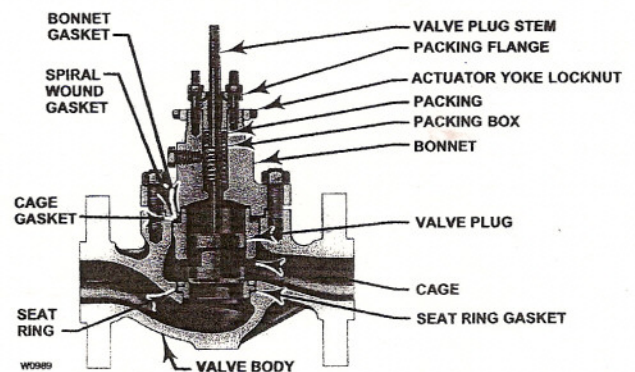
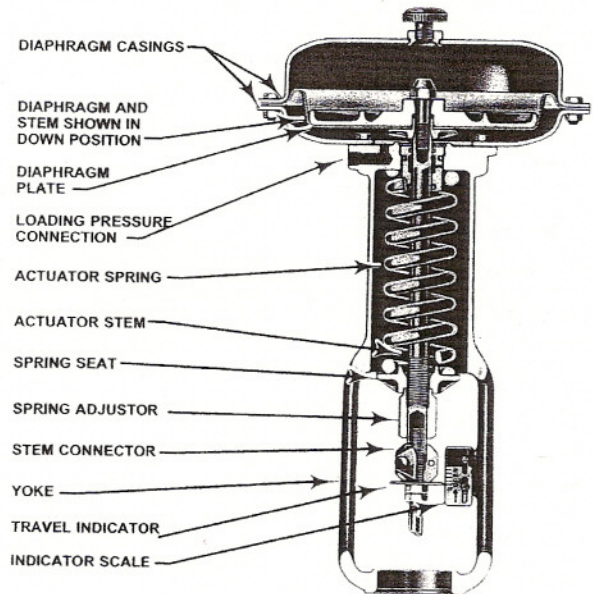


STANDARD REPAIR~CONTROL VALVES

THIS WORKSCOPE APPLIES TO VARIOUS TYPE/MANUFACTURER'S CONTROL VALVES

- Visually inspect control valves. Record all pertinent information such as size, pressure class, manufacturer, serial number, bench set date, etc. Take precautions to ensure that controllers, actuators, positioner, and air regulator orientations are noted for future re-assembly
- Disassemble completely
- Clean all component parts
- Non destructive examination-PT (Penetrant Testing) seating surfaces i.e. disc/seat
- All guide areas i.e. body bores, cages, liners are to be polished for smooth operation
- Verify stem straightness for TIR (True Indicator Reading) runout
- Polish stems to proper RMS finish
- Clean all gasketed surfaces
- Visually inspect the actuator diaphragm for signs of wear, tear or flexibility and replace as necessary. Test for leakage
- Machine, grind and lap plug to the seat ring for 360 degree blue in transfer contact. This is done for both single and double seated valves
- Repack valve using premium packing and gasket materials and/or seals
- Re-assemble completely. Ensure orientations of accessory features such as positioners, controllers, actuators and regulators if applicable. Ensure installation in the "as received" manner
- Cycle the valve from full open to full closed position to assure smooth operation. Operate and bench test as required
- Hydrostatically test the seat/s and shell at 1.5 times the rated pressure
- Paint, tag and ship to customer



NOTE: Minor welding is also covered in the standard repair. Manufacture of new components, heat treating requirements or extensive welding will be considered additional work above and beyond the standard repair work scope. A report noting these conditions will be submitted to the customer for approval prior to proceeding.