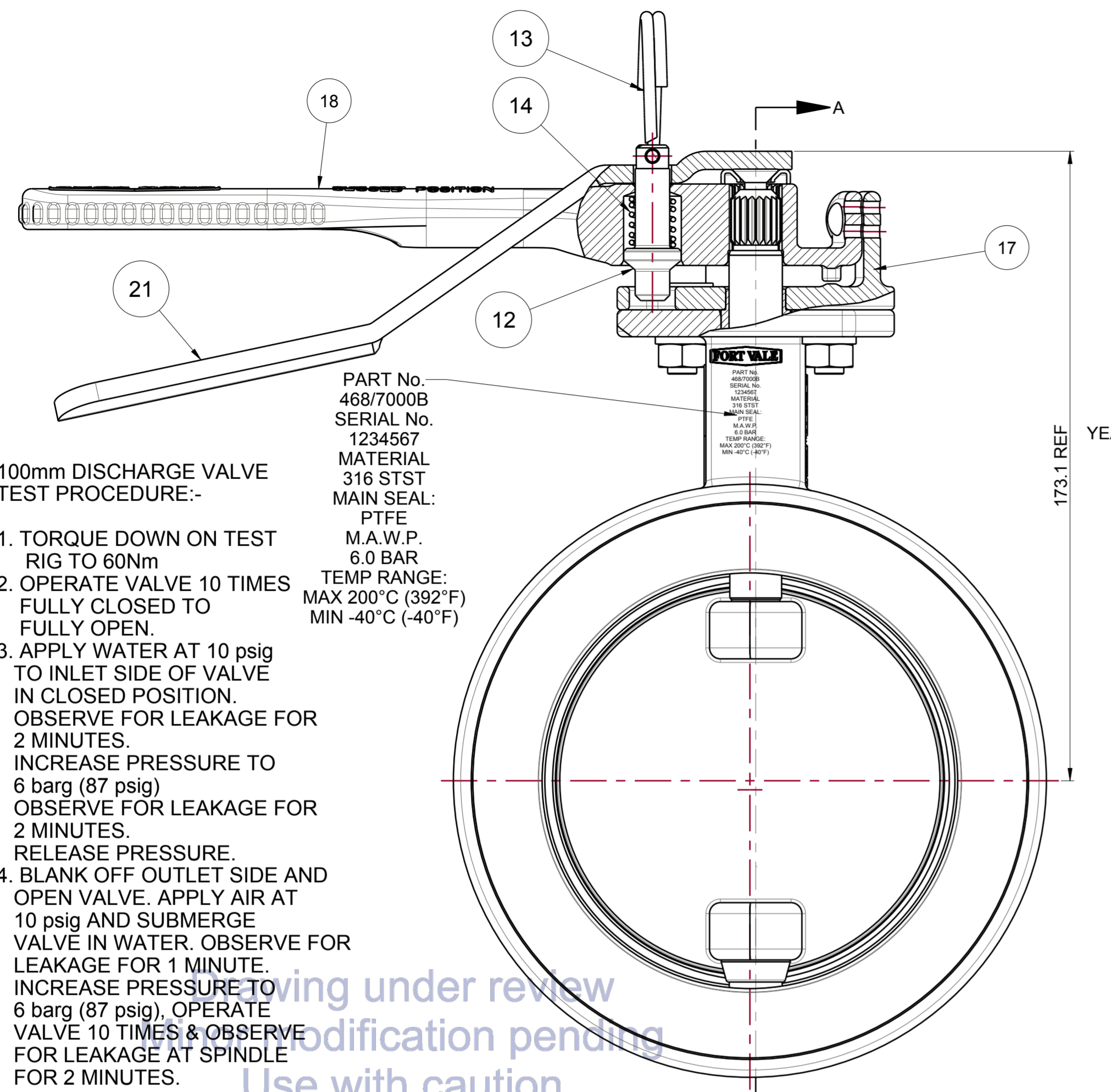


MOD	REVISION	SIG & DATE
01	SERVICE TEST PRESSURE WAS 7.8 BAR (113 PSI)	C GLUYAS 16-Aug-04
02	BUTTERFLY HANDLE UPDATED	PW 07-Sep-04
03	DRAWING METRICATED, LASER MARKING & TEST PROCEDURE UPDATED	M HUGHES 19-May-10
04	LASER MARK UPDATED. 368/0200/1 WAS 368/0200 252/0517 ADDED TO BOM	I ANGUS 21/11/2011
05	368/0200 WAS 368/0200/1	I ANGUS 17/01/2012
06	MIN DESIGN TEMP WAS -29°C NOW -40°C LASER MARK DETAILS UPDATED, TORQUE ADDED TO TEST PROCEDURE NOTE	JB 26/03/13



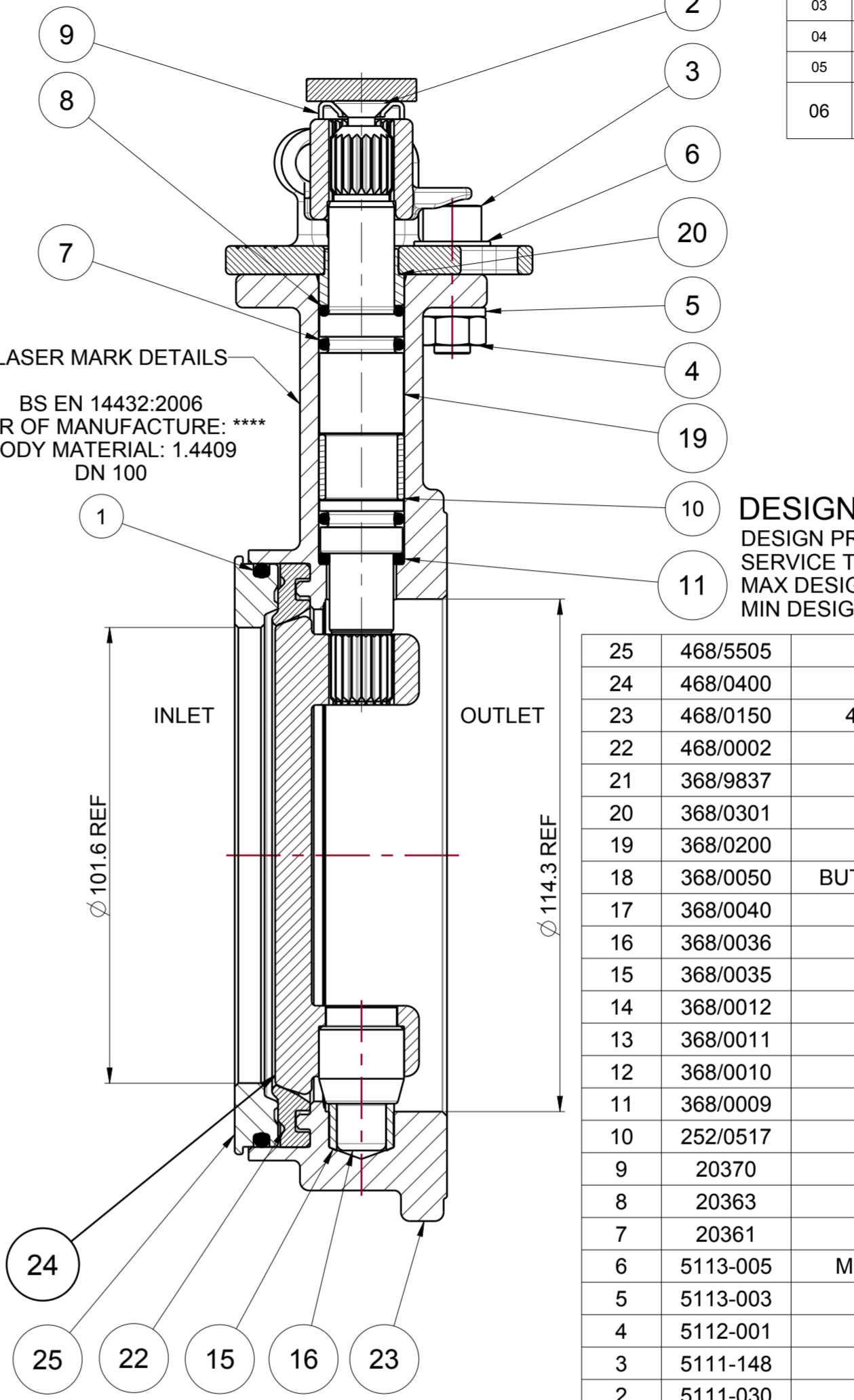
100mm DISCHARGE VALVE TEST PROCEDURE:-

- TORQUE DOWN ON TEST RIG TO 60Nm
- OPERATE VALVE 10 TIMES FULLY CLOSED TO FULLY OPEN.
- APPLY WATER AT 10 psig TO INLET SIDE OF VALVE IN CLOSED POSITION. OBSERVE FOR LEAKAGE FOR 2 MINUTES. INCREASE PRESSURE TO 6 barg (87 psig) OBSERVE FOR LEAKAGE FOR 2 MINUTES. RELEASE PRESSURE.
- BLANK OFF OUTLET SIDE AND OPEN VALVE. APPLY AIR AT 10 psig AND SUBMERGE VALVE IN WATER. OBSERVE FOR LEAKAGE FOR 1 MINUTE. INCREASE PRESSURE TO 6 barg (87 psig), OPERATE VALVE 10 TIMES & OBSERVE FOR LEAKAGE AT SPINDLE FOR 2 MINUTES.

PART No. 468/7000B
SERIAL No. 1234567
MATERIAL 316 STST
MAIN SEAL: PTFE
M.A.W.P. 6.0 BAR
TEMP RANGE: MAX 200°C (392°F) MIN -40°C (-40°F)

PART No. 468/7000B
SERIAL No. 1234567
MATERIAL 316 STST
MAIN SEAL: PTFE
M.A.W.P. 6.0 BAR
TEMP RANGE: MAX 200°C (392°F) MIN -40°C (-40°F)

ACCEPTANCE CRITERIA:
THERE SHOULD BE NO VISUALLY DETECTABLE LEAKAGE FOR THE DURATION OF THE TEST



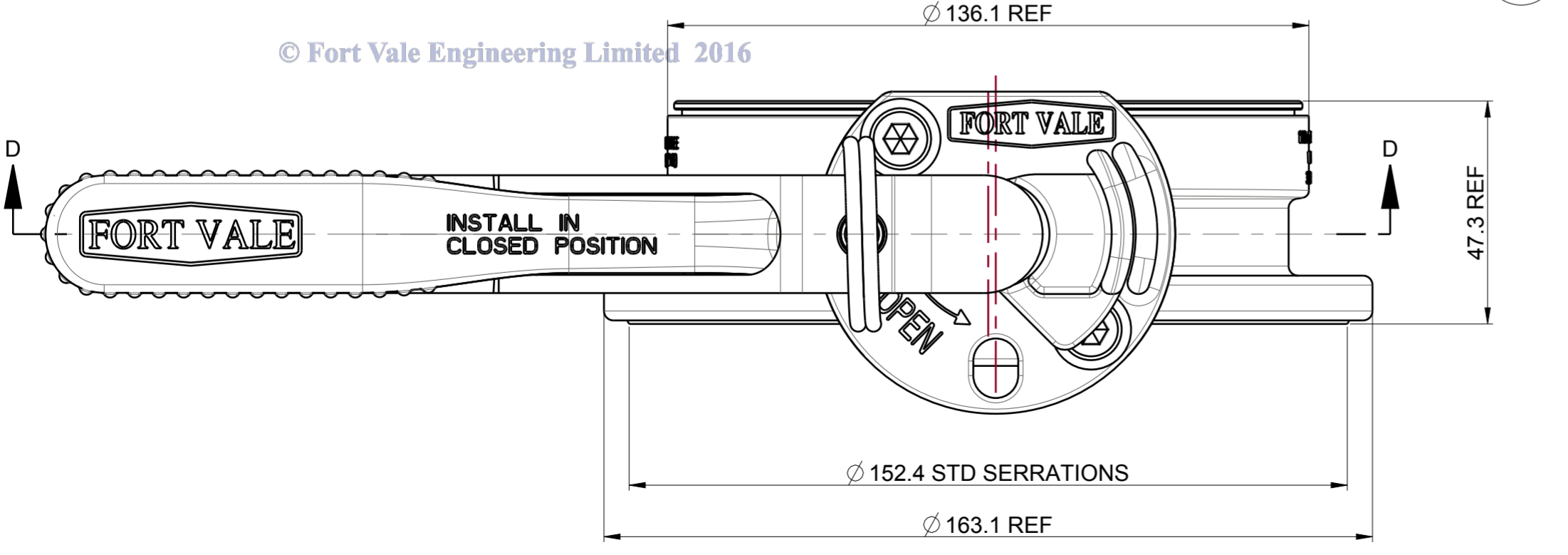
LASER MARK DETAILS
BS EN 14432:2006
YEAR OF MANUFACTURE: ****
BODY MATERIAL: 1.4409
DN 100

SECTION A-A SCALE 7:8

DESIGN CODE : ASME VIII DIV 1 AND EN14432:2006
DESIGN PRESSURE (MAWP) : 6 barg (87 psig)
SERVICE TEST PRESSURE : 10 barg (145 psig)
MAX DESIGN TEMPERATURE : 200°C (392 °F)
MIN DESIGN TEMPERATURE : -40°C (-40 °F)

Index	Part Number	Description	Material	Quantity
25	468/5505	SEAL CLAMP	316 STST	1
24	468/0400	L/H CLOSURE PLATE	316 STST	1
23	468/0150	4" DISCHARGE VALVE BODY	316L STST	1
22	468/0002	4" DISCHARGE SEAL	PTFE	1
21	368/9837	HANDLE LEVER	304 STST	1
20	368/0301	STUFFING CLAMP BUSH	PTFE	1
19	368/0200	SPINDLE	316 STST	1
18	368/0050	BUTTERFLY HANDLE MACHINING	316 STST	1
17	368/0040	STUFFING CLAMP	316 STST	1
16	368/0036	BOTTOM SPINDLE	316 STST	1
15	368/0035	BOTTOM BUSH	REINFORCED PTFE	1
14	368/0012	HANDLE SPRING	ST ST	1
13	368/0011	SPLIT RING	304/316 STST	1
12	368/0010	HANDLE LOCATION PIN	304/316 STST	1
11	368/0009	PTFE SPINDLE SEAT	PTFE	1
10	252/0517	SPLIT BEARING	CROSSFLON 1403	1
9	20370	RETAINING WASHER	316 STST	1
8	20363	BS113 PTFE 'O' RING	PTFE	2
7	20361	BS 113 'O' RING VITON	VITON	1
6	5113-005	M8 PLAIN WASHER IN FORM B	316 STST	2
5	5113-003	M8 SPRING WASHER	304 STST	2
4	5112-001	M8 FULL NUT	304 STST	2
3	5111-148	M8 X 25MM CAP SCREW	304 STST	2
2	5111-030	M6 X 16mm CSK BOLT	304 ST ST	1
1	5005-357	BS 249 'O' RING NITRILE	NITRILE	1

Assembly BOM



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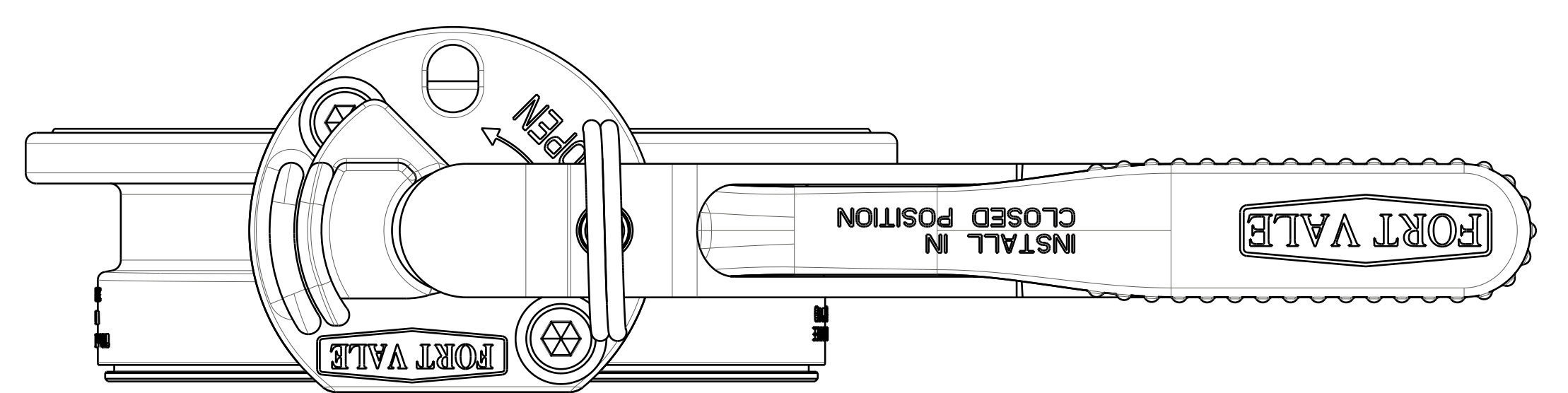
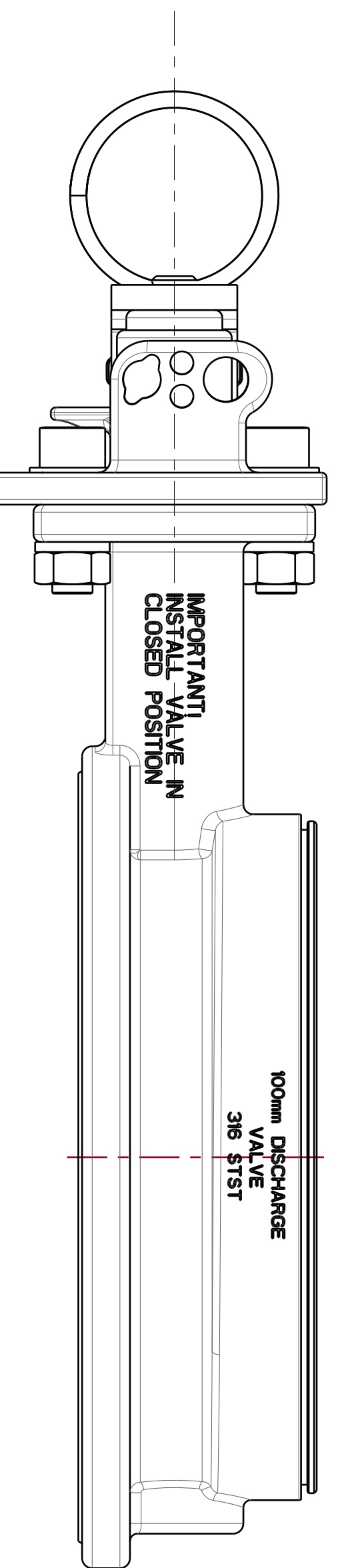
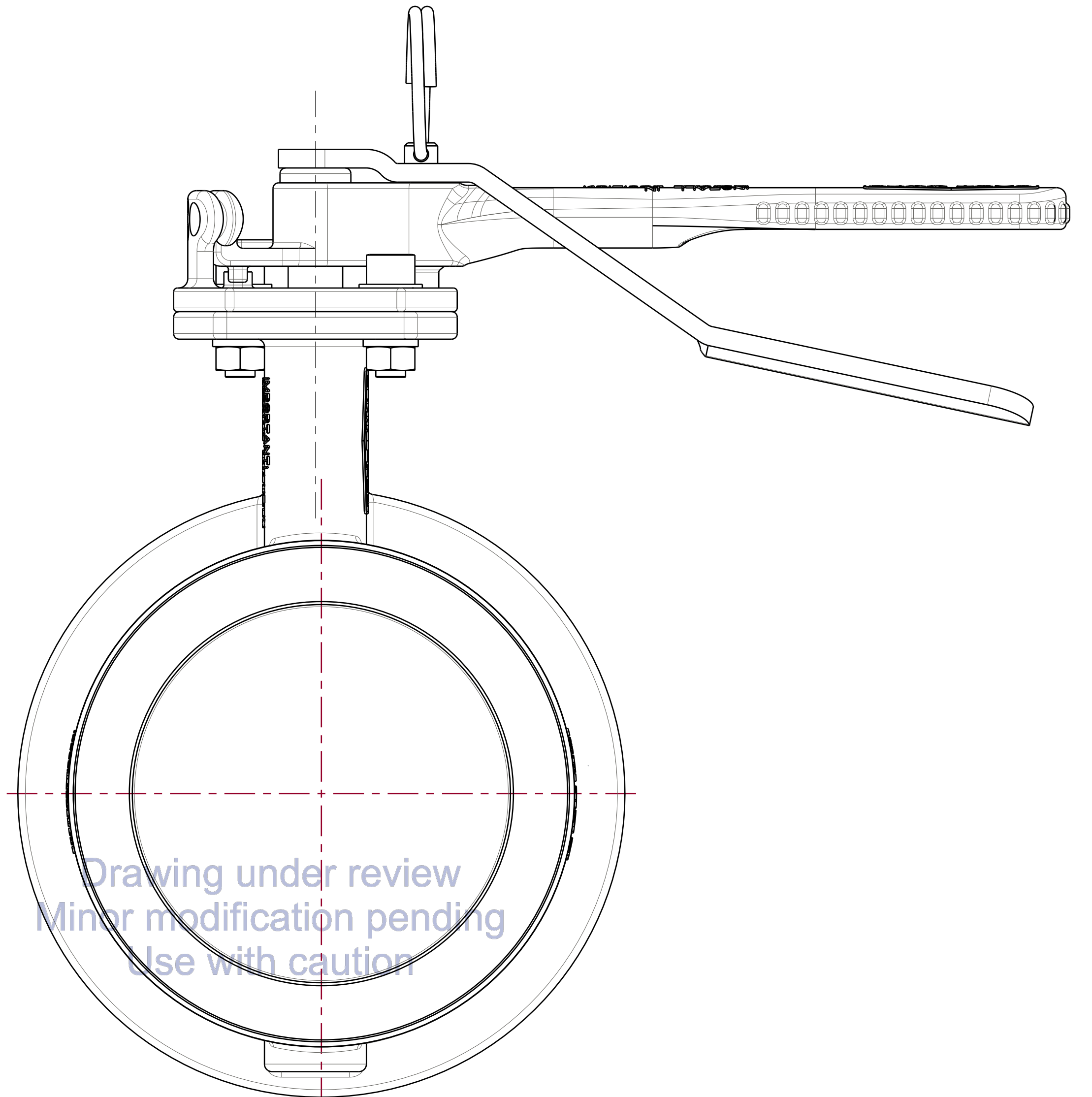
ENGLAND, USA, CHINA
NETHERLANDS, SINGAPORE

DO NOT SCALE- IF IN DOUBT ASK

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UNLESS OTHERWISE STATED		FIRST ANGLE PROJECTION		MATERIAL: 316 STST	
X.X ±0.5	SURFACE FINISH 3.2um MAX	BSI REGISTERED NUMBER FM 20165	CHECKED DVN: 23901	SCALE: NTS MASS: 4.13 kg	
X.XX ±0.25	CORNER RADII 0.8			SHEET 1 OF 1	
X.XXX ±0.125	CORNER CHAMFER 1.0 X 45°			DRAWN BY: D BAILEY DATE: 23-Jul-03	
ANGLES ±0.5°	REMOVE ALL BURRS AND SHARP EDGES	DESCRIPTION		DRG.NO.	
			4" DISCHARGE VALVE		
			LH CLAMPED DISCHARGE VALVE		
			468/7000B		

A2 UNITS mm



FORT VALE

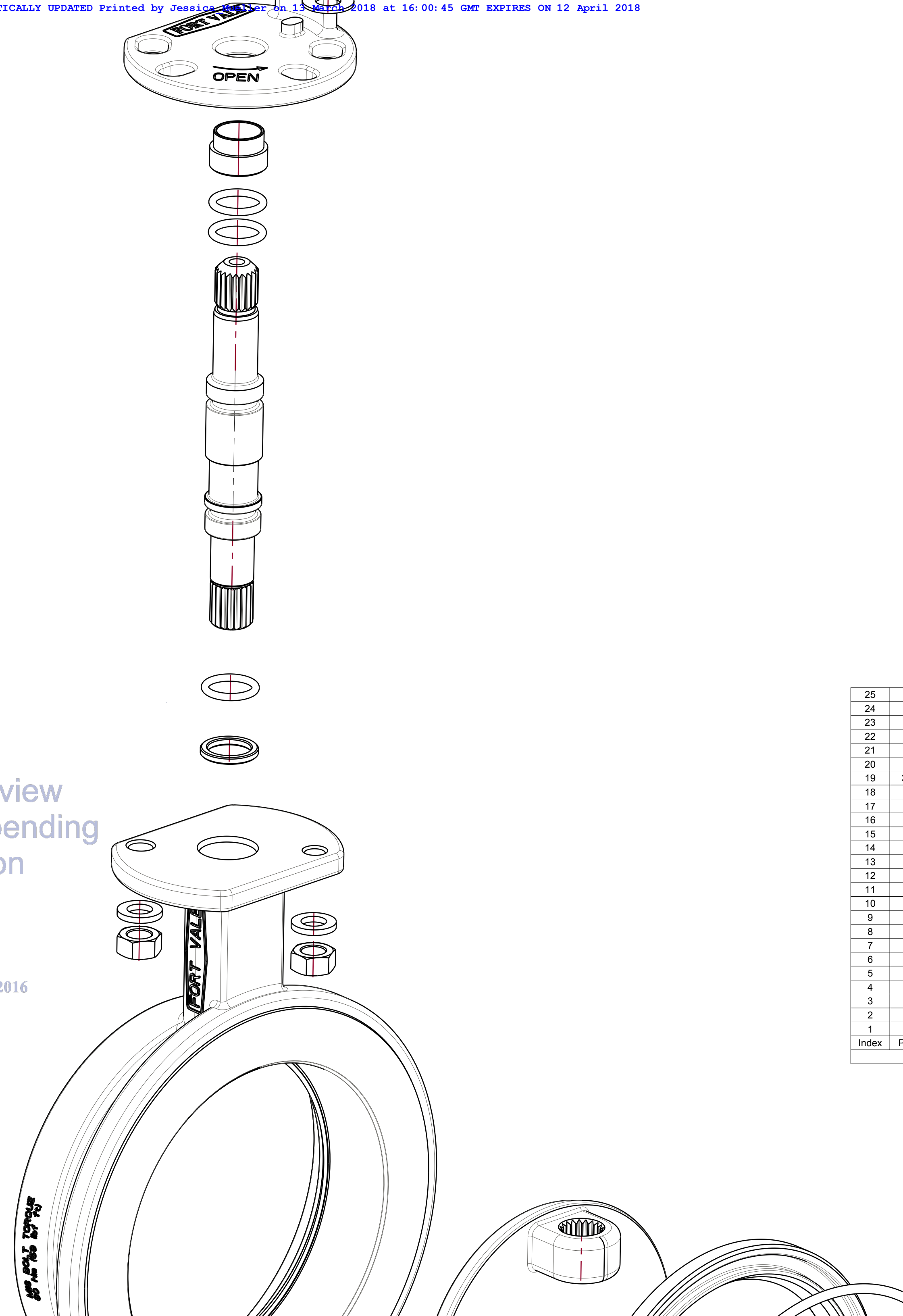
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ENGLAND USA NETHERLANDS



Drawing under review
 Minor modification pending
 Use with caution

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18	368/0200/1	BARREL LOCK HANDLE ASSY C/W TIR	1
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