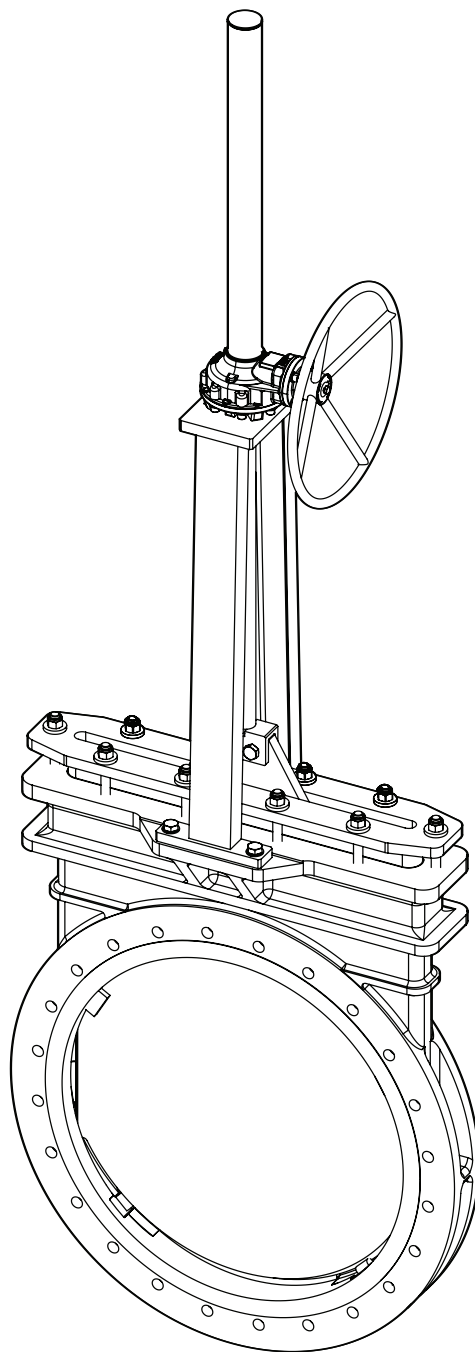


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**SERIES 952/957**

# UNIDIRECTIONAL KNIFE GATE VALVES

Installation, Operation, and Maintenance Manual



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**Bray**®

**TABLE OF CONTENTS**

<b>0.0</b>	Definition of Terms	3
<b>1.0</b>	Introduction	4
<b>2.0</b>	Parts Identification	5
<b>3.0</b>	Valve Identification	6
<b>4.0</b>	Hazard-Free Use	7
<b>5.0</b>	Qualified Personnel	8
<b>6.0</b>	Handling Requirements	9
<b>7.0</b>	Lifting	10
<b>8.0</b>	Storage	12
<b>9.0</b>	Installation & Commissioning	14
<b>10.0</b>	Actuation and Travel Stops	18
<b>11.0</b>	Standard Maintenance	19
<b>12.0</b>	Packing Replacement - Manual Operated Valves	21
<b>13.0</b>	Packing Replacement - Cylinder Operated Valves	22
<b>14.0</b>	Seat Replacement	24
<b>15.0</b>	Troubleshooting	25
<b>16.0</b>	Return Merchandise Authorization	26

**READ AND FOLLOW THESE INSTRUCTIONS CAREFULLY.  
SAVE THIS MANUAL FOR FUTURE USE.**

## 0.0 DEFINITION OF TERMS

All information within this manual is relevant to the safe operation and proper care of your Bray valve. Please understand the following examples of information used throughout this manual.

## 0.0 IDENTIFIES CHAPTER HEADING

**0.00** Identifies and explains sequential procedure to be performed.

**NOTE:** Provides important information related to a procedure.

**SAFETY STATEMENTS:** To prevent unwanted consequences.



Indicates a potentially hazardous situation which, if not avoided, could result in death or serious injury.



Indicates a potentially hazardous situation which, if not avoided, may result in minor or moderate injury.

## NOTICE

Used without the safety alert symbol, indicates a potential situation which, if not avoided, may result in an undesirable result or state, including property damage.

## 1.0 INTRODUCTION

- 1.1 The Bray Knife Gate Series 952/957's one-piece, cast or fabricated body design offers rugged performance in applications ranging from general purpose to severe media handling. Available with integral metal or replaceable soft seat, the Bray Knife Gate Series 952/957 gate valve is easily automated for on/off applications.
- 1.2 Additional **product information** (such as application data, engineering specifications, actuator selection, etc.) is available from your local Bray distributor or sales representative, or online at **BRAY.COM**
- 1.3 For complete details on the latest product **certifications**, visit **BRAY.COM/Certifications**.

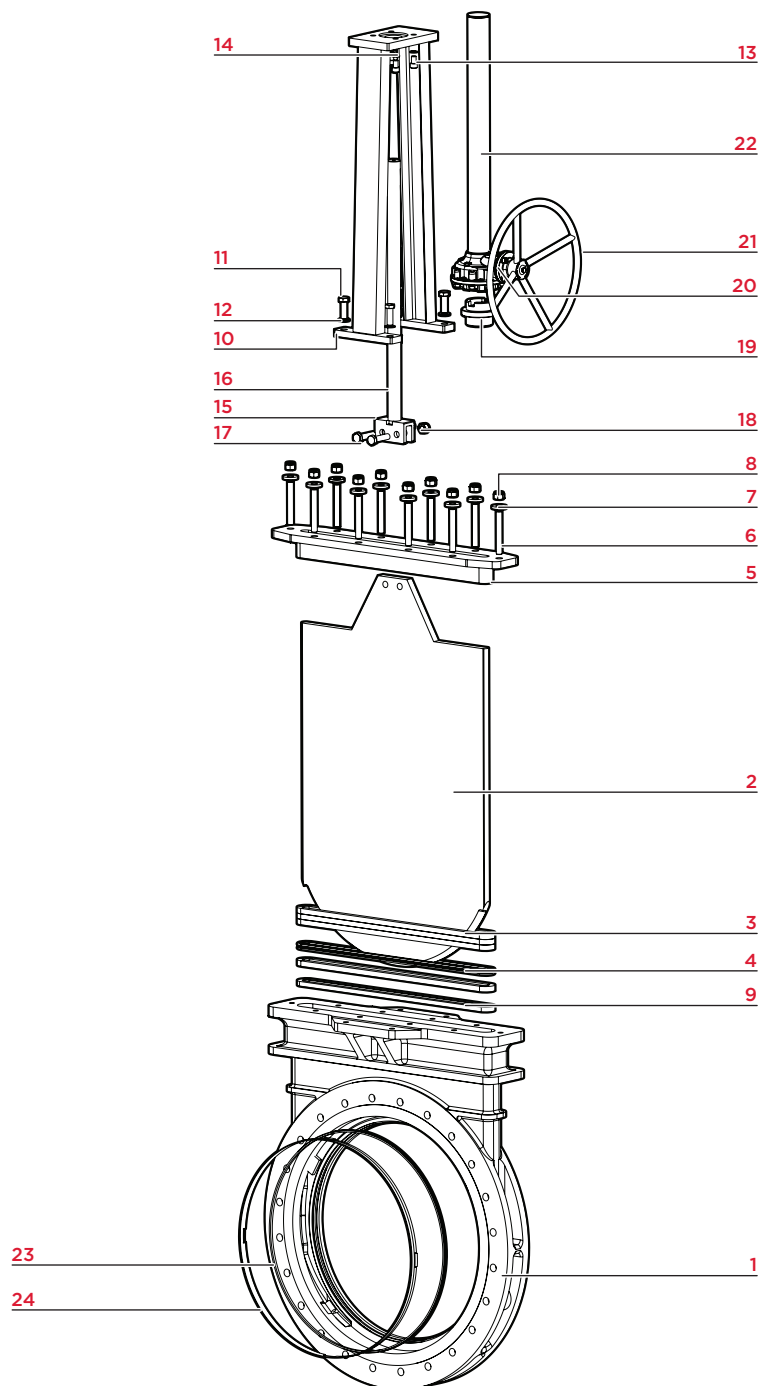
## 2.0 PARTS IDENTIFICATION

**Figure 1: Parts**

Item	Description
1	Body
2	Gate
3	Packing Set
4	Quad Seal (957)
5	Gland
6	Gland Stud
7	Gland Washer
8	Gland Nut
9	Anti-Extrusion Ring (957)
10	Fabricated Yoke
11	Mounting Bolt (Bottom)
12	Spring Washer (Bottom)
13	Mounting Bolt (Top)
14	Spring Washer (Top)
15	Clevis
16	Stem
17	Clevis Bolt
18	Clevis Nut
19	Yoke Sleeve
20	Gear Unit
21	Hand Wheel
22	Stem Cover
23	D-Seat*
24	Seat Retainer*

**NOTE**

\* Optional



### 3.0 VALVE IDENTIFICATION

**3.1** All valves, actuators, or control products are provided with an identification tag that is unique to each device. The following table is a representation of information that may be included.

Data	Label	Description
Serial Number	SERIAL NUMBER	Unique serial number of valve.
Valve Size	SIZE	Valve size e.g. 28 in/700 mm.
Model	MODEL	Series number of the Valve
Flange Drill	FLG. DRILL	Flange Drill e.g. ANSI B16.47 Series A
Temperature Limits	MAX TEMP	Maximum temperature in °F/°C
Maximum Permissible Pressure	CWP	Maximum permissible pressure in psi/bar(g)
Body Material	BODY	Material grade of body e.g. CF8 (304) etc.
Gate Material	GATE	Material grade of gate e.g. 304 Stainless Steel.
Packing Material	PACKING	Material of packing e.g. PTFE w/EPDM Quad Seal.
Seat Material	SEAT	Material of seat e.g. Buna-N.

## 4.0 HAZARD-FREE USE

### NOTICE

Failure to follow these procedures could affect product warranty.

- 4.1** This device left the factory in proper condition to be safely installed and operated in a hazard-free manner. The notes and warnings in this document must be observed by the user if this safe condition is to be maintained and hazard-free operation of the device assured.
- 4.2** Take all necessary precautions to prevent damage to the valve due to rough handling, impact, or improper storage. Do not use abrasive compounds to clean the valve, or scrape metal surfaces with any objects.
- 4.3** The control systems in which the valve is installed must have proper safeguards — to prevent injury to personnel, or damage to equipment — should failure of system components occur.
- 4.4** The upper limits of permitted pressure and temperature (depending on the housing and liner materials) must be observed. These limits are shown on the valve identification tag.
- 4.5** The valve must not be operated until the following documents have been observed:
  - > Declaration on EU Directives
  - > IOM Manual (supplied with the product).

### 5.0 QUALIFIED PERSONNEL

#### NOTICE

Failure to follow these procedures could affect product warranty.

**5.1** A **qualified person** (in terms of this document) is one who is familiar with the installation, commissioning, and operation of the device, and who has appropriate qualifications, such as:

- > Is trained in the operation and maintenance of electrical equipment and systems in accordance with established safety practices.
- > Is trained or authorized to energize, de-energize, ground, tag, and lock electrical circuits and equipment in accordance with established safety practices.
- > Is trained in the proper use and care of personal protective equipment (PPE) in accordance with established safety practices.
- > Is trained in the commissioning, operation, and maintenance of equipment in hazardous locations — in cases where the device is installed in a potentially explosive (hazardous) location.



## 6.0 HANDLING REQUIREMENTS

### 6.1 Packed Valves

Crates: Lifting and handling of the packed valves in crates will be carried out by a fork lift truck, by means of the appropriate fork hitches.

Cases: The lifting of packed valves in cases will be carried out in the lifting points and in the center of gravity position which has been marked. The transportation of all packed material must be carried out safely and following the local safety regulations.

### 6.2 Unpacked Valves

Lifting and handling of valves should be carried out by using appropriate means and observing the carrying limits. Handling must be carried out on pallets, protecting all machined surfaces to avoid any damage.

With large bore valves, rigging the load must be carried out by using the appropriate tools to prevent the valve from falling or moving during the lifting and handling.



For handling and/or lifting, the lifting equipment (fasteners, hooks, etc.) must be sized and selected while taking into account the product weight indicated in our packing list and/or delivery note. Lifting and handling must be performed only by qualified personnel.

Fasteners must be protected by plastic covers in sharp corner areas.

Caution must be taken during handling to avoid this equipment passing over workers, or over any other place where a possible fall could cause injury or damage. In all cases, local safety regulations must be respected.

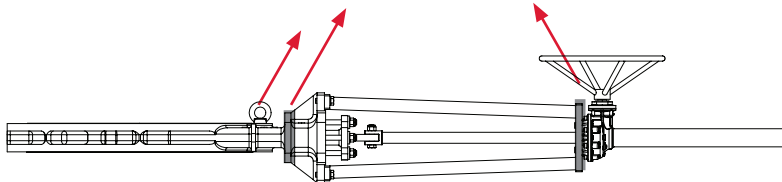
## 7.0 LIFTING THE VALVE



### WARNING

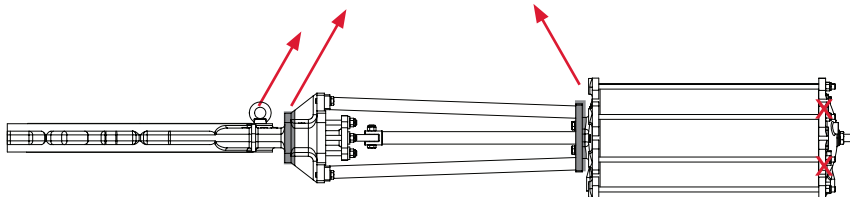
A potential hazard exists with handling valves. Failure to handle valves properly may cause a valve to shift, slip or fall causing serious injury or death and/or equipment damage.

- 7.1** The points below are for reference purposes only, use safe and proper lifting and support techniques. DO NOT lift valves with any adjoining pipe or other equipment attached. Lift with properly rated lifting equipment. Follow jurisdictional safety requirements.
- 7.2** Suggested lifting points are as shown below to lift valve assemblies that are in a horizontal orientation. Eye bolts in flange through holes can be used to lift the valve body.
- 7.3 KNIFE GATE VALVE WITH BEVEL GEAR ACTUATOR:**  
For valves with bevel gear actuators, a sling or chain can be wrapped around the bevel gear actuator body, between the mounting plate and the input shaft housing. This would be in conjunction with lifting from the valve body as well. See **Figure 2**.



**Figure 2:** Knife Gate Valve with Bevel Gear Actuator, Horizontal Lifting

- 7.4 KNIFE GATE VALVE WITH PNEUMATIC CYLINDER ACTUATOR:**  
For valves with pneumatic cylinder actuators, a sling can be wrapped around the cylinder, near the cylinder head (piston rod end). This would be in conjunction with lifting from the valve body. See **Figure 3**.
- 7.5** Utilize caution to not bump, dent or damage the cylinder tube.
- 7.6** DO NOT utilize the cylinder tie-rod ends to lift.



**Figure 3:** Knife Gate Valve with Pneumatic Cylinder Actuator, Horizontal Lifting

(continued)

## 7.7 KNIFE GATE VALVE WITH BEVEL GEAR ACTUATOR:

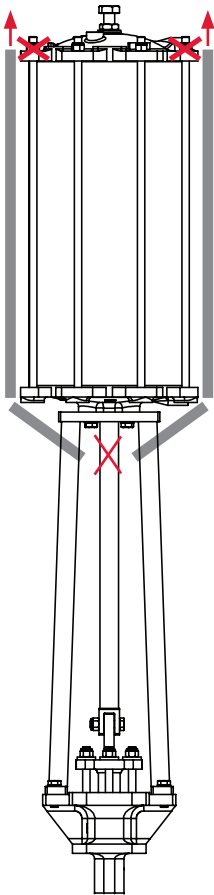
Suggested lifting options are as shown below to lift valve assemblies that are in a vertical orientation. For valves with bevel gear actuators, wrap slings or chains around the top of each leg.

**NOTE:** Use caution not to put any side load on the bevel gear input shaft or on the valves threaded stem. See **Figure 4**.

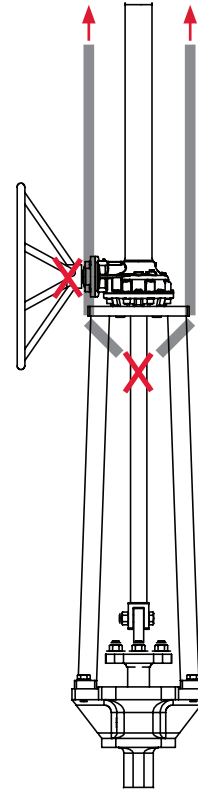
**7.8** For valves with pneumatic cylinder actuators, wrap slings around the top of each leg. Use caution to not bump, dent or damage the cylinder tube and avoid any side load on the cylinder piston rod.

**NOTE:** DO NOT utilize the cylinder tie-rod ends to lift. See **Figure 5**.

**Figure 5:** Knife Gate Valve with Pneumatic Cylinder Actuator, Vertical Lifting



**Figure 4:** Knife Gate Valve w/Bevel Gear Actuator, Vertical Lifting



## 8.0 STORAGE

### NOTICE

The packaging is designed to protect the valve only during shipping. If you are not installing the valve immediately after delivery, then you must store it according to these requirements.

Failure to follow these procedures could affect product warranty.

- 8.1** **Short-term storage** is defined as storage of valves to allow for project construction and will be installed within a relatively short amount of time (typically one to three months). During short-term storage, the following is required:
- 8.2** The preferred storage location is a clean, dry, protected warehouse. Do not expose the valve to temperature extremes.
- 8.3** End protectors shall remain on the valve ends to prevent the entrance of dirt, debris, or insects/wildlife.
- 8.4** Remain in the original shipping container with the original packaging materials. This packaging method will not protect valves that will be stored outside, uncovered, and unprotected.
- 8.5** Storage of valves in an open, uncovered area is permissible, but requires provisions for inclement weather. The product must be elevated from the ground on a pallet, a shelf, or other suitable surface, and must be covered with a secure, waterproof tarp.
- 8.6** **Do not** stack the valves on top of each other.
- 8.7** Manually actuated valves may be stored in the vertical or horizontal position. For air or hydraulic actuated valves, the preferred orientation is with the valve and cylinder in the vertical position. Access ports should be secured to prevent unauthorized entry and prevent contamination.

(continued)

**8.8** **Long-term storage** is defined as storage of valves longer than three months. During long-term storage, the following is required:

**8.9** The storage location shall be a clean, dry, protected warehouse. Do not expose the valve to temperature extremes.

**8.10** End protectors shall remain on the valve ends to prevent the entrance of dirt, debris, or insects/wildlife.

**8.11** Product shall remain in the original shipping container with the original packaging materials.

**8.12** **Do not** stack the valves on top of each other.

**8.13** Manually actuated valves may be stored in the vertical or horizontal position. For air or hydraulic actuated valves, the preferred orientation is with the valve and cylinder in the vertical position. Access ports should be secured to prevent unauthorized entry and prevent contamination.

Valves and equipment containing elastomers, including O-rings, must be stored in a climate-controlled warehouse according to SAE-ARP5316D requiring:

- > The ambient relative humidity to be less than 75%.
- > No exposure from direct ultraviolet or sunlight.
- > Protection from ozone generating equipment or combustible gases and vapors.
- > Storage at temperatures below 100°F (38°C), away from direct sources of heat.
- > No exposure to ionizing radiation.

Storage inspection — visual inspection shall be performed on a semi-annual basis and results recorded. Inspection, as a minimum, shall include reviewing the following:

- > Packaging.
- > Flange covers.
- > Dryness.
- > Cleanliness.

**8.14** Actuators to be stored with all cable/pneumatic entries plugged to prevent entry of foreign material.

**8.15** Leave protective caps and covers on the product.

## 9.0 INSTALLATION AND COMMISSIONING

### WARNING

Verify line is depressurized before installing, removing, or repairing a valve or operator.

Do not pressurize the line without an operator on the valve.

The device generates a large mechanical force during normal operation.

Observe all applicable safety regulations for valves installed in potentially explosive (hazardous) locations.

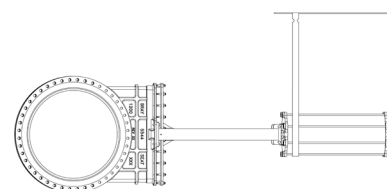
### NOTICE

Flanged valves must be installed on or between flanges compliant with EN1092-1 with sealing faces of type A or B that are machined plane-parallel and must be in alignment. The use of other flanges and/or other forms of sealing face must be confirmed from the manufacturer.

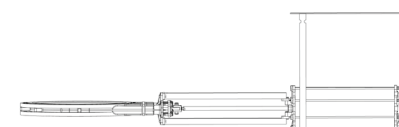
**ATEX** - In ATEX-classified zones, in accordance with ATEX Directive, only valves with ATEX-classification and the relevant valve marking shall be installed. Ensure the valve is part of the plants earth system and the user has performed a rich analysis of the pipeline and valve in accordance with the guidelines of ATEX Directive.

- 9.1** The valve is unidirectional. It should be installed with pressure exerted against the seat. To enable correct orientation the word "SEAT" is marked on the valve body to indicate the position of the valve seat.
- 9.2** It is good practice to provide additional support for all pneumatically, hydraulic and electric actuated valves installed in the horizontal stem position. This includes ALL valve sizes due to the fact that many of these installations are located in high vibration areas. Failure to provide additional support will result in premature valve failure.
- 9.3** It is recommended to provide support around areas indicated in **Figures 6** and **7** with an adjustable sling.
- 9.4** Support from the top as shown or with suitable arrangement from bottom (such as from an access platform) depending on location constraints.
- 9.5** After the support is given, please operate the valve a few times to check free movement and adjust the level (using the sling adjuster or similar device) if required.
- 9.6** Ensure jerk free movement with the supports in place.

**Figure 6:** Installation support for a Valve installed in Horizontal orientation (Stem horizontal)



**Figure 7:** Installation support for a Valve installed in Horizontal orientation (Bore horizontal)



# SERIES 952/957 UNIDIRECTIONAL KNIFE GATE VALVE

Installation, Operation, and Maintenance Manual



- 9.7** Align the mating pipeline flanges. Contact factory to select the length of the flange bolts. Install the valve between flanges using fasteners & gaskets.
- 9.8** Tighten flange bolts in a star pattern. See **Figure 16**.
- 9.9** Refer to GA Drawing/ Technical Bulletin for quantity and size of blind tapped holes on valve chest area.

**Table 1: RECOMMENDED FASTENERS - SERIES 957 ANSI 150 Flanges**

L1 (Figure 8)				L2 (Figure 9)				
Valve Size		Bolt & Nut Size	Flange Bolt Length	Flange Bolt Qty	Chest Bolt Size	Chest Bolt Length	Chest Bolt Qty	Washer* Quantity
NPS	DN	NPS						
26	650	1-1/4"	4.25	28	1-1/4"	3.75	20	48
28	700	1-1/4"	4.25	28	1-1/4"	3.75	28	56
30	750	1-1/4"	4.25	36	1-1/4"	4.0	20	56
32	800	1-1/2"	4.75	24	1-1/2"	4.25	32	56
36	900	1-1/2"	5.0	24	1-1/2"	4.5	40	64

\* Washer Type B Wide

NOTE: Refer General arrangement drawing for thread TPI, UN/UNC information

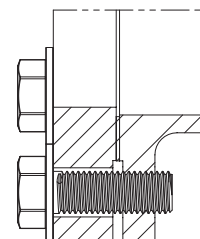
**Table 2: RECOMMENDED FASTENERS - SERIES 957 ANSI 150 Flanges**

		L3(Figure 10)			L4 (Figure 11)			
Valve Size		Stud & Nut Size	Flange Stud Length	Flange Stud Qty	Chest Stud Size	Chest Stud Length	Chest Stud Qty	Washer* Quantity
NPS	DN	NPS						
26	650	1-1/4"	6.0	28	1-1/4"	5.5	20	48
28	700	1-1/4"	6.25	28	1-1/4"	5.5	28	56
30	750	1-1/4"	6.25	36	1-1/4"	5.5	20	56
32	800	1-1/2"	6.75	24	1-1/2"	6.25	32	56
36	900	1-1/2"	7.0	24	1-1/2"	6.75	40	64

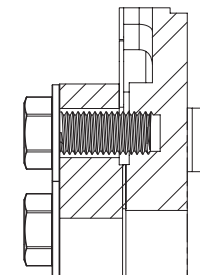
\* Washer Type B Wide

NOTE: Refer General arrangement drawing for thread TPI, UN/UNC information

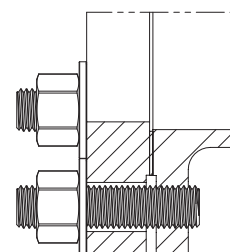
**Figure 8: L1 Flange Bolt**



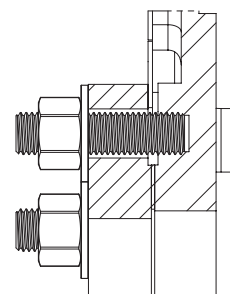
**Figure 9: L2 Chest Bolt**



**Figure 10: L3 Flange Stud**



**Figure 11: L4 Chest Stud**



# SERIES 952/957 UNIDIRECTIONAL KNIFE GATE VALVE

Installation, Operation, and Maintenance Manual



**Figure 12: L1 Lug Bolt**

**Table 3: RECOMMENDED FASTENERS - SERIES 952 ANSI 150 Flanges**

L1 (Figure 12)					L2 (Figure 13)			
Valve Size	Bolt & Nut Size	Lug Bolt Length	Lug Bolt Qty	Chest Bolt Size	Chest Bolt Length	Chest Bolt Qty	Washer* Quantity	
NPS	DN	NPS						
40	1000	1-1/2"	5.0	44	1-1/2"	4.75	28	72
42	1050	1-1/2"	5.0	44	1-1/2"	5.0	28	72
44	1100	1-1/2"	5.5	52	1-1/2"	5.5	28	80
48	1200	1-1/2"	6.25	56	1-1/2"	5.5	32	88
50	1250	-	-	-	1-3/4"	5.5	88	88
52	1300	1-3/4"	7.0	52	1-3/4"	6.25	36	88
54	1350	-	-	-	1-3/4"	6.0	88	88
60	1500	-	-	-	1-3/4"	6.25	104	104

\* Washer Type B Wide

**NOTE:** Refer General arrangement drawing for thread TPI, UN/UNC information

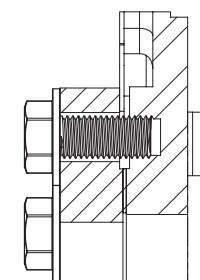
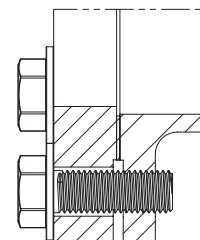
**Figure 13: L2 Chest Bolt**

**Table 4: RECOMMENDED FASTENERS - SERIES 952 ANSI 150 Flanges**

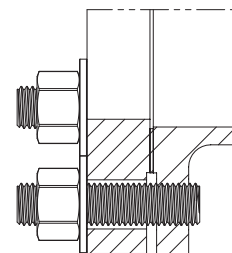
L3 (Figure 14)					L4 (Figure 15)			
Valve Size	Stud & Nut Size	Lug Stud Length	Lug Stud Qty	Chest Stud Size	Chest Stud Length	Chest Stud Qty	Washer* Quantity	
NPS	DN	NPS						
40	1000	1-1/2"	7.0	44	1-1/2"	7.0	28	72
42	1050	1-1/2"	7.0	44	1-1/2"	7.0	28	72
44	1100	1-1/2"	7.25	52	1-1/2"	7.0	28	80
48	1200	1-1/2"	8.0	56	1-1/2"	7.75	32	88
50	1250	-	-	-	1-3/4"	7.75	88	88
52	1300	1-3/4"	9.0	52	1-3/4"	8.75	36	88
54	1350	-	-	-	1-3/4"	8.25	88	88
60	1500	-	-	-	1-3/4"	8.75	104	104

\* Washer Type B Wide

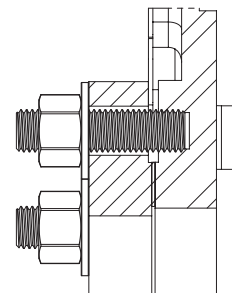
**NOTE:** Refer General arrangement drawing for thread TPI, UN/UNC information



**Figure 14: L3 Lug Stud**



**Figure 15: L4 Chest Stud**





## CAUTION

Care must be taken when installing the studs or bolts in the tapped holes of the flange in the chest area to prevent damage, see **Figure 17**.

## CAUTION

Support should be used for all valve sizes when installed in vertical pipe. Failure to do so can result in improper valve orientation and/or valve failure. Please consult factory for details.

- 9.10** Gland packing is tightened to hold the specified pressure and tested for no leakage before dispatch. However, this may require some adjustment at site due to loosening in transit etc.
- 9.11** Tighten packing gland in a crisscross pattern until the packing ring at the top is slightly compressed.
- 9.12** Pressurize the valve gradually and stop when packing leak is visible or design pressure is reached.
- 9.13** Re-tighten packing gland bolts just enough to stop the leakage.

If maximum design pressure is not reached, continue to pressurize the valve and repeat steps 9.11 and 9.12.

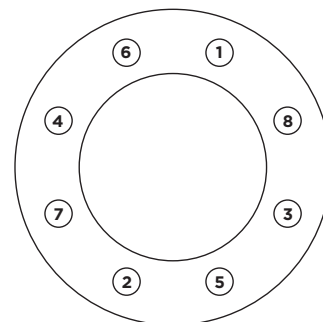
## CAUTION

If the gland nuts are pulled too hard, the force needed to operate the valve will increase, the valve function will be affected and the box packing lifetime will be shortened.

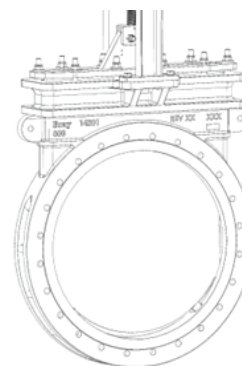
## CAUTION

Incorrect electrical supply to accessories will damage the equipment. Do not over tighten the gland nuts as this may cause excessive friction and premature damage to packing.

**Figure 16:** Bolt Tightening Sequence



**Figure 17:** Bolt holes in the chest or upper flange area are blind tapped



### 10.0 ACTUATION AND TRAVEL STOPS



#### WARNING

Verify line is depressurized before installing, removing, or repairing a valve or operator.

Do not pressurize the line without an operator on the valve.

### 10.1 PNEUMATIC CYLINDER OPERATED VALVES

**10.2** In **Figure 18**, connect instrument quality air, preferably through an air filter/regulator of adequate size.

**10.3** The recommended air pressure is 50-100 psi (3.5-7 bar). Refer to the appropriate bulletin/drawing for port and cylinder size details.

**10.4** Make sure the supply air is free from moisture, dirt, and other foreign particles.

**10.5** Drain the filter regulator before operating the actuator so that pipe rust and dirt if any in the air line will be removed before actuation.

**10.6** If valves are supplied with electrical accessories like limit switch and solenoid valve, ensure wiring is done as per local electrical safety codes and regulations.

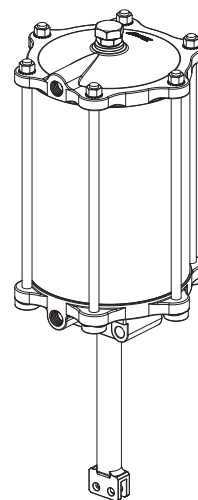
**10.7** Ensure correct electrical supply is given to electrical accessories for proper functioning and safety of the equipment.

**10.8** Open the valve by energizing the solenoid valve/giving air supply to cylinder and operate the valve 2-3 times.

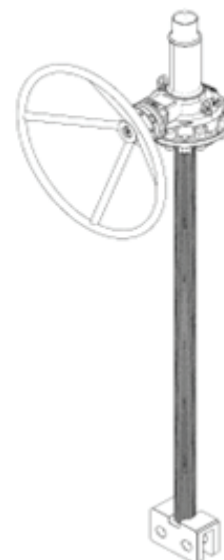
### 10.9 MANUAL VALVES

**10.10** For **Figure 19**, Stroke the valve through the full open and closed position to make sure it is functioning properly.

**Figure 18:** Cylinder Actuator



**Figure 19:** Manual Valve Stem



**11.0 STANDARD MAINTENANCE**



**WARNING**

Verify line is depressurized before installing, removing, or repairing a valve or operator.

Do not pressurize the line without an operator on the valve.



**WARNING**

After completing any alterations or maintenance procedures, the product must be tested to confirm performance requirements.



**WARNING**

When the process fluid is hazardous, thermal (hot or cold), or corrosive, take extra precautions.



**WARNING**

Always wear protective clothing and equipment to safeguard the eyes, face, hands, skin, and lungs from the particular fluid in the line.

**NOTICE**

Any modification or use of unauthorized parts voids any and all warranty considerations.

**NOTICE**

Note assembly positions before removal.



**CAUTION**

Disconnect electrical, pneumatic, and hydraulic power before servicing actuator or automation components.

**Table 5: Recommended Lubrication**

Lubricant Type
Industrial Grease - Medium
C5 - A Compound
XL 47 - F2 - 75
Molytex Grease #2

**11.1** The stem and nut of the knife gate valve are lubricated at the factory before shipment.

**11.2** The manual valve stem should be lubricated at regular intervals for smooth operation of the valve. A lubrication nipple is provided on the collar. See Lubrication requirements in **Table 5**.

**11.3** Cylinder operated valves do not require routine lubrication.

(continued)

**NOTICE**

If the cylinder actuator is disassembled for repair, the cylinder wall and seals need to be lubricated with a lithium-based grease prior to reassembly.

**11.4** Parts recommended as spares as shown in **Table 6**, may be stocked. Provide the valve serial number and work order number from the nameplate for proper parts.

**11.5** We recommend that all 952/957 knife gate valves be inspected at least every 60 days. The following points should be examined and corrected as required:

1. Exterior overview: As piping system components are subject to varying levels of erosion and corrosion, periodic inspections should be made as valves/components may wear over time. Regular inspection of the valve body and gate should be performed, check for general signs of corrosion, component wear and/or damage caused by process media and atmospheric conditions.
2. Packing gland: Check for leaks or worn packing. If leakage is occurring around the packing gland, tighten the packing gland bolts, being careful not to over stress the bolting.
3. If possible stroke the valve through the full open and closed position to make sure it is functioning properly.

**Table 6: Recommended Spare Parts**

Part	Qty
Gland Packing	Set of 4-5 Packing Rows
Spare Seat	1
Cylinder Repair Kit	1
Gate	1

## 12.0 PACKING REPLACEMENT - Manual Valves

12.1 Ensure the valve is fully closed.



### WARNING

Relieve line pressure before loosening gland nuts to avoid injury and/or equipment damage. Fully close the valve. Ensure the line is empty, and flush if necessary. Remove the valve from the pipeline.

12.2 In **Figure 20**, Disconnect the stem from the GATE (2) by removing the clevis BOLTS & NUTS (6).

12.3 Rotate the HANDWHEEL (1) counter-clockwise by holding the stem from rotation, so that the stem retracts fully from the gate.

12.4 For mechanical lockout or full force lockout, where the lockouts are meant to hold the full actuator force, please contact factory for assistance and more information.

### NOTICE

If valves are supplied with bellows, ensure stem is not rotating, as rotation will damage the bellows.

12.5 Remove the old PACKING (3) from the packing chamber, one layer at a time, using a long thin tool to pry it out.

12.6 Insert the new packing one at a time ensuring that the GATE (2) is in full contact with the seat (gate fully down) and not rubbing the bottom of the packing chamber. Stagger the cut end of the packing so they do not line up.

12.7 Install each PACKING (3) ring layer in alternate orientation to the chamber and ensure the ends of each layer are not on the same side. See **Figure 21**

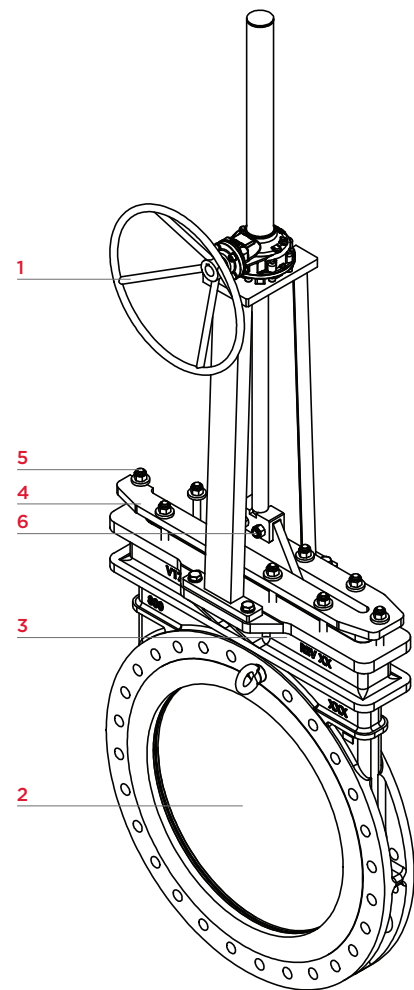
12.8 Install the PACKING GLAND (4) and GLAND NUTS (5).

12.9 Ensure the gap between the gland and the gate is uniform all around.

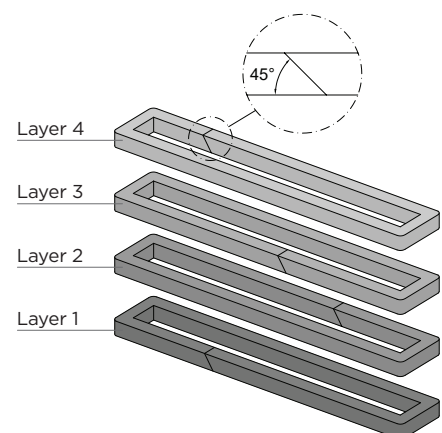
12.10 Tighten the GLAND NUTS (5) finger tight plus one half turn.

12.11 Lower the stem by rotating the handwheel clockwise while holding the stem and fasten the stem to the gate with nuts and bolts.

**Figure 20:** Manual Valve



**Figure 21:** Packing Installation



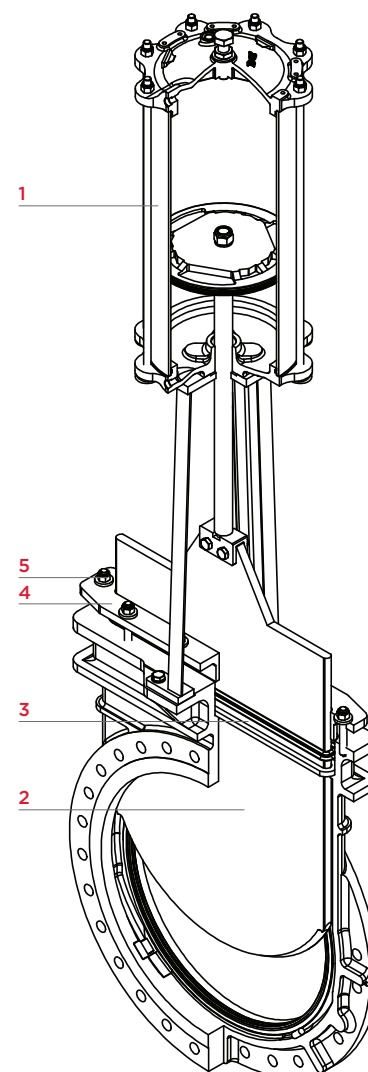
### 13.0 PACKING REPLACEMENT - Cylinder Operated Valves



De-energize before loosening gland nuts to avoid injury and/or equipment damage. Fully close the valve. Ensure the line is empty, and flush if necessary. Remove the valve from the pipeline.

- 13.1** Switch off the electrical supply to the solenoid and limit switches.
- 13.2** In **Figure 22**, remove the cylinder tubing and vent the air inside the CYLINDER (1).
- 13.3** For mechanical lockout or full force lockout, where the lockouts are meant to hold the full actuator force, please contact factory for assistance and more information.
- 13.4** Apply air slightly to the bottom port of the actuator so that the piston rod is retracted from the gate.
- 13.5** Remove the GLAND NUTS (5) and the GLAND (4).
- 13.6** Remove the old PACKING (3) from the packing chamber, one layer at a time, using a long thin tool to pry it out.
- 13.7** The lowest layer is a wiper ring (copper, Inconel etc.), clean it with a common solvent; if damaged, replace with a new one.
- 13.8** Insert the new packing one at a time ensuring that the GATE (2) is in full contact with the seat (gate fully down) and not rubbing the bottom of the packing chamber. Stagger the cut ends of the packing so they do not line up.
- 13.9** Tap each PACKING (3) ring firmly and evenly into the chamber before installing the next ring; the ends of each ring should meet but not overlap.
- 13.10** Install the PACKING GLAND (4) and GLAND NUTS (5).
- 13.11** Ensure the gap between the GLAND (4) and the GATE (2) is uniform all around.
- 13.12** Tighten the GLAND NUTS (5) finger tight plus one half turn.
- 13.13** Mount the actuator assembly to the valve by attaching the fasteners connecting the yokes to the valve body.

**Figure 22:** Cylinder Operated Valve Cutaway



**Table 7: PACKING DETAILS - S957**

Valve Size		Packing Size	Length	Quantity
NPS	DN	mm	mm	
<b>26</b>	<b>650</b>	16	1425	4
<b>28</b>	<b>700</b>	19	1520	4
<b>30</b>	<b>750</b>	19	1640	5
<b>32</b>	<b>800</b>	19	1830	5
<b>36</b>	<b>900</b>	19	2005	5

**Table 8: PACKING DETAILS - S952**

Valve Size		Packing Size	Length	Quantity
NPS	DN	mm	mm	
<b>40</b>	<b>1000</b>	19	2200	5
<b>42</b>	<b>1050</b>	19	2200	5
<b>44</b>	<b>1100</b>	19	2400	5
<b>48</b>	<b>1200</b>	19	2620	5
<b>50</b>	<b>1250</b>	25	2750	5
<b>52</b>	<b>1300</b>	19	2845	6
<b>54</b>	<b>1350</b>	25	2950	5
<b>60</b>	<b>1500</b>	25	3280	5

### NOTICE

If leakage is observed from the packing area after installing the valve in the pipeline and the valve is pressurized or charged with media, tighten the gland nuts evenly side to side just enough to stop leakage. Do not over-tighten the gland nuts.

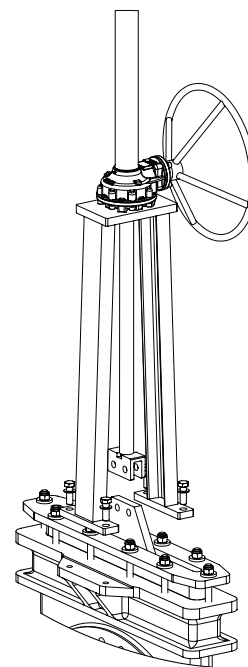
### 14.0 SEAT REPLACEMENT



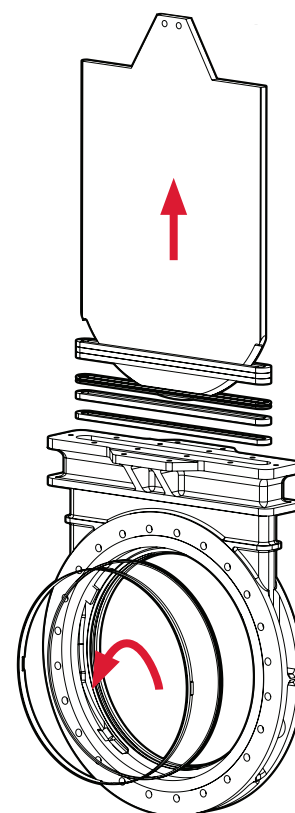
Relieve line pressure before attempting to remove the valve from the line to avoid personnel injury and/or equipment damage. If the valve has a pneumatic actuator, solenoid valve, limit switches, or other accessories, disconnect electrical and pneumatic supply.

- 14.1** Relieve the line pressure and close the valve. Flushing the line may be necessary.
- 14.2** Remove the valve from the line by loosening the flange mounting bolts, studs, and nuts.
- 14.3** Clamp the valve in the vertical position to a fixture. Do not block the valve port when clamping the valve. An overhead hoist may be needed for larger size valves.
- 14.4** Disconnect the stem from the gate by removing the clevis, bolts, and nuts.
- 14.5** Remove Actuator yoke and Actuator from the valve by removing body mounting bolts. See **Figure 23**.
- 14.6** Remove the Gland and Gland Fasteners
- 14.7** Remove the Gate from Body. See **Figure 24**.
- 14.8** Remove the seat and seat retainer from the Body. See **Figure 24**.
- 14.9** Insert the new “D” seat into the seat groove, the joints should be at the 12 O’ clock position.
- 14.10** Insert the seat retainer and fold the slit into the groove.
- 14.11** Assemble the gate.
- 14.12** Assemble the packing (refer the packing replacement procedure 14.4 to 14.9)
- 14.13** Assemble the Yoke and Actuator

**Figure 23:** Lift super structure.



**Figure 24:** Fully lift out gate and remove seat.





**15.0 TROUBLESHOOTING**

TROUBLE	POSSIBLE CAUSE	SOLUTION
Packing leakage	<ul style="list-style-type: none"> <li>&gt; Incompatible Media</li> <li>&gt; Packing Deteriorated</li> <li>&gt; Temperature Variations</li> <li>&gt; Normal Packing Wear</li> </ul>	Replace packing.
Leakage at flange connection	<ul style="list-style-type: none"> <li>&gt; Incorrect bolt length in flanges</li> <li>&gt; Valve not centered at flange connection</li> <li>&gt; Valve not parallel to flanges</li> <li>&gt; Gasket not centered</li> <li>&gt; Incorrect gasket material</li> </ul>	
Soft Seated Valve: In fully closed position, seat leakage	Seat is worn or damaged.	a) Remove worn or damaged seat. b) Inspect and clean seat chamber, install new seat.
	Gate is damaged.	Gate replacement.
High torque during valve seating and unseating	Entrapped foreign media in pipeline prohibiting valve from seating	Please consult factory for proper solutions.
	Packing not tightened to recommended torque.	a) Remove valve from service. b) Review gate to seat interface.
Unable to close or open gate	Solidified media between body and gate.	a) Check for valve orientation, flow direction and flow indication. b) Re-orient valve. c) Replace gate. d) Clean chest area of valve
Valve jerks during open and close	Superstructure fasteners loosened.	Tighten the superstructure fasteners.
	Insufficient air supply.	Pneumatic operated valves: Increase supply pressure.
	Solenoid valve dust accumulation.	Remove and clean solenoid valve.
	Piston rod seal damaged.	Replace seal.
	Packing is too tight.	Loosen packing.

**NOTES:**

- > Bray does not accept any responsibility for the product if wear parts not tested and approved by Bray are used.
- > Bray does not accept any responsibility for the product if maintenance instructions are not followed during maintenance.

## 16.0 RETURN MERCHANDISE AUTHORIZATION

**16.1** All products that are returned require a Return Merchandise Authorization (RMA). Contact a Bray representative to obtain authorization and shipping instructions.

**16.2** The following information must be provided when submitting RMA.

- > Serial number
- > Part number
- > Month and year of manufacture
- > Actuator specifics
- > Application
- > Media
- > Operating temperature
- > Operating pressure
- > Total estimated cycles (since last installation or repair)

**NOTE:** Product information is provided on identification tag attached to device.

### NOTICE

Materials must be cleaned and sanitized prior to return. MSDS sheets and Declaration of Decontamination are required.

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