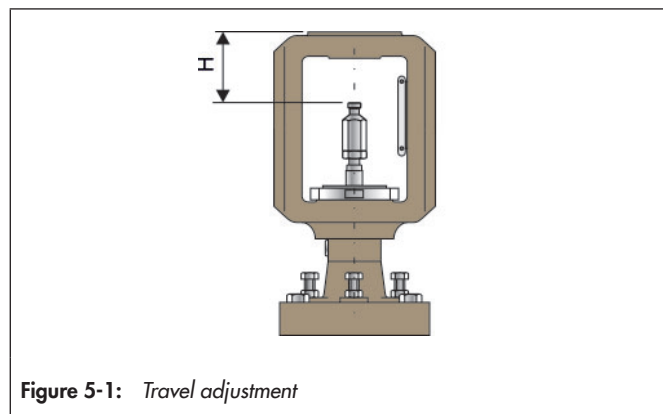


Table 5-1: Travel adjustment when installing SAMSON actuators (valve closed)

Samson-Actuator	H _{Nominal} FAIL CLOSE	H _{Nominal} FAIL CLOSE	H _{Nominal} FAIL OPEN
120	75	78	78
175v2	75	78	78
240	75	78	78
350v2	75	78	85
355v2	75	78	85
700	90	95	104
750v2	90	93	98
1400	165	169	185
2800	315	325	355

Table 5-2: Preferred combinations of the valve BR 01a with SAMSON actuators type 3277 and 3271

Nominal size	DN	15	25	40	50	80	100	150	200
	NPS	½	1	1½	2	3	4	6	8
SAMSON actuator	120 cm ²	•							
	175v2 cm ²		•	•	•				
	240 cm ²		•	•	•				
	350v2 cm ²		•	•	•				
	355v2 cm ²		•	•	•				
	700 cm ²						•	•	•
	750v2 cm ²					•	•	•	•
	1400 cm ²							•	•
	2800 cm ²								•

5.3.1.1 Actuator travel limit

In some cases, a travel limit is required for the actuator. Details about the travel limit can be found in the corresponding actuator documentation.

For SAMSON actuators:

- Pneumatic actuator type 3271, actuator surface: 120 cm², see the Installation and Operating Manual ► EB 8310-1, Chapter "6.2 Setting travel limits".
- Pneumatic actuator type 3271, actuator surface: 1400-60 cm², see the Installation and Operating Manual ► EB 8310-3, Chapter "6.2 Setting travel limits".
- Pneumatic actuator type 3271 and type 3277, actuator surface: 355v2 cm², see the Installation and Operating Manual ► EB 8310-4, Chapter "6.2 Travel limits".
- Pneumatic actuator type 3271 and type 3277, actuator surfaces: 175v2, 350v2 and 750v2 cm², see the Installation and Operating Manual ► EB 8310-5, Chapter "6.2 Travel limits".
- Pneumatic actuator type 3271 and type 3277, actuator surfaces: 240, 350 and 700 cm², see the Installation and Operating Manual ► EB 8310-6, Chapter "6.2 Travel limits".
- Pneumatic actuator type 3271, actuator surface: 2800 cm², see the Installation and Operating Manual ► EB 8310-7, Chapter "6.1.3 Adapting the travel range".

Details about the other actuators can also be found in the corresponding actuator documentation.

The dimensions provided in Table 5-3 reach a suitable pretension that implements the sealing between the seat and the plug.

Table 5-3: Actual travel

Travel 15 mm	Actual travel 16 to 17 mm
Travel 30 mm	Actual travel 31 to 32 mm

5.4 Installing the valve in the pipe

5.4.1 General

NOTE

Damage to the lined valve surface due to improper transport and installation!

Before and during installation, the lined surfaces can be damaged and must be specifically protected.

- ⇒ Transport the valve in its original packaging to the installation site and unpack it only there.
- ⇒ Handle the valve with care and observe the instructions for the flange connection.

Damage to the plastic lined surfaces on the body due to improper installation!

- ⇒ The use of PTFE flange seals is recommended.
- ⇒ The counterflanges must have smooth sealing surfaces.
- ⇒ Other shapes must be agreed upon with PFEIFFER.

- ⇒ Inspect the valve and actuator for transport damage. Damaged valves or actuators may not be installed.
- ⇒ A functional test is to be carried out at the beginning of installation only for manually-operated valves: The valve must close and open correctly. Detected malfunctions must be fixed before commissioning. See also chapter 8 "Malfunction".

DANGER

Danger due to exceeding the limits of use!

Exceeding the limits of use can pose a danger to the user and cause damage to the pipe system.

- ⇒ No valve may be installed whose permissible pressure/temperature range is not sufficient for the operating conditions.
 - ⇒ The max. permissible limits of use are marked on the valve, see Chapter "2 Markings on the device".
 - ⇒ The permissible range is defined in Chapter "1 Safety instructions and safety measures".
- ⇒ Make sure that only valves are installed whose pressure class, connection type (flow rate), type of lining and connection dimensions match the conditions of use. See the corresponding marking on the valve.

- ⇒ The connection ends of the pipes must align with the valve connections and have plane-parallel ends. Connection flanges that are not plane parallel can damage the PTFE lining during installation!
- ⇒ The connection data for the actuator unit must match the control data. See the type plate(s) on the actuator unit.
- ⇒ Prior to installation, the valve and the connected pipe must be carefully cleaned of any contamination, in particular solid foreign matter.
- ⇒ The sealing surfaces on the flange connection and the utilized flange seals must in particular be free of all contamination during installation.
- ⇒ An arrow is marked on the body. The direction of the arrow must correspond to the direction of flow in the pipe.

Info

It may be necessary in special cases for a valve to be tight against the direction of flow.

For installation in these special cases, contact PFEIFFER as this could lead to an excessive strain on the bellows, seat, plug, etc.

- ⇒ When pushing in the valve (and the flange seals) into an already assembled pipe, the distance between the pipe ends must be measured such that all sealing surfaces (and seals) remain undamaged.

NOTE

Tightening the flange connections.

The flange connections must be tightened in at least three steps at the same time and in a criss-cross pattern with the torques indicated in Table 15-7 or Table 15-8 in Chapter "15.1.1 Tightening torques".

Torque wrenches must be used to ensure that the torque is reached but not exceeded.

Tightening the body screws.

As the PTFE plastic sealing surfaces tend to flow, it is strongly recommended, after a long storage period of the lined valve, to retighten the body screws after installation using the tightening torques according to Table 15-1 to Table 15-4 in Chapter "15.1.1 Tightening torques".

- ⇒ Vents are screwed into the exhaust air connections of pneumatic and electropneumatic devices to ensure that the generated exhaust air can be released to the outside (protection against overpressure in the device).
Furthermore, vents allow the intake of air (protection against underpressure in the device).
- ⇒ Carry out venting on the side that faces away from the working area of operating personnel.
- ⇒ When installing peripheral devices, make sure that they can be operated from the working area of operating personnel.

5.4.2 Installing the valve

- ⇒ Close the valve in the pipe for the duration of the installation.
- ⇒ Remove the protective caps on the valve openings prior to installation.
- ⇒ Lift the valve with suitable lifting equipment at the installation site, see chapter "4.3 Transporting and lifting the valve". When doing so observe the flow direction of the valve. An arrow on the valve indicates the flow direction.
- ⇒ Make sure that the correct flange seals are used.
- ⇒ Screw the pipe together with the valve without tension.
- ⇒ After installing the valve, open it slowly in the pipe.

! NOTE

Damage to the valve due to a sudden pressure increase and resulting high flow speed!

Open the valve slowly in the pipe during commissioning.

- ⇒ Check the correct function of the valve.

5.5 Checking the assembled valve

5.5.1 Functional check

! WARNING

Danger of injury due to pressurised components and escaping medium!

– Do not loosen the test connection while the valve is pressurised.

Danger of crushing due to moving actuator stem and stem!

- Do not reach into the yoke as long as the pneumatic power is connected to the actuator.
- Before working on the valve, interrupt and lock pneumatic energy and the control signal.
- Do not allow the jamming of objects in the yoke to hinder the operation of the stem and actuator stem.
- If the actuator stem and stem are blocked (e.g. due to "seizure" if not actuated for a long period of time"), release the residual energy of the actuator (spring tension) before releasing the blockage, see the corresponding actuator documentation.

Danger of injury due to escaping exhaust air!

During operation, when regulating or when opening and closing the valve, exhaust air can escape, for example from the actuator.

⇒ Wear eye protection when working near the valve.

- ⇒ At the end of installation, perform a functional test with the control signals:
The valve must close and open correctly according to the control commands. Detected malfunctions must be fixed before commissioning, see Chapter "8 Malfunction".

! WARNING

Danger due to improperly executed control commands!

Incorrectly executed control commands can cause serious injuries or even death and cause damage to the pipe system.

- ⇒ Check the actuator unit and control command., see chapter "8 Malfunction"

5.5.2 Pressure test of the pipe section

The pressure test was already performed on the valves by PFEIFFER. Observe the following for the pressure test of a pipe section with installed valves:

- ⇒ First carefully rinse newly installed pipe systems in order to wash out all foreign matter.
- ⇒ Ensure the following conditions for the pressure test:
 - Retract the plug in order to open the valve.
 - Valve open: The test pressure may not exceed the value $1.5 \times PN$ (according to the type plate) or the marked test pressure PT.

If a valve leaks, observe chapter "8 Malfunction".

i Info

The plant operator is responsible for performing the pressure test. After Sales Service at PFEIFFER can provide you with support for the planning and implementation of a pressure test specific to your plant.

5.5.3 Travel movement

The travel movement of the actuator stem must be linear without any jerky movements.

- ⇒ Open and close the valve. When doing so, observe the movement of the actuator stem.
- ⇒ Set the maximum and minimum control signal in succession to check the end positions of the valve.
- ⇒ Check the display on the travel indicator.

5.5.4 Fail-safe position

- ⇒ Close and vent the signal pressure line.
- ⇒ Check whether the valve moves to the fail-safe position, see "Fail-safe positions in Chapter "3 Design and principle of operation".

6 Start-up

The work described in this chapter may only be performed by specialist personnel qualified to perform the corresponding task.

WARNING

Danger of burning due to hot or cold components and pipe!

Valve components and pipes can become very hot or very cold during operation and cause burns upon contact.

- ⇒ Let the components and pipes cool down or warm up.
- ⇒ Wear protective garments and protective gloves.

Danger of injury due to pressurised components and escaping medium!

- ⇒ Do not loosen the test connection while the valve is pressurised.

Danger of crushing due to moving actuator stem and stem!

- ⇒ Do not reach into the yoke as long as the pneumatic power is connected to the actuator.
- ⇒ Before working on the valve, interrupt and lock pneumatic energy and the control signal.
- ⇒ Do not allow the jamming of objects in the yoke to hinder the operation of the stem and actuator stem.
- ⇒ If the actuator stem and stem are blocked (e.g. due to "seizure" if not actuated for a long period of time"), release the residual energy of the actuator (spring tension) before releasing the blockage, see the corresponding actuator documentation.

Danger of injury due to escaping exhaust air!

During operation, when regulating or when opening and closing the valve, exhaust air can escape, for example from the actuator.

- ⇒ Wear eye protection when working near the valve

Ensure the following conditions prior to commissioning/recommissioning:

- The valve is installed properly in the pipe, see Chapter "5 Installation".
- The leak and function tests have been completed successfully, see Chapter "5.5 Testing the assembled valve".
- No residual water is present in the flow section of the valve in order to prevent a possible reaction with the medium.
- The current conditions in the concerned plant section correspond to the design of the valve, see Intended use in Chapter "1 Safety instructions and safety measures".

Commissioning/recommissioning

- ⇒ The PTFE plastic sealing surfaces tend to flow. After commissioning and reaching the operating temperature, tighten all flange connections between the pipe and valve with the corresponding tightening torques, see Table 15-7 or Table 15-8 in Chapter "15.1.1 Tightening torque".

- ⇒ If required, retighten the screw connection of the body parts, see Table 15-1 to Table 15-4 in Chapter "15.1.1 Tightening torques".
- ⇒ Open the valve slowly in the pipe. Opening slowly prevents a sudden increase in pressure and a resulting high flow speed that damages the valve.
- ⇒ Check the correct function of the valve.

7 Operation

As soon as the commissioning/recommissioning work is complete, see Chapter "6 Start-up", the valve is ready for operation.

WARNING

Danger of burning due to hot or cold components and pipe!

Valve components and pipes can become very hot or very cold during operation and cause burns upon contact.

- ⇒ Let the components and pipes cool down or warm up.
- ⇒ Wear protective garments and protective gloves.

Danger of injury due to pressurised components and escaping medium!

- ⇒ Do not loosen the test connection while the valve is pressurised.

Danger of crushing due to moving actuator stem and stem!

- ⇒ Do not reach into the yoke as long as the pneumatic power is connected to the actuator.
- ⇒ Before working on the valve, interrupt and lock pneumatic energy and the control signal.
- ⇒ Do not allow the jamming of objects in the yoke to hinder the operation of the stem and actuator stem.
- ⇒ If the actuator stem and stem are blocked (e.g. due to "seizure" if not actuated for a long period of time"), release the residual energy of the actuator (spring tension) before releasing the blockage, see the corresponding actuator documentation.

Danger of injury due to escaping exhaust air!

During operation, when regulating or when opening and closing the valve, exhaust air can escape, for example from the actuator.

- ⇒ Wear eye protection when working near the valve.

Observe the following points during operation:

- ⇒ The PTFE plastic sealing surfaces tend to flow. After commissioning and reaching the operating temperature, tighten all flange connections between the pipe and valve with the corresponding tightening torques, see Table 15-7 or Table 15-8 in Chapter "15.1.1 Tightening torque".
- ⇒ If required, retighten the screw connection of the body parts, see Table 15-1 to Table 15-4 in Chapter "15.1.1 Tightening torques".
- ⇒ The valve/actuator unit must be actuated with the control signals.
- Valves that were delivered from the factory with an actuator are precisely adjusted. The user is responsible for any changes they make.
- For the manual operation or manual override of the actuator (if present), normal manual forces are sufficient and the use of extensions to increase the actuation torque is not permitted.

- Valves with a bellows generally have a test connection (e.g. 1/4") between the bellows and the outer stem sealing. This makes it possible to check if the bellows is not damaged.
- Upon customer request, these valves can also be equipped without a test connection.
- ⇒ If a valve leaks, observe chapter "8 Malfunktion".

8 Malfunction

When rectifying the faults, chapter "1 Safety instructions and safety measures" must be observed.

8.1 Detecting and rectifying errors

Type of fault	Possible cause	Measure
Leaks in the pipe connection	The flange connection of the lined valve is leaky	<p>Tighten the flange screws.</p> <hr/> <p>NOTE</p> <p>An excessive tightening torque when retightening the flange screws can damage the valve and pipe. The permissible torque for retightening the pipe flange screws is limited.</p> <hr/> <p>Retighten the flange connection with the respective tightening torque, see Table 15-7 or Table 15-8 in Chapter "15.1.1 Tightening torques". If necessary, increase the torque 20%.</p>
	The flange connection is still leaky after retightening	<p>Loosen the flange connection and remove the valve, see chapter "1 Safety instructions and safety measures".</p> <p>Check the plane parallelism of the flange connection and correct if it is not sufficient.</p> <p>Check the surfaces on all flanges. If the plastic lining is damaged, replace the valve together with its flange seal.</p> <p>Check the flange seals. If the seals are damaged, replace them.</p>
Leaks in the body parts	The bonnet flange connection loosened	Retighten the flange connection with the respective tightening torque, see Table 15-1 to Table 15-4 in Chapter "15.1.1 Tightening torques".
	Body parts untight after retightening	Replace the body sealing and/or valve, see chapter "1 Safety instructions and safety measures".
Increased medium flow rate with valved closed	Leakage in the closed position	Remove and inspect the valve, see chapter "1 Safety instructions and safety measures".
	The valve is damaged	<p>Repairs are necessary.</p> <p>Remove the valve, see chapter "1 Safety instructions and safety measures".</p> <p>Request spare parts from PFEIFFER, see Chapter "15.2 Spare parts". For the required repair instructions, see Chapter "12 Repairs".</p>
Leaks in the stem sealing	Medium escapes from the test connection	<p>Repairs are necessary.</p> <p>Remove the valve, see chapter "1 Safety instructions and safety measures".</p> <p>Disassemble the valve and replace the bellows or diaphragm.</p> <p>Request spare parts from PFEIFFER, see Chapter "15.2 Spare parts". For the required repair instructions, see Chapter "12 Repairs".</p>
	(Additional possible causes and measures on the following page)	<p>With the option "adjustable stuffing box", medium escapes from the stuffing box</p> <p>This version does not have a test connection on the bonnet. The backup packing is leaky in the delivered state above a gas pressure of approx. 2 bar. This is obtained with an adjustment path of 3 mm with the red paint sealed backup packing.</p>

Type of fault	Possible cause	Measure
Leaks in the stem sealing	Medium escapes from the stuffing box	<p>If the valve on the stuffing box is leaky, the bellows is defective.</p> <hr/> <p>⚠ DANGER</p> <p><i>Danger of injury due to hazardous media!</i> <i>It must be kept in mind that the media is usually hazardous.</i> ⇨ <i>All necessary safety measures must be taken to prevent possible accidents.</i></p> <hr/> <p>Tighten the sealed stuffing box.</p> <hr/> <p>⚠ WARNING</p> <p><i>Danger due to missing primary sealing!</i> <i>The valve is tight again. Sealing by the stuffing box should only take place for a short period, as there is no primary sealing.</i> ⇨ <i>Repair the valve as quickly as possible.</i></p> <hr/> <p>Remove the valve, see chapter "1 Safety instructions and safety measures".</p> <p>Disassemble the valve and replace the bellows. Check the bonnet flange for corrosion caused by the medium and replace if necessary.</p> <p>Request spare parts from PFEIFFER, see Chapter "15.2 Spare parts". For the required repair instructions, see Chapter "12 Repairs".</p>
Malfunction.	The actuator unit or control does not react	Check the actuator unit and control command.
	The actuator and control are OK	Remove and inspect the valve, see chapter "1 Safety instructions and safety measures".
	The valve is damaged	<p>Repairs are necessary.</p> <p>Remove the valve, see chapter "1 Safety instructions and safety measures".</p> <p>Request spare parts from PFEIFFER, see Chapter "15.2 Spare parts". For the required repair instructions, see Chapter "12 Repairs".</p>
Problems in the actuator unit.	The pneumatic actuator must be removed	<p>Disconnect the connection to the control pressure.</p> <p>Remove the actuator from the valve, observe the "Safety instructions and safety measures", see the included actuator unit manuals.</p>

i Info

- In the case of faults that are not listed in the table, contact the After Sales Service at PFEIFFER.
- Spare parts must be ordered indicating all the data according to the valve marking. Only original parts from PFEIFFER Chemie-Armaturenbau GmbH may be installed.
- If it is determined after removal that the PFA lining is not sufficiently resistant for the medium, parts must be selected made of a suitable material.

8.2 Carrying out emergency measures

In the case of a power supply failure, the valve automatically switches to the preset fail-safe position, (see "Fail-safe positions" in Chapter "3 Design and principle of operation").

The system operator is responsible for emergency measures.

In case of a valve fault:

- Close the valves upstream and downstream of the valve so that no medium flows through the valve.
- Troubleshoot the error, see chapter „8.1 Detecting and rectifying errors“.
- Rectify the fault that can be fixed as indicated in the instructions provided in this installation and operating manual. For faults that cannot be fixed, contact the After Sales Service at PFEIFFER.

Recommissioning after faults

See Chapter "6 Start-up".

9 Servicing

The work described in this chapter may only be performed by specialist personnel qualified to perform the corresponding task.

The following documents are required in addition for the maintenance of the valve:

- Installation and operating manual for the installed actuator, e.g. ► EB 8310-X for actuators type 3271 and type 3277 or the corresponding actuator documentation of other manufacturers.

WARNING

Danger of burning due to hot or cold components and pipe!

Valve components and pipes can become very hot or very cold during operation and cause burns upon contact.

- ⇒ Let the components and pipes cool down or warm up.
- ⇒ Wear protective garments and protective gloves.

Danger of injury due to pressurised components and escaping medium!

- ⇒ Do not loosen the test connection while the valve is pressurised.

Danger of crushing due to moving actuator stem and stem!

- ⇒ Do not reach into the yoke as long as the pneumatic power is connected to the actuator.
- ⇒ Before working on the valve, interrupt and lock pneumatic energy and the control signal.
- ⇒ Do not allow the jamming of objects in the yoke to hinder the operation of the stem and actuator stem.
- ⇒ If the actuator stem and stem are blocked (e.g. due to "seizure" if not actuated for a long period of time), release the residual energy of the actuator (spring tension) before releasing the blockage, see the corresponding actuator documentation.

Danger of injury due to escaping exhaust air!

During operation, when regulating or when opening and closing the valve, exhaust air can escape, for example from the actuator.

- ⇒ Wear eye protection when working near the valve.

Danger of injury due to prestressed springs!

Actuators with preloaded actuator springs are pressurised. These actuators can be identified by the elongated screws on the bottom of the actuator.

- ⇒ Release the compression from the preloaded springs before working on the actuator, see the corresponding actuator documentation.

Danger of injury due to residual medium in the valve!

When working on the valve, residual medium can escape and, depending on the medium properties, cause injuries (e.g. scalding, chemical burns).

- ⇒ Wear protective garments, protective gloves and eye protection.

NOTE

Damage to the valve due to excessively high or low tightening torques!

The valve components must be tightened with specific torques. Excessively tightened components are subject to increased wear. Insufficiently tightened components can cause leakage.

- ⇒ Observe the tightening torques, see Table 15-1 to Table 15-4 in Chapter "15.1.1 Tightening torques".

Damage to the valve due to unsuitable tools!

- ⇒ Only use tools approved by PFEIFFER, see Chapter "15.1.3 Tools".

Damage to the valve due to unsuitable lubricants!

- ⇒ Only use lubricants approved by PFEIFFER, see Chapter "15.1.2 Lubricants".

Info

The valve was checked by PFEIFFER prior to delivery.

- Certain test results certified by PFEIFFER are no longer valid when disassembling the valve. This includes the test for seat leakage and the leak test (outer tightness).
- If maintenance and repair work is performed without approval from the After Sales Service of PFEIFFER, the product guarantee will be voided.
- Only use original parts from PFEIFFER as spare parts that correspond to the original specification.

9.1 Periodic tests

- ⇒ Depending on the conditions of use, the valve must be checked at defined intervals in order to take remedial measures prior to possible malfunctions. The plant operator is responsible for preparing a suitable test plan
- ⇒ PFEIFFER recommends the following inspections that can be carried out during operation:

Test	Measures in the case of a negative test result
If present, check the test connection and bellows sealing for tightness. WARNING! Danger of injury due to pressurised components and escaping medium! Do not loosen the test connection while the valve is pressurised.	Decommission the valve, see chapter "10 Decommissioning". Contact the After Sales Service at PFEIFFER to repair the bellows, See chapter "12 Repairs".

Test	Measures in the case of a negative test result
Check the lifting movement of the actuator stem and stem for linear, smooth movement.	Tighten the packing correctly. If the actuator stem and stem are blocked, remove the blockage. WARNING! If the actuator stem and stem are blocked (e.g. due to "seizure" if not actuated for a long period of time) they can release unexpectedly and move uncontrolled. This can lead to crushing if reaching into them. Before trying to release a blockage of the actuator stem and stem, interrupt and lock the pneumatic energy and the control signal. Release the residual energy of the actuator (spring tension or compressed air reservoir) before releasing the blockage, see the corresponding actuator documentation.
If possible, check the fail-safe position of the valve by briefly interrupting the power supply.	Decommission the valve, see chapter "10 Decommissioning". Then determine the cause and remedy it, see Chapter "8 Malfunctions".

9.2 Maintenance work

- ⇒ The valve must be prepared before all maintenance work, see Chapter 12 "Repairs".
- ⇒ After all maintenance work, the valve must be checked prior to recommissioning, see Chapter "5.5 Checking the mounted valve".

9.2.1 Replacing the seat and plug

NOTE

Damage to the sealing surfaces on the seat and plug due to incorrect maintenance!

- ⇒ Always replace the seat and plug together.

- ⇒ Check the condition of the plug and seat.
- ⇒ Remove the seat (4) as described in Chapter "12.4 Replacing the seat". Check the seat as well as all plastic parts for damage and if in doubt replace them.
- ⇒ Remove the plug (14) as described in Chapter "12.5 Replacing the plug". Check the seat, plug as well as all plastic parts for damage and if in doubt replace them.

9.3 Ordering spare parts and consumables

Information about spare parts, lubricants and tools can be received from the After Sales Service at PFEIFFER.

Spare parts

Information on spare parts can be found in Chapter "15.2 Spare parts".

10 Decommissioning

The work described in this chapter may only be performed by specialist personnel qualified to perform the corresponding task.

WARNING

Danger of burning due to hot or cold components and pipe!

Valve components and pipes can become very hot or very cold during operation and cause burns upon contact.

- ⇒ Let the components and pipes cool down or warm up.
- ⇒ Wear protective garments and protective gloves.

Danger of injury due to pressurised components and escaping medium!

- ⇒ Do not loosen the test connection while the valve is pressurised.

Danger of crushing due to moving actuator stem and stem!

- ⇒ Do not reach into the yoke as long as the pneumatic power is connected to the actuator.
- ⇒ Before working on the valve, interrupt and lock pneumatic energy and the control signal.
- ⇒ Do not allow the jamming of objects in the yoke to hinder the operation of the stem and actuator stem.
- ⇒ If the actuator stem and stem are blocked (e.g. due to "seizure" if not actuated for a long period of time"), release the residual energy of the actuator (spring tension) before releasing the blockage, see the corresponding actuator documentation.

Danger of injury due to escaping exhaust air!

During operation, when regulating or when opening and closing the valve, exhaust air can escape, for example from the actuator.

- ⇒ Wear eye protection when working near the valve.

Danger of injury due to residual medium in the valve!

When working on the valve, residual medium can escape and, depending on the medium properties, cause injuries (e.g. scalding, chemical burns).

- ⇒ Wear protective garments, protective gloves and eye protection.
- ⇒ Do not loosen the test connection while the valve is pressurised.

To decommission the valve for maintenance and repair work or for disassembly, perform the following steps:

- ⇒ Close the valves upstream and downstream of the valve so that no medium flows through the valve.
- ⇒ Empty the pipe and valve completely.
- ⇒ Shut off the pneumatic power and lock it, to depressurise the actuator.
- ⇒ Let the pipe and valve components cool down or warm up.

11 Removal

The work described in this chapter may only be performed by specialist personnel qualified to perform the corresponding task.

WARNING

Danger of burning due to hot or cold components and pipe!

Valve components and pipes can become very hot or very cold during operation and cause burns upon contact.

- ⇒ Let the components and pipes cool down or warm up.
- ⇒ Wear protective garments and protective gloves.

Danger of crushing due to moving actuator stem and stem!

- ⇒ Do not reach into the yoke as long as the pneumatic power is connected to the actuator.
- ⇒ Before working on the valve, interrupt and lock pneumatic energy and the control signal.
- ⇒ Do not allow the jamming of objects in the yoke to hinder the operation of the stem and actuator stem.
- ⇒ If the actuator stem and stem are blocked (e.g. due to "seizure" if not actuated for a long period of time"), release the residual energy of the actuator (spring tension) before releasing the blockage, see the corresponding actuator documentation.

Danger of injury due to residual medium in the valve!

When working on the valve, residual medium can escape and, depending on the medium properties, cause injuries (e.g. scalding, chemical burns).

- ⇒ Wear protective garments, protective gloves and eye protection.
- ⇒ Do not loosen the test connection while the valve is pressurised.

Danger of injury due to prestressed springs!

- ⇒ SAMSON actuators with preloaded actuator springs are pressurised. These actuators can be identified by the elongated screws on the bottom of the actuator.
- ⇒ Before working on the actuator, release the compression from the preloaded springs.

Prior to disassembly, make sure that the following conditions are met:

- The valve is decommissioned, see chapter "10 Decommissioning".

11.1 Removing the valve from the pipe

- ⇒ Loosen the flange connection.
- ⇒ Remove the valve from the pipe, see Chapter "4.3 Transporting and lifting the valve".

WARNING

If a used valve is sent to PFEIFFER for service:

The valves must be decontaminated properly in advance.

- ⇒ When returning a used valve, include the safety data sheet for the medium as well as confirmation of decontamination of the valve. Otherwise the valve will not be accepted.

Tip

PFEIFFER recommends documenting the following contamination data in the form FM 8.7-6 "Declaration regarding the contamination of PFEIFFER valves and components".

11.2 Disassembling the actuator

See the corresponding actuator documentation.

12 Repairs

If the valve no longer works properly or if it does not work at all, it is defective and must be repaired or replaced.

WARNING

Danger due to defective lining!

⇒ *The lining may not be repaired!*

NOTE

Damage to the valve due to improper maintenance and repair!

- ⇒ *Do not perform maintenance and repair work on your own.*
- ⇒ *Contact the After Sales Service at PFEIFFER for maintenance and repair work.*

In special cases, certain maintenance and repair work may be performed.

The work described in this chapter may only be performed by specialist personnel qualified to perform the corresponding task.

The following instructions apply additionally for valves. For decommissioning and disassembly, observe Chapter "10 Decommissioning" and Chapter "11 Disassembly".

12.1 Replacing the bellows

If a leak is found in the test connection (24), the bellows (15) is defective.

- ⇒ Check the condition of the bellows.
- Disassemble the valve for the removal of the bellows. For this purpose, observe Chapter "1 Safety instructions and safety measures".
- ⇒ Clamp the assembled valve with the bonnet flange facing up in a vice.
- ⇒ Release the screws (36) and, depending on the design, the nuts (37).
- ⇒ Carefully lift the bonnet flange up off the valve body and place it on a clean, even surface.
- ⇒ Check the bellows as well as all plastic parts for damage and if in doubt replace them.
- ⇒ Assemble the valve as described in Chapter 3.5.1 and Chapter 3.5.2.

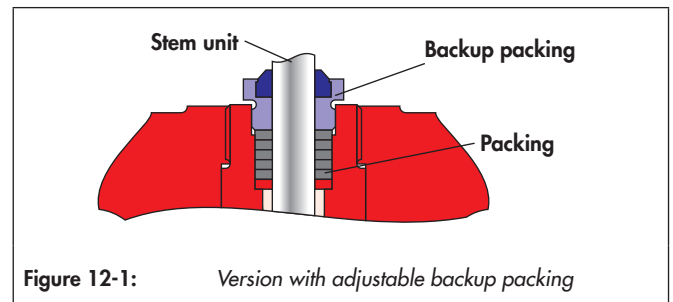
12.2 Replacing the bellows and the packing

If the stuffing box is not tight, the packing and the bellows can be defective.

- ⇒ Check the condition of the packing and the bellows.
- Disassemble the valve for the removal of the stuffing box and the bellows. For this purpose, observe Chapter "1 Safety instructions and safety measures".
- ⇒ Place the valve with the stem guide facing up on an even work surface.

- ⇒ Release the stuffing box (27) and screw it out of the bonnet flange.
- ⇒ Remove the graphite packing (26) or the PFFE V-ring packing (33), check for damage and if in doubt replace it.
- ⇒ Remove the bellows (15) as described in Chapter "12.1 Replacing the bellows". Check the bellows as well as all plastic parts for damage and if in doubt replace them also.
- ⇒ Assemble the valve as described in Chapter 3.5.1 and Chapter 3.5.2.

12.3 Adjusting the stuffing box (option)



This version does not have a test connection on the bonnet.

- ⇒ The stuffing box
 - is not tight in the delivered state above a gas pressure of approx. 2 bar
 - is glued in place with Loctite 668
 - is sealed with red paint as a visual marking
 - adjustment YES/NO
 - can be tightened further approx. 3 mm and is then gas tight up to 16 bar.
- ⇒ The glued connection
 - is constantly stuck and afterwards can be tightened without problems with a tool.
 - is designed for a temperature range of -10 to +200°C
- ⇒ If the valve on the stuffing box is not tight, the bellows are defective.

DANGER

Danger due to a leak in the stuffing box!

- ⇒ *All necessary safety measures must be taken to prevent possible accidents:*
- ⇒ *It must be kept in mind that the media is usually hazardous*

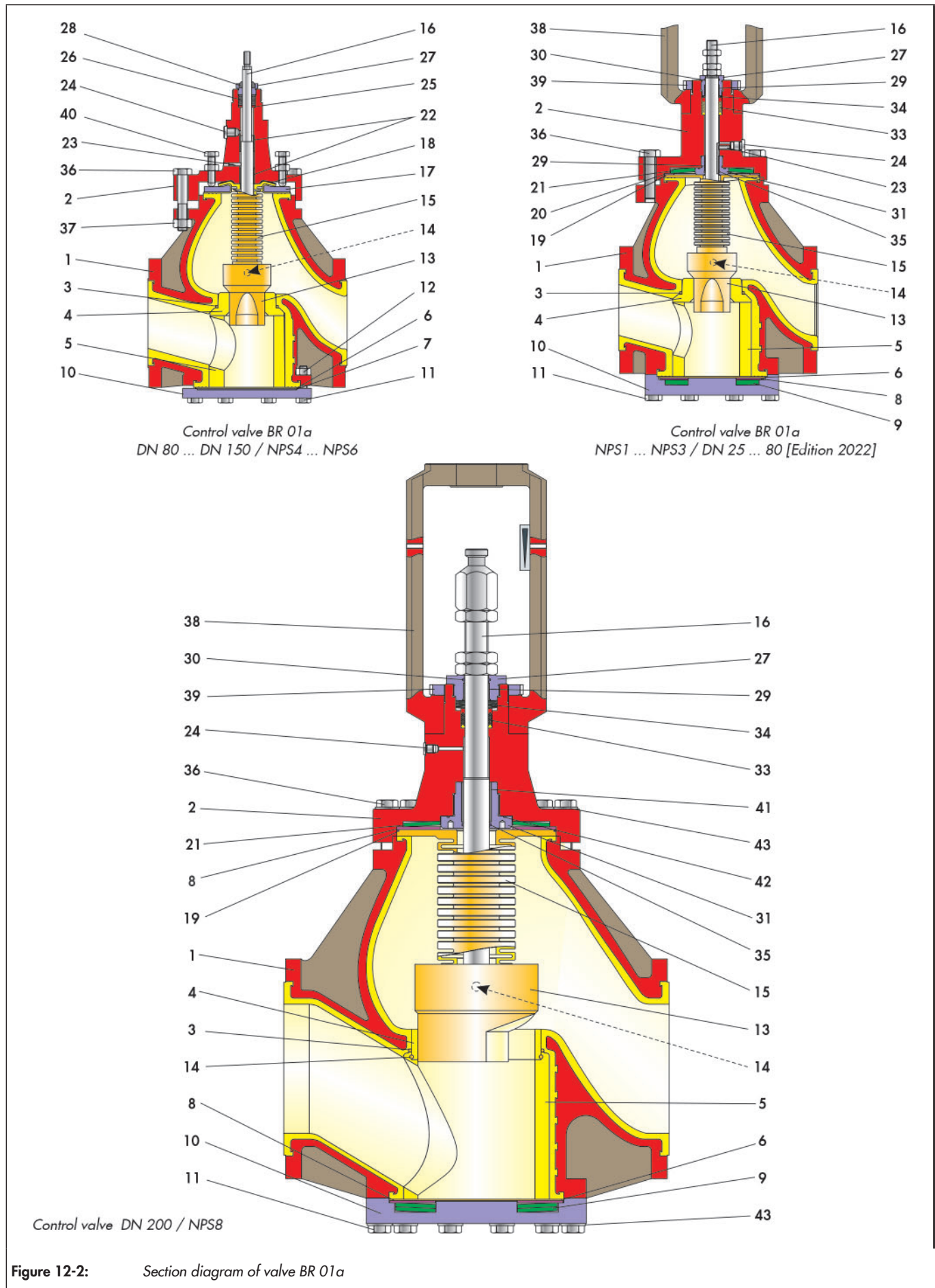


Figure 12-2: Section diagram of valve BR 01a

Table 12-1: Parts list

Item	Designation	Item	Designation	Item	Designation	Item	Designation
1	Valve body	12	Nut	23	Grooved pin	34	Set of spring washers
2	Bonnet flange	13	Plug	24	Screw plug	35	O-ring
3	O-ring	14	Cord	25	Washer	36	Screw
4	Seat	15	Bellows	26	Packing	37	Nut
5	Spacer	16	Stem	27	Stuffing box	38	Yoke
6	Washer	17	Bordered flange	28	Wiper ring	39	Grooved nut
7	Inlay	18	Washer	29	Bearing bushing	40	Support bolt
8	Thrust washer	19	O-ring	30	O-ring	41	Bearing bushing
9	Spring washer	20	Thrust washer	31	Guide bushing	42	O-ring
10	Bottom flange	21	Spring washer	32	Distance bushing	43	Washer
11	Screw/ stud bolt	22	Bushing	33	V-ring packing		

⇒ Tighten the stuffing box.

i Info

The valve is tight again but must be repaired as soon as possible, as there is no primary sealing and the stuffing box should be sealed only for a short period.

⇒ The repair must be made as described in Chapter "12.1 Replacing the bellows".

12.4 Replacing the seat

If a leak is found in the flow, the seat and plug can be defective.

⇒ Check the condition of the seat.

Disassemble the valve for the removal of the seat. For this purpose, observe Chapter "1 Safety instructions and safety measures".

- ⇒ Clamp the valve with the stem guide facing down in a vice.
- ⇒ Release the screws (11) and, depending on the design, the nuts (12).
- ⇒ Remove the bottom flange (10).
- ⇒ Remove the washer (6) and inlay (7), thrust washer (8) and spring washer (9), if applicable.
- ⇒ Undo and remove the spacer (5).
- ⇒ Remove the seat (4).
- ⇒ Check the seat as well as all plastic parts for damage and if in doubt replace them.
- ⇒ Assemble the valve as described in Chapter 3.5.1 and Chapter 3.5.2.

12.5 Replacing the plug

If a leak is found in the flow, the seat and plug can be defective.

⇒ Check the condition of the plug.

Disassemble the valve for the removal of the bellows. For this purpose, observe Chapter "1 Safety instructions and safety measures".

- ⇒ Clamp the assembled valve with the bonnet flange facing up in a vice.
- ⇒ Release the screws (36) and, depending on the design, the nuts (37).
- ⇒ Carefully lift the bonnet flange up off the valve body and place it on a clean, even surface.
- ⇒ Check the plug, bellows as well as all plastic parts for damage and if in doubt replace them.
- ⇒ Assemble the valve as described in Chapter 3.5.1 and Chapter 3.5.2.

12.6 Additional repairs

⇒ In the case of additional major damage, it is recommended to have repairs performed by PFEIFFER.

12.7 Sending devices to PFEIFFER

Defective valves can be sent to PFEIFFER for repair.

Proceed as follows to send devices:

WARNING

Danger due to a contaminated valve!

- ⇒ *When returning a used valve to the manufacturer for service, decontaminate the valve properly in advance.*
- ⇒ *When returning a used valve, include the safety data sheet for the medium as well as confirmation of decontamination of the valve. Otherwise the valve will not be accepted.*

Tip

PFEIFFER recommends documenting the contamination data in the form FM 8.7-6 "Declaration regarding the contamination of PFEIFFER valves and components".

-
- ⇒ Include the following information for returns:
 - Manufacturer number
 - Valve type
 - Article number
 - Nominal size and version of the control valve
 - Manual valve / automated valve
 - Medium (designation and consistency)
 - Medium pressure and temperature
 - Flow rate in m³/h
 - Bench range of the actuator (e.g. 0.2 to 1 bar)
 - Number of actuations (year, month, week or day)
 - Installation drawing if available
 - Completed declaration regarding contamination. This form is available at ► www.pfeiffer-armaturen.com.

13 Disposal

- ⇒ For disposal, observe the local, national and international regulations.
- ⇒ Do not dispose of old components, lubricant and hazardous materials with domestic waste.

14 Certificates

The declaration of conformity is available on the following pages:

- Declaration of conformity according to Pressure Equipment Directive 2014/68/EU for automated valves, see page 14-2.
- Declaration of conformity according to Pressure Equipment Directive 2014/68/EU for manually operated valves, see page 14-3.
- Declaration of conformity for completed machinery according to Machinery Directive 2006/42/EC for valve BR 01a, see page 14-4.
- Declaration of conformity for partly completed machinery according to Machinery Directive 2006/42/EC for valve BR 01a, see page 14-5.

The printed certificates correspond to the status at the time of printing. Further optional certificates are available upon request.

DECLARATION OF CONFORMITY

As per Pressure Equipment Directive 2014/68/EU
TRANSLATION



The manufacturer	PFEIFFER Chemie-Armaturenbau GmbH , D47906 Kempen, Germany
declares that:	Type 01a PTFE-lined Control Valves (BR 01a) with PTFE bellows seal <ul style="list-style-type: none"> • with pneumatic/ electric/ hydraulic actuator • with free shaft end for subsequent mounting of an actuator
<p>1. The valves are pressure accessories within the meaning of the Pressure Equipment Directive 2014/68/EU and conform with the requirements of this Directive.</p> <p>2. They may only be operated observing the Installation and operating instructions ► EB 01a delivered together with the valve.</p> <p>The commissioning of these valves is only permitted after the valve has been installed from both sides in the pipeline and a risk of injury can be ruled out. (See ► EB 01a, Chapter 1 for control valves intended for dead-end service)</p>	

Applied standards:

AD 2000 Regulations	Regulations for pressurized valve body parts
----------------------------	--

Type designation and technical features:

PFEIFFER Data sheet ► TB 01a NOTE: This Manufacturer's Declaration applies to all valve types listed in this catalogue.
--

Applied conformity assessment procedure:

Conforming to Annex III of the Pressure Equipment Directive 2014/68/EU, Module H


Name of notified body:

Identification number of the notified body:

TÜV Rheinland Service GmbH Am Grauen Stein 51101 Köln Germany	0035
---	------

These Declarations become invalid when modifications are made to the control valves and/or assemblies that affect the technical data of the control valve or the <Intended use> described in ► EB 01a, Chapter 1 of the Installation and operating instructions, and considerably change the valve or an assembly delivered with it.

Kempen, 1. September 2022



 Stefan Czayka
 Head of Quality Management/IMS Representative

DECLARATION OF CONFORMITY

As per Pressure Equipment Directive 2014/68/EU
TRANSLATION



The manufacturer	PFEIFFER Chemie-Armaturenbau GmbH , D47906 Kempen, Germany
declares that:	Type 01a PTFE-lined Control Valves (BR 01a) with PTFE bellows seal • with hand wheel
<p>1. The valves are pressure accessories within the meaning of the Pressure Equipment Directive 2014/68/EU and conform with the requirements of this Directive.</p> <p>2. They may only be operated observing the Installation and operating instructions ► EB 01a delivered together with the valve.</p> <p><i>(See ► EB 01a, Chapter 1 for control valves intended for dead-end service)</i></p>	

Applied standards:

AD 2000 Regulations	Regulations for pressurized valve body parts
----------------------------	--

Type designation and technical features:

<p>PFEIFFER Data sheet ► TB 01a <i>NOTE: This Manufacturer's Declaration applies to all valve types listed in this catalogue.</i></p>

Applied conformity assessment procedure:

Conforming to Annex III of the Pressure Equipment Directive 2014/68/EU, Module H

Name of notified body:

Identification number of the notified body:

<p>TÜV Rheinland Service GmbH Am Grauen Stein 51101 Köln Germany</p>	0035
---	------

These Declarations become invalid when modifications are made to the control valves and/or assemblies that affect the technical data of the control valve or the <Intended use> described in ► EB 01a, Chapter 1 of the Installation and operating instructions, and considerably change the valve or an assembly delivered with it.

Kempen, 1. September 2022


Stefan Czayka
Head of Quality Management/IMS Representative

EU DECLARATION OF CONFORMITY TRANSLATION



The manufacturer	PFEIFFER Chemie-Armaturenbau GmbH, 47906 Kempen, Germany
declares for the listed products that:	<p>Type 01a PTFE-lined Control Valve (BR01a)</p> <ul style="list-style-type: none"> • with a Type 3271 Pneumatic Actuator • with a Type 3277 Pneumatic Actuator • with an actuator of a different make <p>Prerequisite: the unit was sized and assembled by PFEIFFER Chemie-Armaturenbau GmbH. The serial number on the valve refers to the entire unit.</p>
<p>1. It complies with all applicable requirements stipulated in Machinery Directive 2006/42/EC.</p> <p>2. In the delivered state, the valve with actuator is considered to be final machinery as defined in the above mentioned directive.</p> <p>The start-up of these units is only permitted after the valve has been installed from both sides in the pipeline and a risk of injury can be ruled out as a result.</p>	

Referenced standards:

<p>a) VCI, VDMA, VGB: "Leitfaden Maschinenrichtlinie (2006/42/EG) – Bedeutung für Armaturen, Mai 2018" [German only]</p> <p>b) VCI, VDMA, VGB: "Zusatzdokument zum Leitfaden Maschinenrichtlinie (2006/42/EG) – Bedeutung für Armaturen vom Mai 2018" [German only], based on DIN EN ISO 12100:2011-03</p>
--


Product description and technical features:

<p>Tight-closing valve for aggressive media, particularly for strict requirements in chemical applications, fitted with an actuator.</p> <p>For product descriptions refer to: PFEIFFER data sheet for Type 01a Valve ▶ TB 01a SAMSON data sheet for Types 3271 and 3277 Actuators ▶ T 8310-X PFEIFFER mounting and operating instructions for Type 01a Valve ▶ EB 01a SAMSON mounting and operating instructions for Types 3271 and 3277 Actuators ▶ EB 8310-X PFEIFFER safety manual for Type 01a Valve ▶ SH 01 SAMSON safety manual for Types 3271 and 3277 Actuators ▶ SH 8310</p> <p>Valve accessories (e.g. positioners, limit switches, solenoid valves, lock-up valves, supply pressure regulators, volume boosters and quick exhaust valves) are classified as machinery components and do not fall within the scope of the Machinery Directive as specified in § 35 and § 46 of the Guide to Application of the Machinery Directive 2006/42/EC issued by the European Commission.</p>

This declaration becomes invalid when modifications are made to the control valves and/or assemblies that affect the technical data of the control valve or the intended use (▶ EB 01a, section 1) and considerably change the valve or an assembly delivered with it.

Persons authorized to compile the technical file:

Kempen, 28 May 2021



Stefan Czayka
 Head of Quality Management/IMS Representative

DECLARATION OF CONFORMITY

TRANSLATION



The manufacturer	PFEIFFER Chemie-Armaturenbau GmbH, 47906 Kempen, Germany
declares for the listed products that:	Type 01a PTFE-lined Control Valve (Type 01a) <ul style="list-style-type: none"> with free shaft end
<p>1. In the delivered state, the valve prepared for mounting on a linear actuator (not a clearly defined actuator system) is considered to be partly completed machinery as defined in the Machinery Directive 2006/42/EC.</p> <p>Machinery is considered to be partly completed machinery when the machinery manufacturer has not determined all required specifications such as model type, thrusts, torques etc.</p> <p>The start-up of these units is only permitted after the valve has been installed from both sides in the pipeline and a risk of injury can be ruled out as a result.</p>	

Referenced standards:

- a) VCI, VDMA, VGB: "Leitfaden Maschinenrichtlinie (2006/42/EG) – Bedeutung für Armaturen, Mai 2018" [German only]
- b) VCI, VDMA, VGB: "Zusatzdokument zum Leitfaden Maschinenrichtlinie (2006/42/EG) – Bedeutung für Armaturen vom Mai 2018" [German only], based on DIN EN ISO 12100:2011-03

Product description and technical features:

Tight-closing control valve for aggressive media, particularly for strict requirements in chemical applications.

For product descriptions refer to:

PFEIFFER Data Sheet for Type 01a Control Valve ▶ TB 01a

PFEIFFER Mounting and Operating Instructions for Type 01a Control Valve ▶ EB 01a

Valve accessories (e.g. positioners, limit switches, solenoid valves, lock-up valves, supply pressure regulators, volume boosters and quick exhaust valves) are classified as machinery components and do not fall within the scope of the Machinery Directive as specified in § 35 and § 46 of the Guide to Application of the Machinery Directive 2006/42/EC issued by the European Commission.

This declaration becomes invalid when modifications are made to the control valves and/or assemblies that affect the technical data of the control valve or the intended use (▶ EB 01a, section 1) and considerably change the valve or an assembly delivered with it.

Persons authorized to compile the technical file:

Kempen, 22 November 2021

Stefan Czayka

Head of Quality Management/IMS Representative

15 Annex

15.1 Tightening torques, lubricant and tools

15.1.1 Tightening torques

i Info

- All tightening torques are indicated in Nm.
- Tightening torque tolerance: $\pm 10\%$.
- After long operating times or use at temperatures above 80°C , the breakaway torque can be considerably higher.

15.1.1.1 Bottom flange

For the connection of the bottom flange (10) with the valve body, the screw connections are tightened in a criss-cross pattern with the tightening torques indicated below.

Table 15-1: Tightening values for the bottom flange screw connections for DIN version

DN [mm]	25	40	50	80	100	150	200
MA [Nm]	10	15	25	30	30	40	

Table 15-2: Tightening values for the bottom flange screw connections for ANSI version

NPS [inch]	1	1½	2	3	4	6	8
MA [Nm]	50	50	50	50	30	40	

15.1.1.2 Bonnet flange

For the connection of the bonnet flange (2) with the valve body, the screw connections are tightened in a criss-cross pattern with the tightening torques indicated below.

Table 15-3: Tightening values for the bonnet flange screw connections for DIN version

DN [mm]	25	40	50	80	100	150	200
MA [Nm]	45	45	45	80	80	130	

Table 15-4: Tightening values for the bonnet flange screw connections for ANSI version

NPS [inch]	1	1½	2	3	4	6	8
MA [Nm]	45	45	45	80	80	130	

15.1.1.3 Support bolts

To pretension the flared flange, the support bolts (40) are tightened alternately and evenly according to the following torques.

Table 15-5: Tightening values of the support bolts on the DIN version

DN [mm]	80	100	150
MA [Nm]	20	20	20

Table 15-6: Tightening values of the support bolts on the ANSI version

NPS [inch]	4	6
MA [Nm]	20	20

15.1.1.4 Flange connections

Table 15-7: Tightening values for the DIN flange connections

DN [mm]	25	40	50	80	100	150	200
MA [Nm]	25	50	60	65	75	140	

Table 15-8: Tightening values for the ANSI flange connections

NPS [inch]	1	1½	2	3	4	6	
MA [Nm]	15	30	40	65	50	100	

15.1.2 Lubricant

Table 15-9: Recommended lubricant

Use	Temperature range	Lubricant
-10 ... +200°C	Screws and nuts	Heavy-duty grease paste (e.g. Gleitmo 805, manufacturer Fuchs) Not suitable for grease-free valves or for use with oxygen!
-10 ... +200°C	Stem sealing and parts in contact with media	Water-free grease, e.g. halo-carbon TM

15.1.3 Tools

Suitable tools are required to work on the valve. Unsuitable tools can damage the valve.

15.2 Spare parts

PFEIFFER recommends spare part sets for "Commissioning" and for "2-year operation", see Chapter:

- „15.2.1 Spare parts for DIN-Valves, DN 25 ... 50“
- „15.2.2 Spare parts for DIN-Valves, DN 80 ... 150“
- „15.2.3 Spare parts for DIN-Valves, DN 200“
- „15.2.4 Spare parts for ANSI-Valves, NPS1 ... 3 and DIN-Valves, DN 25 ... 80 [Edition 2022]“ and DIN-Valves, DN 25 ... 80 [Edition 2022]
- „15.2.5 Spare parts for ANSI-Valves, NPS4 ... 6“
- „15.2.6 Spare parts for ANSI-Valves, NPS8“

15.2.1 Spare parts for DIN-Valves, DN 25 ... 50

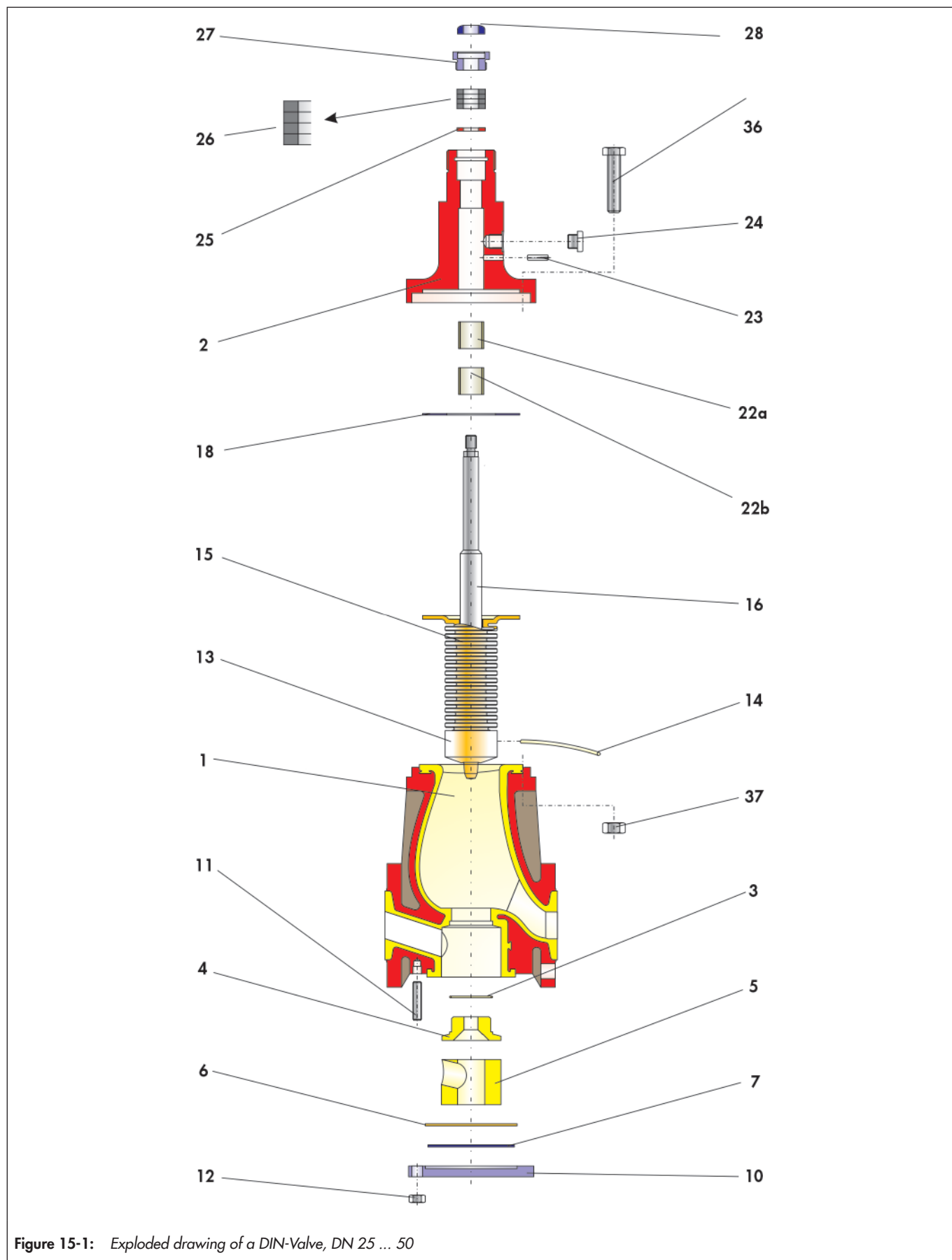


Figure 15-1: Exploded drawing of a DIN-Valve, DN 25 ... 50

Table 15-10: Recommended spare parts for a DIN-Valve, DN 25 ... 50

Item	Designation	Material	In the spare parts set for commissioning	Included in the set of seals	In the spare parts for 2 year operation
1	Valve body	EN-JS 1049 / PTFE			
2	Bonnet flange	EN-JS 1049			
3	O-ring	PTFE	•		•
4	Seat	PTFE		•	•
5	Spacer	PTFE			
6	Washer	PTFE	•		•
7	Inlay	Uniseal 3400	•		•
10	Bottom flange	EN-JS 1049			
11	Screw / Stud bolt	A2-70			
12	Nut	A2-70			
13	Plug	PTFE		•	•
14	Cord	PTFE	•		•
15	Bellows	PTFE			•
16	Stem	1.4571			
18	Washer	Uniseal 3400	•		•
22	Bushing	Glycodur F	•		•
23	Grooved pin	1.4301	•		•
24	Locking screw	Steel galvanized	•		•
25	Washer	1.4571	•		•
26	Packing	PTFE-Graphite	•		•
27	Stuffing box	1.4301			
28	Wiper ring	Buna	•		•
36	Screw	A2-70			
37	Nut	A2-70			

15.2.2 Spare parts for DIN-Valves, DN 80 ... 150

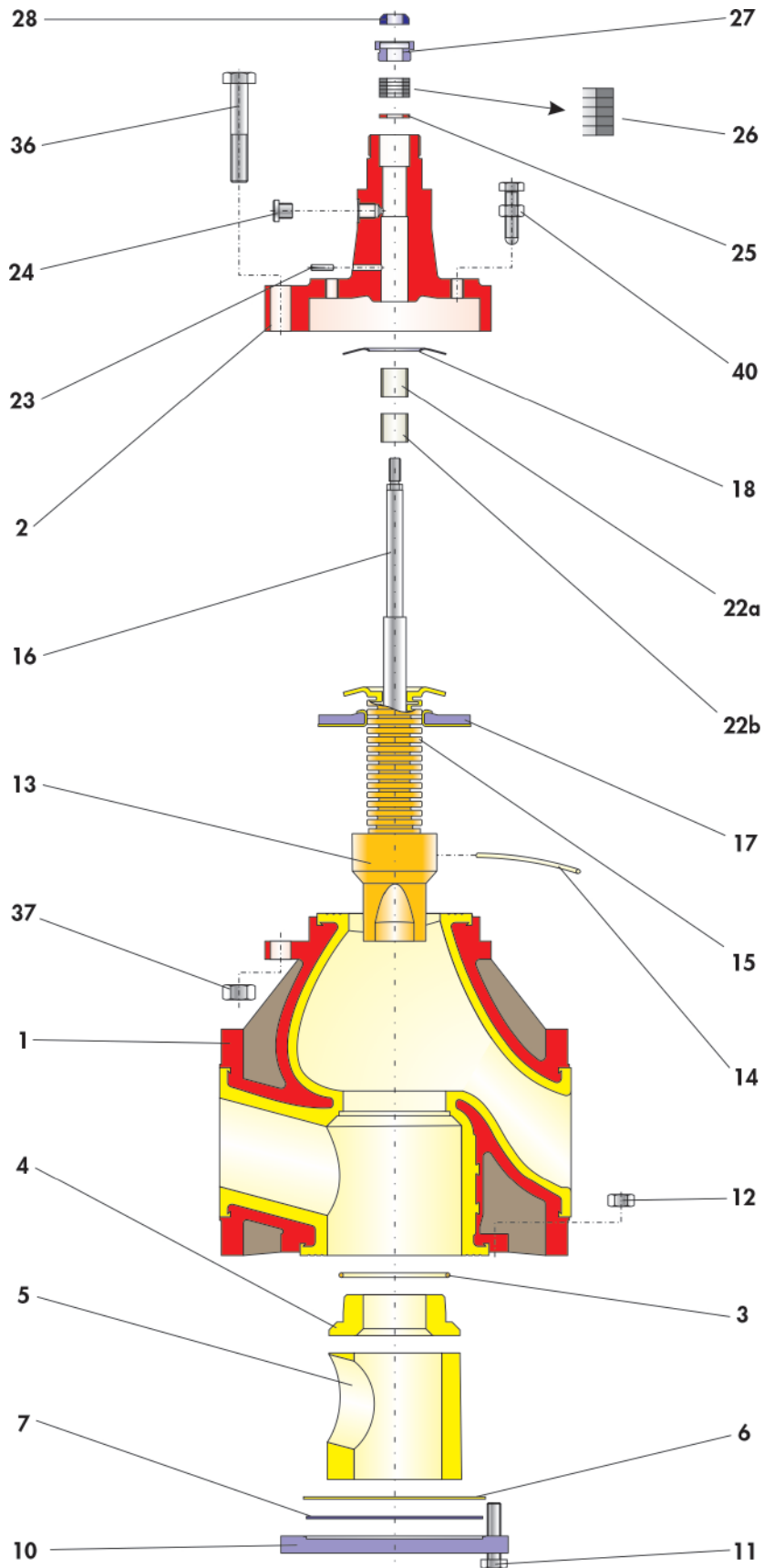


Figure 15-2: Exploded drawing of a DIN-Valve, DN 80 ... 150

Table 15-11: Recommended spare parts for a DIN-Valve, DN 80 ... 150

Item	Designation	Material	In the spare parts set for commissioning	Included in the set of seals	In the spare parts for 2 year operation
1	Valve body	EN-JS 1049 / PTFE			
2	Bonnet flange	EN-JS 1049			
3	O-ring	PTFE	•		•
4	Seat	PTFE		•	•
5	Spacer	PTFE			
6	Washer	PTFE	•		•
7	Inlay	Uniseal 3400	•		•
10	Bottom flange	EN-JS 1049			
11	Screw / Stud bolt	A2-70			
12	Nut	A2-70			
13	Plug	PTFE		•	•
14	Cord	PTFE	•		•
15	Bellows	PTFE			•
16	Stem	1.4571			
17	Bordered flange	St 37 / PTFE	•		•
18	Washer	Uniseal 3400	•		•
22	Bushing	Glycodur F	•		•
23	Grooved pin	1.4301	•		•
24	Locking screw	Steel galvanized	•		•
25	Washer	1.4571	•		•
26	Packing	PTFE-Graphit	•		•
27	Stuffing box	1.4301			
28	Wiper ring	Buna	•		•
36	Screw	A2-70			
37	Nut	A2-70			
40	Screw	A2-70			

15.2.3 Spare parts for DIN-Valves, DN 200

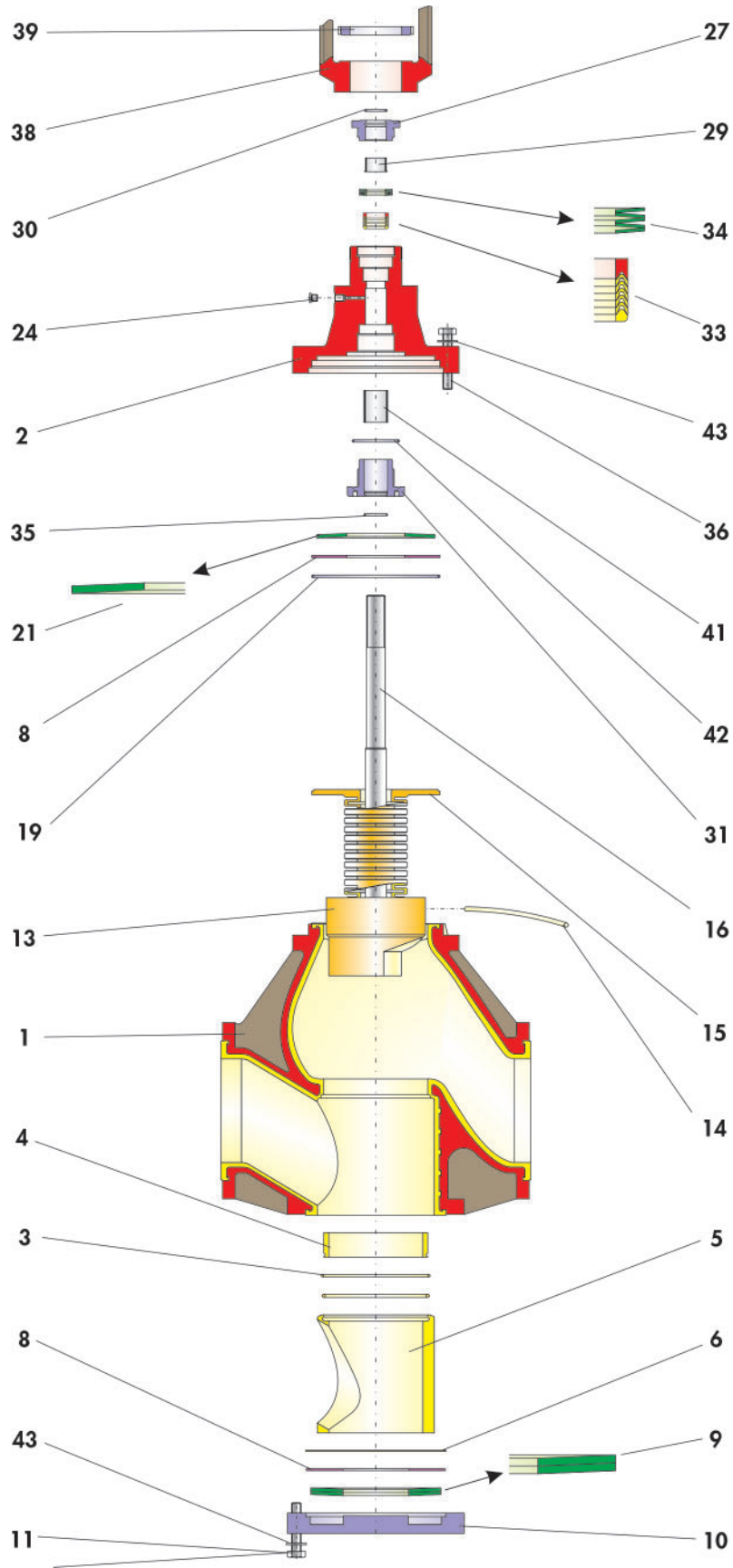


Figure 15-3: Exploded drawing of a DIN-Valve, DN 200

Table 15-12: Recommended spare parts for a DIN-Valve, DN 200

Item	Designation	Material	In the spare parts set for commissioning	Included in the set of seals	In the spare parts for 2 year operation
1	Valve body	EN-JS 1049 / PTFE			
2	Bonnet flange	EN-JS 1049			
3	O-ring	PTFE	•		•
4	Seat	PTFE		•	•
5	Spacer	PTFE			
6	Washer	PTFE	•		•
8	Thrust washer	1.4301			
9	Spring washer	1.8159 / DeltaTone	•		•
10	Bottom flange	EN-JS 1049			
11	Screw / Stud bolt	A2-70			
13	Plug	PTFE		•	•
14	Cord	PTFE	•		•
15	Bellows	PTFE			•
16	Stem	1.4571			
19	O-ring	EPDM	•		•
21	Spring washer	1.8159 / DeltaTone	•		•
24	Locking screw	Steel galvanized	•		•
27	Stuffing box	1.4301			
29	Bearing bushing	PTFE with 25% carbon	•		•
30	O-ring	Viton	•		•
31	Guide bushing	1.4305			
33	V-ring packing	1.4305 / PTFE	•		•
34	Set of spring washers	1.8159 / DeltaTone	•		•
35	O-ring	Viton	•		•
36	Screw	A2-70			
38	Yoke	EN-JS 1049			
39	Slotted nut	A2-70			
41	Bearing bushing	PTFE with 25% carbon	•		•
42	O-ring	PTFE	•		•
43	Washer	A2			

15.2.4 Spare parts for ANSI-Valves, NPS1 ... 3 and DIN-Valves, DN 25 ... 80 [Edition 2022]

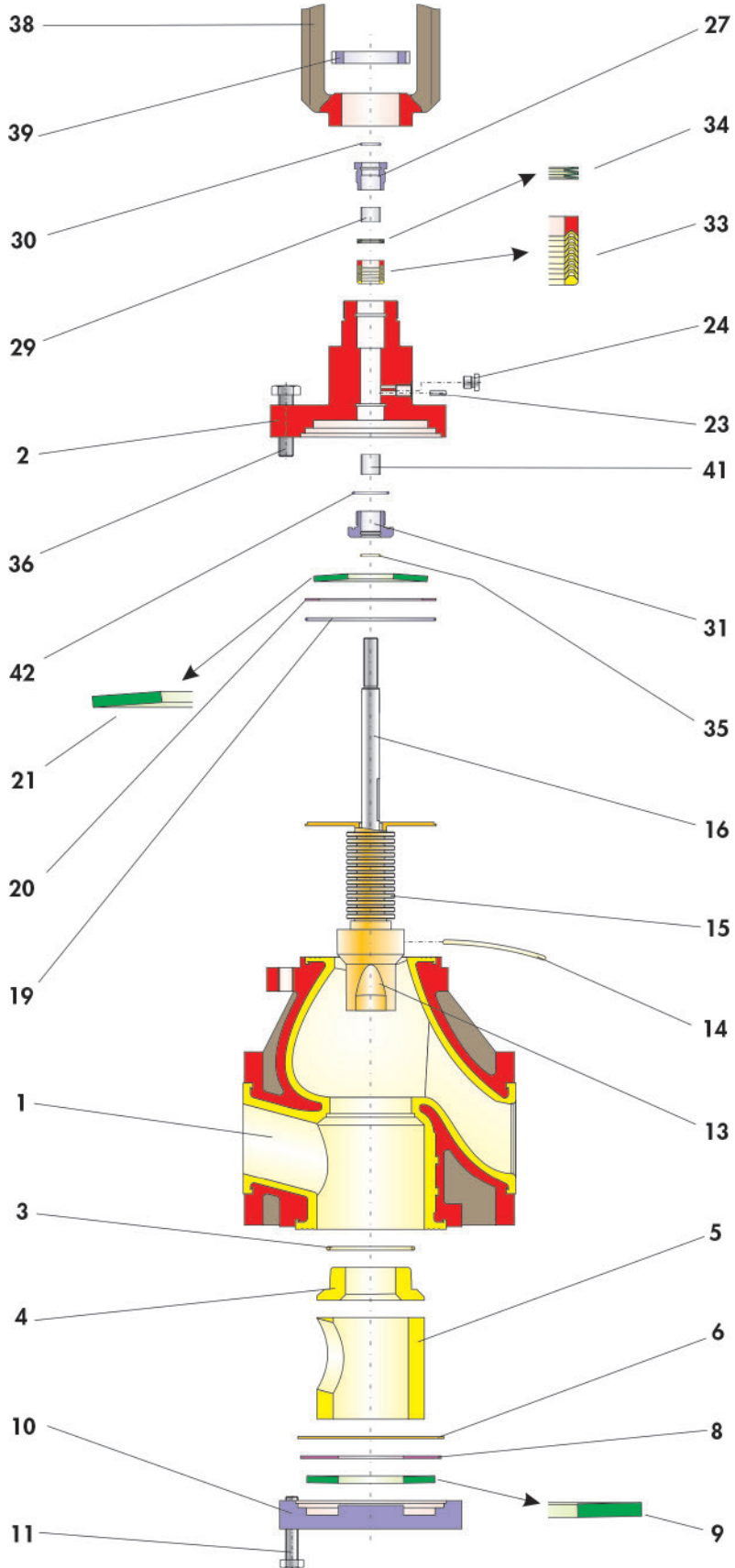


Figure 15-4: Exploded drawing of a ANSI-Valve, NPS1 ... 3

Table 15-13: Recommended spare parts for a ANSI-Valve, NPS1 ... 3

Item	Designation	Material	In the spare parts set for commissioning	Included in the set of seals	In the spare parts for 2 year operation
1	Valve body	A395 / PTFE			
2	Bonnet flange	A395			
3	O-ring	PTFE	•		•
4	Seat	PTFE		•	•
5	Spacer	PTFE			
6	Washer	PTFE	•		•
8	Thrust washer	1.4301			
9	Spring washer	1.8159 / DeltaTone	•		•
10	Bottom flange	A105			
11	Screw / Stud bolt	A193-B7			
13	Plug	PTFE		•	•
14	Cord	PTFE	•		•
15	Bellows	PTFE			•
16	Stem	1.4571	•		•
19	O-ring	EPDM	•		•
20	Thrust washer	1.4301			
21	Spring washer	1.8159 / DeltaTone	•		•
23	Grooved pin	1.4301	•		•
24	Locking screw	Steel gavanized	•		•
27	Stuffing box	1.4301			
29	Bearing bushing	PTFE with 25% carbon	•		•
30	O-ring	Viton	•		•
31	Guide bushing	1.4305			
33	V-ring packing	1.4305 / PTFE	•		•
34	Set of spring washers	1.8159 / DeltaTone	•		•
35	O-ring	Viton	•		•
36	Screw	A193-B7			
38	Yoke	EN-JS 1049			
39	Slotted nut	A2-70			
41	Bearing bushing	PTFE with 25% carbon	•		•
42	O-ring	PTFE	•		•

15.2.5 Spare parts for ANSI-Valves, NPS4 ... 6

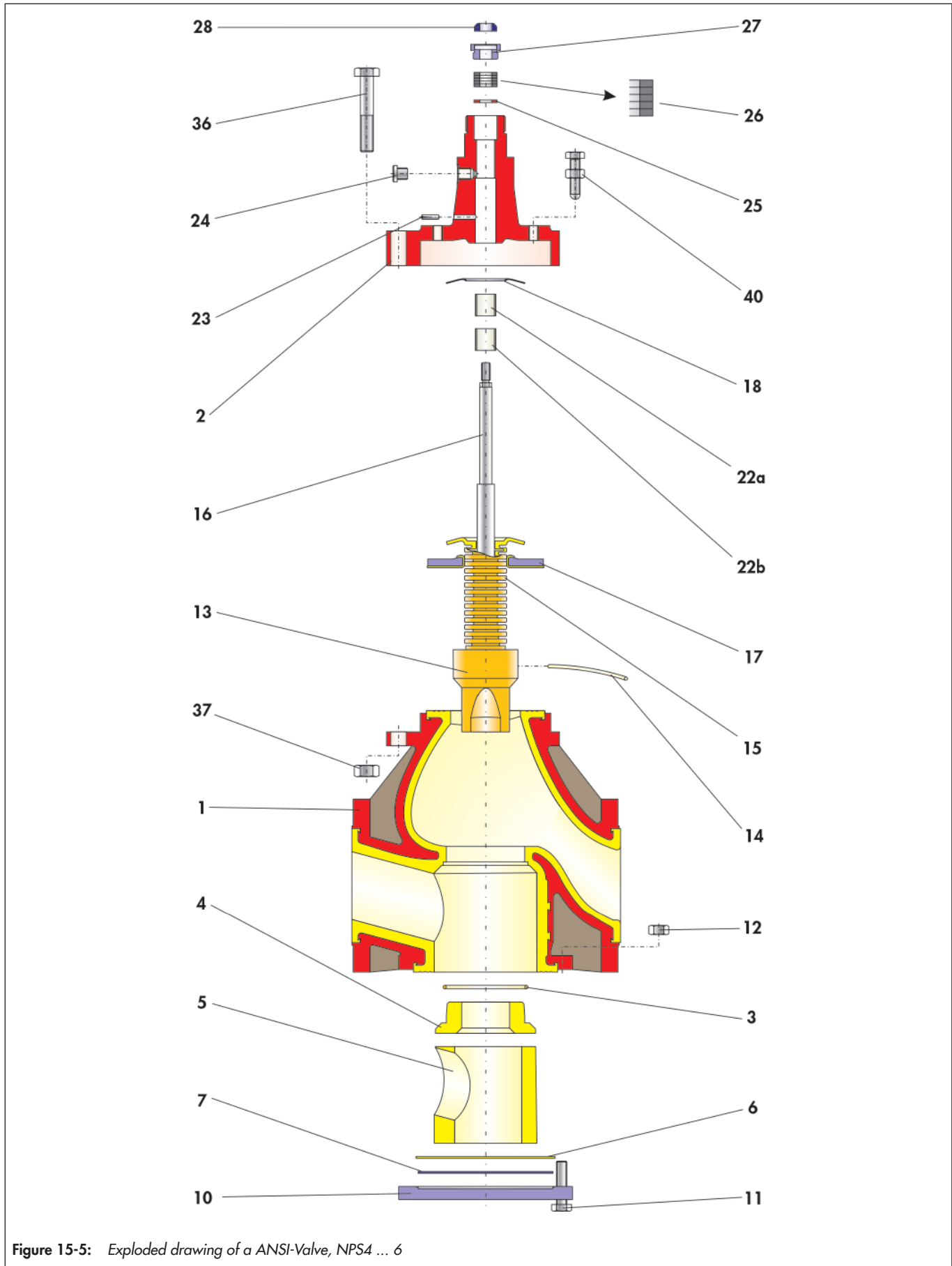


Figure 15-5: Exploded drawing of a ANSI-Valve, NPS4 ... 6

Table 15-14: Recommended spare parts for a ANSI-Valve, NPS4 ... 6

Item	Designation	Material	In the spare parts set for commissioning	Included in the set of seals	In the spare parts for 2 year operation
1	Valve body	A395 / PTFE			
2	Bonnet flange	A395 1049			
3	O-ring	PTFE	•		•
4	Seat	PTFE		•	•
5	Spacer	PTFE			
6	Washer	PTFE	•		•
7	Inlay	Uniseal 3400	•		•
10	Bottom flange	A105			
11	Screw / Stud bolt	A193-B7			
12	Nut	A2-70			
13	Plug	PTFE		•	•
14	Cord	PTFE	•		•
15	Bellows	PTFE			•
16	Stem	1.4571			
17	Bordered flange	St 37 / PTFE	•		•
18	Washer	Uniseal 3400	•		•
22	Bushing	Glycodur F	•		•
23	Grooved pin	1.4301	•		•
24	Locking screw	Steel galvanized	•		•
25	Washer	1.4571	•		•
26	Packing	PTFE-Graphite	•		•
27	Stuffing box	1.4301			
28	Wiper ring	Buna	•		•
36	Screw	A193-B7			
37	Nut	A2-70			
40	Screw	A2-70			

15.2.6 Spare parts for ANSI-Valves, NPS8

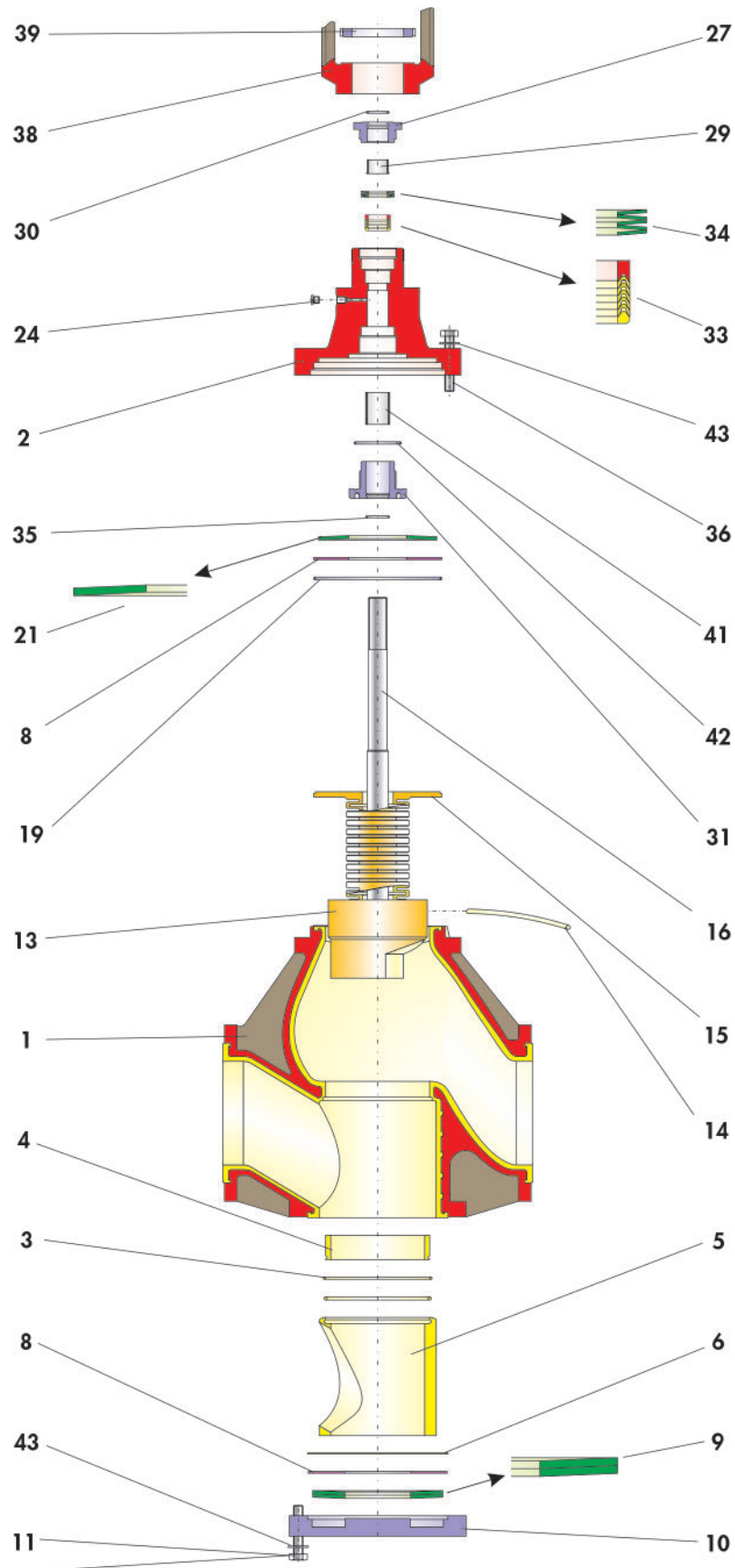


Figure 15-6: Exploded drawing of a ANSI-Valve, NPS8

Table 15-15: Recommended spare parts for a ANSI-Valve, NPS8

Item	Designation	Material	In the spare parts set for commissioning	Included in the set of seals	In the spare parts for 2 year operation
1	Valve body	A395 / PTFE			
2	Bonnet flange	A395 1049			
3	O-ring	PTFE	•		•
4	Seat	PTFE		•	•
5	Spacer	PTFE			
6	Washer	PTFE	•		•
8	Thrust washer	1.4301			
9	Spring washer	1.8159 / DeltaTone	•		•
10	Bottom flange	A105			
11	Screw / Stud bolt	A193-B7			
13	Plug	PTFE		•	•
14	Cord	PTFE	•		•
15	Bellows	PTFE			•
16	Stem	1.4571			
19	O-ring	EPDM	•		•
21	Spring washer	1.8159 / DeltaTone	•		•
24	Locking screw	Steel galvanized	•		•
27	Stuffing box	1.4301			
29	Bearing bushing	PTFE with 25% carbon	•		•
30	O-ring	Viton	•		•
31	Guide bushing	1.4305			
33	V-ring packing	1.4305 / PTFE	•		•
34	Set of spring washers	1.8159 / DeltaTone	•		•
35	O-ring	Viton	•		•
36	Screw	A193-B7			
38	Yoke	EN-JS 1049			
39	Slotted nut	A2-70			
41	Bearing bushing	PTFE with 25% carbon	•		•
42	O-ring	PTFE	•		•
43	Washer	A2			

15.3 Service

For maintenance and repair work as well as malfunctions or defects, contact the After Sales Service at PFEIFFER for support.

E-mail

The After Sales Service can be reached at the e-mail address "sales-pfeiffer-de@samsongroup.com".

Necessary data

Provide the following information in the case of questions and for troubleshooting:

- Manufacturer number
- Valve type
- Article number
- Nominal size and version of the valve
- Manual valve/automated valve
- Medium (designation and consistency)
- Medium pressure and temperature
- Flow rate in m³/h
- Bench range of the actuator (e.g. 0.2 to 1 bar)
- Number of actuations (year, month, week or day)
- Installation drawing if available
- Completed declaration regarding contamination. This form is available at ► www.pfeiffer-armaturen.com.

Further information

The indicated data sheets and further information are available, also in English, at the following address:

PFEIFFER Chemie-Armaturenbau GmbH

Hooghe Weg 41 • 47906 Kempen • Germany

Phone: +49 2152 2005-0 • Fax +49 2152 1580

E-Mail: sales-pfeiffer-de@samsongroup.com

Internet: www.pfeiffer-armaturen.com



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