

ASSEMBLY PROCEDURES - 80mm Pressure Relief Valve

Tooling required

Ring spanner 19mm

Pliers

Thread tape

Bench vice with aluminium jaws

Assembly Jigs required

80mm PRE/VAC assembly jig

Testing Jigs required

80mm PRE/VAC TEST jig (seat tightness 27kPa)

ASSEMBLY PROCEDURE

Fitment and assembly of sealing disc and sealing disc rod

- 1 Thread the thread type around the thread of the sealing disc rod (#4) with lesser thread
- 2 Clamp and secure the sealing disc rod (#4) in the bench vice with the thread with thread type facing upwards
- 3 Screw and secure the sealing disc (#2) onto the sealing disc shaft (#4) followed by (#11) lock nut
use ring spanner 19mm to tighten the lock nut. Remove from bench vice.
- 4 Fit BS337 o-ring (#3) onto sealing disc groove (#2)

Fitment and assembly of main body, sealing disc assembly, spring top and bottom retainer and spring

- 5 Insert and secure the sealing disc assembly (#2/4) into the 80mm PRE/VAC assembly jig
- 6 Fit the top retainer (#8) over the sealing disc rod (#4) followed by the spring (#9) and bottom retainer (#10)
- 7 Secure the retainers (#8/10) and spring (#9) into place using 2 x nut (#13) and lock in place using
ring spanner 19mm
- 8 Fit split pin (#12) into the split pin hole located in sealing disc rod (#4) and secure in place with pliers

TESTING PROCEDURE - 80mm Pressure Relief Valve

- 1 Fit and secure the "80PRE/VAC TEST JIG" jig to the "TEST FL 150" jig with washers and nuts.
- 2 Fit and secure the 80mm pressure relief valve onto the "80PRE/VAC TEST JIG" with washers and nuts
ensure nuts are fully and securely fastened to the jig
- 3 Test the Seat tightness at 27kPa for 5 minutes
- 4 Check for leaks
 - a - internal sealing area - sealing disc/main body sealing area

As per EN12266-1:2012 testing regulations Table A.5

criteria:

"A"

No visually detectable leaks for the duration of the test

"B"

DN32 x 0.01 cubic millimetres per second

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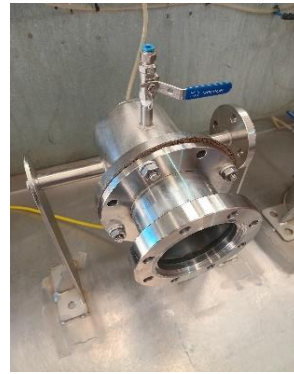


1-4 sealing disc and sealing disc rod





5 - 8 main body, sealing disc assembly, spring top and bottom retainer and spring



Test 1: Seat Tightness @ 27kPa