KEYSTONE K-LOK® SERIES 36 AND 37 HIGH PERFORMANCE BUTTERFLY VALVE

Seat replacement instructions

PTFE, RTFE AND UHMWP SEATS

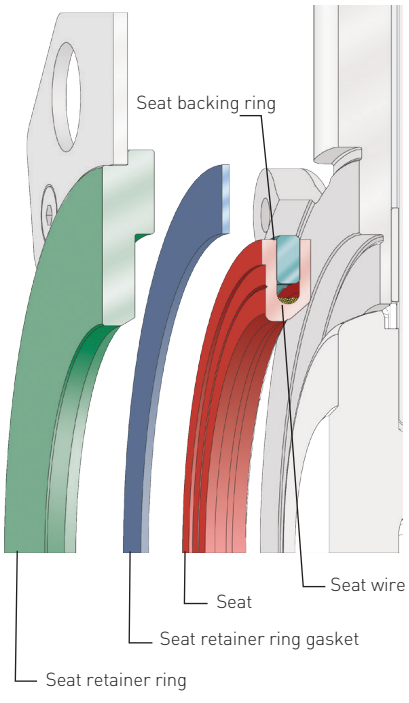
1. Remove the socket head screws which secure the flange bolt guides and/or retaining clips on wafer style valves, or the seat retaining ring on lug style valves.
2. Remove the flange bolt guides or retaining clips.
3. Remove the seat-retaining ring. Do not gouge or leave a raised edge on the seat-retaining ring.
4. Remove the seat and external gasket. Seat consists of the seat, wire wrap, and seat backing ring.
5. Check and clean the disc edge and seat pocket. If the disc edge is damaged, contact the factory for a disc replacement assembly. Make certain that all gasket and sealing surfaces are clean and undamaged. Remove any gasket material that may have adhered to the mating body surfaces.
6. Close the disc. Be sure to position the disc against the disc position stop located in the valve body.
7. Rotate the seat assembly until the seat backing ring split aligns with the body shaft journals.
8. Place the seat assembly into the valve body seat pocket. The seat assembly is correctly placed when the 'V' groove on the side of the seat is facing toward the assembler.
9. Install the seat-retaining ring gasket and seat retainer ring, using the flange bolt guide or retaining clips for wafer style valves. For lug style valves align the holes in the seat retainer ring with the holes in the gasket and the body.
10. Install and tighten the socket head screws.
11. When pressing the seat retainer into the seat and body, use C-Clamps. The number of C-Clamps used should equal half the number of flange bolts of the valve. For instance, if the valve has 12 flange bolts, 6 C-Clamps should be used. To press the seat retainer ring with the C-Clamps, place the C-Clamps around the valve assembly to allow an even load to be applied all around the seat retainer ring. Tighten until the seat retainer gasket is compressed. After the gasket is compressed by the C-Clamps, complete the tightening of the socket head screws.

CAUTION

The standard seat retainer screws only provide enough force to hold the seat retainer ring for shipment and installation. If cycling or testing of the valve is required prior to installation, the seat retainer must be pressed into the seat to prevent damage to the seat or leakage past the seat.

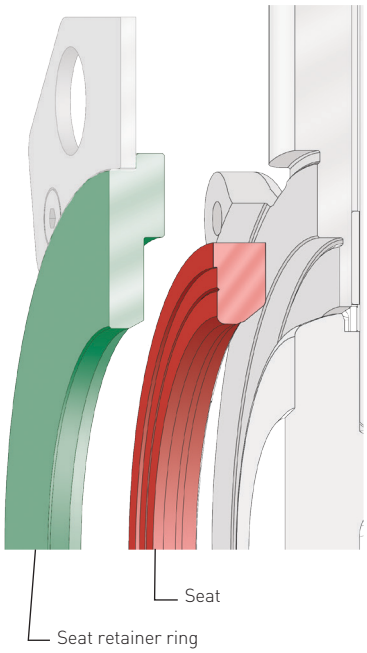
CAUTION

Always use the cardboard or brass shims to protect the valve body, disc, flange and sealing surfaces from damage. Failure to do so may result in serious damage to the valve.



NBR, EPDM AND FLUOROELASTOMER (FKM) SEATS

1. Remove the socket head screws which secure the flange bolt guides and/or retaining clips on wafer style valves, or the seat retaining ring on lug style valves.
2. Remove the flange bolt guides or retaining clips.
3. Remove the seat-retaining ring. Do not gouge or leave a raised edge on the seat-retaining ring.
4. Remove the seat. Seat assembly consists of a rubber ring. Seat retaining ring gaskets are not used with the elastomer seats.
5. Check and clean the disc edge and seat pocket. If disc edge is damaged, contact the factory for a disc replacement assembly. Make certain that all gasket and sealing surfaces are clean and undamaged.
6. Close the disc. Be sure to position disc against disc position stop located inside the valve body.
7. Install the seat with the smallest inside diameter down. If the seat is incorrectly installed, it will ride higher on the disc than if installed correctly. Do not use any gaskets between the valve body and seat-retaining ring when installing an elastomer seat.
8. Install the seat retaining ring using the flange bolt guide or retaining clips for wafer style valves. For lug style valves align the holes in the seat retainer ring with the holes in the body.
9. Install and tighten the socket head screws.
10. When pressing the seat retainer into the seat and body, use C-Clamps. The number of C-Clamps used should equal half the number of flange bolts of the valve. For instance, if the valve has 12 flange bolts, 6 C-Clamps should be used. To press the seat retainer ring with the C-Clamps, place the C-Clamps around the valve assembly to allow an even load to be applied all around the seat retainer ring. Tighten until the seat is compressed. After the seat is compressed by the C-Clamps, complete the tightening of the socket head screws.



CAUTION

The standard seat retainer screws only provide enough force to hold the seat retainer ring for shipment and installation. If cycling or testing of the valve is required prior to installation, the seat retainer must be pressed into the seat to prevent damage to the seat or leakage past the seat.