

Engineering Specification PS-125

Torque For Front and Back Seating Brass Compression Packed Valves

Purpose:

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

Scope:

This specification extends to brass packed valves with stem torque requirements for front and back seats requiring refrigerant tight seals.*

Process:

Prior to applying recommended torque to stem, apply refrigerant oil to either the stem button or stem seat, to prevent galling or fretting of seat sealing surface.

After applying torque and actuating valve stem, it is absolutely necessary to re-torque the packing gland nut. Refer to process specification PS-104 for gland nut torque requirements.

Torque Requirements:


Body Size & Shape	Body Style	Recommended Torque for Front & Back Seats
3/4" Hex or Sq.	Packed	9 to 12 Ft. - Lbs.
7/8" Sq.	packed	15 to 18 Ft. - Lbs.
1" Sq.	Packed	21 to 24 Ft. - Lbs.
1 1/8" Sq.	Packed	25 to 28 Ft. - lbs.
1 3/8" Sq.	Packed	35 to 40 Ft. – lbs.

Caution:

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

Recommended Power Torque Tool:	Chicago Pneumatic Model 3017 TADSUM or equivalent
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- *Leak Test per Electronic Leak Test, Specification PS-105

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