F&M Armaturen Vertriebs GmbH / Maria-Merian-Straße 16 / 73230 Kirchheim/Teck
Telefon: +49 (0) 7021-980100 / Telefax: +49 (0) 7021-9801060
E-mail: info@fm-armaturen.de / Internet: www.fm-armaturen.de

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1. Generalities

The following operation instructions are valid for Fromme - Gate valves of figure no.

101,103,114,120,121,122,126,150,151, 201,211,213

which serve to shut the flow of liquids, gases and steams in pipelines, and of course to let it through, whenever they are in OPEN status.

Fromme Valves are subjected to the rules according to DIN EN standards as well as the technical regulations AD2000 A4 and PED 2014/68/EU in their development and construction.

By a correct assembling, maintenance or repair we guarantee an activity free of troubles.

The manufacturer carries no responsibility for efficiency and safety of the valves, whenever these operating instructions are not observed and followed accurately.

The valves are marked, according to DIN/EN 19 (ISO 5209) as follows: nominal diameter (DN), nominal pressure (PN), body material, heat-no or specimen-no, manufacturer brand and factory number, and if necessary, flow direction arrow, admissible operating temperature and admissible operating pressure (bar).

By affixing the CE mark to the fittings, we also declare conformity according to DRGL 2014/68 / EU

ATTENTION! The valves must not be activated beyond the limits and rules indicated in the different documents (such as operation rules, purchase documents, type sheets). Operations beyond the indicated limits lead to overstrain which cannot be sustained by the valves.

A non-observance of this warning can cause injuries to persons and defects of the machines, such as:

- Injuries caused by escaped medium (cold/hot, toxic, under pressure),
- Affect in activity or damage of the valve.

The descriptions and rules included in this operation instruction refer to standard types but are also valid for alternatives.

These operation instructions do not take into consideration:
- Any accident and incident which can arise by assembling, operation or commissioning of the valves.
- Any safety rule in relation with the place where the valve is installed. The operator is responsible for the observation of the safety rules, - also by the assembling staff.

The connected loads prescribed for driven valves, as well as the instructions for assembling, commissioning and operation have absolutely to be observed.

ATTENTION! It is essential that the valves are handled by skilled staff that must be aware of the interactions between the valves and the system in which they are installed.

An incorrect use of a valve may cause strong consequences to the complete system, such as:
- Escape of medium
- Stop of the unit
- Affects, decreases or increases of operation or work of a system or unit.

For any further inquiries or in case of damage, please contact FROMME Armaturen.

In case of local inquiries or orders, especially for spare parts, please indicate the production or factory serial number, the type, the model version and possibly also the year of construction.

The technical data referring to the valves can be found in their technical documentations (paragraph 4).

In case of a return transport it must be proceeded as explained in paragraph 3 <Transport>.

2. Safety

These operation instructions contain essential information that has to be observed by assembling, operation and commissioning of the valves.

For this reason, they have to be read by the assembling staff, by the skilled staff and by the operator before the valve is assembled and put into operation and they should always be kept in the proximity of the valve.

Not only the general safety rules indicated in this main paragraph have to be observed, but also the other ones indicated in other paragraphs.

2.1 Indication of notes in the operation instructions

The safety warnings contained in this operation instruction, which have to be observed in order to avoid injuries to persons, are indicated by the following general and particular picot-graphs:

Warning!

Security signal acc. to DIN 4844 W 9, beware of the electrical tension!

Security signal acc. to DIN 4844 - W 8

In order to avoid defects of valve efficiency and of its accesso-ries the following warning mark has to be observed:

ATTENTION!

The signs marked directly on the valve (such as DN) have absolutely to be considered and kept in a readable condition.

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2.2 Dangers that can result if safety instruct - tions are not observed.

If the safety instructions are not observed injuries to persons, environment and valve, or system can arise, and the indemnity rights get lost.

In particular the non-observance of the safety notes can cause dangers such as:
- Break down of important functions of the valve or unit
- Failure of prescribed methods of commissioning and handling
- Danger to persons caused by electrical, mechanical and chemical impacts.
- Environmental injuries caused by a leakage of dangerous materials.

2.3 Working with safety consciousness

The safety instructions included in this paper, the national regulations for prevention of accidents, as well as the internal regulations referring to work, operation and safety have to be observed by the operator.

2.4 Safety instructions for the operator / user

- When ever some hot or cold valve parts (f. ex. Casing parts or handwheel) may cause any danger, these parts have to be constructed in a way that they are protected from contacts.
- The contact protection for moving parts (such as coupling) must not be taken away while the machine is working.
- Leakages (f. ex. in spindle gaskets) of dangerous conveyed materials (explosive, toxic, hot) have to be removed in a way that no danger to persons or environment can arise. Legal determinations must be respected.
- Injuries by electrical energy have to be excluded (please find details to this point in the VDE and local power supply enterprise regulations).

2.5 Safety instructions for commissioning, inspection and assembly works.

It must be provided that all commissioning, inspection and assembly works are executed by skilled staff, who must have previously studied these operation instructions.

Basically, when any kind of work on a valve is executed, the valve has to be cooled down and free of pressure and the evaporation temperature of the medium must be lower than the temperature of all parts it gets in contact with.

Also, basically, works on a valve have to be executed when it is stopped. The procedure to stop a valve operation is described in this paper and has absolutely to be observed.

Valves which get in touch with health injuring media have to be decontaminated.

Immediately after the work is done, all safety and protection devices have to be put into position or operation again. Before putting the valve into operation again, the points referring to paragraph 6 <putting into operation> have to be observed.

2.6 Arbitrary reconstruction and manufacture of spare parts

Reconstructions or modifications of the valve are only acceptable under agreement with the manufacturer. The use of original spare parts and by the manufacturer authorized accessories promotes safety. If any damage is caused by using other parts the liability for the consequences can be cancelled.

2.7 Inadmissible operation modes

A safe operation is only guaranteed if the valve is used according to the determinations included in the „generalities"of this operation instruction. The limits included in the technical documentation must not be exceeded.

3. Protection, Transport, and storage

3.1 Corrosion protection

3.1.1 Carbon steel valves

Valves made out of unalloyed or low alloyed cast steel are painted with a hard-sticking primer made of a 2-components color based on epoxy resin paint. The minimum film thickness is 70 µm. The inner surfaces are free of paint and only coated with a temporary corrosion protection (e.g. oil). Machined flange facings are protected against outside influences with a strippable vanish.

3.1.2 Stainless steel valves

Valves made out of stainless steel will be delivered without coating.

3.2 Transport

The valves are delivered in a closed condition and its connecting holes are shut up by cover caps.

Valves will be supplied as ready for operation.

ATTENTION! During transportation and storage valve have to be closed. Connecting holes have to be shut up by suitable means (cover caps, foils) in order to avoid any damage to the valve seats.

ATTENTION! In order to avoid damages the valves must not be hanging on the handwheel, or on a possible connected motor or on any other accessory.

Valve weights are indicated in the corresponding manufacturer documents (type sheets ☞ paragraph 4.1 <corresponding documents> acknowledgement)

After delivery, respectively before assembly the valves have to be inspected in order to exclude any transportation damage.

3.3 Storage

The storage has to be effected in a way that it can work perfectly even after a longer storage period.

For this purpose, it is necessary.
- To keep the valve closed (in order to protect the seat facings)
- To take measures against soiling (dust, sand, mortar, respectively building materials), frost and corrosion using plastic foils.

When storing valves with soft gaskets (of elastomer) the storage regulations for elastomer (DIN 7716) have to be observed:
- The store must be dry, free of dust and moderately ventilated. Store temperature should not go over 25°C.,
- stocks on hand have to be used up in order to avoid long storage periods,
- As already mentioned above, the valves have to be in "closed" position during the storage.
- However, the soft closure elements should be shut with little power, in order to avoid a rush aging of the elastomer.

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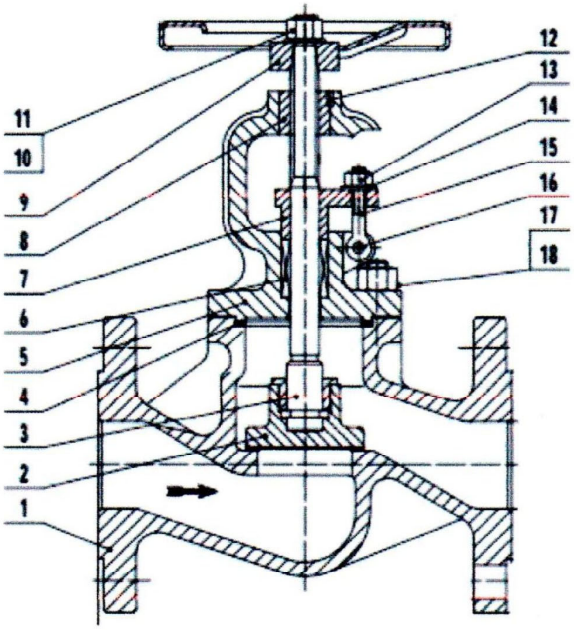
4. Description / documents

The following pictures represent some examples for the principle valve construction. Pictures and information referring to particular construction series can be found in the corresponding type sheets.

4.1 General view: documents

4.1.1 Globe valve with packing

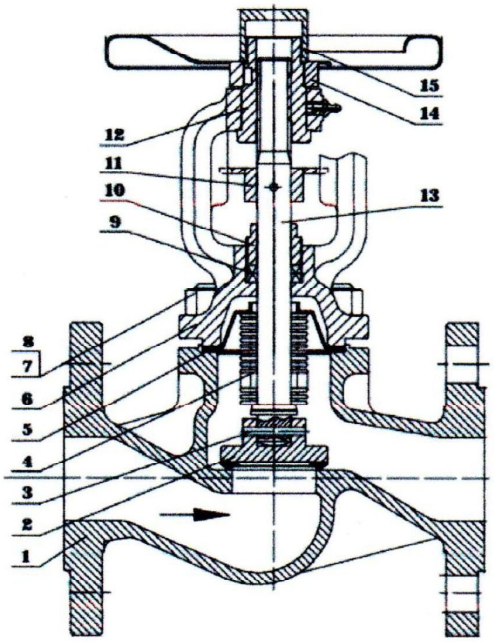
bolted bonnet,
outside screw and yoke,
rising stem,
rising handwheel,
stem seal stuffing box,
back seat,
flanges acc. to EN 1092-1,
facing acc. to EN 1092-1
length acc. to EN 558, R1



Pos.	Benennung	Designation	Material	WNr./DIN
1	Gehäuse	body	GP240GH+N	1.0619N
1.1	Dichtfläche gehäuse	body seat	Stellit	/
2	Kegel	disk	GP240GH+N	1.0619N
2.1	Dichtfläche Kegel	disk seat	13% Cr	/
3	Spindel	stem	X20Cr13	1.4021
4	Dichtung	gasket	graphite/SS	/
5	Bügelaufsatz	yoke	GP240GH+N	1.0619N
6	Packung	packing	graphite	/
7	Stopfbuchsbrille	gland flange	GP240GH+N	1.0619N
8	Gewindebuchse	threaded bush	GJS-400-15	0.7040
9	Handrad	handwheel	C-stahl	1.0036
10/11	Handradmutter	handwheel nut	C35E	1.1181
12	Splint	Lock bolt	/	1.1181
15	Klappschraube	hinged screw	25CrMo4	1.7218
17	Gewindebolzen	stud bolt	25CrMo4	1.7218
18	Skt.-Mutter	hexagon nut	25CrMo4	1.7218

4.1.2 Globe valve with bellow seal

bolted bonnet,
outside screw and yoke,
rising stem,
non rising handwheel,
bellow seal
safety stuffing box
back seat,
flanges acc. to EN 1092-1,
facing acc. to EN 1092-1
length acc. to EN 558, R1



Pos.	Benennung	Designation	Material	WNr./DIN
1	Gehäuse	body	GP240GH+N	1.0619N
1.1	Dichtfläche gehäuse	body seat	Stellit	/
2	Kegel	disk	GP240GH+N	1.0619N
2.1	Dichtfläche Kegel	disk seat	13% Cr	/
3	Splint	Lock bolt	X20Cr13	1.4021
4	Faltenbalg	bellow	/	1.4401
5	Dichtung	gasket	graphite/SS	/
6	Bügelaufsatz	yoke	GP240GH+N	1.0619N
7	Gewindebolzen	stud bolt	25CrMo4	1.7218
8	Skt.-Mutter	hexagon nut	25CrMo4	1.7218
9	Packung	packing	graphite	/
10	Stopfbuchsmutter	gland nuts	GP240GH+N	1.0619N
11	Anzeige Vorrichtung	position indicator	C-steel	/
12	Gewindebuchse	threaded bush	GJS-400-15	0.7040
13	Spindel	stem	X20Cr13	1.4021
14	Handrad	handwheel	C-stahl	1.0036
15	Handradmutter	handwheel nut	C35E	1.1181

4.3 Function mode

4.3.1 Globe Valve with packing

Globe valves consist of the pressure leading parts: body, yoke and working unit.

Body and bonnet yoke are connected by the stud bolts and hex. nuts and are sealed up outside by the gasket.

The closure unit consist essentially of:

- in globe valves with disk, stem and the driving element handwheel.

The passage of the stem through the yoke is sealed up by a packing ring which is tighten by nuts with the stuffing box glands.

The seal seats of body and disk are of rustproof materials.

4.3.2 Globe valve with bellows and Safety stuffing box

Globe valves consist of the pressure-loaded parts, body and yoke attachment, as well as the functional unit.

The body and yoke are connected by stud bolts with nuts. The bellows insert is clamped with the bellow seal house between the body and the yoke attachment and sealed to the outside with the flat seals.

The functional unit essentially consists of:

Bellows insert and actuating element [handwheel]. The cone is rolled onto the spindle and is movable. The bellows is welded to the cone and the washer.

The functional unit is primarily sealed by the Bellows insert with the flat seal. If the bellows is damaged, the valve is also sealed by the secondary sealing system [flat gasket and stuffing box packing]. The stuffing box packing is tightened using a stuffing box nut.

The sealing surfaces of the body seat and cone are made of stainless materials.

4.4 Applications limits

ATTENTION! Depending on the materials the pressure temperature graduations (rating tables) of the respective materials are to be taken in consideration. Moreover, application is limited depending on the choice of the seal material and it is influenced by the material combination of the connecting elements (bolts and nuts).

4.5 Alternatives / accessories

4.5.1 Globe Valve with packing

Stem sealing:

a) Stuffing box with lantern and testing and flushing connection

b) Spring loaded stuffing box (centralized or decentralized set of springs)

- Regulating cone
- Relief cone (from DN125 PN40)
- Isolation extension
- Position indicator
- Stem extension
- Extended bonnet
- Heating Jacket

4.5.2 Globe Valve with bellow seal

- Regulating cone
- Relief cone (from DN125 PN40)
- Isolation extension
- Position indicator
- Stem extension
- Extended bonnet
- Heating Jacket

5. Installation

5.1 Generalities

ATTENTION! The pipeline has to be installed in a way that injurious shearing and bending forces during installation and activity are kept away from the valve bodies (1). This is to avoid leakiness and destruction of the body.

ATTENTION! Before installation the cover caps have to be removed from the connecting holes.

The flange facings must be clean and undamaged.

The flange gaskets must be well centralized.

Only bolts and gaskets of admissible materials may be used. For the flange connection all flange drill holes have to be used.

When varnishing the pipelines, no bolts and nuts, stems, stuffing boxes and accessories must be painted (function affects). During any construction work the valves have to be protected from dust, sand and any other construction material. (Please cover with suitable means).

Valve hand wheels, by-passes and all other adjacent parts must not be used as steps.

Valves and pipelines working in high temperatures (>50°C) or low (<0°C) must be protect from touch by insulating. Alternatively, the danger must be indicated by warning boards on the valve side.

ATTENTION! If in air-conditioning, cooling and refrigerating systems any condensation water, respectively danger of icing appears, a specialistic and diffusion-tight insulation of the whole valve, if necessary, including the handwheel, has to be provided.

Icing causes a blocking of the valve operation capabilities.

If a globe valve is mounted in a pipeline as an end valve it has to be secured by convenient measures from an unauthorized or unintended opening. It can also be shut by a blind flange on the exit side, in order to prevent any injury to parts and / or persons.

5.2 Installation position

All spindle-operated valves are designed so that
Turn the handwheel to the right "Close" and to the left
rotations cause the shut-off element to "open".
For globe valves, the installation position in relation to the spindle any direction. However, the fittings are preferred
vertical spindle pointing upwards.
Shut-off valves are normally installed in such a way that the pressure
serve from the underside of the cone.

If the limits listed in the table below are exceeded
led differential pressures in the closed state, the
Valves designed with a relief cone.
The valves are so installing the pipeline so that the pressure of the medium increases weighs on the cone.

DN	65	80	100	125	150	200	250	300
Δp (bar)	110	70	44	33	21	14	9	6

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5.3 Avoiding excessive pressures

FROMME Armaturen are generally only suitable for operating conditions that are shown in the associated pressure / temperature tables. Appropriate measures must be taken to ensure that there are no impermissible loads on the fittings, the arrangement in the pipelines or unfavorable operating conditions.

Should it e.g. in terms of system technology or because of the mode of operation, that the heated medium enclosed in the third valve room when the valve is closed causes an impermissibly high pressure, the system planner or operator must provide appropriate safety devices such as provide a pressure relief hole or the like.

5.4 Welding instructions / pipeline assembly

For welding works on the valves, the pipeline manufacturer is responsible.

ATTENTION! Whenever the valves are welded with butt welding ends or socket weld ends and the pipeline is welded with valves that are already installed (pipeline assembly), it has to be taken care that no impurity get inside of the body or even stay there, otherwise the seat facings and the stem thread can be damaged.

ATTENTION! During welding works valves have to be as wide open as to exclude any contact between the sealing parts, otherwise the seats can get fused.

ATTENTION! If welding works are done in the proximity of soft seal valves, it has to be taken care that the valve is not warmed up over the temperature limit indicated in the type of sheet. (Reason: damage of the seat surfaces.)

ATTENTION! The welding cable (opposite pole) must be attached by no means to any functioning parts of the valve, otherwise scorching can be caused.

The insert depth of valves with socket weld ends has to be observed accordingly to the referring standard. A gap between pipe end and sleeve ground serve as prevention from inadmissible welding seam strain.

5.5 Valves with motor

The rules according to VDE 0100 and VDE 0165 (ex-protection) have to be observed. All electric devices such as adjusters, switch boxes, magnetic valves, end switches, etc., have to be installed in dry rooms and safe from overflow. Tension and frequency have to correspond to the data on the factory label.

5.6 Assembly work

Suitable transport and lifting equipment must be used for the assembly work.

Make sure there is enough space to dismantle / assemble the valve

6. Operation/putting into and out of operation

(see also indications in paragraph 5 <installation>)

6.1 Operation / putting into operation

6.1.1 Generalities

Before putting the valve into operation its material, pressure and temperature data have to be compared with the operation terms of the pipeline.

6.1.2 Operation

Looked at from above the valves can be closed by a clockwise rotation of the handwheel and opened by a counterclockwise rotation. Relative symbols are to be seen on the handwheel top.

ATTENTION! The use of any auxiliary lever to turn the hand- wheel is not admitted. Too big forces could be injurious especially for soft seal valves because their seat seals could be squeezed.

Gate valves are applied in a way that they are either completely open or completely closed.

ATTENTION! When throttling it can happen that a too high noise grows, and an unwanted wear or destruction of the valve is caused by cavitation's.

Eventually appearing shock pressures (water hammer) should not exceed the maximal admissible pressure. Protective measures have to be provided.

The line system of new plants and especially after repair works has to be flushed in order to remove harmful solid matters, respectively bead of weld.

6.1.3 Function check up

The following functions have to be checked up:

The shutting function of the installed valve must be checked up opening and closing it several times.

The stuffing box packing efficiency has to be checked up before the first loading by full operation pressure and temperature. If necessary, the nuts on the stuffing box glands, respectively the stuffing box have to be evenly tightened.

The sealing efficiency of the bolted bonnet connections with the flat seal must be examined after the first loading/warming up of the valve. (Maintenance-free valves too!) If necessary, the bolts connections have to be gently, crosswise and evenly tightened.

ATTENTION! Before tightening the bolts, the gate valve has to be opened by approximately two handwheel turns. (Prevention of tensions).

6.1.4 Valves with actuator

In the case of valves with electric / pneumatic / hydraulic actuators, the travel ranges / forces must be limited.

Electric actuators are to be switched as follows:

- End position "CLOSED": torque-dependent
- End position "OPEN": travel-dependent

6.2 Decommissioning

During periods of standstill, liquids that change their state due to a change in concentration, due to polymerization, crystallization, solidification or the like, must be drained from the line system. The pipe system must be flushed if necessary.

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7. Commissioning / maintenance

7.1 Safety notes

During all commissioning and maintenance works on the valves the following safety notes as well as the general indications under paragraph 2 <safety> must be observed.

ATTENTION! In any case, also in emergency, only suitable spare parts and tools have to be used, otherwise a perfect function is not guaranteed.

7.1.1 Valve disassembly

Before dismounting from the pipeline or before commissioning and repair works are made directly on the valve, more precisely:

- before loosing the bolted bonnet
- before loosing the gland bolts, respectively the stem bushes or the stem nuts
- before opening the yoke top for commissioning the bearing
- before dismounting the bonnet, respectively the yoke
- before disassembling a directly on the yoke connected motor
- before loosing shutting, opening and pressure release threaded plugs
- before removing the ring nut for repair

the valve has to be completely discharged from pressure and has to be cooled up until the evaporation temperature of the medium is lower than all the chambers getting in contact with it. Then any scald can be excluded.

Opening a valve under pressure is a lethal danger!

In case those toxic or easily inflammable mediums are conveyed, or mediums the residues of which in contact with humidity of the air can lead to corrosion damages, the valve has to be drained and flushed, respectively ventilated.

If necessary protecting clothes and protective masks have to be worn.

Due to the installation position the residual liquid possibly remained in the valve have to be drained off and correctly disposed.

Before a possible transportation, the valves have to be carefully emptied and flushed.

7.1.2 Motor dismounting

In case that stray supplied motors (electric, pneumatic, hydraulic) have to be dismounted from the valves, the stray energy supply must be switched out at first and the warnings under paragraphs 2 7.1.1 as well as the motor operation instructions have to be observed.

Actuators with an integrated spring load cannot be dismounted.
Attention: prestressed springs!

For any further information please contact Fromme Armaturen

7.2 Maintenance

The valves are constructed in almost all their parts maintenance free. Materials for sliding parts are chosen which cause a very minimal wear. In order to improve operation safety and to minimize repair costs, all valves, specially those ones which are seldom put into operation or are hard to get to, should be regularly tested, that means, put into operation (OPEN – CLOSED) at least once or twice a year.

The operator is responsible to determine the convenient test and maintenance intervals depending on the application of the valve.

The durability of maintenance-free valves and not can be extended if:

- the stem and stuffing chamber surfaces are kept clean and undamaged;
- the mobile parts, such as stems and stuffing box bolts are greased (except oxygen valves) by using standard lubricants acc. to DIN 51825;
- the stuffing box is punctually additionally packed or the packing is renewed;
- the gasket is punctually renewed;

The safety warnings in par. 2, 7.1 and in par. 8 must be observed.

7.3 Valve mounting

After reassembling and before putting into operation the valves have to be subjected to a strength- and tightness-test acc. to EN 12266

Before assembling the shut-off valve, the contact surface of the seal must always be cleaned, and a new seal inserted.

The cover screws are to be tightened evenly and crosswise.

Tightening torques of the screw connection.

DN	Schrauben / Muttern	Drehmoment Nm
16-32	M10	20-35
40	M12	25-40
50-65	M12	60-80
80-150	M16	100-125
200-250	M20	150-200
300-400	M24	340-410

After reassembly and before commissioning, the valves must be subjected to a tightness and strength test in accordance with EN 12266.

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8. Troubles and their elimination

8.1 Generalities

All repair and maintenance works have to be done with suitable tools and original spare parts.

The safety notes in par. 2 and 7 have to be observed.

8.2 Troubles / Elimination

Leakage of closing device (seat/disk)

In hard sealing valves:

Renew the seat facings of the disc, respectively disk and body by means of suitable grinding devices after bolts have been dismounted. Body and disc respectively disk seat facings must be grinded so long until their facings show a bearing and continuous moulding.

In soft sealing valves:

- renew the wedge sealing ring after the cover screw has been dismounted.

Leakage of gasket

- Tighten up the cover bolts
- Renew the gasket after the bolts have been dismounted.

Before inserting a new packing ring, respectively a new gasket the facings of bonnet and body must be carefully flushed.

ATTENTION! No additional auxiliary sealing means have to be used for sealing rings free of asbestos. For non-sticking coating only means explicitly recommended by the seal manufacturer have to be used.

For any further information please contact Fromme Armaturen.

Leakage of stuffing box packing. (without bellow seal)

- Tighten the stuffing box packing with the nuts to the stuffing box glands, respectively with the stuffing box connections or stem nuts. Hereby it has to be taken care that the friction force does not increase very much.
- Additionally packing the stuffing box: loosen the nuts *and lift the stuffing box glands, respectively loosen the stuffing box connections or stem box.*

Before repacking, the stuffing box chamber has to be carefully cleaned.

Slotted packing rings have to be inserted with the cut located in opposite position between one ring and the other, precisely 120°-180°.

Lifting a valve for installation on horizontal pipelines (examples)

Picture 1

The lifting belts 1 und 2 must be twisted round the body. In order to keep the valve in the shown position and to prevent falling vertically, the two lifting belts should lead to the hook through the handwheel arms.

Picture 2

The lifting belts 1 and 2 must be twisted round the body. Lifting belt 3 serves to hold the valve in horizontal position.

Valves must not be lifted by the handwheel!