

FOR VALVES WITH WELD-END CONNECTORS TO PIPELINE

General

- For maximum results and long valve life, follow the recommended procedures for installing Habonim valves with weld-end connectors.
- Standard valves may be installed in either direction. Valves with an upstream pressure relief hole in the ball are unidirectional and must be fitted with the flow arrow pointing downstream.
- A packet with replacement body seals is provided with the valve. Only Habonim authorized spare parts should be used.
- The working area should be clean and clear of any debris that would contaminate the valve, and the pipeline flushed free of dirt, weld spatter etc. before installation.
- Please read welding instructions and safety precautions carefully before installation.

Installation

1. with the valve in the open position, remove body connector nuts & bolts (or screws).
2. separate body connectors from the body, and remove the seats. dispose of the body o-ring seals.
3. support ball to prevent it from dislodging from the body. turn valve to the closed position for removal.
4. place all components on a clean surface, clear of welding splatter.
5. by replacing 2 nuts & bolts, reassemble body connectors to the valve body.
6. align valve to the pipeline. ensure proper fit to minimize pipe load. tack weld only.
7. dismantle body bolts, and remove valve body. place parts on a clean surface, clear of welding splatter (refer figure1).
8. complete the welding. protect body connector faces from welding splatter. allow adequate time for cooling.
9. carefully replace the ball in the body, and set valve to the fully open position. replace body seals from the packet provided, and then assemble ball seats. do not reuse the o ring body seals. keep the valve in the open position until the flushing process is complete.
10. ease the body assembly between the body connectors. take care not to score connector faces or damage seals. replace body connector nuts & bolts (or screws).
11. tighten the nuts & body bolts according to torque figures shown in table 1, and according to tightening patterns shown in figure 2.

Pipeline Flushing

Flushing is an important precaution taken to prevent damage to valve ball and seats. While flushing, keep all valves in the fully 'open' position, to allow dirt, sand, grit, welding slag or other debris to be flushed thoroughly from the pipeline.

When the flushing media is clean, the valves can be shut off. Actuated valves in the fail-safe 'closed' position, should be activated to the 'open' position during the flushing procedure.

Figure 1

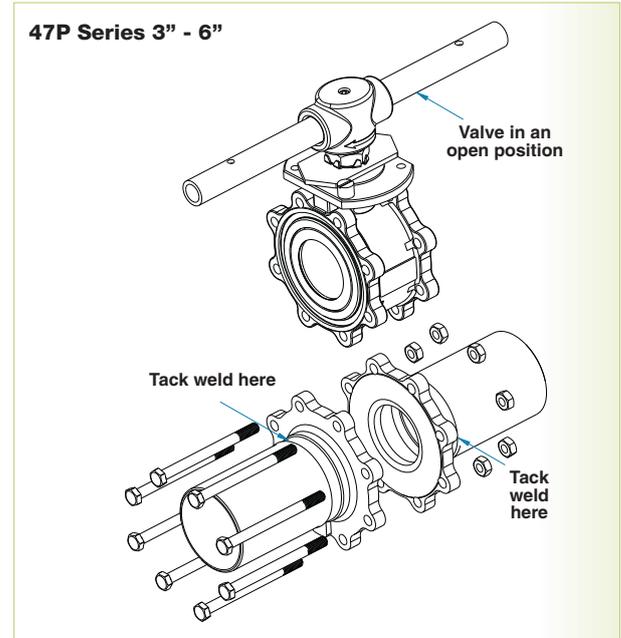
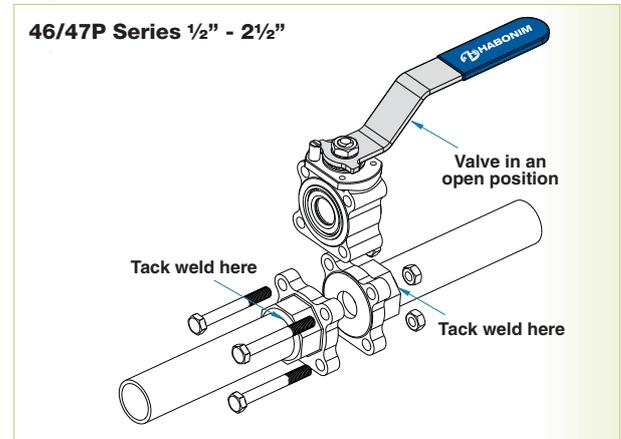
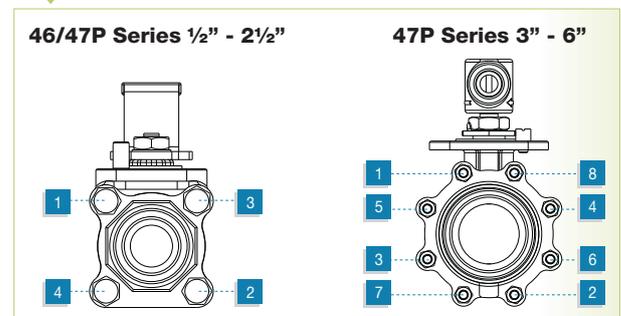
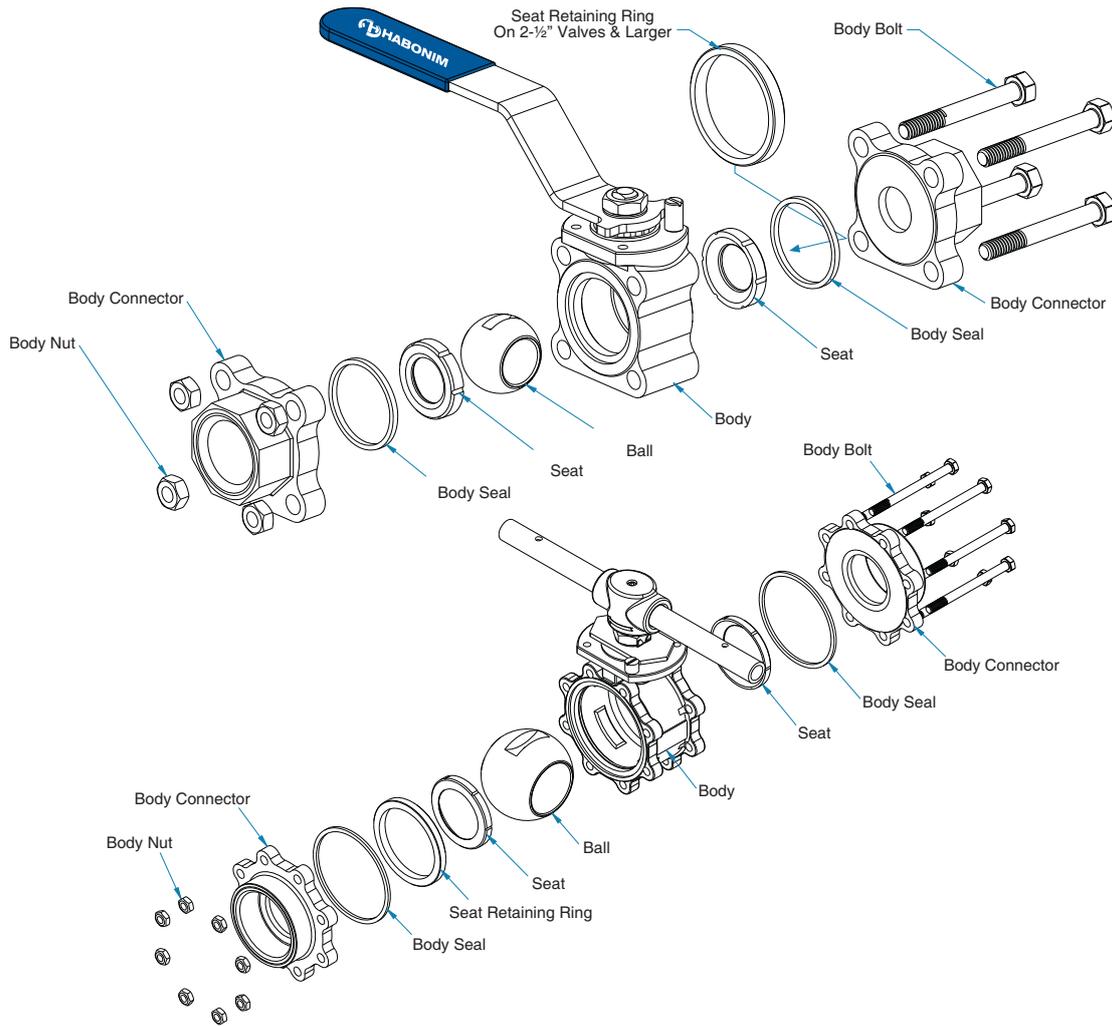


Figure 2



46/47P WELDING INSTRUCTION FOR VALVES WITH WELD-END CONNECTORS TO PIPELINE



Body Bolt Tightening Torque

46 - 47P

| valve size | Bolt Thread | Tightening torque | |
|------------|-------------|-------------------|-------|
| | | NM | In Lb |
| 1/2"-3/4" | M6 | 9 | 80 |
| 1"-1 1/4" | M8 | 18 | 160 |
| 1 1/2"-2" | M10 | 39 | 345 |
| 2 1/2"-3" | M10 | 39 | 345 |
| 4" | M12 | 65 | 575 |
| 4" FB | M16 | 160 | 1420 |
| 6" | M20 | 300 | 2655 |

AF46 - 47P

| valve size | Bolt Thread | Tightening torque | |
|---------------|-------------|-------------------|-------|
| | | NM | In Lb |
| 1/2"-3/4" | M8 | 18 | 160 |
| 1"-1 1/4" | M10 | 39 | 345 |
| 1 1/2"-2 1/2" | M12 | 65 | 575 |
| 3" | 1/2"-13 UNC | 80 | 708 |
| 4" | M16 | 160 | 1420 |
| 4" FB | M20 | 300 | 2655 |

In accordance with our policy to strive for continuous improvement of the product, we reserve the right to alter the dimensions, technical data and information included in this catalogue when required.

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