



STRAINER SERVICING INSTRUCTIONS

A. INSTALLATION

- 1) Perform installation welding in accordance with ASME Boiler and Pressure Vessel Code, Sec. 1, Part AW, or ANSI B31.1 Para 127.
- 2) Allow 1/16" gap between bottom of socket weld end and end of pipe (PW 41.5.7, or ANSI B31.1, Para. 127.3.3)
- 3) Preheat per Table 1

B. MAINTENANCE

All components of the Clampseal ® strainer are shown and named in Figure A.

- 1) Cleaning or replacing of the strainer basket.
CAUTION: Before any attempt is made to disassemble the strainer, verify that the strainer is isolated from system pressure and secured against accidental pressurization. Follow standard tag out safety procedures before proceeding.
 - a) Completely remove the clampbolt (item #4 in Figure A) from the yoke and screw it into the opposite (threaded) side of the clampbolt lug. Place a metal flat (like a fender washer) into the yoke split to stop the clampbolt. Tighten the clampbolt, using it as a jacking screw, until the yoke split expands by 1/16". (This is to relieve yoke thread friction.)
 - b) Unscrew the yoke, (Item #5 in Figure A) using a Convolve yoke wrench. Remove the yoke and bonnet (Item #3 in Figure A). If the bonnet becomes stuck in the body, use a small wedge under the bonnet flange to work the bonnet out.
 - c) Remove the strainer basket (Item #2 in Figure A) for cleaning and replacement.
 - d) Before re-assembly of the strainer, check the bonnet seat in the body (Item #1 in Figure 1). To make sure the surface is clean and scratch free. If it is not, small surface defects can be lapped out using the bonnet lapping tool as shown in Figure B.

Apply a small amount of Lapping Compound to the seating surface of the Bonnet Lapping Tool. Use compound 120 (coarse) for rough lapping, 280 (fine) for final lapping.

Apply slight downward pressure on the Bonnet Lapping Tool. Lap back and forth until a smooth finish or the Bonnet lip is achieved.

Clean parts thoroughly with solvent and a clean rag.

2. REASSEMBLY

- a) Clean all parts thoroughly with cleaning solvent.
- b) Coat body / yoke threads with a nickel anti-seize lubricant.
- c) Assemble the components in the following order:
 - 1) Position the strainer basket snugly in the body.
 - 2) Place the bonnet over the strainer basket ensuring that the bonnet lip is making contact with the seal area of the body.
 - 3) Screw the yoke back onto the body. Apply torque as specified in Table 2. Return clampbolt to normal position and tighten per Table 2. Use of nickel anti-seize lubricant on the clampbolt threads will allow for easier thread engagement.

Table 1

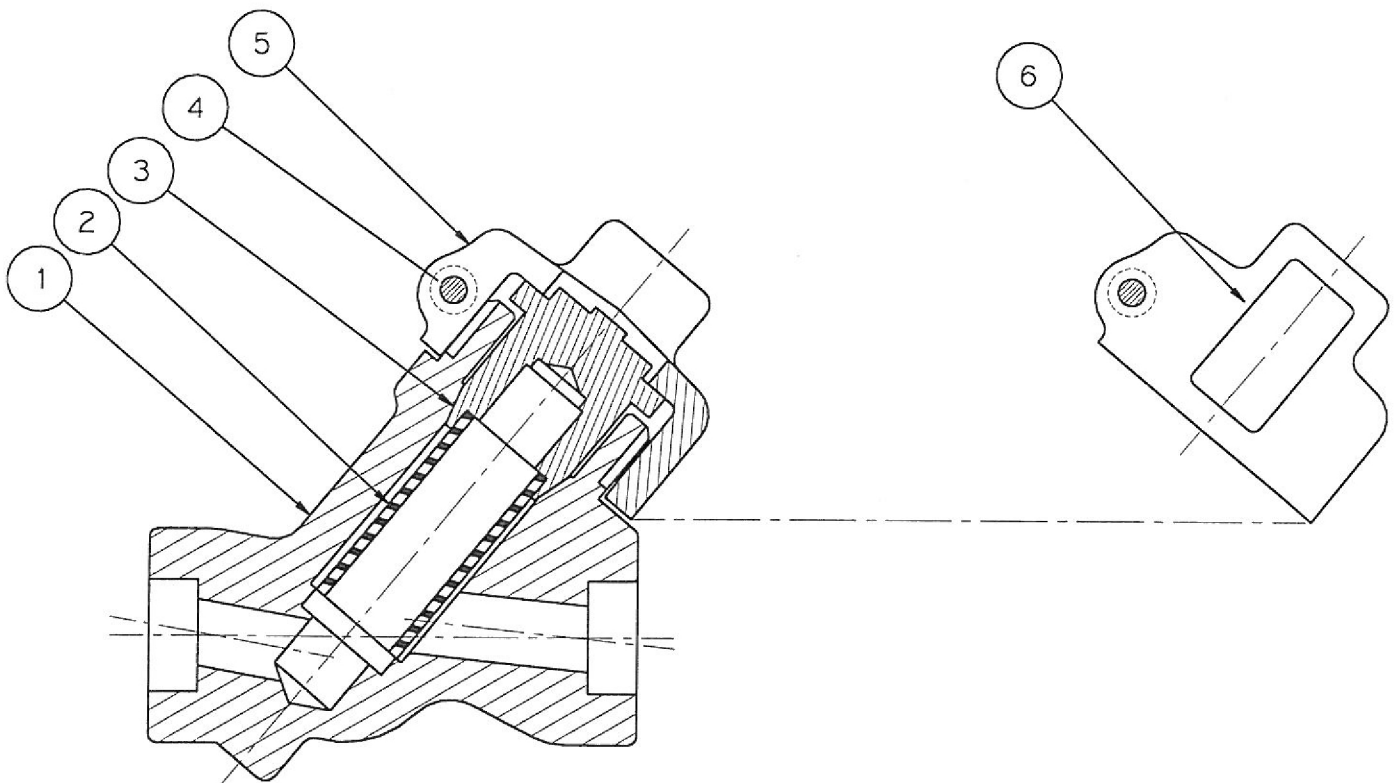
PREHEAT AND POSTWELD HEAT TREAT REQUIREMENTS		
P - 1 SA - 105	P - 5 SA - 182 GR. F22	P - 8 SA - 182 GR. F316
PREHEAT 50° F (A100.4.1) *	PREHEAT 400° F (A100.4.4) *	PREHEAT NONE REQUIRED (A100.4.7) *
POST WELD HEAT TREAT NONE REQUIRED (PW - 39)	POST WELD HEAT TREAT REQUIRED WHEN NOMINAL WALL THICKNESS EXCEEDS 5/8" (PW - 39) LOCALIZED ONLY PER (PW - 39 - 2)	POST WELD HEAT TREAT NONE REQUIRED (PW - 39)
* ASME BOILER AND PRESSURE VESSEL CODE, SECTION I, PART PW - 38		

Table 2

OPERATING TORQUES (FT - LBS)		
SIZE CODE	YOKE	CLAMPBOLT
3C 3D	100	15
5C 5D	150	15
5E 5F 5G	150	15
6E 6F 6G 6H	200	15
7E	250	25
7F 7G 7H 7J	250	25
8F	350	25
8G 8H 8J 8K	350	25
9G 9H	425	60
9J 9K 9L	425	60
10H	600	105
10J	600	105
10K 10L 10M	600	105

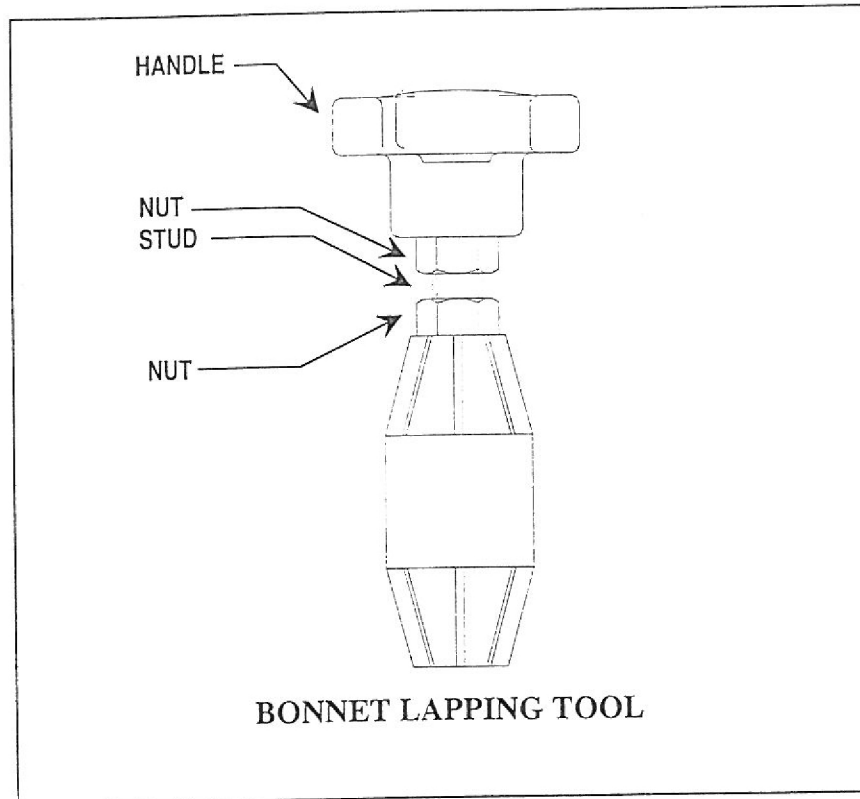
NO.	NAME
1	BODY
2	STRAINER
3	CHECK BONNET
4	CLAMP BOLT
5	CHECK YOKE
6	I.D. PLATE

FIGURE "A"



Gonval
SOMERS, CONNECTICUT

FIGURE B



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