

**R-SERIES
TRIM
REPLACEMENT**

REMINGTON VALVE

Severe Service Ball Valves



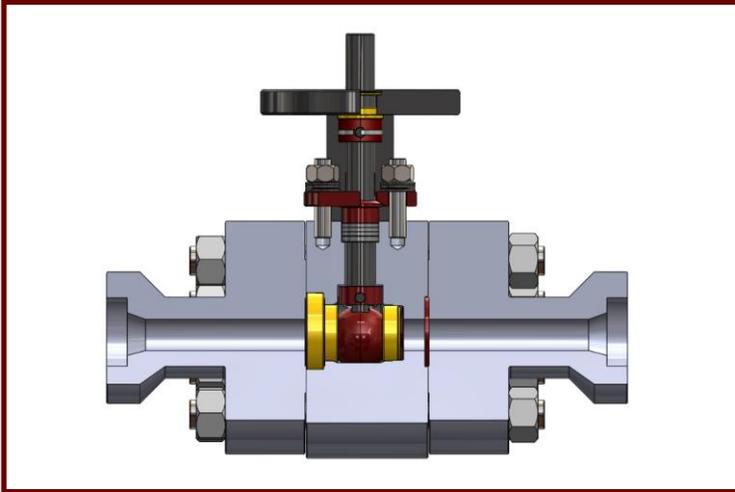
R-SERIES TRIM REPLACEMENT INSTRUCTIONS

Manufactured in Houston, Texas

Made to measure, built to last.

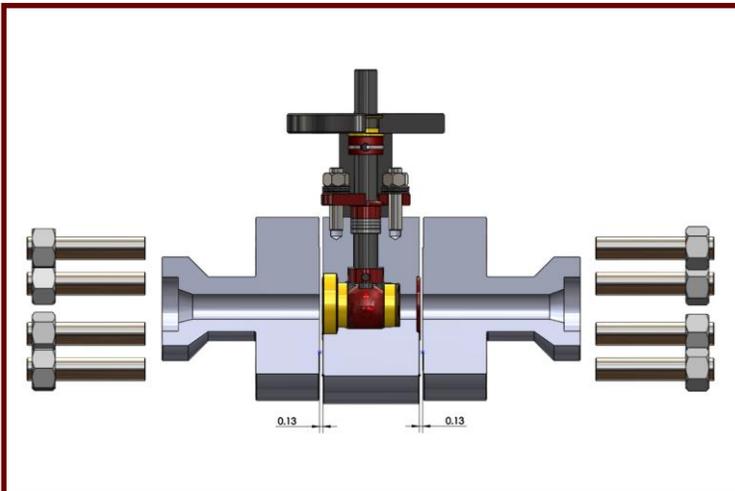
TRIM SET PARTS IN ORDER:

- Gasket • Flanged Seat • Gasket • Ball • Pusher Seat • Spring



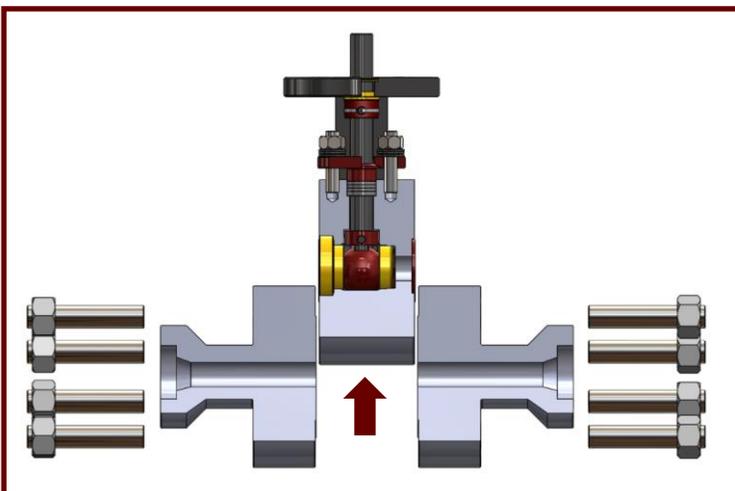
STEP 1:

- Do **NOT** cut installation weld. No need to remove actuation. Place valve in closed position.



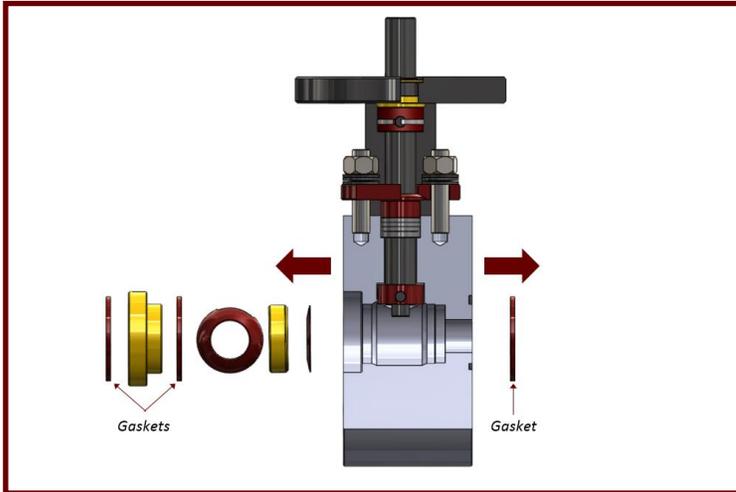
STEP 2:

- Remove body nuts and bolts. Spread the valve 1/8" each side.



STEP 3:

- Lift center section out of the end connections.

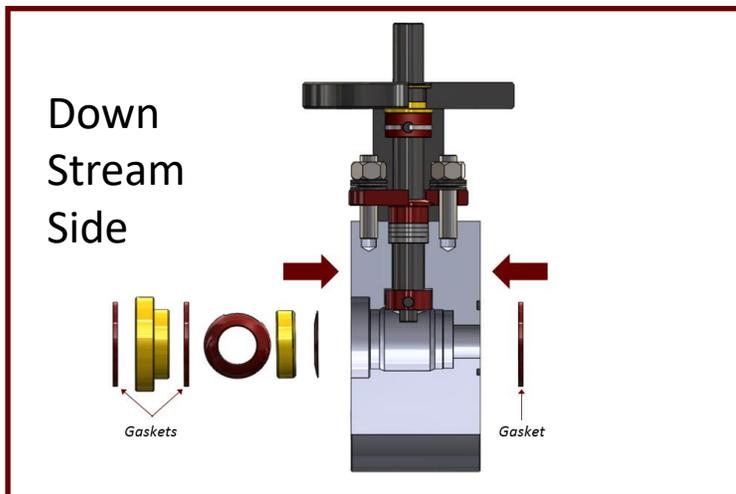


STEP 4:

- Remove trim set and gaskets from the body. Inspect and clean any debris found in the valve.

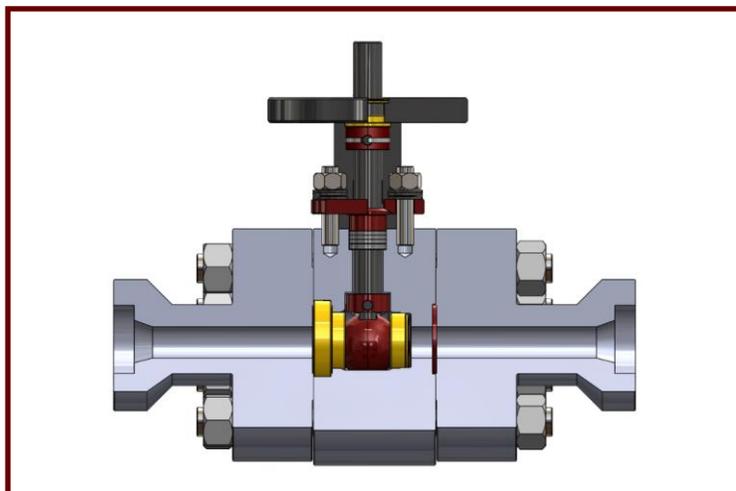
TRIM SET PARTS IN ORDER AS INSTALLED IN BODY:

- Spring • Pusher Seat • Ball • Gasket • Flanged Seat • Gasket



STEP 5:

1. **Spring:** Cone pointing downstream.
2. **Pusher seat:** Insert backwards into the bore allowing to flip over stem inside the valve (Rotate stem if necessary).
3. **Ball:** Place valve in closed position, insert **ball with dot in stem slot facing downstream.**
4. **Gasket:** Insert gaskets on flanged seat.
5. **Flanged Seat:** Insert flanged seat and gaskets into valve.



STEP 6:

- Install center section between flanges with outer gaskets and secure bolting. See bolting torque chart on next page for proper body torques.

Body to End Connect Bolt Torque

Always follow Safety Protocol when torquing bolts. Never adjust bolt torque while valve is in service.

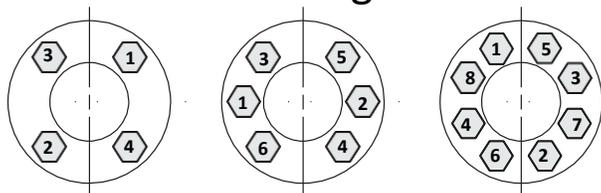
Bolt torque listed below is LUBRICATED using copper-based lubricant. Max nut factor is 0.15.

Gaskets must be seated before starting final loading torque. To seat gaskets, start with 50 lb-ft and increase by 50 lb-ft until body and raised face portion of end connect are in contact (metal to metal). Then proceed to incremental final torque.

Below are listed final torque for Grade b7 and b16 (105 KSI Yield)

| Stud Size | Hex Size | Torque Lb-Ft. | Yield % of bolt |
|-----------|----------|---------------|-----------------|
| 1/2"-13 | 7/8" | 70 | 75 |
| 5/8"-11 | 1-1/16" | 139 | 75 |
| 3/4"-10 | 1-1/4" | 247 | 75 |
| 7/8"-9 | 1-7/16" | 398 | 75 |
| 1"-8 | 1-5/8" | 596 | 75 |
| 1-1/8"-8 | 1-13/16" | 875 | 75 |
| 1-1/4"-8 | 2" | 1,230 | 75 |
| 1-3/8"-8 | 2-3/16" | 1,447 | 75 |
| 1-1/2"-8 | 2-3/8" | 2,203 | 75 |
| 1-5/8"-8 | 2-9/16" | 2,839 | 75 |
| 1-3/4"-8 | 2-3/4" | 3,587 | 75 |
| 1-7/8"-8 | 2-15/16" | 4,456 | 75 |
| 2"-8 | 3-1/8" | 5,455 | 75 |
| 2-1/4"-8 | 3-1/2" | 7,879 | 75 |

Bolt tightening patterns. Final bolt torque should be done in increments on 1/4 until final loading is achieved.



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