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disclosure cat.:	II	proofread:	Cal	published date:	tbd	effect. date:	02/12
author:	AW	released by:	KUW	replaces:	initial	status:	published
resp. depart.:	PP	date of release:	01/31/12	revision No.:	0		
doc. type:	LGS	change rep. No.:		retention period:	10y.		

## 1 General information for separating the Main Valve from the Pilot Valve

### 2 Purpose

The documentation describes the marriage of the main valve and the pilot valve. The description contains every single working step, supplies, tools and appliances.

### 3 Competences

The generation, maintenance and distribution of the documentation takes place in the organisation department. The defaults will be generated by the technical department in consultation with the final assembly department and production planning department.

### 4 Scope

This document must be applied to the dismantling of a Pilot Operated Safety Valve in agencies and subsidiaries of LESER GmbH & Co. KG customers and independent service center.

### 5 Disclaimer

LESER puts in a great deal of effort into making up-to-date and correct documentation available. Nevertheless, LESER GmbH & Co. KG gives no guarantee that the recommended actions presented here are entirely correct and error free.

This document is to be applied exclusively to the specified type. LESER GmbH & Co. KG declines any liability or responsibility for the correctness and completeness of the content.

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### 6 Qualified fitting personnel

LESER safety valves may only be dismantled by trained or qualified fitters. The qualifications must be obtained through the appropriate training measures.

### 7 Remarks



Gloves must be worn during the entire dismantling process.

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## 8 Basic safety guidelines

### Dangerous media

Poisoning, caustic burns, burns, injuries

- Use suitable protective devices
- Use suitable collecting tanks.
- Wear suitable protective equipment.

### Foreign bodies in the safety valve

Danger from failure of safety valve or leaks

- Flush the system before installation of a safety valve.
- Check the safety valve for foreign objects.
- Remove foreign objects

### Bug screen is damaged or missing (B or option)

Dirt, objects or insects get into the safety valve. Danger from malfunction of the safety valve.

- Install the bug screen correctly.
- Check the bug screen regularly.

### Ambient temperature is too high

Material expansion. Danger from malfunction of the safety valve.

### Ambient temperature is too low

Icing, freezing vapours, reduced flow rate due to congealing media. Danger from functional disruption of the safety valve.

### Abrasive or corrosive media

Moving parts jam or become stuck. Danger from functional disruption of the safety valve.

- Service the safety valve after each time it opens.

### Media with high proportion of particles

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**(only B)**

Deposits and clogging. Danger from malfunction of the safety valve.

- Use a filter with the correct mesh size.
- Use additional filters to increase the filter capacity.

**Residual media in the safety valve**

Poisoning, caustic burns, burns, injuries

- Wear suitable protective equipment.
- Remove residual media

**WARNING**

**Leaky safety valve**

Danger from leaking media due to damaged gaskets and sealing surfaces.

- Protect the safety valve against vibrations and blows especially during transport and installation.
- Check safety valve regularly for leaks.

**Open bonnet or spindle guides**

Danger from leaking media

- Make sure that no danger can arise from leaking media.
- Keep a safe distance.
- Wear suitable protective equipment.

**CAUTION**

**Hot medium**

Burns or scalding.

- Wear suitable protective equipment.

**Hot surfaces**

Burns.

- Wear suitable protective equipment.

**Aggressive medium**

Caustic burns.

- Wear suitable protective equipment.

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**Open bonnet or spindle guides**

Pinching danger from moving parts.

- Install suitable safeguards.

**Sharp edges and burrs**

Danger of injury.

- Wear safety gloves.
- Handle the safety valve carefully

**High noise emission**

Hearing damage.

Wear ear protection.

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## 9 Disassembly instructions

### 9.1 Marriage of the pilot valve and the main valve



#### 1. Steps – Descriptions

- 1** Screw pilot valve and manifold block with 4 screws [22] on top plate [9] of main valve

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#### 2. Supplies

Lubricate components acc. to LID

#### 3. Tools

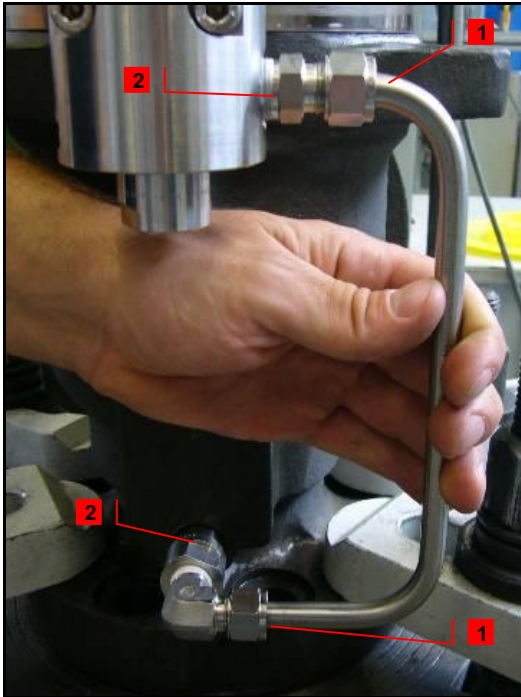
Allen key acc. to LID  
Torque wrench (Tightening torques acc. to LID)

#### 4. Appliance

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Test bench

## 9.2 Assembly of the tube



### 1. Steps – Descriptions

- 1** Stick tube into fitting of pilot valve and main valve
- 2** Screw on compression fittings. Use gap gage and while tightening compression fittings counter fittings.

**Consider assembly instructions of manufacturer for compression fittings.**

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### 2. Supplies

None

### 3. Tools

Open-end wrench acc. to LID  
Gap gage for compression fittings

### 4. Appliance

Test bench

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## 9.3 Sealing the valve

### 1. Steps – Descriptions



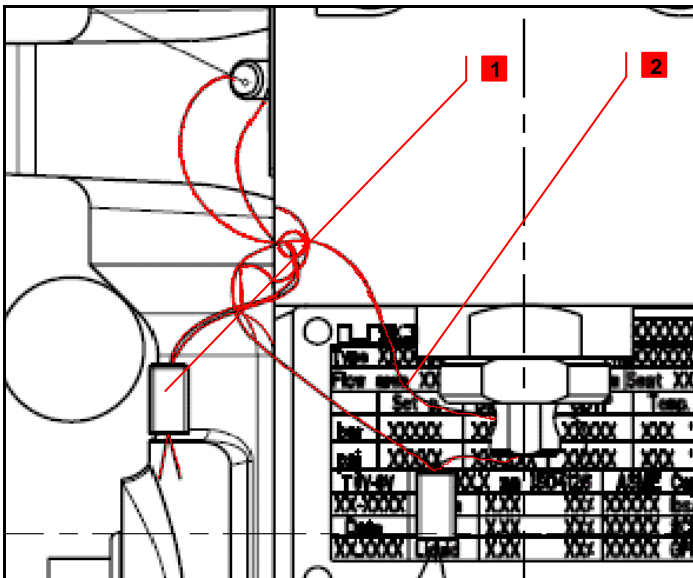
#### Sealing after assembly and passed tests!

Seal valve, if constructive possibility exists. Otherwise next workstation has to weld on sealing noses (cap; bonnet; body)

**1** Connect sealing hole/ nose of pilot valve and main valve with wire tight and in clockwise

**2** Close wire ends with seal

**Note:** In case of required certifications (TÜV etc.) sealing ensued after certification



### 2. Supplies

None

### 3. Tools

Sealing pliers

### 4. Appliance

None

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