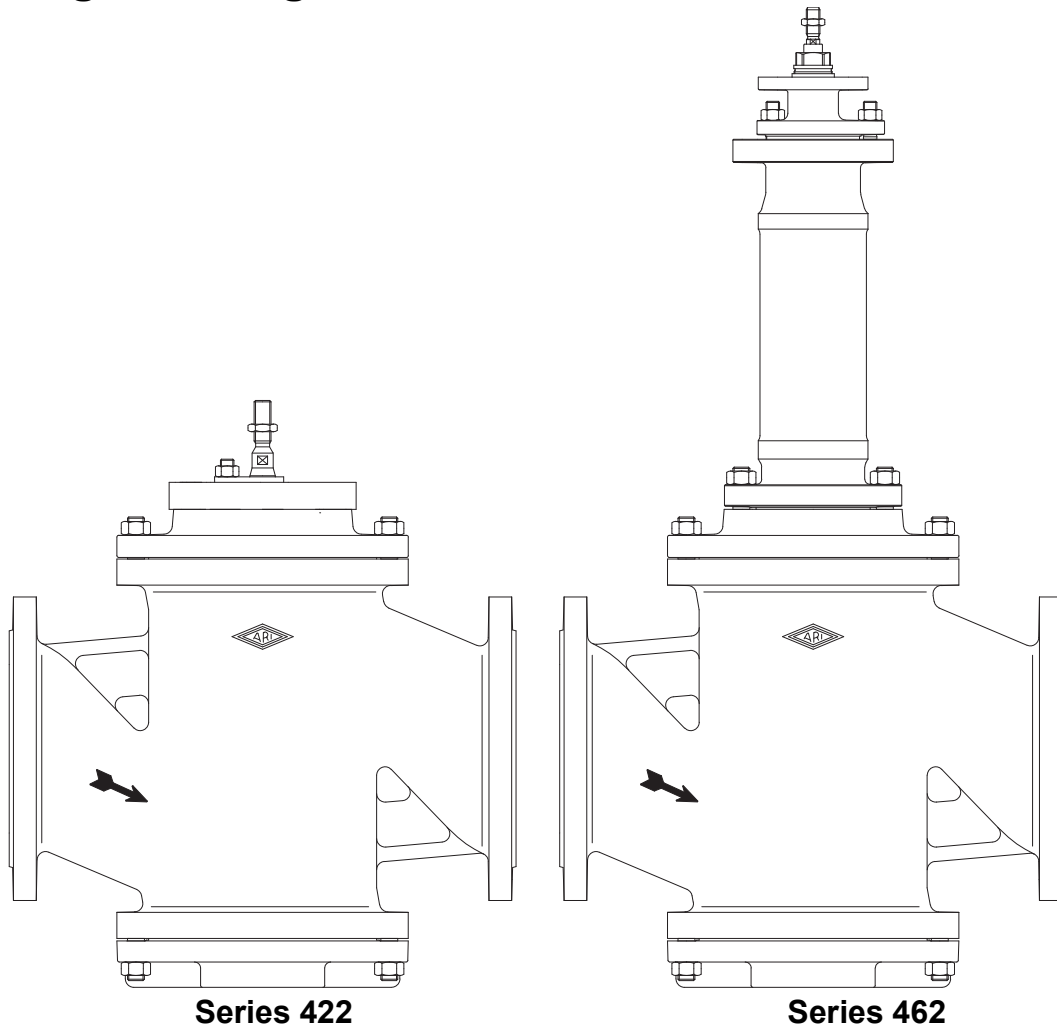




Operating and installation instructions

Straight through control valves - STEVI® 422 / 462



Contents

1.0 General information on operating instructions	2-2
2.0 Notes on possible dangers.....	2-2
2.1 Significance of symbols	2-2
2.2 Explanatory notes on safety information	2-2
3.0 Storage and transport	2-2
4.0 Description	2-3
4.1 Scope of applications	2-3
4.2 Operating principles	2-3
4.3 Diagram.....	2-4
4.3.1 Plug design	2-4
4.4 Technical data	2-4
4.5 Marking	2-5
5.0 Installation.....	2-5
5.1 General notes on installation.....	2-5
5.2 Requirements at the place of installation	2-6
5.3 Installation instructions concerning actuators	2-6
6.0 Putting the valve into operation.....	2-7
7.0 Care and maintenance	2-8
7.1 Replacement of stem sealings	2-8
7.1.1 Stuffing box packing design	2-8
7.1.2 EPDM sealing design	2-9
7.1.3 Bellows seal design	2-10
7.2 Replacement of internal parts	2-11
7.2.1 Replacment of plug and stem	2-11
7.2.2 Replacement of seals of pressure balanced plugs	2-11
7.2.3 Replacement of the seat ring	2-12
7.3 Tightening torques.....	2-12
7.3.1 Tightening torques for nuts	2-12
7.3.2 Anzugsdrehmomente der Sitzringe	2-12
8.0 Troubleshooting	2-12
9.0 Troubleshooting table	2-13
10.0 Dismantling the valve or the top part....	2-14
11.0 Warranty / Guarantee	2-14

1.0 General information on operating instructions

These operating instructions provide information on mounting and maintaining the valves. Please contact the supplier or the manufacturer in case of problems which cannot be solved by reference to the operating instructions.

They are binding for transport, storage, installation, start-up, operation, maintenance and repair.

The notes and warnings must be observed and adhered to.

- Handling and all other work must be carried out by expert personnel or all activities supervised and checked.

It is the owner's responsibility to define areas of responsibility and competence and to supervise personnel.

- In addition, current regional safety requirements must be applied and observed when taking the valves out of service as well as when maintaining and repairing them.

The manufacturer reserves the right to introduce technical modifications or improvements at any time.

These operating instructions comply with the requirements of EU Directives.

2.0 Notes on possible dangers

2.1 Significance of symbols



ATTENTION !

...

Warning of general danger.

2.2 Explanatory notes on safety information

In these operating and installation instructions dangers, risks and items of safety information are highlighted to attract special attention.

Information marked with the above symbol and "**ATTENTION !**" describe practices, a failure to comply with which can result in serious injury or danger of death for users or third parties or in material damage to the system or the environment. It is vital to comply with these practices and to monitor compliance.

All other information not specifically emphasised such as transport, installation, operating and maintenance instructions as well as technical data (in the operating instructions, product documentation and on the device itself) must also be complied with to the fullest extent in order to avoid faults which in turn can cause serious injury to persons or damage to property.

3.0 Storage and transport



ATTENTION !

- *Protect against external force (like impact, vibration, etc.).*
- *Valve mountings such as actuators, handwheels, hoods must not be used to take external forces, e.g. they are not designed for use as climbing aids or as attachment points for lifting gear.*
- *Suitable materials handling and lifting equipment should be used.*
See catalog sheet for weights.

- At -20 °C to +65 °C.

- The paint is a base coat to protect against corrosion during transportation and storage. Do not damage paint protection.



4.0 Description

4.1 Scope of applications

Valves are used for „controlling the flow of liquids, gases and vapours in chemical and other processing plants and for plant engineering“.



ATTENTION !

- Refer to the data sheet for applications, limits on use and possibilities.
- Certain media require or preclude the use of special materials.
- The valves are designed for standard operating conditions. If conditions exceed these requirements, e.g. aggressive or abrasive media, the operator should state the higher requirements when ordering.
- Valves made from grey cast iron are not authorised for use in systems subject to TRD 110.

The information complies to the Pressure Equipment Directive 2014/68/EU.

It is the responsibility of the machine planner to ensure compliance.

The special markings on the valve must be taken into account.

Refer to the catalogue sheet to see which materials are used in standard versions.

Please contact the supplier or the manufacturer if you have any questions.

4.2 Operating principles

The control valves are especially suitable for actuation by pneumatic or electrical actuators.

Three plug types are available to suit the various applications:

- parabolic plug (standard pattern)
- perforated plug
- pressure balanced plug

The flow through control valves is always against the closing direction.

In the case of control valves with perforated plugs, gases and vapours flow against the closing directions, but liquids flow through in the closing direction. If a pneumatic actuator is to be used on a straight-way valve with a perforated plug with the fluid moving in the closing direction, a higher closing force will be needed. This is to prevent vibration as the plug approaches the closed position.

If the forces generated by the actuators are too low, arrangements should be made to relieve the pressure as far as this is compatible with service conditions.

4.3 Diagram

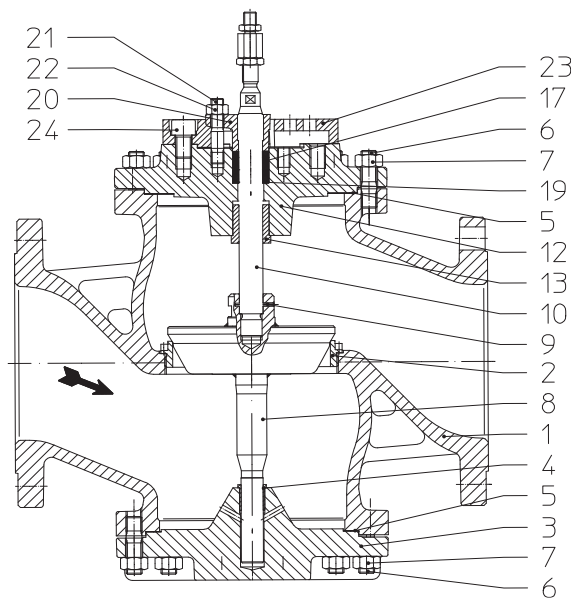


Fig. 1: Series 422

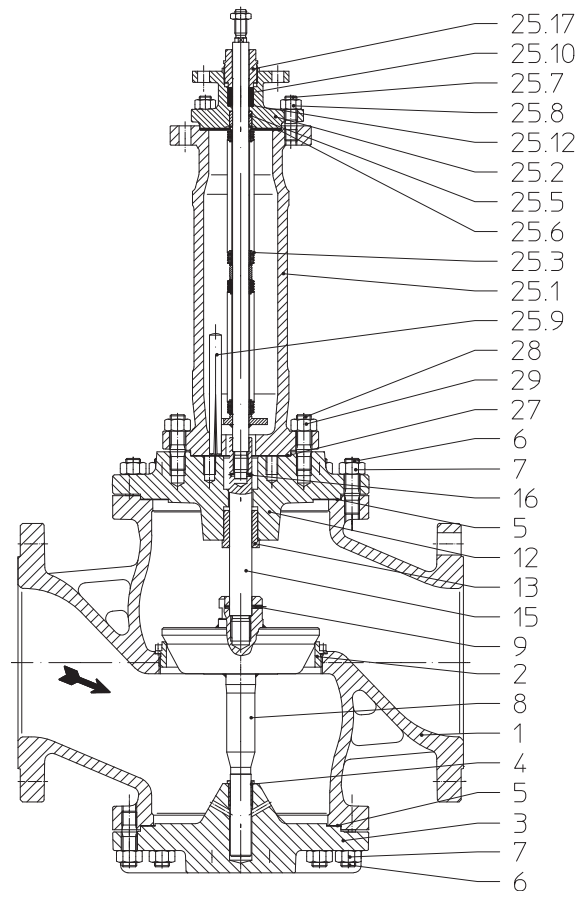


Fig. 2: Series 462

4.3.1 Plug design

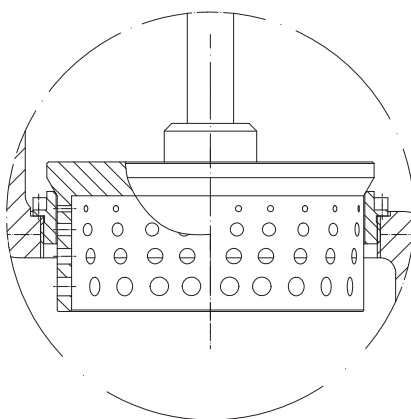


Fig. 3: Perforated plug

(Pressure balanced plug
refer to Fig. 13)

4.4 Technical data

for

- Principal dimensions
- Pressure-temperature-ratings, etc. refer to data sheet.



4.5 Marking

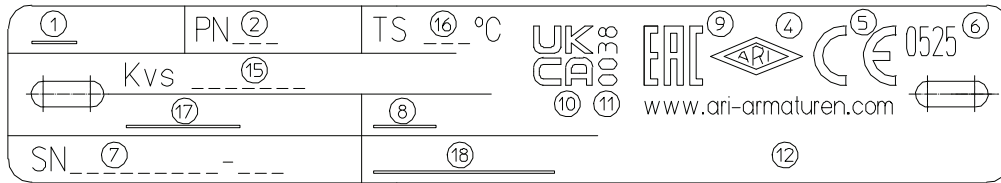


Fig. 4

No.	Value
1	Figure / Product
2	Nominal pressure
4	Manufactured by ARI-Armaturen
5	CE marking
6	Notified body
7	Serial number
8	Year of manufacture
9	EAC marking
10	UKCA marking
11	Notified body
12	Marking at approval
15	Kvs-value / Zeta-value
16	Permissible maximum temperature
17	Stem sealing • V-Ring = <i>PTFE-V-ring unit</i> • PTFE = <i>PTFE packing</i> • PTFE FDA = <i>PTFE FDA packing</i> • PTFE-seal FDA = <i>PTFE gasket set FDA</i> • Graphit = <i>pure graphite-packing</i> • Graphit 99,85% = <i>pure graphite 99,85%-packing</i> • EPDM = <i>EPDM sealing</i> • EPDM FDA = <i>EPDM FDA sealing</i> • NBR = <i>NBR sealing</i> • H-NBR = <i>H-NBR sealing</i> • bellows seal = <i>Stainless steel bellows</i>
18	Customer-specific text

Address of manufacturer: refer to item 11.0 Warranty / Guarantee

According to the Pressure Equipment Directive table 6, annex II valves without safety function are only allowed to bear the CE-marking DN32 onwards.

5.0 Installation

5.1 General notes on installation

The following items should be taken into account besides the general principles governing installation work:



ATTENTION !

- Remove flange covers if present.
- The interior of valve and pipeline must be free from foreign particles.
- Note installation position with reference to flow, see mark on valve.
- Steam line systems should be designed to prevent water accumulation.
- Lay pipelines so that damaging transverse, bending and torsional forces are avoided.
- Protect valves from dirt during construction work.
- Connection flanges must mate exactly.
- Connecting bolts for pipe flanges should be mounted preferably from the counter flange side (hexagon nuts from the valve side).
At DN15-32: If valves should be mounted directly to valves, the upper flange connecting bolts should be preferably executed with studs and hexagon nuts on both sides.
- Valve mountings such as actuators, handwheels, hoods must not be used to take external forces, e.g. they are not designed for use as climbing aids, or as connecting points for lifting gear.
- Suitable materials handling and lifting equipment should be used.
Refer to data sheet for weights.
- Keep the thread and shaft of the stem free from paint.
- Centre gaskets between the flanges.
- Strainers or filters should be installed before the valves.

- Planners / construction companies or operators are responsible for positioning and installing products.
- The valves are designed for application, not influenced from weather.
- For application outside or in adverse environments like corrosion-promoting conditions (sea water, chemical vapours, etc.), special constructions or protective measures are recommended.

5.2 Requirements at the place of installation

The place of installation should be easily accessible and provide ample space for maintenance and removing the actuator. Stop valves should be installed before and after the control valve to enable maintenance working without draining the piping system. The valve should preferably installed vertically with the actuator at the top. Inclined or horizontal installation without supports is permissible only with light actuators.

For this installation position, the two distance columns (or joke) have to be above each other in the vertical plane.

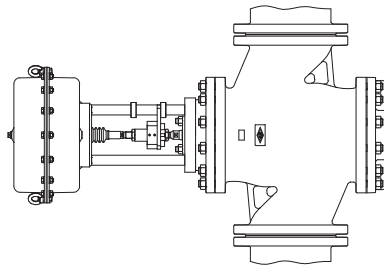


Fig. 5: Pipeline vertically

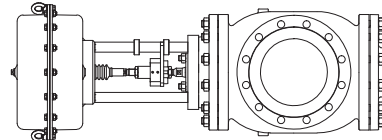


Fig. 6: Pipeline horizontally

Permissible servo weights for valves with unsupported horizontal stems:

55 kg for DN200-250

The pipes must be lagged to protect the actuators from excessive heat. Sufficient space must be left for the maintenance of the stem packing.

To ensure that the servo controlled valves function correctly, the pipe run should be straight for at least 2 x n.d. upstream and 6 x n.d. downstream of the valve.

5.3 Installation instructions concerning actuators

Normally, servo controlled valves are supplied complete with actuator fitted.

It is not permitted to mantle / dismantle actuators with valves operating and service conditions (temperature and pressure). The actuators must be assemble as describe in the operating instructions during conversion and maintenance.

During assembly work, the plug is not be turned on its seating at closing pressure.



ATTENTION !

Care must be taken with the bellow type valves when actuators are mounted or removed. (Hold the valve-stem against turning with an open-end wrench!)

When retrofitting actuators, the maximum permissible force for valve actuation must be taken into account:

Fig. 422

59kN for DN 200-250

Fig. 462

37kN for DN 200-250



6.0 Putting the valve into operation



ATTENTION !

- *Before putting the valve into operation, check the material, pressure, temperature and direction of flow.*
- *Regional safety instructions must be adhered to.*
- *Residues in piping and valves (dirt, weld beads, etc.) inevitably lead to leakage and / or damage.*
- *Touching the valve when it is operating at high ($> 50\text{ °C}$) or low ($< 0\text{ °C}$) media temperatures can cause injury.*

Affix a warning notice or provide protective insulation as appropriate.

Before putting a new plant into operation or restarting a plant after repairs or modification, always make sure that:

- *All work has been completed correctly.*
- *The valve is in the correct position for its function.*
- *Safety devices have been attached.*

7.0 Care and maintenance

Maintenance and maintenance intervals have to be defined by the operator according to the service conditions.

7.1 Replacement of stem sealings

7.1.1 Stuffing box packing design

The stuffing box packing (pos. 17) requires maintenance.

If leaks develop, immediately tighten the hexagon nuts (pos. 22) gradually until the packing (pos. 17) stops leaking.

The service life of stuffing box packings (pos. 17) can be increased by checking regularly leakage.

If leaks can no longer be stopped by tightening the nuts (pos. 22), a new packing ring (pos. 17) must be inserted into the gland.

Replacement of stuffing box packing:



ATTENTION !

Refer to item 10.0 and 11.0 before dismantling the valve.

- Remove actuator. (Refer to operating instructions for actuator!)
- Insert the new packing ring (pos. 17) as shown in Fig. 8

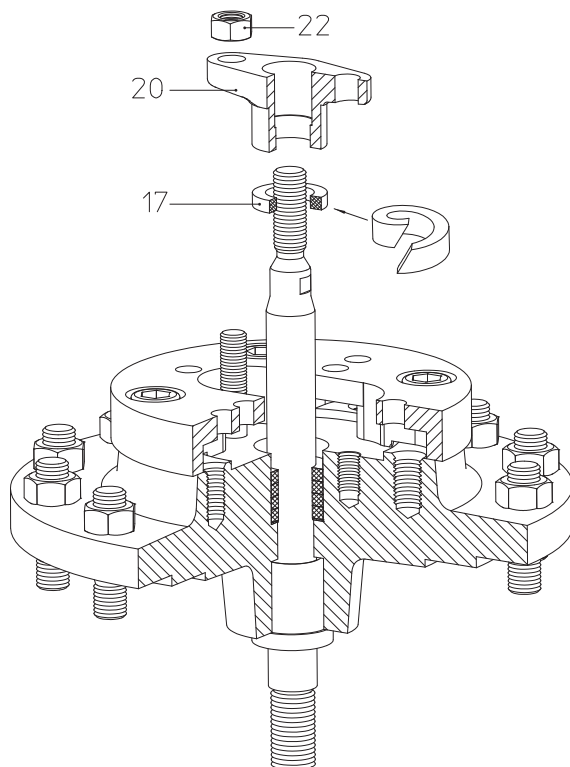


Fig. 7: Stuffing box packing

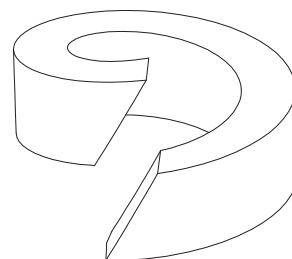


Fig. 8: split packing ring

If a split packing ring is used, cut with a chamfer as shown in Fig. 8.

Damaged stems must also be replaced (refer to item 7.2 for instructions) since a new ring pack will soon start leaking again if the stem is damaged.

7.1.2 EPDM sealing design

This sealing system can be used for water and steam up to an operating temperature of 180°C. Owing to the elastomer material, the sealing rings are self-sealing and therefore maintenance free. If the stem starts leaking, the seal is worn out and must be replaced.

Replacement of EPDM sealing rings:



ATTENTION !

Before dismantling the valve, refer to sections 10.0 and 11.0.

- Remove the actuator including the universal adapter flange (pos. 23) by loosening the socket head cap screws (pos. 24) (refer to the operating instructions for the actuator!)
- Loosen nuts (pos. 22).
- Remove upper part (pos. 20).
- To replace the sealing elements, you must replace the complete stem seal (pos. 120) including the integral seals.
- complete stem seal (pos. 120) including the integral seals.

Damaged stems must also be replaced (for a description, refer to section 7.2) because a new ring pack will soon start leaking again if the stem is damaged.

Assemble in reverse order.

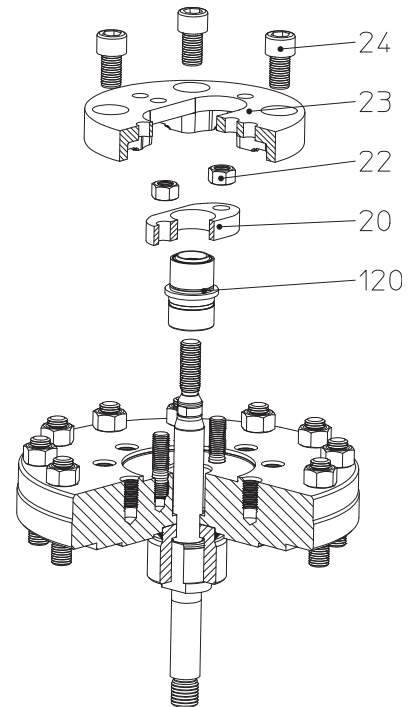


Fig. 9: EPDM Abdichtung

7.1.3 Bellows seal design

If the stem leaks, the bellows seal is defective. The leak can initially be stopped by tightening the sleeve nut (pos. 25.16).

Stem and bellows (pos. 25.3) can only be replaced together.

Replacement of bellows seal:



ATTENTION !

Refer to item 10.0 and 11.0 before dismantling the valve.

- Remove actuator.
(Refer to operating instructions for actuator!)
- Loose nuts (pos. 7).
- Detach bellows assembly (pos. 25) incl. stuffing box housing (pos. 12).
- Slacken screw joint (pos. 25.17) resp. sleeve nut (pos. 25.16) by about one turn.
- Loose nuts (pos. 29).
- Lift bellows housing (pos. 22.1).
- Drive spring pin (pos. 16) out with a drift.
- Unscrew stem adapter (pos. 15) with plug (pos. 8).
- Loose nuts (pos. 25.8).
- Detach mounting bonnet (pos. 25.2) or stuffing box housing (pos. 25.2).
- Extract stem-/bellows unit (pos. 25.3) from the bellows housing (pos. 25.1).
- Bolt new parts together and drill them.
- Replace 2 gaskets (pos. 25.6) and 1 gasket (pos. 5).
- Assemble in reverse order.



ATTENTION !

- Ensure that the torsion lock is correctly positioned when inserting new stem/bellows unit. Introduce the grooved pin (pos. 25.9) into the torsion lock groove. Make sure it runs smoothly!

- Secure with nuts (pos. 7, 25.8 and 29) and tighten them crosswise.
(For tightening torques refer to item 7.3.1)
- Tighten the screw joint (pos. 22.17) resp. the sleeve nut (pos. 22.16) gradually up to tightness of the stuffing box packing (pos. 22.10).

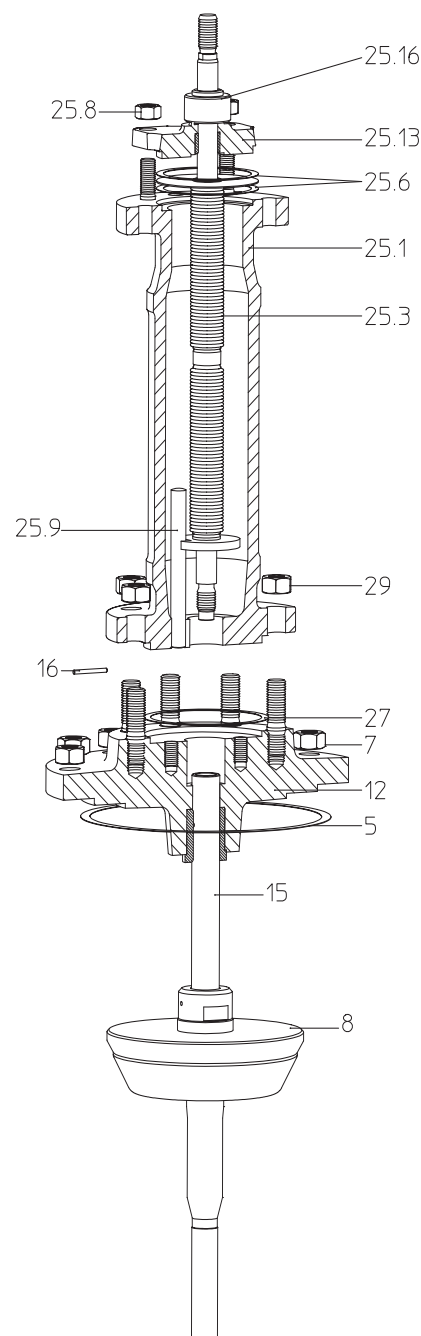


Fig. 10: BR 462

7.2 Replacement of internal parts

7.2.1 Replacement of plug and stem



ATTENTION !

Refer to item 10.0 and 11.0 before dismantling the valve.

- Remove actuator.
(Refer to operating instructions for actuator!)

BR 422

- Loose nuts (pos. 7).
- Detach stuffing box housing (pos. 12).
- Slacken nuts (pos. 22) by 2 or 3 turns.
- Extract plug (pos. 8) and stem (pos. 10).
- Drive pin (pos. 9) out with a drift.
- Unscrew plug (pos. 3).
- Bolt new parts together and drill them.
- Replace gasket (pos. 5).
- Assemble in reverse order.
- Secure with nuts (pos. 7) and tighten them crosswise.
(For tightening torques refer to item 7.3.1)

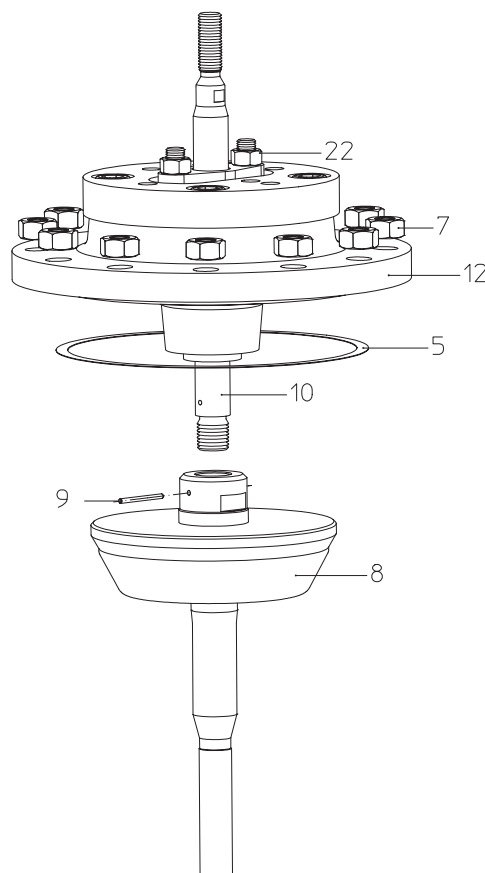


Fig. 11: BR 422

BR 462

For replacement of plug and stem with bellows sealing (Series 462) refer to item 7.1.3.

7.2.2 Replacement of seals of pressure balanced plugs



ATTENTION !

Refer to item 10.0 and 11.0 before dismantling the valve.

- Remove actuator.
(Refer to operating instructions for actuator!)
- Remove plug as described in item 7.2.
- Prise worn piston seal (pos. 32) out of groove in plug with suitable tool (e.g. screwdriver).
- Insert new piston seal (pos. 32), taking care that it is in the correct position (refer to Fig. 12).
- Replace guide ring (pos. 31).
- Clean sliding surface of guide bush (pos. 30); smooth with fine abrasive if necessary.
- Replace 2 gaskets (pos. 5).
- Assemble in reverse order.
- Secure with nuts (pos. 10) and tighten them crosswise.
(For tightening torques refer to item 7.3.1)

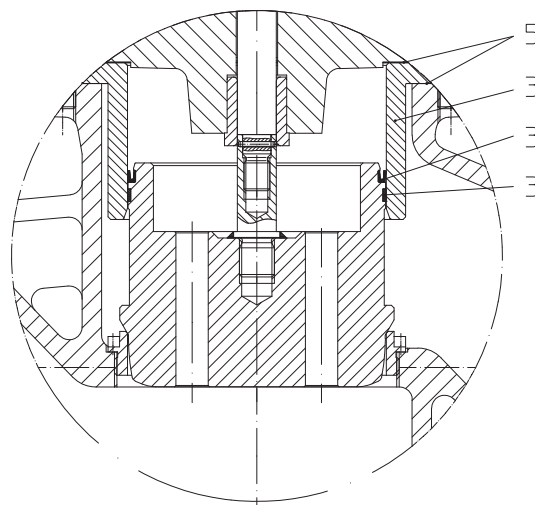


Fig. 12: Pressure balanced plug



7.2.3 Replacement of the seat ring



ATTENTION !

Refer to item 10.0 and 11.0 before dismantling the valve.

- Remove actuator. (Refer to operating instructions for actuator!)
- Loose nuts (pos. 11).
- Detach valve top part.
- Unscrew seat ring (pos. 2) with a special wrench (can be obtained from the manufacturer).
- Clean thread and sealing taper in body (pos. 1) and apply with suitable lubricant.
- Replace respectively recondition seat ring (pos. 2).
- Install seat ring (pos. 2). (For tightening torques refer to item 7.3.2.)
- Replace gasket (pos. 5).
- Assemble valve top part.
- Secure with nuts (pos. 11) and tighten them crosswise.
(For tightening torques refer to item 7.3.1.)

7.3 Tightening torques

7.3.1 Tightening torques for nuts

M 16	=	80 - 120 Nm
M 20	=	150 - 200 Nm
M 24	=	340 - 410 Nm

7.3.2 Tightening torques for seat rings

DN 200	=	3800 Nm
DN 250	=	4000 Nm

! Refer to operating instructions for actuator concerned for installing actuators !

8.0 Troubleshooting

In the event of malfunction or faulty operating performance check that the installation and adjustment work has been carried out and completed in accordance with these Operating Instructions.



ATTENTION !

- It is essential that the safety regulations are observed when identifying faults.

If malfunctions cannot be eliminated with the help of the following table "9.0 Troubleshooting table", the supplier or manufacturer should be consulted.



9.0 Troubleshooting table



ATTENTION !

- read item 10.0 and 11.0 prior to dismantling and repair work!
- read item 6.0 before restarting the plant !

Fault	Possible cause	Corrective measures
No flow	Valve closed	Open valve (using actuator)
	Flange covers not removed	Remove flange covers
Little flow	Valve not sufficiently open	Open valve (using actuator)
	Dirt sieve clogged	Clean / replace sieve
	Piping system clogged	Check piping system
	Kvs value of valve unsuitable	Fit valve with higher Kvs value
Valve stem moves in jerks.	Stuffing box sealing too tight (for valves with graphite packings)	Slacken stuffing box gland or hex. nut (pos. 22) slightly, valve must not start leaking!
	Valve plug slightly seized owing to solid dirt particles	Clean internals, smooth rough spots
Valve stem or plug cannot be moved.	Seating and plug clogged with dirt; especially with V-port and perforated plugs	Clean seating and plug with suitable solvent
	Valve plug seized in seating or guide owing to deposits or dirt in medium	Replace plug and seating; use parts made from different material if necessary
Valve stem leaking.	Stuffing box gland too slack in valves with stuffing box packings	Tighten or repack stuffing box gland or nuts (pos. 22); refer to item 7.1.1
	Bellows defective in valves with bellows seal	Replace bellows unit; refer to item 7.1.3
Leakage too high when valve is closed.	Sealing surfaces of plug eroded or worn	Replace plug - refer to item v
	Sealing edge of seating damages or worn	Replace seating; refer to item 7.2, fit dirt sieve if necessary
	Piston sealing ring worn (pressure-relieved valves)	Replace sealing ring
	Seating and/or plug dirty.	Clean internals of valve, fit dirt sieve if necessary
	Pneumatic actuator not completely vented; spring force not fully effective	Vent actuator air chamber completely
	Actuator not powerful enough	Install more powerful actuator; check service data



10.0 Dismantling the valve or the top part



ATTENTION !

The following points must be observed:

- *Pressureless piping system.*
- *Medium must be cool.*
- *Plant must be drained.*
- *Purge piping systems in case of caustic, inflammable, aggressive or toxic media.*

11.0 Warranty / Guarantee

The extent and period of warranty cover are specified in the "Standard Terms and Conditions of Albert Richter GmbH & Co. KG" valid at the time of delivery or, by way of departure, in the contract of sale itself.

We guarantee freedom of faults in compliance with state-of-the-art technology and the confirmed application.

No warranty claims can be made for any damage caused as the result of incorrect handling or disregard of operating and installation instructions, technical data sheets and relevant regulations.

This warranty also does not cover any damage which occurs during operation under conditions deviating from those laid down by specifications or other agreements.

Justified complaints will be eliminated by repair carried out by us or by a specialist appointed by us.

No claims will be accepted beyond the scope of this warranty. The right to replacement delivery is excluded.

The warranty shall not cover maintenance work, installation of external parts, design modifications or natural wear.

Any damage incurred during transport should not be reported to us but rather to the competent cargo-handling depot, the railway company or carrier company immediately or else claims for replacements from these companies will be invalidated.

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