

1.0 ASSEMBLY DEPARTMENT PROCEDURE FOR BALL VALVES

1.1 PURPOSE

1.1.1 To establish an assembly and testing procedure for all BuTech Pressure Systems standard ball valves.

This procedure shall be used for all standard ball valves, unless otherwise stipulated on the register face or in the work instructions for a specific order.

1.2 ASSEMBLY

1.2.1 All ball valve components shall be accumulated in the Assembly Department from either stores or directly from manufacturing.

1.2.2 The Valve Assembler shall, as a minimum, check all components for the following:

- (A) Cleanliness
- (B) Identification
(Ref: applicable assembly drawing)

the Note: All non-conformities are to be reported to Quality Control Department.

1.2.3 The Valve Assembler shall assemble all ball valves in accordance with the latest applicable assembly drawing.

1.2.4 The Valve Assembler shall lubricate all valve components requiring lubrication with "Moly-Lit", as follows:

(A) STEM - Shall be lubricated on the face of the shoulder opposite the ball and the part that comes in contact with the packing.

(B) CLOSURE O-RINGS - Shall be lightly lubricated all over.

(C) CLOSURE GLANDS - Shall be lubricated on all external threads and the face that comes in contact with the retainer o-ring.

(D) PEEK SEALS - Lubricate with Christo-Lube

(E) PACKING GLAND - Lubricate the first three threads.

Note: Other lubricants such as Triolube 16 or Neolube, or as specified, may be used.

1.2.5 Packing gland torque shall be as specified by current engineering specifications.

1.2.6 Valve actuator shall be assembled in accordance with the latest applicable assembly drawing.

1.3 TESTING

1.3.1 SAMPLING

- (1) 100% of all assembled ball valves of a specific lot shall be pressure tested.
- (2) A "lot" is the amount of ball valves with the same characteristics required for a specific order.

1.3.2 SEAT TEST

(1) With the stem in the closed position, the valve shall be pressurized to the hydro-test pressure as specified on the latest applicable assembly drawing.

(A) The valve is to be pressurized through the inlet connection.

Note: If no leaks are observed in 30 seconds, the valve shall be accepted.

(B) Any permanent deformation is cause for rejection.

1.4 VALVE TEST REPORT

(1) A BuTech Pressure Systems Valve Test Report (Form 5) shall only be furnished if required.

(2) When required, the testing shall be witnessed as specified in the working instructions.

Note: Distribution of the Valve Test Report shall be as specified on the Register Face.