

Table 1

Pos.	Quant.	Description
1	1	Body
•• 3	1	Ball
• 4	2	Seat
•• 5	1	Stem
• 6	1	Stem seal
• 7	1	Packing
8	1	Gland packing
11	1	Cover
13	-	Cover bolt
• 14	1	Body seal 1
•• 19	1	Spring
•• 20	1	Antistatic ball
• 31	2	Bearing
• 32	2	Bearing disk
• 34	1	Body seal 2
• 35	2	Stem O-ring
41	-	Stud
42	-	Nut
• 43	2	Seat seal 1
44a	2	Seat ring 1
44b	2	Seat ring 2
44c	2	Seat ring 3
45	-	Spring
• 46	2	Seat seal
•• 50	1	Subjection ring
64	1	Body cover
86	6	Plug
• 108	4	Seat O-ring
• 109*	1	Body cover 2 seal
•• 110	1	Subjection ring seal
128*	1	Body cover 2
• 148*	1	Body cover 2 O-ring
159	2	Lug
163*	-	Body cover 2 bolt
164a	3	Grease cup
164b	3	Check valve
• 165	2	Stem bearing

- Start-up: 5% of ordered quantity
- SOFT PARTS
- METALLIC PARTS

Torque screw tightness values for fasteners (Nr. 41 and 42) can be found attached in document DC-08-07-03 PF "Screw torque."

1. SCOPE

This manual is intended as a guide to assist customers or end-users in the correct storage, installation and maintenance of PEKOS Full Trunnion Top Entry ball valves.

2. APPLICABILITY

This manual is applicable to PEKOS Full Trunnion Top Entry ball valves as per norm ANSI with full bore or reduced bore and soft seats. Nominal sizes and pressures covered by this manual: Full bore: NPS 6" – 42" Class 150-600; Reduced bore: NPS 8" – 42" Class 150-600.

3. STORAGE

3.1 Supplying conditions


Carbon steel ball valves are supplied with a phosphatising treatment to protect against corrosion. These conditions are standard, but they can be changed on demand.

3.2 Maintenance during the storage

- Stainless steel and carbon steel valves should be stored separately, to protect the stainless steel against corrosion.
- Valves must remain in open position with plastic end covers fitted.
- If possible, it would be advisable to leave the ball valves in their own packing cases.
- Valves to be stored for a long time shall be checked by the quality control personnel every 6 months.
- Degreased valves shall only be unpacked before installation.

3.3 Environment conditions

- Valves shall be stored in dry conditions. Other corrosive environment conditions must be also avoided.
- Valves must be protected against ambient dust.

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4. INSTALLATION

- Verify that valves have not been damaged during transit. Inspect inside of the valves and the pipeline of the installation to be able to verify there are no strange particles.
- It is advisable to use protective filters during the installation and check-in period while the possibility of dirt or even oxidation of the pipes exists. They have to be used until pipes are absolutely free of particles in suspension.
- If possible, valve shall be mounted in such way to allow periodic inspections.
- Valves are bidirectional, so fluid can run in both directions.
- In order to enable a correct maintenance valves must be mounted with the valve in horizontal position and the stem in vertical position and upwards.
- It is necessary to obtain correct alignment and parallelism to avoid any kind of stress.
- Once the installation is completed, valve must be operated for at least one opening and closing action to ensure perfect operation.
- After cleaning, protective filters could be removed.
- Protective filters should remain installed on dirty applications.

5. MAINTENANCE

Pekos recommends inspecting the valves at least every five (5) years. These inspection intervals could be affected by the process service (fluid, temperature, service, and cycles), and environmental condition.

5.1 Valves revision

PEKOS ball valves do not need lubrication and the packing does not need maintenance (auto-adjustable).

Seats (4), stem seal (6), stem packing (7), bearings (31), bearing disks (32), stem O-rings (35), body seals (14 and 34), seat seals (43 and 46), seat O-rings (108), body cover 2 O-ring (148), stem bearings (165), ball (3) and stem (5) can be replaced easily using common tools. As replacement pieces is advisable to follow the instructions below table1 in page 1.

Prior to carrying out work on valves the pipeline must be completely empty, including the ball valve body cavity by half opening valve to allow any pressure build up to escape.

Care must be taken to avoid contact with dangerous or toxic chemical products. The valves must be thoroughly cleaned, in particular the body cavity, before handling and dismantling.

5.2 Stem leakage

The packing system of the *stem (5)* of PEKOS ANSI ball valves has been designed for durability. In case of leakage, the stem seals should be replaced as follows:

- If the valve comes with a handle installed, loosen the *handle bolt (17)* and remove the *handle (16)*.
- Remove the *subjection ring (50)* and the *subjection ring seal (110)* from the *stem (5)*.
- Make alignment marks on the *body (1)* and *body cover (64)* prior to dismantling, to ensure a correct alignment when reassembling. Loosen the *nuts (42)* and the *lugs (159)*.
- Remove the *body cover (64)* from the *body (1)*.
- Loosen the *cover bolts (13)* from the *cover (11)* and check the *stem bearing (165)*.
- Remove the *stem (5)* from the *body cover (64)*.
- Remove the *stem O-rings (35)*, the *gland packing (8)* and the *stem packing (7)* from *body cover (64)*, check them and replace if necessary.
- Remove the *stem seal (6)* from the *stem (5)*, check it and replace it if necessary.
- Reassemble the pieces accordingly as indicated in point 6.

5.3 Body leakage

The shell of these valves is constructed in 2 pieces; *body (1)* and *body cover (64)*. Body fasteners should be checked for tightness. If leakage occurs, and if necessary, the *body seal 2 (34)* should be replaced as it follows:

- Make alignment marks on the *body (1)* and *body cover (64)* prior to dismantling, to ensure a correct alignment when reassembling. Loosen the *nuts (42)* and the *lugs (159)*.
- Remove the *body cover (64)* from the *body (1)*.
- Substitute the *body seal 2 (34)* from the *body (1)*.
- Reassemble the pieces accordingly as indicated in point 6.

5.3 Body Cover 2 leakage


- Loosen *body cover bolts (163)* and remove the *body cover 2 (128)*.
- Replace the *body cover 2 seal (109)* and the *body cover 2 O-ring (148)* if necessary.
- Reassemble the pieces accordingly as indicated in point 6.

5.4 Seat leakage

According to API 598 it is not allowed any leakage.

The tools for the extraction of the ball and seats (mounting screws) are not standard and will be supplied by Pekos.

- Make alignment marks on the *body (1)* and *body cover (64)* before disassembling, to ensure proper alignment when reassembling. Loosen the *lugs (159)* and the *nuts (42)* and remove the *body cover (64)*.
- Remove the *plugs (86)* of the *body (1)* and introduce the *mounting screws (191)*.
- Turn the 4 *seats mounting screws (191)* at the same time clockwise in order to separate the *Ring seat 2 (44b)* from the *ball (3) + ring seat set (4+44a)*.
- Screw a lug to the ball (3) in order to elevate the *ball (3) + seat rings 1 (44a) set* and check the *seats (4)*.

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- e. Check and replace the *bearing disks (32)* if necessary.
- f. Turn the *seats mounting screws (191)* counter clockwise in order to remove the *ring seats 2 (44b)* and check them.
- g. Replace *seat seals (43 and 46)* and *O-ring seats (108)* if necessary.
- h. Assemble the pieces accordingly as indicated in point 6.

6. RE-ASSEMBLY

Prior to re-assembly, all components and body cavity should be cleaned of any incrustation, dirt, rust etc., especially in the areas of seats and seals.

Body

- a. Put the *body seal 2 (34)* into the housings of the *body (1)*.
- b. For 6"-8" valves put the *bearing (31)* into the housing of the *body (1)*.

Fixed guide seats

- c. The *ring seat 2 (44b)*, the *ring seat 3 (44c)* and the *springs (45)* will be supplied by Pekos in an assembled Kit.
- d. Place the *seat seals (46)* and *O-ring seats (108)* in the *seat ring 2 (44b)* and introduce them in the cavity of *body (1)*.
- e. Repeat these steps with the other seat.

Body - Body Cover 2 (for 10"-12" valves)

- f. Introduce the *body cover 2 seal (109)* and the *body cover 2 O-ring (148)* onto the *body cover 2 (128)*.
- g. Fasten the *body cover 2 (128)* to the *body (1)* by means of the *body cover bolts (163)*.

Ball - Seats

- h. Assemble the *bearing disks (32)* in the trunnions of the *ball (3)*.
- i. Screw the *mounting screws (191)* clockwise.
- j. Place the *seat seal 1 (43)* in the *seat ring 1 (44a)*.
- k. Introduce both *ring seat 1 (44a)* together with the *ball (3)* through the top entry of the *body (1)* placing the *ball (3)* in closed position.
- l. Remove the *mounting screws (191)*.
- m. Screw the *plugs (86)*.
- n. The set ball-seats will be completely aligned when the *body cover (64)* is fit into the *body (1)*.

Stem – Body cover

- o. Put the *stem seal (6)* and the *stem bearing (165)* onto the *stem (5)*. Check the *antistatic device (19, 20)*.
- p. Put the *body seal 1 (14)*, the *stem O-rings (35)* and the *bearing (31)* into the housings of *body cover (64)*.
- q. Assemble the *stem (5)* into the *body cover (64)*.
- r. Slide in the following components onto the *stem (5)* in the following order: *packing (7)* and *gland packing (8)*.
- s. Put the *stem bearing (165)* in the *cover (11)*.
- t. Fasten the *cover (11)* to the *body cover (64)* by means of *body bolts (13)*.
- u. Put the *subjection ring (50)* and the *subjection ring seal (110)* onto the *stem (5)*.

Body – Body cover

- v. Ensure the alignment marks of the *body (1)* and the *body cover (64)* match each other.
- w. Place the *body cover (64)* and two *bolts (41)* and *nuts (42)* to guide the *ball-seats set* to its right position.
- x. Fasten the rest of the *nuts (42)* and evenly tighten them in diagonal using a torque wrench and the values indicated in document DC-08-07-03 PF "Screw torque" attached.
- y. If the valve comes with a handle installed, put the *handle (16)* into its housing in the *stem (5)*, and tighten the *handle bolt (17)*.
- z. Screw the *grease plugs (164a and 164b)*.
- aa. Cycle slowly the valve until completing 1 cycle to ensure coupling between the *seats* and the *ball (3)*.
- bb. Cycle carefully the valve twice in order to check the correct operation. The *stem (5)* should rotate smoothly offering resistance as indicated by the manufacturers torque figures. Tests should be carried out according to API 598 before reinstallation.

The end user is responsible, in case that the fluid is not communicated, checking the compatibility of the service media/ fluid with the valve materials.