

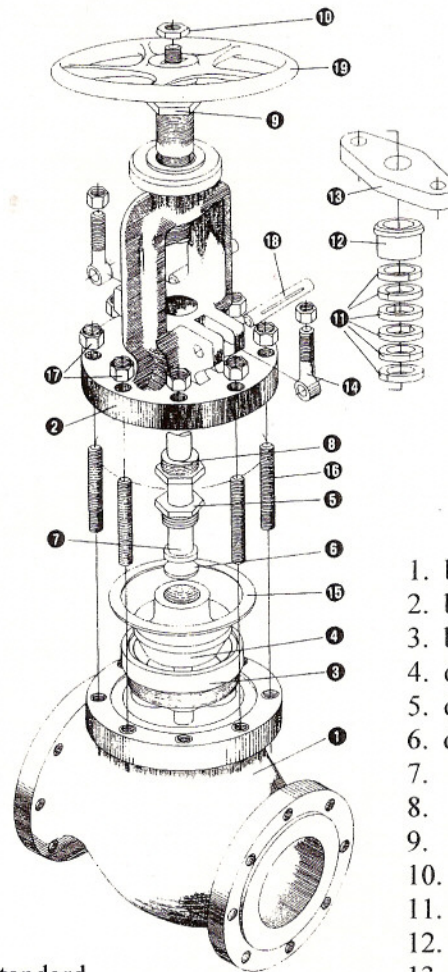
STANDARD REPAIR GLOBE VALVES AND GLOBE NON-RETURN VALVES

THIS WORKSCOPE APPLIES TO BOLTED TYPE BONNET AND PRESSURE SEAL BONNET GLOBE VALVES

- Disassemble completely
- Clean all component parts
- Inspect all component parts for wear and defect
- Non Destructive Examination-PT (Penetrant Testing) all seating surfaces i.e. seat face, disc face, bonnet and stem backseat areas
- Grind/polish disc and seat surface. Seat contact proved by 360 degree blue in. Verify stem/bonnet backseat contact is 360 degrees
- Verify body bore/disc outside diameter clearance
- Verify stem straightness for TIR (true indicator reading) run out
- Polish stem to necessary RMS finish
- Clean all gasket surfaces

PRESSURE SEAL VALVES

- Inspect body pressure seal bore diameter dimensionally and surface finish. Hone to proper surface finish and record dimensions for new pressure seal gaskets. recondition pressure seal angle on valve bonnet
- Re-assemble using premium quality packing and gasket materials
- Hydrostatically test seat/s and shell @ 1.5 times rated pressure.
- Paint, tag and ship to customer



1. body
2. bonnet
3. body seat ring
4. disc
5. disc stem ring
6. disc washer
7. stem
8. bonnet bushing
9. yoke bushing
10. wheel nut
11. packing
12. gland
13. gland flange
14. gland eye bolts
15. bonnet gasket
16. bonnet studs
17. bonnet nuts
18. groove pin
19. hand wheel

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 scope. A report noting these conditions will be submitted to the customer for approval prior to proceeding.