

Installation, Operation, Maintenance Instructions

Pneumatic Diaphragm On-Off Actuators

Series 2, Types: P0, P1

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1 USING KÄMMER VALVES AND ACTUATORS CORRECTLY

1.1 General

The following instructions are designed to assist in unpacking, installing and performing maintenance as required on Kämmer products. Product users and maintenance personnel should thoroughly review this bulletin prior to installing, operating or performing any maintenance.



DANGER: *In most cases Kämmer valves and actuators are designed for specific applications (e.g. with regard to medium, pressure, temperature). For this reason they should not be used in other applications without first contacting the manufacturer.*

1.2 Terms concerning safety

The safety terms **DANGER**, **WARNING**, **CAUTION** and **NOTE** are used in these instructions to highlight particular dangers and/or to provide additional information on aspects that may not be readily apparent.



DANGER: *indicates that death, severe personal injury and/or substantial property damage will occur if proper precautions are not taken.*



WARNING: *indicates that death, severe personal injury and/or substantial property damage can occur if proper precautions are not taken.*



CAUTION: *indicates that minor personal injury and/or property damage can occur if proper precautions are not taken.*



NOTE: *indicates and provides additional technical information, which may not be very obvious even to qualified personnel.*

Compliance with other, not particularly emphasised notes, with regard to transport, assembly, operation and maintenance and with regard to technical documentation (e.g. in the operating instruction, product documentation or on the product itself) is essential, in order to avoid faults, which in themselves might directly or indirectly cause severe personal injury or property damage.

1.3 Protective clothing

Kämmer products are often used in problematic applications (e.g. extremely high pressures, dangerous, toxic or corrosive mediums). In particular valves with bellows seals point to such applications. When performing service, inspection or repair operations always ensure, that the valve and actuator are depressurised and that the valve has been cleaned and is free from harmful substances. In such cases pay particular attention to personal protection (protective clothing, gloves, glasses etc.).

1.4 Qualified personnel

Qualified personnel are people who, on account of their training, experience and instruction and their knowledge of relevant standards, specifications, accident prevention regulations and operating conditions, have been authorised by those responsible for the safety of the plant to perform the necessary work and who can recognise and avoid possible dangers.

1.5 Installation



DANGER: *Before installation check the order-no, serial-no. and/or the tag-no. to ensure that the valve/actuator is correct for the intended application.*

Do not insulate extensions that are provided for hot or cold services.

Pipelines must be correctly aligned to ensure that the valve is not fitted under tension.

1.6 Spare parts

Use only Kämmer original spare parts. Kämmer cannot accept responsibility for any damages that occur from using spare parts or fastening materials from other manufactures. If Kämmer products (especially sealing materials) have been on store for longer periods check these for corrosion or deterioration before using these products. Fire protection for Kämmer products must be provided by the end user.

1.7 Service / repair

To avoid possible injury to personnel or damage to products, safety terms must be strictly adhered to. Modifying this product, substituting nonfactory parts, or using maintenance procedures other than outlined in this instruction could drastically affect performance and be hazardous to personnel and equipment, and may void existing warranties. Between actuator and valve there are moving parts. To avoid injury Flowserve provides pinch-point-protection in the form of cover plates, especially where side-mounted positioners are fitted. If these plates are removed for inspection, service or repair special attention is required. After completing work the cover plates must be refitted.

Apart from the operating instructions and the obligatory accident prevention directives valid in the country of use, all recognised regulations for safety and good engineering practices must be followed.



WARNING: Before products are returned to Kämmer for repair or service Kämmer must be provided with a certificate which confirms that the product has been decontaminated and is clean. Kämmer will not accept deliveries if a certificate has not been provided (a form can be obtained from Kämmer).

1.8 Storage

In most cases Kämmer Products are manufactured from stainless steel. Products not manufactured from stainless steel are provided with an epoxy resin coating. This means that Kämmer products are well protected from corrosion. Nevertheless, Kämmer products must be stored adequately in a clean, dry environment. Plastic caps are fitted to protect the flange faces and to prevent the ingress of foreign materials. These caps should not be removed until the valve is actually mounted into the system.

1.9 Valve and actuator variations

These instructions cannot claim to cover all details of all possible product variations, nor in particular can they provide information for every possible example of installation, operation or maintenance. This means that the instructions normally include only the directions to be followed by qualified personal where the product is being used for is defined purpose. If there are any uncertainties in this respect particularly in the event of missing product-related information, clarification must be obtained via the appropriate FLOWSERVE sales office.

2 UNPACKING

2.1 Each delivery includes a packing slip. When unpacking, check all delivered valves and accessories using this packing slip.

2.2 Larger valves can be lifted using slings on the yoke rods or, if present, on the lugs provided for this purpose. If slings are used, attach them so that the outer tubing or attaching parts are not damaged.



WARNING: If slings are used, be aware that the centre of gravity of the valve may be above the lifting point. In this case, secure or support the valve against rotating, to prevent damage or personnel injury.

2.3 Report transport damage to the carrier immediately.

2.4 In case of discrepancies, contact your nearest FLOWSERVE sales office.

3 INSTALLATION

3.1 Clean tubing prior to installing.

3.2 If possible, install the valve in an upright position (actuator on top), to ease maintenance. An upright installation position is important with low-temperature applications, in order to keep the distance between the packing material and the medium as large as possible. The packing material then retains the ambient temperature as much as possible.



NOTE: Do not insulate extension bonnets that are provided for hot or cold services

3.3 Make sure that sufficient overhead clearance above the actuator is maintained, to allow for disassembly of plug from the valve body.

3.4 After installing, check direction of flow again. The direction of flow is shown by the arrow on the housing.

3.5 If the valve is to be welded into the line, make sure that the valve is shielded from excessive heat.

3.6 Connect supply pressure and signal lines. Control valves are supplied with a positioner. The end connections for supply pressure and signal are clearly marked. Series 4 actuators and positioners are suitable for max. 4.2 bar (60 psi) supply pressure. If the supply pressure exceeds the pressure specified on the nameplate, a pressure reducing station is required. If instrument air is not available, install an oil separator/air filter in the air inlet line. All connections must be leak free.



WARNING: Prevent other items of equipment from making mechanical contact with the actuator housing.

4 QUICK CHECK

Before operating, check the valve as follows:

4.1 Open and close the valve, and observe the movement of the actuator stem. The movement must be smooth and linear.

4.2 Check for maximum stroke through change of signal

(for pneumatic positioners, 0.2 - 1.0 bar or corresponding split-range values; for IP positioners, 4-20 or 0-20 mA).

- 4.3 Check all air connections for leaks.
- 4.4 Tighten packing nut (see table 1).

Thread	Torque	
	PTFE	Grafoil
M20 x 1,5	1	3
M30 x 1,5	6	15
M38 x 1,5	15	35
M45 x 1,5	17	40

Table 1

 **NOTE:** An excessively tightened gland nut can cause excessive packing wear and can hinder the free movement of the plug stem.

- 4.5 Check fail-safe position. To do this, close supply pressure and observe whether the valve opens or closes as defined.
- 4.6 After use at fluctuating temperatures, re-tighten all bolt connections and check for leaks.

5 MAINTENANCE

Check valves for correct functioning at regular intervals (at least once every 6 months) as follows. This check can be made when installed and in many cases without interrupting production. If internal defects are suspected, see section „Disassembly and Assembly of Valve“.

- 5.1 Examine gaskets for leaks and if necessary re-tighten bolts (see Fig. 1).
- 5.2 Check bellows gasket and test connection - if present - for external leaks.
- 5.3 Check valve for damage caused by corrosive residues or corrosive vapours.
- 5.4 Clean valve/actuator and repaint as necessary.

 **Warning:** To prevent a buildup of electrostatic charge clean the actuator/valve with a damp cloth only.

- 5.5 Check gland nut for correct torque (see table 1).

 **NOTE:** An excessively tightened gland nut can cause excessive packing wear and can hinder the free movement of the plug stem.

- 5.6 If possible, open and close valve and check for maximum stroke and smooth movement of the plug stem. Irregular movement of the plug stem may indicate internal defects.



NOTE: With graphite packing, irregular movement of the plug stem is normal.



WARNING: Keep hands, hair, clothing, etc. away from all moving parts. Failure to do so can lead to serious injury.

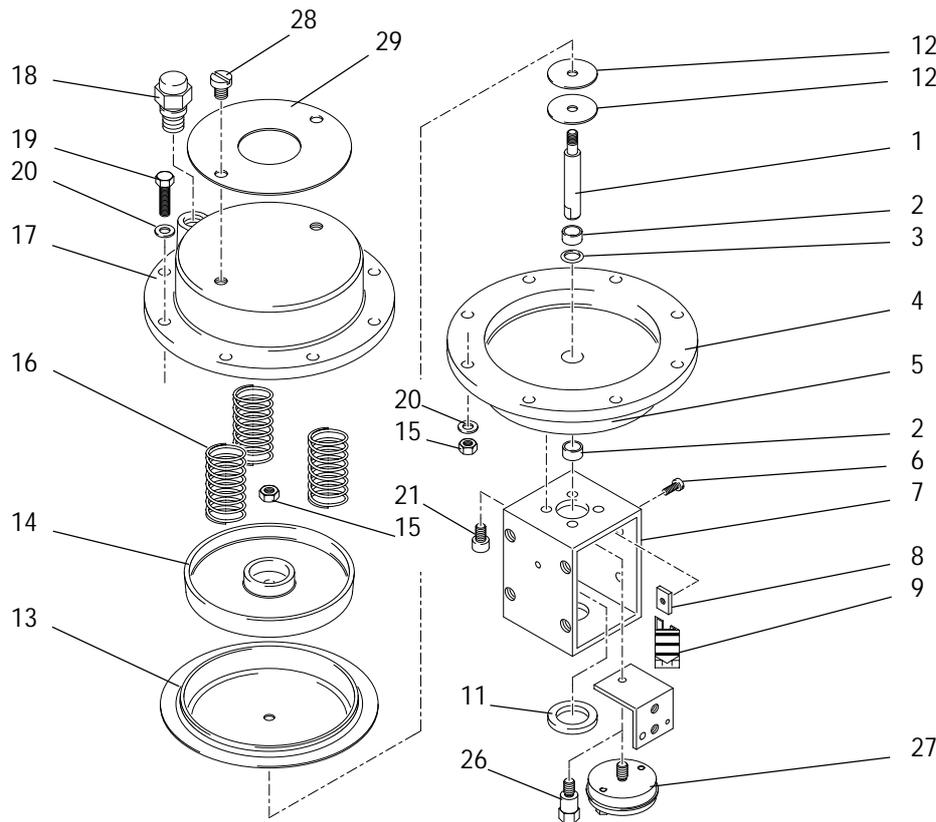
- 5.7 Check all accessories for firm seating.
- 5.8 If possible, close supply pressure and check the fail-safe position.
- 5.9 Check stem boot for wear.
- 5.10 Check actuator for leaks. To do this, spray housing, air connections and plug stem guide with leak spray and check for any bubble formation.
- 5.11 Clean plug stem.
- 5.12 Check air filter, if present, and if necessary replace insert.



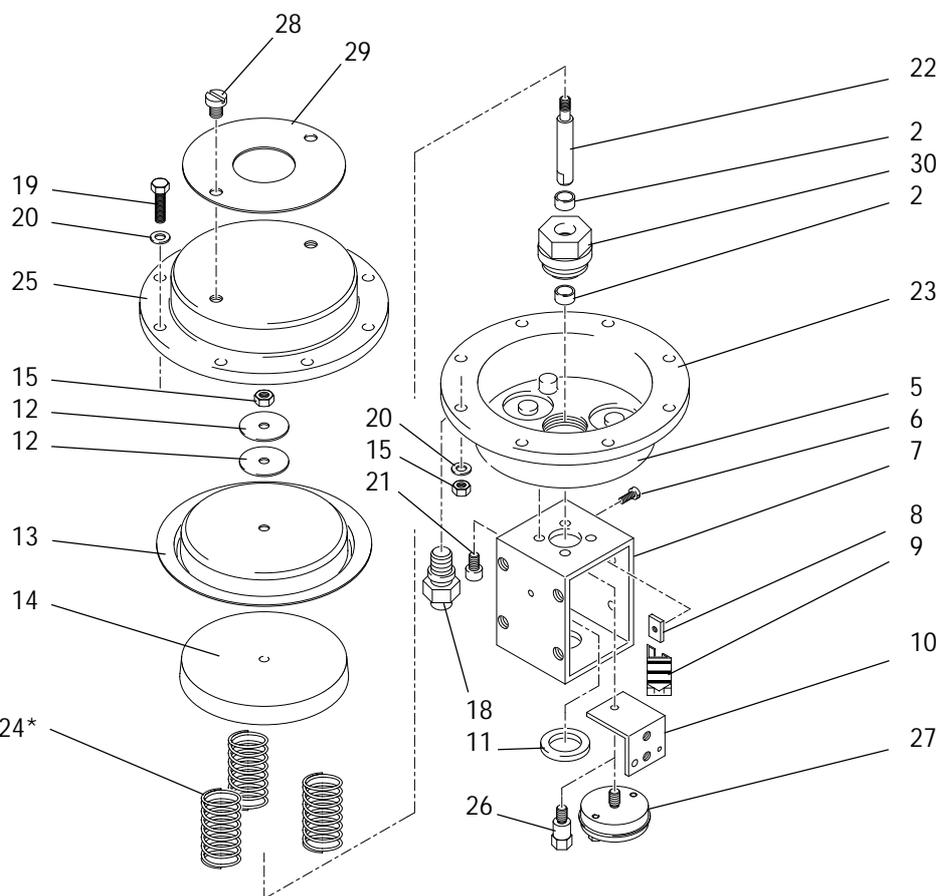
Note: For further information regarding service and maintenance please contact your nearest FLOWSERVE office.



DANGER: On actuators with aluminium cases the actuator springs must be renewed with original spare parts every 10 years or after 50.000 operating hours which ever occurs first.



- 1 Actuator stem
- 2 Bushing
- 3 O-Ring, 10 x 2,4
- 4 Diaphragm case
- 5 Label
- 6 Screw
- 7 Yoke
- 8 Square nut
- 9 Travel indicator
- 10 Bracket (NAMUR)
- 11 Washer
- 12 Washer



- 13 Diaphragm
- 14 Piston
- 15 Nut
- 16 Spring set
- 17 Spring case
- 18 Vent plug
- 19 Screw
- 20 Washer
- 21 Screw
- 22 Actuator stem
- 23 Spring case
- 24* Spring (set)
- 25 Diaphragm case
- 26 Nut
- 27 Coupling
- 28 Bellows seal coupling

* For Actuator P0, air-to-close/spring-to-open, one central actuator spring

6 REMOVING AND REPLACING ACTUATOR

General information

All repair work is best performed when the actuator is removed from the valve body.

However, many service repairs and adjustments can be accomplished in the field while the actuator and valve body are still connected to each other.



WARNING: *Ensure that the plug assembly is not rotated with the plug seated. This may cause irreparable damage to the seating faces.*

Always remove the yoke (7) with the actuator as an assembly.

6.1 Remove actuator

- 6.1.1 On actuators with air-to-close action partially vent actuator, on actuators with air-to-open action apply supply pressure to raise the plug (half stroke).



CAUTION: *Galling of critical surfaces may result if the plug is not correctly positioned between seat ring and bonnet.*

- 6.1.2 With a wrench, hold the actuator stem to prevent it from rotating while using a second wrench to loosen the plug stem locknut on the plug stem (27) or coupling screws (28).
- 6.1.3 Loosen the packing nut as far as possible.
- 6.1.4 Loosen the slotted nut as far as possible.
- 6.1.5 Completely rotate the actuator off the plug stem by continuously loosening locknut, packing nut and slotted nut ensuring that the plug stem does not rotate in the bonnet.



CAUTION: *Do not allow the plug to drop and impact against the seat after turning the actuator off the plug stem threads.*

- 6.1.6 When the actuator is free release supply pressure and remove actuator.

6.2 Replace actuator

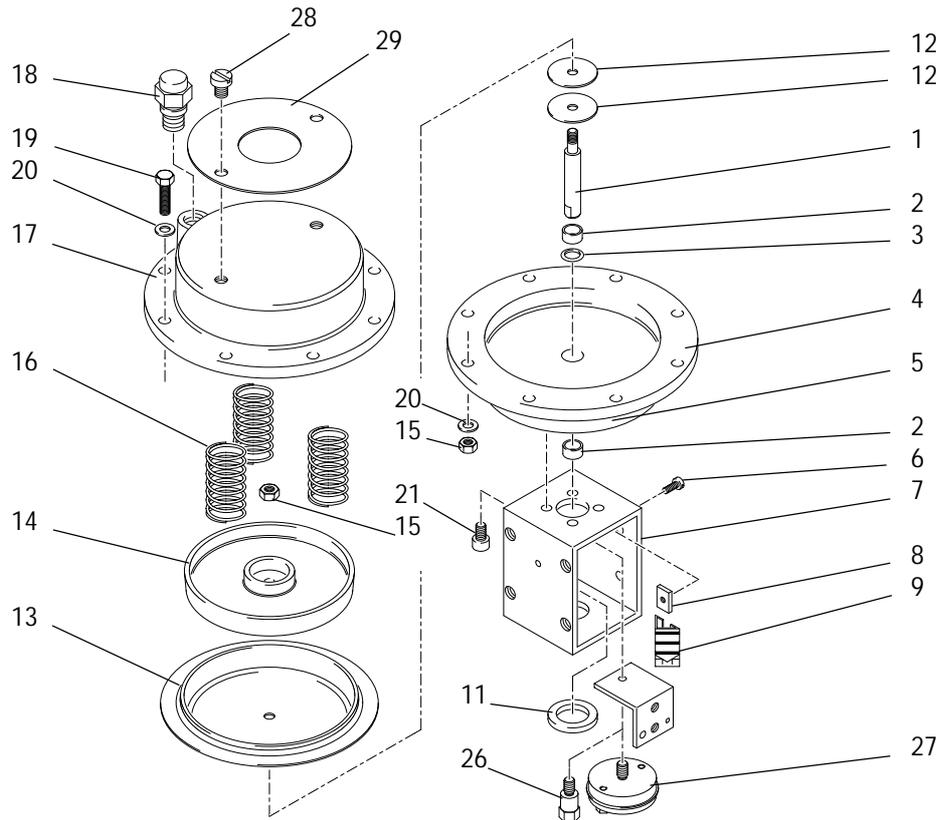
The actuator stem must be fully extended: Actuators with air-to-open action must be fully vented. Actuators with air-to-close action apply supply pressure.

- 6.2.1 As required remove packing nut and slotted nut from the valve bonnet.
- 6.2.2 Manually depress the plug stem to ensure the plug is fully seated.
- 6.2.3 Place the actuator over the valve adding slotted nut, and packing nut.
- 6.2.4 Thread the plug stem locknut as far as possible onto the plug stem.
- 6.2.5 Engage the plug stem and coupling threads and rotate actuator in a clockwise direction until the clearance between the yoke base and the bonnet seating face is around 2 mm.

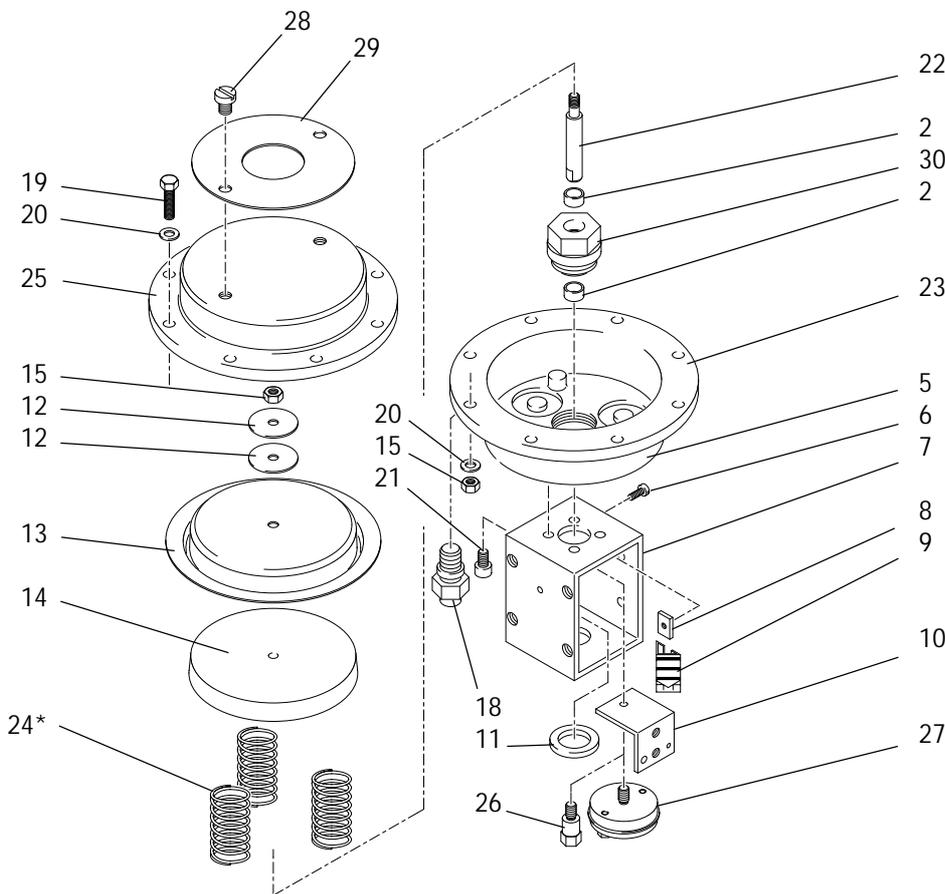


WARNING: *Ensure that the plug assembly is not rotated with the plug seated. This may cause irreparable damage to the seating faces.*

- 6.2.6 On actuators with air-to-close action partially vent actuator, on actuators with air-to-open action apply supply pressure to raise the plug (half stroke).
- 6.2.7 Tighten slotted nut.
- 6.2.8 With a wrench, hold the actuator stem to prevent it from rotating while using a second wrench to tighten the plug stem locknut against the coupling.
- 6.2.9 Tighten packing nut (see table 1).
- 6.2.10 Vent actuator and adjust travel indicator (9).



- 1 Actuator stem
- 2 Bushing
- 3 O-Ring, 10 x 2,4
- 4 Diaphragm case
- 5 Label
- 6 Screw
- 7 Yoke
- 8 Square nut
- 9 Travel indicator
- 10 Bracket (NAMUR)
- 11 Washer
- 12 Washer
- 13 Diaphragm
- 14 Piston
- 15 Nut
- 16 Spring set
- 17 Spring case
- 18 Vent plug
- 19 Screw
- 20 Washer
- 21 Screw
- 22 Actuator stem
- 23 Spring case
- 24* Spring (set)
- 25 Diaphragm case
- 26 Nut
- 27 Coupling
- 28 Bellows seal coupling



* For Actuator P0, air-to-close/spring-to-open, one central actuator spring

7 DISASSEMBLE ACTUATOR

(refer to Figs. 1 and 2)

7.1.1 Remove the actuator from the valve.



WARNING: In many actuators the actuator springs (see Figs. 1 and 2, pos. 16 or 24) are pre-tensioned. For this reason NEVER remove the case screws (see Figs. 1 and 2, pos. 19) without using a suitable press or the method described below.

7.1.2 If long (de)compression screws are not already fitted to the actuator remove 2 diametrically opposite case retaining screws (19).

7.1.3 Insert 2 at least 35 mm long (de)compression screws, and tighten them with nuts (15) hand tight.

7.1.4 Remove the 2 remaining short case retaining screws (19).

7.1.5 Unscrew the long (de)compression screws in equal measures until the actuator springs are fully decompressed and the upper case is loose.

7.2 Valve with action: Air-to-open
(For valve with action air-to-close proceed with 3)
(refer to fig. 1)

7.2.1 Remove the upper case half (17).

7.2.2 Remove spring set.

7.2.3 Remove coupling (27) or (28) and bracket (10).

7.2.4 Secure the actuator stem (1) with a wrench across the flats on the stem's lower part against rotating and remove the nut (26).

7.2.5 Remove following parts: piston (14), diaphragm (13), washers (12) and actuator stem (1).

7.2.6 Remove 4 screws (21) and remove yoke.

7.2.7 Remove the guide (4) and upper yoke plate (8).

7.3 Valve with action: Air-to-close
(refer to fig. 2)

7.3.1 Remove the upper case half (25).

7.3.2 Remove coupling (27) or (28) and Bracket (10).

7.3.3 Secure the actuator stem (1) with a wrench across the flats on the stem's lower part against rotating and remove the nut (26).

7.3.4 Remove following parts: washers (12), diaphragm (13), piston (14), and actuator stem (1).

7.3.5 Remove spring set (24)

7.3.6 Remove 4 screws (21) and remove yoke.

8 ASSEMBLE ACTUATOR

8.1 Valve with action: Air-to-open
(For valve with action air-to-close proceed with 5)
(refer to fig. 1)

8.1.1 Refit the actuator stem (1), washers (12), diaphragm (13) and piston (14).

8.1.2 Secure the actuator stem (1) with a wrench across the flats on the stem's lower part against rotating and retighten the retaining nut (26).

8.1.3 Refit bracket (10) and coupling (27) or (28).

8.1.4 Replace spring set (16).

8.1.5 Replace the upper case half (17).

8.1.6 Insert 2 at least 35 mm long (de)compression screws through the upper and lower actuator case halves and tighten with nuts (15) in equal measures until the casing halves contact.

8.1.7 Insert and tighten the 2 remaining short case retaining screws (19).

8.1.8 As required replace the long (de)compression screws/nuts with the short screws/nuts.

8.1.9 Refit yoke with 4 screws (21).

8.1.10 As required refit the actuator assembly to the valve.

8.2 Valve with action: Air-to-close
(refer to fig. 2)

8.2.1 Refit the actuator stem (22), spring set (24), piston (14), diaphragm (13) and washers (12) .

8.2.2 Secure the actuator stem (1) with a wrench across the flats on the stem's lower part against rotating and retighten the retaining nut (26).

8.2.3 Refit bracket (10) and coupling (27) or (28).

8.2.4 Replace the upper case half (25).

8.2.5 Insert 2 at least 35 mm long (de)compression screws through the upper and lower actuator case halves and tighten with nuts (15) in equal measures until the casing halves contact.

8.2.6 Insert and tighten the 2 remaining short case retaining screws (19).

8.2.7 As required replace the long (de)compression screws/nuts with the short screws/nuts.

8.2.8 Refit yoke with 4 screws (21).

8.2.9 As required refit the actuator assembly to the valve.

9 Troubleshooting chart

Problem	Possible cause	Corrective Action
Stem pulsates	<ol style="list-style-type: none"> 1. Unstable air supply 2. Vent or passage blocked 	<ol style="list-style-type: none"> 1. Adjust air supply 2. Clean vent or passage
Actuator slow	<ol style="list-style-type: none"> 1. Air supply too low 2. Diaphragm case leaks air 3. Spring case vent blocked 	<ol style="list-style-type: none"> 1. Adjust air supply 2. Seal diaphragm case 3. Renew vent
Actuator will not return to end position	<ol style="list-style-type: none"> 1. Air supply too low 2. Actuator movement blocked 	<ol style="list-style-type: none"> 1. Adjust air supply 2. Dissassemble actuator and check
Actuator will not return to the failsafe position	<ol style="list-style-type: none"> 1. Air supply not switched off 2. Broken actuator spring 3. Actuator movement blocked 	<ol style="list-style-type: none"> 1. Adjust air supply 2. Renew all actuator springs 3. Dissassemble actuator and check

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