

Installation, operation and maintenance instructions for Flowrox™ PVEG valves

Installation, maintenance and operating instructions



These instructions must be read carefully and understood prior to the installation, use, and servicing of this product.

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Table of Contents

1	Declaration of Incorporation	4
2	Introduction	5
2.1	General safety instructions	5
2.2	Applications and purpose of use	5
2.3	General description	6
2.4	Technical data	7
3	Transportation, Storage and Lifting	8
4	Installation	9
4.1	General	9
4.2	Flow direction, valve support and position	9
4.3	Valve installation	10
5	Operation	10
5.1	Commissioning and decommissioning	10
5.2	Recycling and disposal	10
6	Maintenance	11
6.1	General maintenance and checks	11
6.2	Scheduled maintenance	11
6.3	Spare parts	11
6.4	PVEG disassembly and sleeve replacement	11
6.5	Troubleshooting	12
	APPENDIX A: Dimensions	13
	APPENDIX B: Type Code	14
	APPENDIX C: General safety warnings	25

READ THESE INSTRUCTIONS FIRST!

These instructions provide information about safe handling and operation of the product.

If you require additional assistance, please contact the manufacturer or manufacturer's representative.

SAVE THESE INSTRUCTIONS!

Addresses and phone numbers are printed on the back cover.

1 Declaration of Incorporation

This declaration is issued under the sole responsibility of the manufacturer:

VALMET FLOW CONTROL OY

Marssitie 1

53600 Lappeenranta

Finland

Tel. +358 (0)10 417 5000

Product model/type: Pinch Valve (PVEG, PVG)

The object of the declaration described above is in conformity with the relevant Union harmonisation legislation:

Machinery Directive 2006/42/EC: Annex IIB partly completed machinery

As the product may be used as parts or components in machinery, we declare that this product must not be put into service until the relevant machinery into which it is to be incorporated has been declared in conformity with the provisions of the Machinery Directive.

Follow the valve installation, operating and maintenance instructions in this manual.

Person authorised to compile the technical file is Technology Manager Jarmo Partanen.

On behalf of Valmet Flow Control Oy

In Lappeenranta, 1st April 2022



Riku Salojärvi

Head of Operations

2 Introduction

2.1 General safety instructions

The symbols in Table 1 are used in this manual to highlight the parts requiring particular attention.

Hazard severity panels.












	 DANGER! DANGER indicates a hazard with a high level of risk which, if not avoided, will result in death or serious injury.
	 WARNING! WARNING indicates a hazard with a medium level of risk which, if not avoided, could result in death or serious injury.
	 CAUTION! CAUTION indicates a hazard with a low level of risk which, if not avoided, could result in minor or moderate injury.

Table 1. Warning and safety signs.

Symbol	Description
	Risk to personal safety: Neglecting the safety measures can cause serious injury or death.
	Crushing hazard.
	Read the operation and maintenance instructions: Read and understand the operation and maintenance instructions before using the product.
	Mandatory action symbol: Obey these instructions to prevent machine malfunctions.
	Forbidden action.

Prevent accidents and ensure the valve's appropriate operation by complying with the installation, safety, and maintenance instructions in this manual. Installation and maintenance of the valve must be carried out by persons with appropriate training. Electrical installation work of the actuator must be performed by a qualified electrician.

Access to the IOM-manual must be guaranteed at all times at the place of operation of the valve. It is required to observe the IOM-manual in all work tasks for the valve.

Use personal protective equipment when performing any checks or maintenance operation for the valve (goggles, helmet, clothing and gloves). Always follow the factory safety regulations.

In case of any discrepancies between translations, the English version shall prevail.

2.2 Applications and purpose of use

Flowrox PVEG is made for low cycle applications involving abrasion, corrosion and aggressive slurries. In open position, the PVEG valve is at full bore with no flow restrictions.

The core of the PVEG valve is an elastic sleeve, which is the only part in contact with the process medium. Designed to withstand wear, corrosion and chemicals, Flowrox sleeves guarantee non-clogging, trouble free operation and extended lifetime. The sleeves are bubble tight and easily replaceable if necessary.

See appendix C - General safety warnings.

Restrictions on use for PVEG valves

The valve temperature and pressure range must not be exceeded. The temperature ranges are given in Table 2 for standard sleeve materials. Check the pressure class from the valve type plate. Do not use higher pipeline pressure than rated for the valve.

Table 2. Temperature ranges for PVEG valves.

Sleeve material	SBRT	EPDM
Min valve operating temperature °C (°F)	0 (32)	0 (32)
Max valve operating temperature °C (°F)	+70 (+158)	+70 (+158)

Using the valve in explosive conditions

This valve type is not designed for Ex-areas.


2.3 General description

Principle of operation

Flowrox PVEG valve is built with a corrosion resistant and light-weight plastic body and a rubber sleeve as a standard structure. Removable sleeve means no parts of the body are in contact with the process medium.

In the open position the valve provides full bore through which the medium can travel.

When closing the valve, the upper side of the sleeve is pushed progressively towards the other side until it reaches the fully closed position. When the valve is fully closed, the sleeve is squeezed between the closing element and the valve body, effectively sealing and completely containing the line pressure.

	<p>The valve must not be used to throttle the flow as this will lead to premature failure of the sleeve.</p>
--	--

This valve is intended for on-off operation only.

Mechanical structure

Flowrox valves are normally delivered fully assembled with actuators and ready for use. Exploded views of valve with the alternative actuators, manual and pneumatic are shown in Figure 1 and Figure 2.

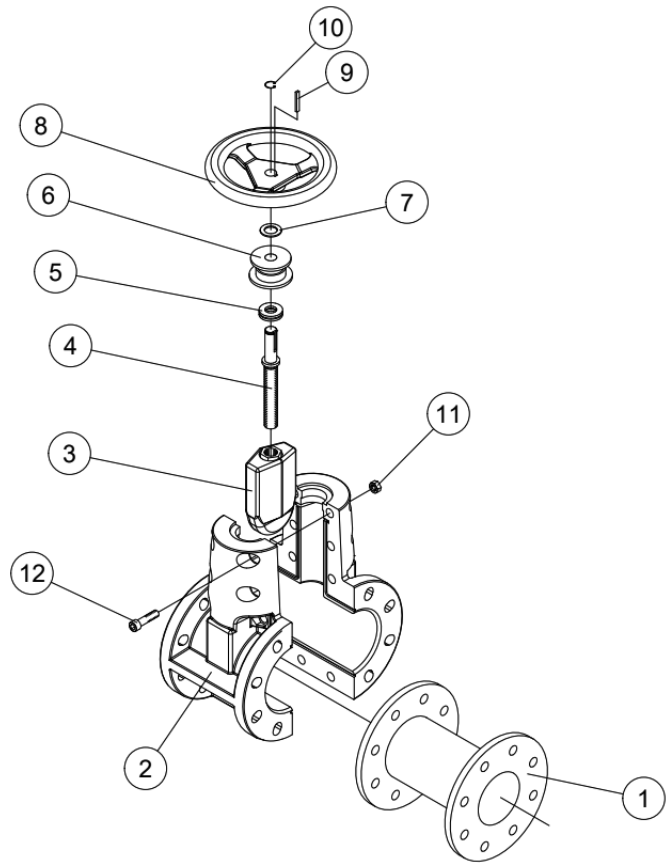


Figure 1. Exploded view of PVEG valve with manual actuator.

Table 3. Part list of PVEG valve with manual actuator.

Part	Description	Part	Description
1	Sleeve	7	Slide ring
2	Body	8	Handwheel
3	Pusher	9	Key
4	Stem	10	Retaining ring
5	Bearing	11	Hex nut
6	Bushing	12	Hex socket screw

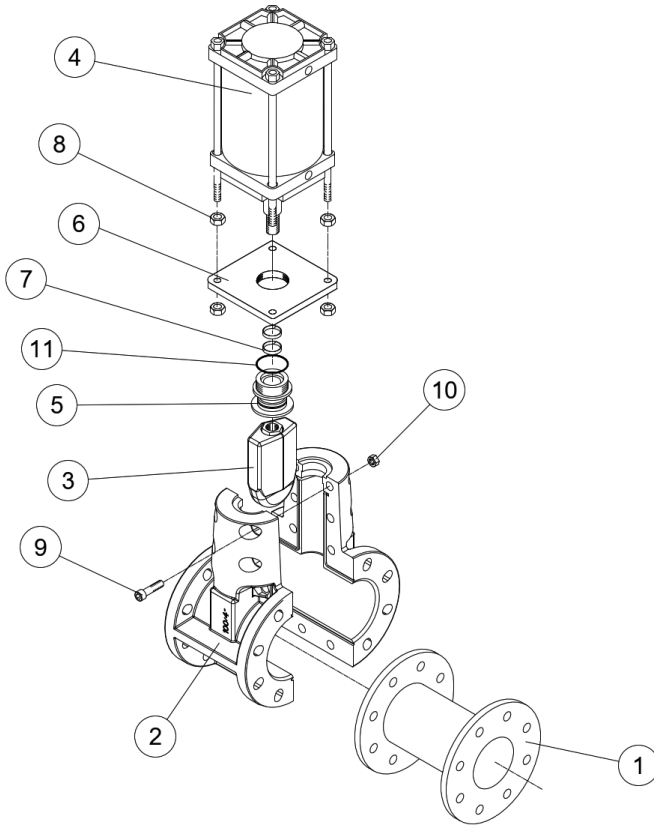


Figure 2. Exploded view of PVEG valve with pneumatic actuator.

Table 4. Part list of PVEG valve with pneumatic actuator.

Part	Description	Part	Description
1	Sleeve	7	Guide ring
2	Body	8	Hex nut
3	Pusher	9	Hex socket head screw
4	Pneumatic actuator	10	Hex nut
5	Bushing	11	O-ring
6	Attachment frame		

2.4 Technical data

Actuators

Standard actuators:

- Manual
- Pneumatic

Manual valves are closed by turning the hand wheel clockwise. Do not use additional levers or long wrenches for valve operation.

Pneumatic actuators are with a fixed stroke and do not require external controls. The pneumatic actuator is designed for a nominal supply of 6 bar (90psi). Use correct sized pneumatic hoses to ensure sufficient air flow.

The air must be clean, dry, lubricated and properly filtered. An air quality of minimum requirement to ISO 8573-1:2010 [7:4:4] is recommended. If any component used on the valve has a stricter requirement (pressure rating, air quality), the stringent shall prevail.

Pneumatic actuator noise level may exceed 85 dB and it is recommended to use ear protectors when working near the valve.

Consult the manufacturer's instructions on actuator requirements or/and limitations. If actuator is changed or valve needs adjustment, follow the Maintenance instructions.

Valve identification


Use attachment: Name plate, and see PV, PVE IMO for descriptions.

3 Transportation, Storage and Lifting

Check and document any damages in the valve packages or valves. Contact the transportation company in case of damage. When new or unused valves are removed from operation or stored for a long period of time, the following procedures should be complied with:

1. Prior to storage, thoroughly drain valves of all water.
2. Indoor storage is required. For unfavourable environment, cover the equipment with protective tarpaulin that will allow proper air circulation
3. Protect the equipment from temperature and humidity extremes and exposure to excessive dust, moisture, vibration and sunlight.
4. It is preferred to store valves in the open position.
5. Avoid dirt and/or moisture contamination of the stem (threaded rod).
6. Ensure pneumatic cylinder actuators have appropriate pipe plugs installed in the respective supply ports to prevent contamination of the cylinders.
7. Protect valve sleeves from heat, sunlight and exposure to ozone.
8. Cover the flange openings.
9. Do not store any objects on top of the rubber sleeves.
10. Follow the actuator instructions for storage.
11. Before start-up clean the valve.

When storing used valves, wash the valve with fresh water and follow the steps above. For storage periods greater than 36 months, please contact Valmet as the rubber parts need to be changed before use.

	<p>Lifting equipment must be used for valves weighing over 25 kg (55 lbs).</p>
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Lift the valves securely from the body (part 1 in Figure 1) or actuator (part 3 in Figure 2) and use existing lifting eyes when available. When lifting eyes are not available, use soft straps to lift valve.

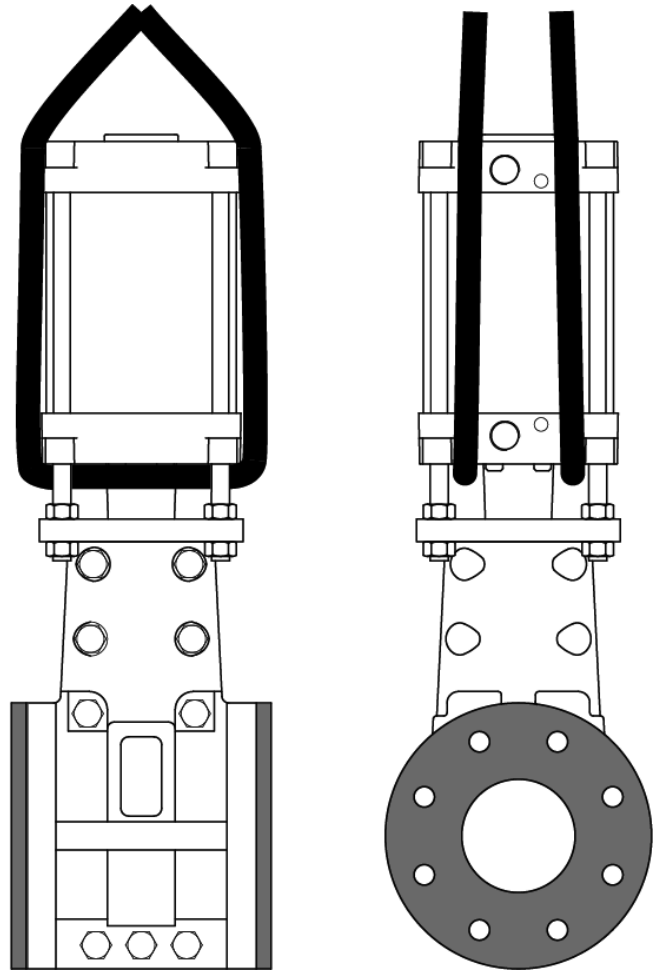


Figure 3. Lifting PVEG valve with pneumatic actuator.

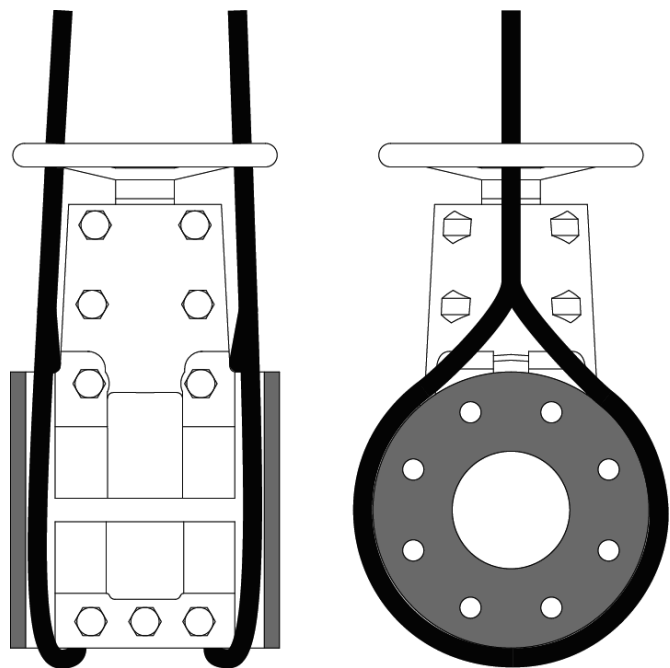




Figure 4. Lifting PVEG valve with manual actuator.

4 Installation

WARNING!	
	<p>Crushing hazard.</p> <p>Do not put your hands or fingers inside the sleeve when the valve cycles. Do not energize the actuator before the valve is properly attached to the pipeline. Disconnect and de-energize the actuator before installation and maintenance work.</p>
	<p>High pressure injection hazard.</p> <p>Do not use higher pressure than rated for the valve. Higher pressures can cause serious damage to the valve or harm to operating personnel.</p>

4.1 General

Flowrox valves are normally delivered fully assembled and ready for use. The valve can be installed either way in terms of flow direction. Only personnel with appropriate training are allowed to install the valves. If the valve is delivered without an actuator or accessories, they must be installed in accordance with the manufacturer's instructions.

4.2 Flow direction, valve support and position

If the PVEG valve **with pneumatic (A) actuator** is installed horizontally, it must be supported to ensure smooth operation. Support is also recommended when the valve is installed at any position other than vertical.

The support can be fixed on the wall (1), on the floor (2) or the pipeline (3). Also a simple rope, wire rope, chain etc. (4) can be used to support the actuator (see drawing 2.).

The valve is bidirectional thus, can be installed in either way with respect to the flow direction.

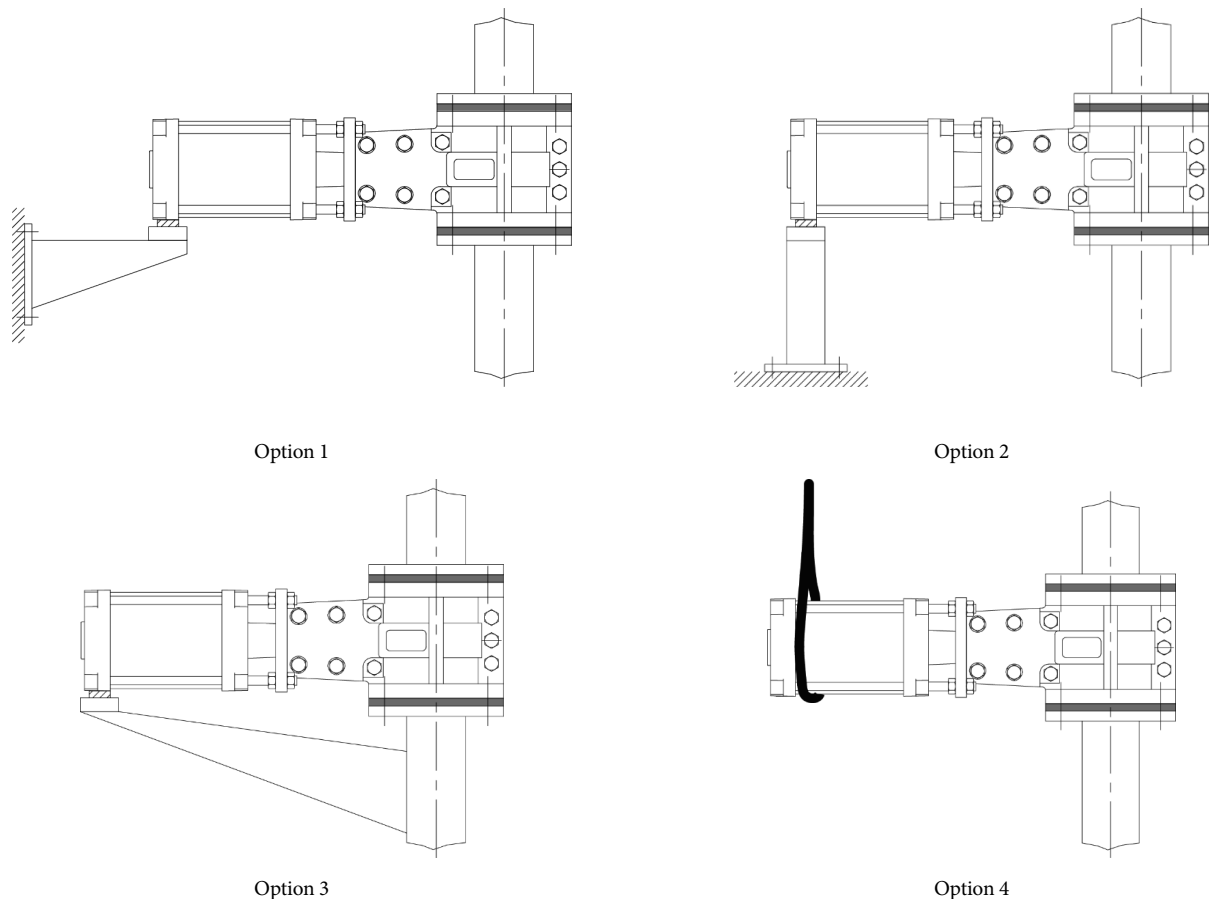


Figure 5. Valve support options.

4.3 Valve installation

At least the following must be ensured before valve installation:

- The pipeline is isolated from the process and there is no pressure in it.
- The pipeline is empty, clean, and cooled down.
- The pipeline flanges are parallel, concentric and with correct distance.
- The flange connection bolts size is correct.
- The valve is in OPEN position.

1. Disconnect pneumatic actuator from the pneumatic supply.
2. Before starting the installation of Flowrox PVEG, loosen pipe supports from both sides of the valve.
3. Adjust the distance between the pipe flanges to be equal to the face-to-face dimension of the Flowrox valve.
4. Lift the valve on place with appropriate lifting equipment.
5. Tighten the flange bolts evenly in a crosswise sequence.
6. Connect pneumatic actuator to the pneumatic supply.
7. Check that all connections have been fastened and the actuator is connected correctly.
8. Run a few open/close cycles without pressure in the pipeline. Refer to Troubleshooting if the valve does not operate smoothly or without extra force.

The maximum allowed torque is shown in the table. Ensure that during tightening, the compression of the rubber flange does not exceed the values given in the table.

Table 5. Flange bolt torques and compression values.

VALVE SIZE	MAX TORQUE	MAX COMPRESSION
PVEG 50 (2")	20 Nm (15 lbf-ft)	2 mm (0.08 in)
PVEG 80 - 150 (3"-6")	30 Nm (20 lbf-ft)	3 - 5 mm (0.12 - 0.2 in)

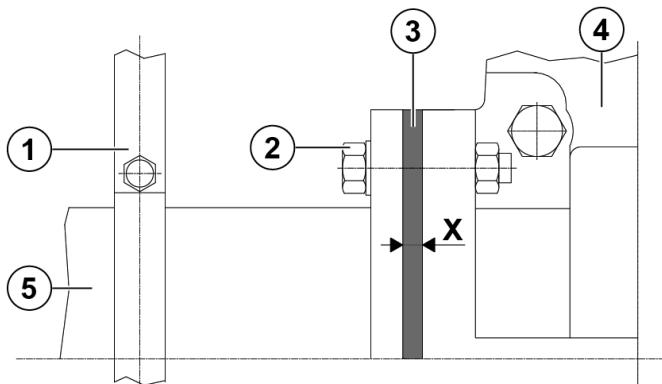
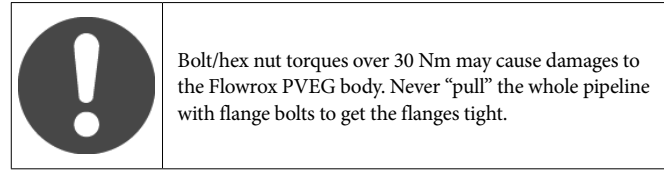


Figure 6. Valve installation.

Part	Description	Part	Description
1	Pipe support	4	Valve body
2	Flange bolts	5	Pipeline
3	Sleeve	X	Recommended compression



5 Operation

5.1 Commissioning and decommissioning

Before the valve is operated within the pipeline, ensure that it has been installed in accordance with this manual and applicable safety regulations.

The following must also be ensured:

- The valve is used for the purpose specified at the time of sales
- Required accessories are installed if applicable
- Possible explosive conditions have been taken into account

When a valve is decommissioned, dispose the valve parts and electric/pneumatic devices (actuators) according to the local regulations and the instructions given by the part or device manufacturer.







Collect and dispose dangerous process media, so that people and environment are not endangered. Follow the local regulations.

5.2 Recycling and disposal

Most valve parts can be recycled. Separate recycling and disposal instructions are available from the manufacturer. A valve can also be returned to the manufacturer for recycling and disposal for a fee.

6 Maintenance

6.1 General maintenance and checks

	 WARNING!
	Unexpected start-up hazard. De-energize actuators before maintenance.
	Crushing hazard. Keep your hands and feet clear of moving parts. De-energize actuators before maintenance.
	 CAUTION!
	Depressurize, empty and cool down the valve before any maintenance work. Valve surface can be hot. Isolate the valve completely from the process and follow the factory safety regulations.
	Do not step on a valve installed in horizontal or angled position.

Only personnel with appropriate training are allowed to service the valves. For actuator service instructions consult the manufacturer's documentation supplied with the valve.

Check the condition of the valve regularly. When the valve is tight and it actuates flawlessly, periodic inspection is the only mandatory maintenance task. Do not neglect it as sleeves wear over time depending on conditions and process

6.2 Scheduled maintenance

Include the valves in your factory maintenance program. Maintenance tasks and service intervals are offered as a guideline in Table 6 Schedules will vary with applications.

Table 6. Maintenance schedule.

Maintenance task	Frequency & advice
Do a leakage inspection	Regularly. Refer to Troubleshooting.
Run an open/close cycle	Suggested once a month for smooth and reliable operation.
Examine the valve for erosion and wear	Every six months.

6.3 Spare parts


To ensure correct and quick delivery of spare parts, the order must contain at least the following information:

- Valve type
- Serial number
- Spare part name and quantity (example: Sleeve, 1 piece)

You can order the spare parts from Valmet offices, distributors or agents. Contact information is available at www.valmet.com/flowcontrol.

It is recommended to keep one sleeve as a spare part at your factory warehouse. For part numbers refer to Mechanical structure.

6.4 PVEG disassembly and sleeve replacement

	Do not disconnect a pressurized valve from the pipeline in any case!
--	--

1. Open the valve and detach it from the pipeline.

The body bolts of the PVEG valve are stainless steel and can be removed by a 10 mm hexagon key and 19mm socket wrench for 2" and 3" valves, and a 14 mm hexagon key and 24mm socket wrench for 4" and 6" valves.

2. If other body half cannot be removed from a valve equipped with pneumatic actuator, remove lower nuts (part 8.) and close the valve carefully by pneumatic cylinder so that cylinder (part 4.) raises up from the attachment frame (part 6.). Do not change the position of upper nuts (part 8.).
3. Remove the body bolts (parts 9/10 or 11/12) and other body half.
4. Remove the broken sleeve (part 1.) and put in the new sleeve.
5. Install body half and body bolts.
6. If lower nuts (part 8.) had to be removed from PVEG A valve, open the valve by pneumatic cylinder so that cylinder (part 4.) lands down and it is possible to install removed lower nuts (part 8.). Check that the valve will close totally.
7. Install the valve into the pipeline.

6.5 Troubleshooting

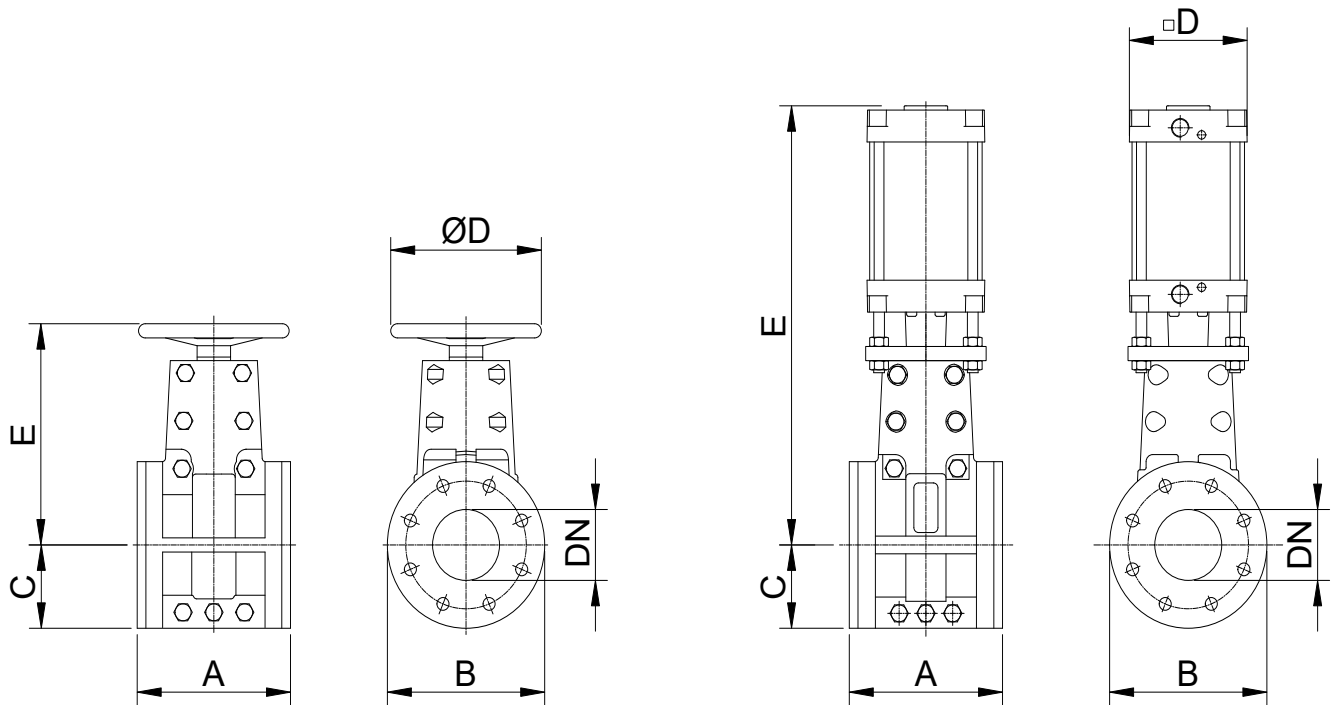
Table 7. Troubleshooting.

Problem	Possible reason	Action
Leakage from flange connection	Flange connection is loose	Tighten the flange connection bolts to correct torque
	Pipeline flanges and valve are misaligned	Check that the flanges are parallel and concentric with the valve
Sleeve lifetime is short	Damaged valve body	Check valve body for scrapes and sharp edges and change if damaged
	Unsuitable sleeve material for process	Check with Neles
	Damaged pusher	Check pusher for scrapes and sharp edges and change if damaged
Valve does not open/ close or valve is not tight	Fault in actuator or control system	Check and fix actuator operation
	Too low pneumatic supply pressure	Fix air supply
	Damaged sleeve or pusher	Check and change damaged parts
Valve does not open/ close smoothly	Insufficient lubrication	Lubricate the actuator.

APPENDIX A: Dimensions

Manual

Pneumatic



Valve size (PVEG) M&A	A	B	C	D		E		Weight (kg)		Max shut-off pressure (Bar)	
				M	A	M	A	M	A	M	A
50	178	165	82,5	175	116	230	435	6	11	10	6
80	203	209	104,5	200	136	290	545	8	18	10	6
100	229	235	117,5	225	176	320	630	11	25	10	6
150	406	280	140	400	270	450	840	29	74	10	6

Valve size (PVEG) M&A	A	B	C	D		E		Weight (lbs)		Max shut-off pressure (PSI)	
				M	A	M	A	M	A	M	A
2	7	6.5	3.2	6.9	4.6	9.0	17.1	14	25	150	75
3	8	8.2	4.1	7.9	5.4	11.4	21.5	18	40	150	75
4	9	9.3	4.6	8.9	6.9	12.6	24.8	25	55	150	75
6	16	11	5.5	15.7	10.6	17.7	33.0	64	163	150	75

APPENDIX B: Type Code

1.	2.	3.	4.	5.
PVEG	0100	J	B010	A

1. Sign	VALVE SERIES
PVEG	General Pinch valve plastic body
PVG	General Pinch valve Cast iron body

2. Sign	BODY SIZE	
0050	DN50	2"
0080	DN80	3"
0100	DN100	4"
0150	DN150	6"
0200	DN200	8"
0250	DN250	10"

3. Sign	FLANGE DRILLING
C	ASME B16.5 Class 150
J	PN 10 EN 1092

4. Sign	PRESSURE RATING
B006	6 BAR
B010	10 BAR

5. Sign	SLEEVE MATERIAL
A	SBRT Styrene Butadiene, Flowrox™ Blend
B	EPDM Ethylene Propylene

For further information on the new type code on valve and actuators, see the product Technical bulletin.

APPENDIX C: General safety warnings

Lifting

1. Always use a lifting plan created by a qualified person to lift this equipment. Lifting guidance is provided in this IMO (Installation, Maintenance and Operation manual) to assist in lifting plan development. Think about the **point** center of gravity (CG) of the equipment being lifted. Make sure the CG is always under the central lifting point.
2. Valves may be equipped with lifting threads on the body or on the flanges. These are which are intended for use with the lifting plan.
3. Use only correct and approved lifting devices. Ensure that lifting devices and straps are securely attached to the equipment prior to lifting.
4. Check, that lifting devices are not damaged and in good condition with a valid check stamp prior to use.
5. Workers must be trained for lifting and handling valves.
6. Never lift an assembly by the instrumentation (solenoid, positioner, limit switch, etc.) or by the instrumentation piping. Straps and lifting devices should be fitted to prevent damage to instrumentation and instrumentation piping. Failure to follow the lifting guidance provided may result in damage and personal injury from falling objects.

Work activities on the valve

1. Wear your personal safety equipment. Personal safety equipment includes but is not limited to protective shoes, protective clothing, safety glasses, helmet, hearing protection and working gloves.
2. Always follow the local safety instructions in addition to the Valmet instructions. If Valmet instructions conflict with local safety instructions, stop work and contact Valmet for more information.
3. Before beginning service on the equipment, make sure that the actuator is disconnected from any kind of power source (pneumatic, hydraulic, and/or electric), and no stored energy is applied on the actuator (compressed spring, compressed air volumes, etc.). Do not attempt to remove a spring return actuator unless the stop screw is carrying the spring force.
4. Make sure that there is a LOTOTO (Lock Out / Tag Out / Try Out) procedure in place for the system in which the valve is installed and strictly follow it.
5. Always make sure that the pipeline is depressurized and in ambient temperature condition before maintenance work is started.
6. Keep hands and other body parts out of the flow port when the valve is being serviced and the actuator is connected to the valve. There is a high risk of serious injury to hands and/or fingers due to malfunction if the valve suddenly starts to operate.
7. Beware of Disc & Ball movement even when the valve is disassembled. Discs and balls may move simply due to the weight of the part or change in position of the valve. Keep hands or other body parts away from locations where they may be injured by movement

General disclaimers

Recieve, handle and unpacking

1. Respect the safety warnings above!
2. Valves are critical components for pipelines to control high pressure fluids and must therefore be handled with care.
3. Store valves and equipment in a dry and protected area until the equipment is installed.
4. Do not exceed the maximum storage temperatures given in the IMO (installation, maintenance, and operating instructions).
5. Keep the original packaging on the valve as long as possible to avoid environmental contamination by dust, water, dirt, etc.
6. Remove the valve endcaps just before mounting into the pipeline.

7. FOR YOUR SAFETY IT IS IMPORTANT THE FOLLOWING PRECAUTIONS BE TAKEN PRIOR TO REMOVAL OF THE VALVE FROM THE PIPELINE OR BEFORE ANY DISASSEMBLY: Be sure you know what fluid is in the pipeline. If there is any doubt, confirm with the proper supervisor.
- Wear any personal protective equipment (PPE) required for working with the fluid involved in addition to any other PPE normally required.
 - Depressurize the pipeline, bring to ambient temperature, and drain the pipeline fluid.
 - Cycle the valve to relieve any residual pressure in the body cavity.
 - After removal but before disassembly, cycle the valve again until no evidence of trapped pressure remains.
 - The butterfly valve's offset shaft creates greater disc area on one side of the shaft. This will cause the valve to open when pressurized from the preferred direction without a locking handle or an actuator installed.
 - **WARNING: DO NOT PRESSURIZE THE BUTTERFLY VALVE WITHOUT A HANDLE OR AN ACTUATOR MOUNTED ON IT!**
 - **WARNING: DO NOT REMOVE A HANDLE OR AN ACTUATOR FROM A BUTTERFLY VALVE UNDERPRESSURE!**
 - Before you install the butterfly valve in or remove it from the pipeline, cycle the valve closed. Butterfly valves must be in the closed position to bring the disc within the face to face of the valve. Failure to follow these instructions will cause damage to the valve and may result in personal injury.

Operating

8. The type plate (nameplate, or engraved markings) on the valve gives the information of max. process conditions to the valve.
9. (For soft seats) The practical and safe use of this product is determined by both the temperature and pressure ratings of the seat and body. Read the type plate and check both ratings. This product is available with a variety of seat materials. Some seat materials have pressure ratings that are lower than the body ratings. All body and seat ratings are dependent on the valve type, size and material of the body and seat. Never exceed the marked rating.
10. Temperatures and pressures must never exceed values marked on the valve. Exceeding these values may cause uncontrolled release of pressure and process fluid. Damage or personal injury may result.
11. The operating torque of the valve may rise over time due to wear, particles or other damage the seat. Never exceed the actuator torque preset values (air supply, position). Application of excessive torque may cause damage to the valve.
12. Valmet valves typically are designed to be used in atmospheric conditions. Do not use valves under external pressurized conditions unless specifically designed and explicitly marked for this service.
13. Avoid Pressure shocks or water hammer. Systems with high pressure valves should be equipped with a bypass to reduce the differential pressure before opening the valve to avoid pressure shock.
14. Avoid thermal shock. High temperature, Low temperature and cryogenic valves should be operated in a way that limits the rate of increase or decrease in temperature. The valve should be thermally stabilized before being pressurized.
15. Materials of the valve are carefully selected for the process conditions. Changes to the process media can have a major impact on function and safety of the valve. Always confirm the materials are suitable for the service prior to installation.
16. As the use of the valve is application specific, a number of factors should be taken into account when selecting a valve for a given application. Therefore, some situations in which the valves are used are outside the scope of this manual.
17. It is the end user's responsibility to confirm compatibility of the valve materials with the intended service, however if you have questions concerning the use, application, or compatibility of the valve for the intended service, contact Valmet for more information.
18. Never use a valve with enriched or pure oxygen if the valve is not explicitly designed and cleaned for oxygen. Selected materials and design have a major impact on the safety to operate the valve with oxygen.
19. Valves intended for use in or with explosive atmospheres must be equipped with a grounding device and marked according ATEX (or equivalent international standards).
20. Manual handles are available for specific butterfly valve sizes and maximum line pressures. Do not operate a valve with a handle or wrench outside the size and pressure limits stated in the IMO. High line pressure may create a large enough force to pull the handle from the operator's hands. Damage or personal injury may result.

Maintenance

14. Respect the safety warnings above!
15. Plan service and maintenance actions, that spare parts, lifting devices and service personnel is available. Maintain the valve within the recommended minimum maintenance intervals or within the recommended maximum operating cycles.
16. Always make sure that the valve and the pipeline is depressurized before starting any kind of maintenance work at a valve.
17. Always check the position of the valve before starting maintenance work. Follow the Lock out /tag out (LOTO) rules at the site before starting any maintenance activity.
 - See IMO for the correct stem position.
 - Consider that the positioner may give the wrong signals.
18. Sealing materials (soft sealing parts) should be changed when the valve is maintained. Always use original equipment manufacturers (OEM) spare parts to ensure proper performance of the repaired valve.
19. All pressure containing parts must be inspected visually for damage or corrosion. Damaged parts must be replaced.
20. Valve pressure bearing parts and all internals must be inspected for corrosion or erosion which may result in reduced wall thickness on pressure bearing parts. Damaged pressure bearing parts must be replaced with original equipment manufacturer's (OEM) replacement parts or repaired to factory specifications by an authorized Valmet service partner in order to maintain the warrantee.
21. Do not use sharp tools, grinding machines, or files to work on functional surfaces such as sealing, seating or bearing surfaces as this can damage these surfaces.
22. Check the condition of sealing surfaces on the seats, closure device (disc, ball, cage, plug, etc.), body and body cap. Replace parts if there are significant wear, scratches, or damage.
23. Check the wear of bearings and bearing contact surfaces on the shaft and replace damaged parts if necessary.
24. Do not weld on pressure bearing parts without an ASME and PED qualified procedure and personnel.
25. Pressure bearing parts of valves in high temperature applications must be carefully examined for the effects of material creep and fatigue.
26. Make sure that the valve is positioned in the correct flow direction into the pipeline.
27. If the valves are marked to be suitable for explosive atmospheres, the correct function of the discharging device must be tested before returning to service.
28. Always work in a clean environment. Avoid getting particles inside the valve due to machining, grinding, or welding nearby.
29. Never store a maintained valve without flow port protection.
30. When pressure testing valve seats, never exceed the maximum operating pressure of the system or the maximum shut-off pressure marked on the valve identification plate.
31. Actuator mounting and unmounting:
 - Before installing the actuator on to the valve, be sure the actuator is properly indicating the valve position. Failure to assemble these to indicate correct valve position may result in damage or personal injury.
 - When installing or removing a linkage kit, best practice is to remove the entire linkage assembly, including couplings which may fall off the valve during lifting or when position changes.
 - Mounting sets have been designed to support the weight of the Valmet actuator and recommended accessories. Use of the linkage to support additional equipment or additional weight such as people, ladders, etc. may result in equipment damage or personal injury.
32. The valve should be installed between flanges using appropriate gaskets and fasteners that are compatible with the application, and in compliance with applicable piping codes and standards. Center the gaskets carefully when fitting the valve between the flanges. Do not attempt to correct pipeline misalignment by means of the flange bolting.

33. Repairs on valves for special service like Oxygen, Chlorine, and Peroxide, have special requirements.
- Parts must be cleaned appropriate to the service and protected from contamination prior to assembly.
 - Assembly areas and tools must be clean and dry to prevent contamination of the parts during assembly.
 - Test equipment must be clean and dry to prevent contamination during testing. This includes the test equipment internals that may allow particles or other contamination into the test fluid during the test.
 - Lubrication shall be used only if specifically required in the instructions. Where lubrication is required, the lubricant must be approved for the service by the end user.

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