

UPDATE

NORTH AMERICAN SAFETY VALVE

Winter, 2008



Allen Tanis
President

“We will do everything in our power to make your life as easy as possible.”

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From the President's Desk

I know you've heard me say this before – lots of times – but I'm going to say it again.

We guarantee our work.

We can do that because we test every valve before it leaves here. So if there is a problem, 99.9% of the time it isn't us. Most of you are probably thinking “We've never had a problem with your valves, so what's the big deal?” Well, you will at some point. It is the nature of the beast.

That's because a safety valve may not look delicate, but it's a sensitive instrument. A big 8 x10 that weighs 700 lbs. has a seating surface that is 1/8" wide and it is 20" all the way around. That valve can reseat itself after 500 pops or it can leak after the first one if a piece of debris passes through the valve and scratches the seating surface.

Recently, we repaired a 50-year-old 6 x 8 for a local plant. The valve was set at 15 psig, and the customer called to tell me it leaked when he put it on the system. I told him the valve was fine when it left here, but we'd check it out. Turns out the tip of a 12" welding rod was stuck between the seat and the disc. It wasn't there when it left our place. No wonder the valve leaked.

I can tell you what happened: The valve was after a reducing valve, and the customer played with the reducing valve to get the pressure up to see if the safety valve would work. It worked once and dislodged a welding rod that had been in the pipe for 50 years.

Other than debris in the system, some common end user errors that cause problems are:

- improper installation
- unsupported outlet piping
- operating pressure that is too close to the valve's set pressure
- bringing the pressure up manually and popping the valve allowing debris across the seals

We will gladly help troubleshoot and advise ways to avoid reoccurrence of the problems. We cannot warranty the end user's errors, but we will do our best to make each complaint call as easy on you as possible.

Thank you for another great year. We look forward to doing business with you in 2008. Together we can work through any bumps in the road. I guarantee it.

Allen Tanis

Safety Valve Installation and Operating Instructions

Pre-Installation Handling

Safety and relief valves are designed to protect equipment from overpressure. The valve should be handled with care, not subject to heavy shock loads, and protected to prevent dirt from getting inside. It should be installed correctly. Failure to do so could result in property damage or serious injury to your personnel.

Installation

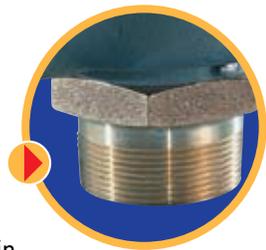
Mount the valve in a vertical position so the valve body is self-draining. If a body drain port is provided, make sure it is open when required by the ASME code. Do not plug bonnet vent openings. The inlet piping should be as short as possible, with no elbows, and equal to or greater than the size of the pressure relief valve inlet connection. This will help to limit the inlet pressure drop to 3% or less when the valve is relieving.

When discharge piping is connected to valve outlet, it needs to be self-draining when a body drain port is not used. The valve should not be connected to any discharge pipe that contains pressure before the valve opens or to any pipe where the pressure build-up is greater than 10% of the set pressure when the valve is open and relieving.

Discharge piping, other than a short tailpipe, must be supported by something other than the valve. Due to thermal expansion, for steam service a drip pan elbow or flexible connection between the valve

and pipe should be used to prevent excessive pipe stress from being imposed on the valve body.

For threaded valves, apply a small amount of pipe thread sealing compound to external threads only. Do not put any sealing compound on the first thread or any internal threads. To do so may cause the sealing compound to enter the valve, resulting in seat leakage.



Use wrench flats provided to tighten the valve to the connecting pipe. Do not use the valve body or bonnet and do not over-tighten. To do so may cause valve leakage.



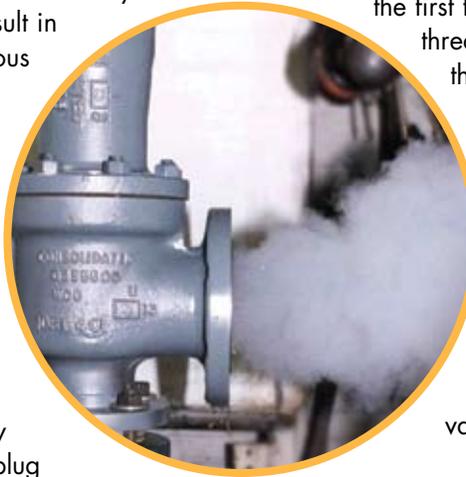
For flanged valves, use new gaskets and tighten the mounting studs evenly.

Operation

Maintain a system operating pressure of at least 5 psig or 10% below the set pressure of the valve, whichever is greater. Operating too close to the valve set pressure will cause seat leakage and shorten the valve maintenance schedule.



Do not use the safety valve as a control valve to regulate system operating pressure. Excessive operation will cause seat leakage and will require more frequent valve maintenance.



ASME Section I and VIII valves equipped with lift levers are designed to be relieved manually only when the system pressure is 75% of the set pressure or greater. ASME Section IV valves may be operated at any system pressure. When hand operating the valve, hold it open long enough to purge any foreign matter from the seat area. If a cable or wire is attached to the lift lever for remote actuation, make sure the direction of pull is the same as it would be if the lever were pulled directly by hand.



Maintenance

Maintenance should be performed on a regular basis. An initial inspection interval of 12 months is recommended. The inspection interval may be decreased or increased depending on the service conditions and the condition of the valve.



Warranties You Can Count On

Two years on remanufactured valves:

We guarantee the workmanship and parts of our remanufactured safety valves for two years.

We also provide an unconditional guarantee on our remanufactured valves – any customer not satisfied with the valves can return them within five days of receipt for a full refund.

One year on new valves:

Our warranty on new safety valves for parts and workmanship is one year.

The real key to our warranties, however, is how we back them up. It is rare that either workmanship or parts come into play on a customer's complaint. A customer returned a new Kunkle 6252 series with incorrectly tapped outlet threads. It appeared the threads were stripped towards the back of the valve. We issued a full credit for the valve and freight.

A more common occurrence involves leakage. We sometimes hear, "My valve is leaking and it has been less than a year since we purchased it. Send me another one. My customer can't remove the old valve until he has the replacement."

Truth is, leakage can happen after one pop or 500, and the problem can often be traced to debris. A single piece of debris passing through the valve, scratching or cutting the seating surface, can cause leakage.

Damage caused by your customer's debris is not covered by our warranty. If your customer cannot wait for their valve to be repaired, sell him a replacement valve. He can keep the repaired valve as a backup.

Field Service Unit

Delivering on-site valve testing and repair

Our self-contained repair shop and mobile testing stand unit offers on-site repair and resetting of safety valves during scheduled maintenance shutdowns. The unit has all the equipment necessary to perform the highest-caliber repairs. Completed safety valve work carries the VR stamp.

The Field Service Unit also includes a state-of-the-art computerized lift-assist testing unit that allows for testing set pressures and resetting high-pressure safety valves in the field. The unit tests valves that are welded in-line or stationary without removing the valves.

There's no need to pressure down or increase pressure to test for set pressure. The testing unit also allows for resetting valves after repairs have been made while the valves are on-line.

If removing valves from service and shipping them aren't practical or possible at your customer's plant, the on-site Field Service Unit is the perfect answer.

Contact one of our application engineers for more details.



North American Safety Valve Industries, Inc.

For on-site testing repair and resetting of:

- Safety Valves

Plus, on-site repair of:

- Regulator valves
- Control valves
- Pressure-sealed gate valves
- Globe valves

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