

Engineering Specification PS-110

Torque Specification For Non-back Seating O-Ring Style Brass & Steel Shutoff Valves

PURPOSE:

Provide a specification that addresses stem seating torque requirements for brass and steel shutoff valves.

SCOPE:

This specification applies to brass and steel shutoff valves requiring specific stem seating torque rates applied to o-ring style non-back seating valves.

PROCESS:

Prior to applying recommended torque to stem, lightly oil stem button and/or stem seat to prevent galling/fretting of seat sealing surface.

Prior to assembling stem into valve, lightly oil o-ring to assist in providing a refrigerant tight seal. *

TORQUE RECOMMENDATIONS:


Material	Body Size & Shape	Body Style	Front Seating Torque
Brass or Steel	11/16 Sq., 3/4 Hex or 3/4 Sq.	O-Ring	6 to 8 Ft. - Lbs.
Brass	7/8 Inch Sq.	O-Ring	18 to 20 Ft. - Lbs.
Brass	1 Inch Sq.	O-Ring	18 to 20 Ft. - Lbs.
Brass	1 1/8 Inch Sq.	O-Ring	22 to 25 Ft. - Lbs.

CAUTION:

1. Construction of brass and steel valves requires seating and sealing be brought together at slow speeds or rpm's. Torque drivers of constant drive design, must not exceed 360 rpm, and are to be used only on 11/16, 3/4, and 7/8 inch size valves.

Recommended Power Torque Tool:	Chicago Pneumatic Model 3017 TADSUM or equivalent
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2.*Leak test per Electronic Leak Test, Specification PS-I05

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