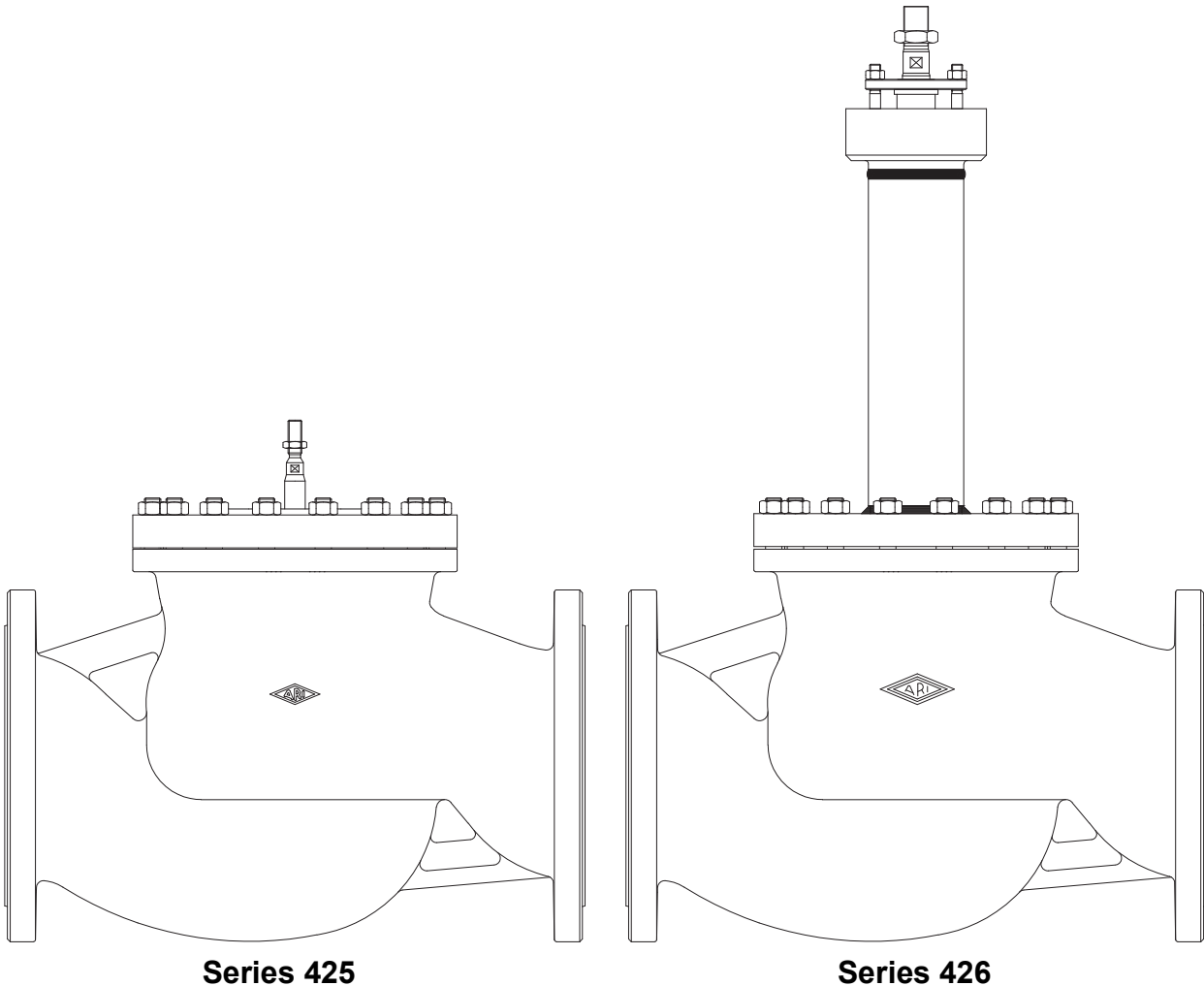




# Operating and installation instructions

## Straight through control valves - STEVI® 425 / 426



Series 425

Series 426

### Contents

|                                                                |            |                                                             |             |
|----------------------------------------------------------------|------------|-------------------------------------------------------------|-------------|
| <b>1.0 General information on operating instructions .....</b> | <b>2-2</b> | 7.1 Replacement of stem sealings .....                      | 2-9         |
| <b>2.0 Notes on possible dangers.....</b>                      | <b>2-2</b> | 7.1.1 EPDM-ring stem sealing design .....                   | 2-9         |
| 2.1 Significance of symbols .....                              | 2-2        | 7.1.2 Stuffing box packing design .....                     | 2-10        |
| 2.2 Explanatory notes on safety information .....              | 2-2        | 7.1.3 Bellows seal design .....                             | 2-11        |
| <b>3.0 Storage and transport .....</b>                         | <b>2-2</b> | 7.2 Replacement of internal parts .....                     | 2-12        |
| <b>4.0 Description.....</b>                                    | <b>2-3</b> | 7.2.1 Replacement of plug and stem .....                    | 2-12        |
| 4.1 Scope of applications .....                                | 2-3        | 7.2.2 Replacement of seals of pressure balanced plugs ..... | 2-12        |
| 4.2 Operating principles .....                                 | 2-3        | 7.2.3 Replacement of the seat ring .....                    | 2-13        |
| 4.3 Diagram .....                                              | 2-4        | 7.3 Tightening torques.....                                 | 2-13        |
| 4.3.1 Plug design .....                                        | 2-6        | 7.3.1 Tightening torques for nuts .....                     | 2-13        |
| 4.4 Technical data .....                                       | 2-6        | 7.3.2 Tightening torques for seat rings .....               | 2-13        |
| 4.5 Marking .....                                              | 2-6        | <b>8.0 Troubleshooting .....</b>                            | <b>2-13</b> |
| <b>5.0 Installation.....</b>                                   | <b>2-7</b> | <b>9.0 Troubleshooting table .....</b>                      | <b>2-14</b> |
| 5.1 General notes on installation.....                         | 2-7        | <b>10.0 Dismantling the valve or the top part ...</b>       | <b>2-15</b> |
| 5.2 Requirements at the place of installation .....            | 2-8        | <b>11.0 Warranty / Guarantee .....</b>                      | <b>2-15</b> |
| 5.3 Installation instructions concerning actuators .....       | 2-8        |                                                             |             |
| <b>6.0 Putting the valve into operation.....</b>               | <b>2-9</b> |                                                             |             |
| <b>7.0 Care and maintenance .....</b>                          | <b>2-9</b> |                                                             |             |

## 1.0 General information on operating instructions

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

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

The notes and warnings must be observed and adhered to.

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

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

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

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

These operating instructions comply with the requirements of EU Directives.

## 2.0 Notes on possible dangers

### 2.1 Significance of symbols



Warning of general danger.

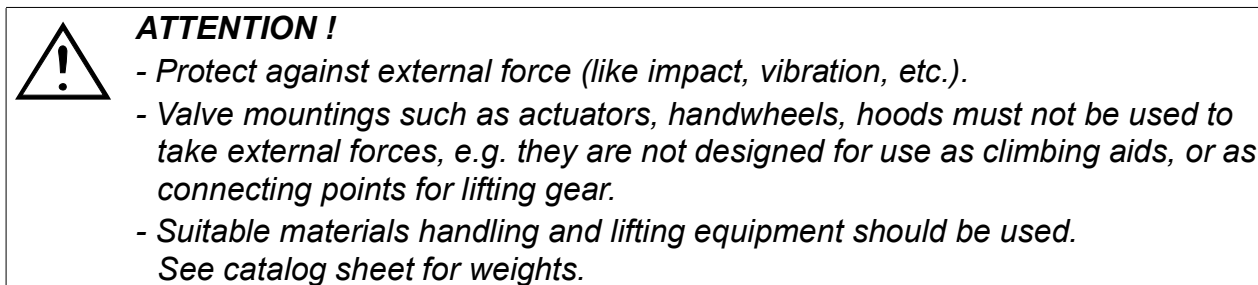
### 2.2 Explanatory notes on safety information

In this operating and installation Instruction 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



- 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:

- V-port 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

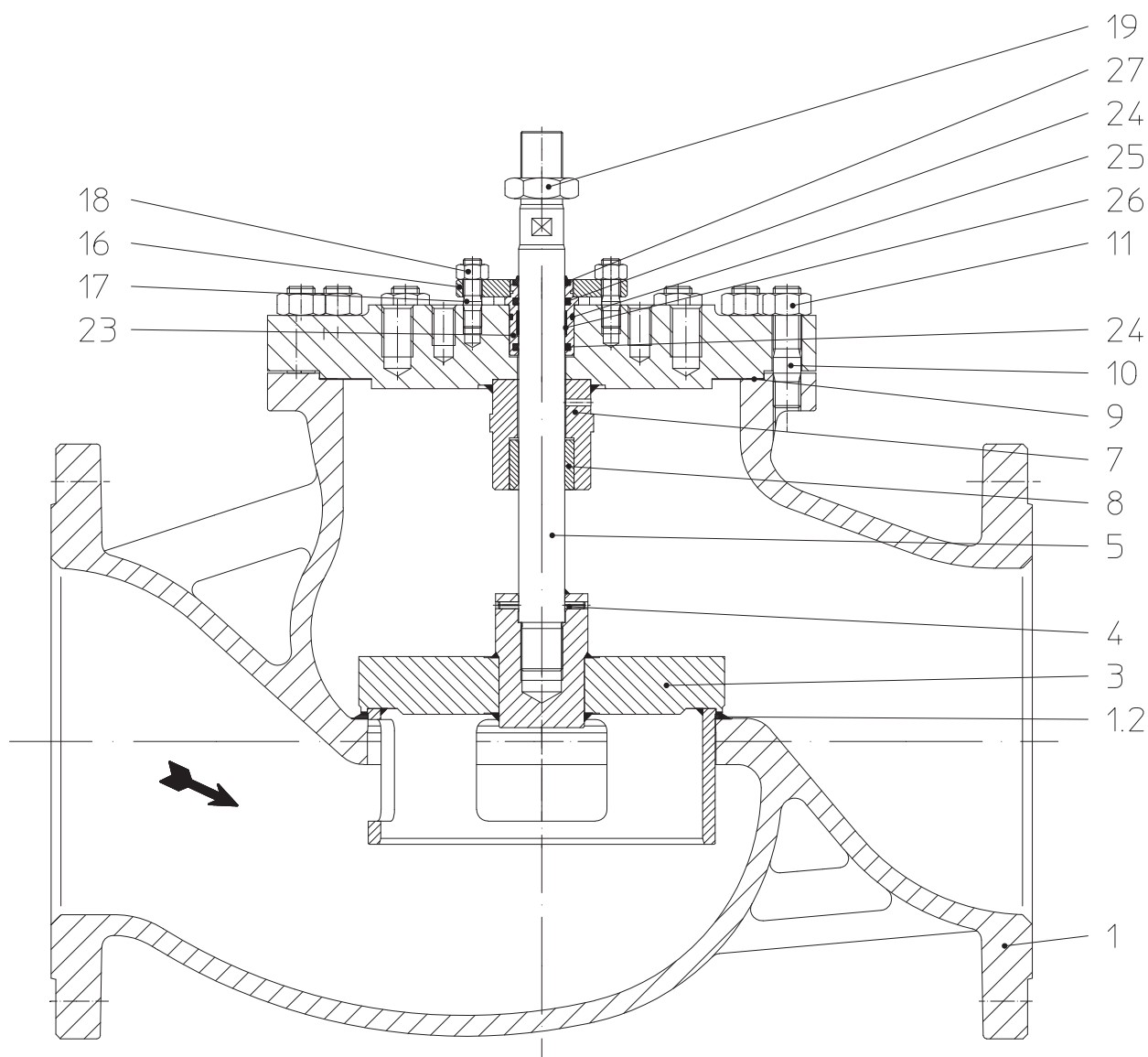


Fig. 1: Series 425

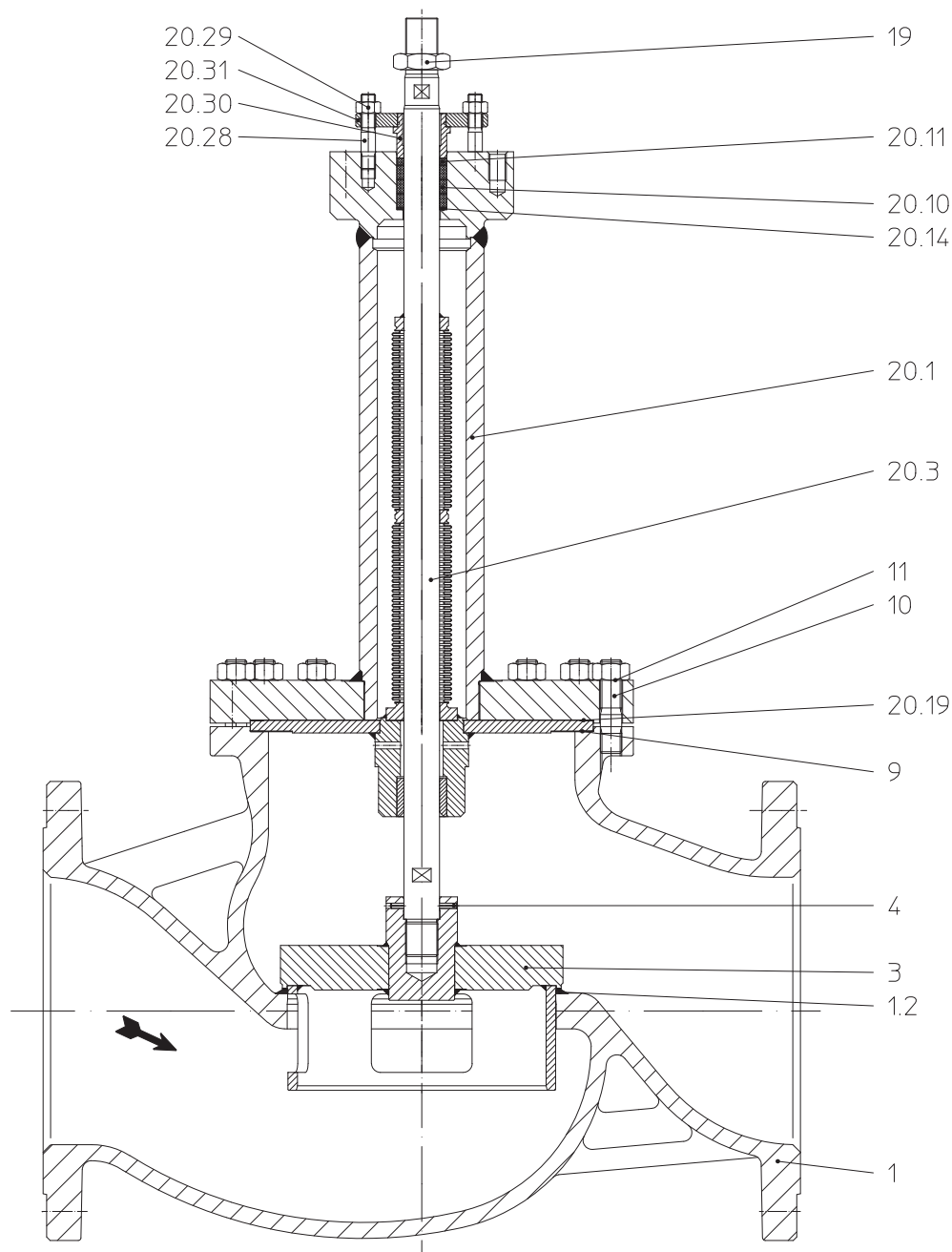
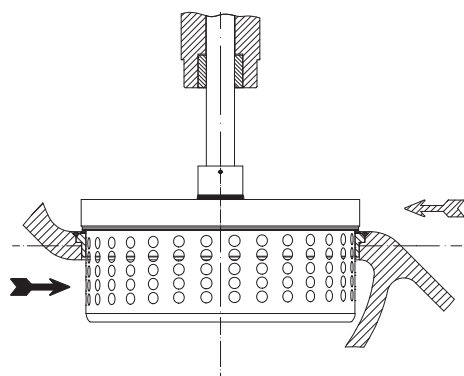


Fig. 2: Series 426

### 4.3.1 Plug design



(Design with pressure balanced plug  
refer to Fig. 12)

Fig. 3: Design with perforated plug



### 4.4 Technical data

for

- **Principal dimensions**

- **Pressure-temperature-ratings, etc.** refer to data sheet.

### 4.5 Marking

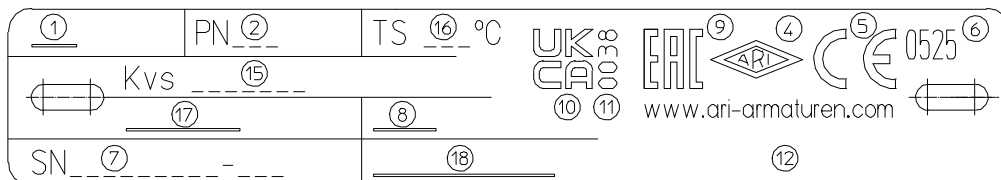


Bild 4

| 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 / Cv- value                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |
| 16  | Permissible maximum temperature                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |
| 17  | Stem sealing <ul style="list-style-type: none"> <li>• V-Ring = <i>PTFE-V-ring unit</i></li> <li>• PTFE = <i>PTFE packing</i></li> <li>• PTFE FDA = <i>PTFE FDA packing</i></li> <li>• PTFE-seal FDA = <i>PTFE gasket set FDA</i></li> <li>• Graphit = <i>pure graphite-packing</i></li> <li>• Graphit 99,85% = <i>pure graphite 99,85%-packing</i></li> <li>• EPDM = <i>EPDM sealing</i></li> <li>• EPDM FDA = <i>EPDM FDA sealing</i></li> <li>• NBR = <i>NBR sealing</i></li> <li>• H-NBR = <i>H-NBR sealing</i></li> <li>• bellows seal = <i>Stainless steel bellows</i></li> </ul> |
| 18  | Customized 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).
- 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.

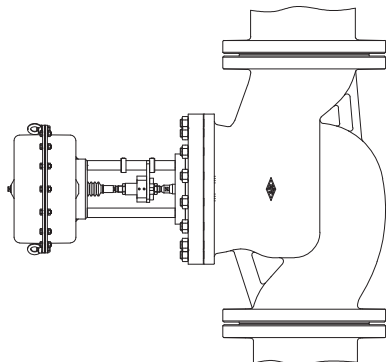


Fig. 5: Pipeline vertically

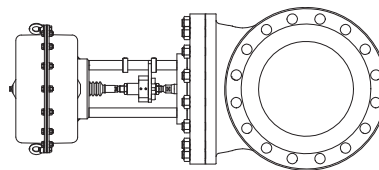


Fig. 6: Pipeline horizontally

Permissible servo weights for valves with unsupported horizontal stems:

65 kg for DN300 - 500

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:

220kN for DN 300-500

## 6.0 Putting the valve into operation



### **ATTENTION !**

- Before putting the valve into operation, check 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.
- Touching the valve when it is operating at high ( $> 50\text{ °C}$ ) or low ( $< 0\text{ °C}$ ) media temperatures can cause injury.

*Affix warning notice or protective insulation as appropriate!*

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

- All works has been completed!
- 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 EPDM-ring stem sealing design

Stem sealing consisting of:

- 1 scraper (pos. 27)
- 2 gaskets (pos. 24)
- 1 O-ring (pos. 25)

This sealing can be used for water and steam up to  $130\text{ °C}$  operating temperature. Because of the elastomer material the sealing rings are maintenance free.

If the stem starts leaking, the ring pack is worn out and must be replaced.

#### Replacement of EPDM-stem sealings:



### **ATTENTION !**

**Refer to item 10.0 and 11.0 before dismantling the valve.**

- Remove actuator.  
(Refer to operating instructions for actuator!)
- When replacing the sealings (pos. 24, 25), make sure that the parts are installed in the correct order and positions (refer to Fig. 7).

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

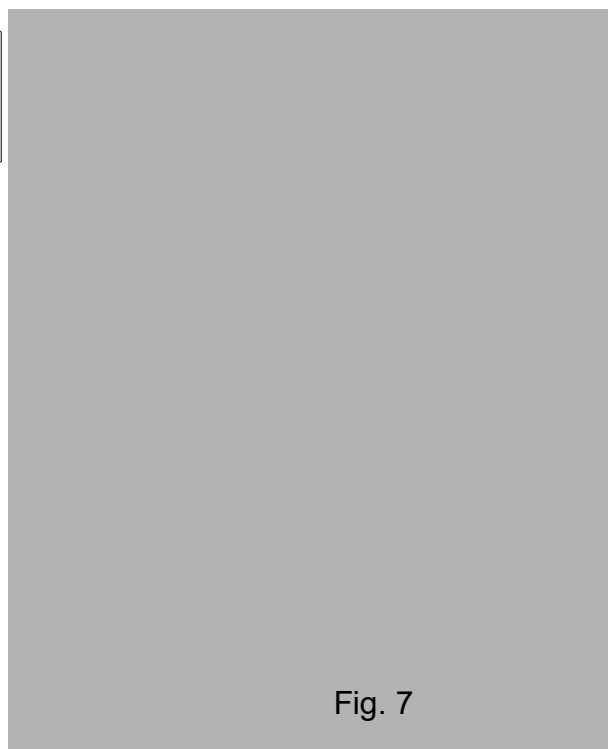


Fig. 7

### 7.1.2 Stuffing box packing design

Stuffing box packings (pos. 12) require maintenance.

If leaks develop, immediately tighten the hexagon nuts (pos. 18) gradually until the packing (pos. 12) stops leaking.

The service life of stuffing box packings (pos. 12) can be increased by checking regularly leakage.

If leaks can no longer be stopped by tightening the nuts (pos. 18), a new packing ring (pos. 12) must be inserted into the gland.

#### Replacement of stuffing box packings:



#### **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 as shown in Fig. 8 - Fig. 9.

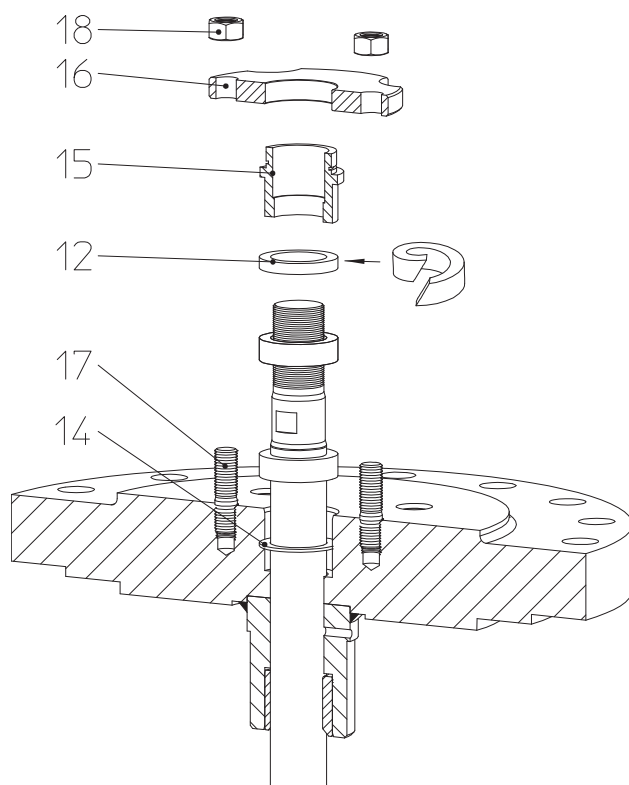


Fig. 8

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

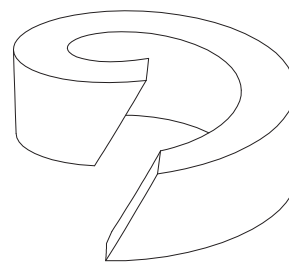


Fig. 9: Split packing ring

If a split packing ring is used, cut with a chamfer as shown in Fig. 9.

### 7.1.3 Bellows seal design

If the stem leaks, the bellows seal (pos. 20.3) is defective. The leak can initially be stopped by tightening the stuffing box gland with nuts (pos. 20.29).

Stem and bellows (pos. 20.3) can only be replaced together.

#### Replacement of bellows seals:



#### **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 bellows assembly (pos. 20) .
- Slacken nuts (pos. 20.29) by about 2-3 turns.
- Extract stem-bellows unit (pos. 20.3) from the bellows housing (pos. 20.1).
- Drive pin (pos. 4) out with a drift.
- Unscrew stem-/bellows unit (pos. 20.3) and plug (pos. 3).
- Bolt new parts together, drill and pin them.
- Replace 2 gaskets (pos. 20.19, 9).
- Assemble in reverse order.
- Secure with nuts (pos. 11) and tighten them crosswise.  
(For tightening torques refer to item 7.3.1)
- Tighten nuts (pos. 20.29) gradually up to tightness of the stuffing box packing (pos. 20.10).

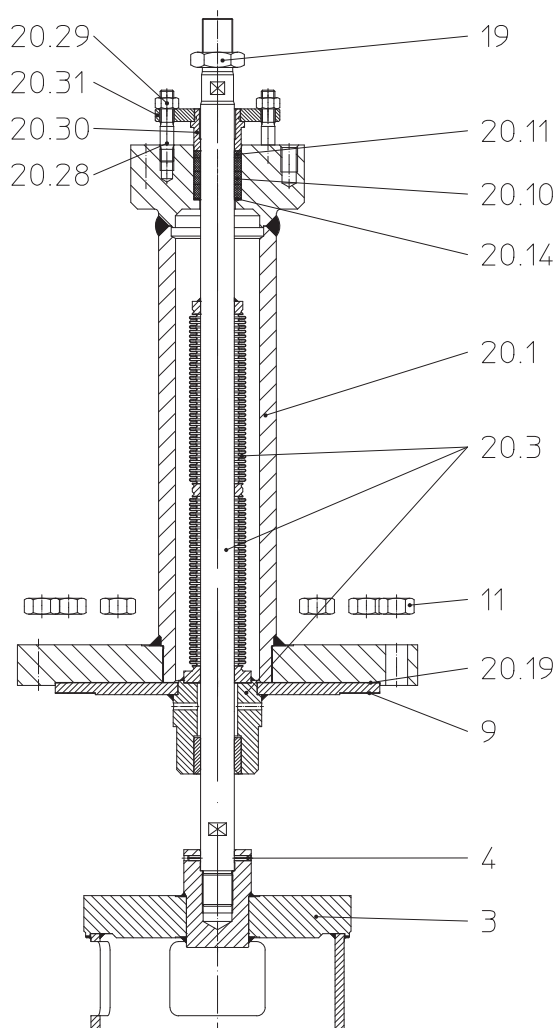


Fig. 10: Series 426

## 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!)

#### **Series 425:**

- Loose nuts (pos. 11).
- Detach stuffing box housing (pos. 7).
- Slacken nuts (pos. 18) by about 2-3 turns.
- Extract plug (pos. 3) and stem (pos. 5).
- Drive pin (pos. 4) out with a drift.
- Unscrew stem (pos. 5) and plug (pos. 3).

#### **Note:**

In some designs the stem is locked by a spot weld, which has to be removed with a grinding machine.

- Bolt new parts together, drill and pin them.
- Replace gasket (pos. 9).
- Assemble in reverse order.
- Secure with nuts (pos. 11) and tighten them crosswise.  
(For tightening torques refer to item 7.3.1)

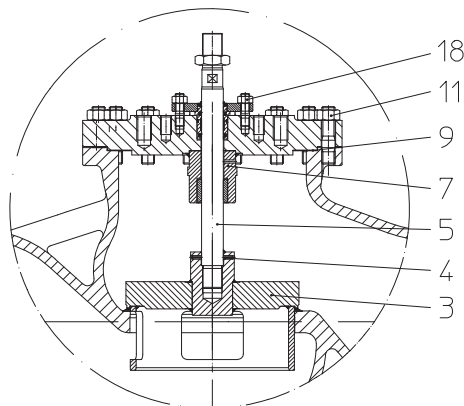


Fig. 11

#### **Series 426:**

For replacement of plug and stem with bellows sealing (Series 426) 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 7.2.1.
- Prise worn piston seal (pos. 30) out of groove in plug with suitable tool (e.g. screwdriver).
- Insert new piston seal (pos. 30), taking care that it is in the correct position (refer to Fig. 12).
- Replace guide ring (pos. 29).
- Clean sliding surface of guide bush (pos. 28);  
smooth with fine abrasive if necessary.
- Replace 2 gaskets (pos. 9).
- Assemble in reverse order.
- Secure with nuts (pos. 11) and tighten them crosswise.  
(For tightening torques refer to item 7.3.1.)

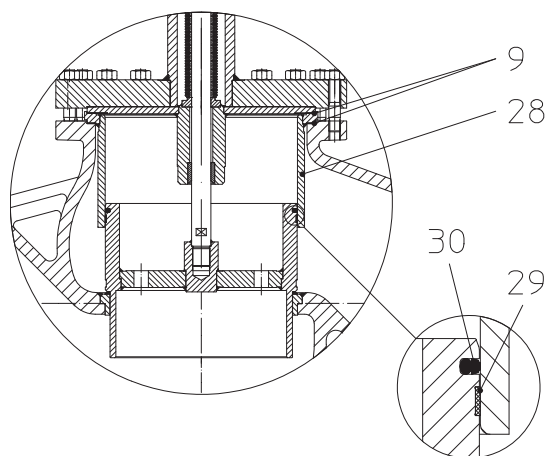


Fig. 12: Pressure balanced plug



### 7.2.3 Replacement of the seat ring

Only with bodies (pos. 1) of cast iron the seat ring is screwed in.



#### **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. 9).
- 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 24 | = | 340 - 370 Nm |
| M 27 | = | 420 - 460 Nm |

### 7.3.2 Tightening torques for seat rings

|        |   |         |
|--------|---|---------|
| DN 300 | = | 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 with nut (pos. 18 resp. 20.29); 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 are 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; refer to item 7.2 |
| Valve stem leaking.                    | Defective stem sealing in valves with EPDM stem sealing                             | Replace stem sealing; refer to item 7.1.1                                                        |
|                                        | Stuffing box gland too slack in valves with stuffing box packings                   | Tighten stuffing box gland with nuts (pos. 22) or repack; refer to item 7.1.2                    |
|                                        | Bellows defective in valves with bellows seal                                       | Replace bellows unit (pos. 20.3); 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 7.2                                                                  |
|                                        | Sealing edge of seating damages or worn                                             | Grind the seat resp. replace seat ring; refer to item 7.2, fit dirt sieve if necessary.          |
|                                        | Piston sealing ring worn (pressure-relieved valves)                                 | Replace sealing ring; refer to item 7.2.2                                                        |
|                                        | 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 pipe 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, datasheets 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.

#### **Importer to UK and responsible for compilation of the documentation:**

ARI Armaturen UK Ltd  
Energy House, Formal Industrial Park, Northway Lane, GL20 8GY Tewkesbury,  
United Kingdom



Your valve made by ARI®  
ari-armaturen.com

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Telephone (+49 5207) 994-0 Telefax (+49 5207) 994-158 or 159  
Internet: <https://www.ari-armaturen.com> E-mail: [info.vertrieb@ari-armaturen.com](mailto:info.vertrieb@ari-armaturen.com)



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ari-armaturen.com

# Operating and installation instructions

## Straight through control valves - STEVI® 425 / 426

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