

NAVSEA
STANDARD ITEM

FY-11

ITEM NO: 009-49
DATE: 24 JUL 2009
CATEGORY: II

1. SCOPE:

1.1 Title: Pressure Seal Bonnet Valve; repair (in-line)

2. REFERENCES:

2.1 T9074-AS-GIB-010/271, Requirements for Nondestructive Testing Methods

2.2 MIL-STD-2035, Nondestructive Testing Acceptance Criteria

2.3 803-6074287, Repair Guide, Pressure Seal Valves

2.4 803-5001021, Pressure Seal Rings Standard and Oversize Valve Pressure Class 600-1500

2.5 S9253-AD-MMM-010, Maintenance Manual for Valves, Traps, and Orifices (Non-Nuclear), User's Guide and General Information

3. REQUIREMENTS:

3.1 Matchmark valve parts.

(V) "INSPECT PARTS FOR DEFECTS"

3.2 Disassemble, clean free of foreign matter (including paint), and inspect parts for defects.

(I) "LIQUID PENETRANT INSPECT"

3.2.1 Accomplish liquid penetrant inspection of seats (including back seat), discs or gate, and body inlay area in accordance with 2.1.

3.2.1.1 Acceptance criteria shall be in accordance with Paragraph 7 of 2.2, except hairline cracks in hard-faced seats and discs or gate are acceptable provided the valve does not show evidence of leakage.

3.3 Repair valve as follows:

3.3.1 Straighten stem to within 0.002-inch total indicator reading. Polish stem to a 32 Root-Mean-Square (RMS) finish in way of packing surface and remove raised edges and foreign matter.

3.3.2 Chase and tap exposed threaded areas.

3.3.3 Inspect and repair sealing surfaces of inlay area and bonnet as follows:

(V) "VISUAL INSPECT"

3.3.3.1 Inspect valve body to verify that stainless steel inlay is free of steam cuts and cracks and that diameter of inlay area is round to within 0.003 inch and free of non-design taper. Measure diameter at top and bottom of inlay area in increments of 45 degrees, on each circle.

3.3.3.2 For the inlay, correct out-of-round, non-design tapered condition and provide 32 RMS finish. Finished inlay diameter shall not exceed oversize number one diameter, plus 0.002 to 0.005-inch clearance described by 2.3.

3.3.3.3 Machine valve bonnet tapered area for concentricity and design angle to within 0.002-inch total indicator reading and 32 RMS finish.

3.3.4 Machine, grind, or lap and spot-in discs or gate to seats (including back seat) to obtain a 360-degree continuous contact.

(V) "INSPECT CONTACT"

3.3.4.1 Inspect contact using blueing method.

3.3.4.2 Transfer line for gate valve shall not exceed 3/16-inch in width and shall appear within the lower 75 percent of the gate seating surface.

3.3.4.3 Transfer line for globe valve shall not exceed 1/16-inch in width.

(I)(G) "VERIFY LEVEL I PARTS AND CLEANLINESS"

3.4 Assemble valve, installing new fasteners in accordance with Attachment A.

3.4.1 Install new seal ring in accordance with 2.3, using 2.4 for guidance.

3.4.1.1 The SUPERVISOR must approve new seal rings to inlay bores above first oversize.

3.4.1.2 Attach a metal identification tag to the valve bonnet indicating the size of seal ring installed, straight or tapered body neck, name of installing activity, and date of installation.

3.4.2 Install new valve stem packing conforming to MIL-P-24503/24583 combination in accordance with Chapter 6 of 2.5.

4. NOTES:

4.1 Operational test of the valve will be specified in Work Item.

4.2 Repair of valve operating gear will be specified in Work Item.

ATTACHMENT A

VALVE BODY MATERIAL

	Alloy Steel ^{1/}	Carbon Steel
Studs and Bolts to MIL-DTL-1222 ^{2/}	Grade B-16	Grade B-16
Nuts to MIL-DTL-1222	Grade 4 or 7	Grade 4 or 7
Socket Head Cap Screws	FF-S-86	FF-S-86

^{1/} Alloy steel is of Composition A - 2-1/4 percent Chromium, one percent Molybdenum, Composition B - 1-1/4 percent Chromium, 1/2 percent Molybdenum, and Composition C - Carbon Molybdenum.

^{2/} Studs shall be Class 2 or 3 fit on the nut end and Class 5 fit on the stud end, except that a Class 3 fit with a thread locking compound may be used where temperatures do not exceed 250 degrees Fahrenheit. The thread locking compound shall conform to ASTM D 5363. Check Class 3 fit stud ends in accordance with SAE-J2270.