

VALVE CHECKING	
DENOMINATION	MATERIAL INSPECTION
BODY	CT / TT / VI / UT / PT
SEAT	CT / TT / VI / UT / PT
NEEDLE	CT / TT / VI / UT
SHAFT	CT / TT
GUIDE BEARING	CT / TT
PISTON	CT / TT / VI
CAM STEM	CT / TT / VI

UT: Ultrasonic Test / CT: Chemical Test / TT: Tensile Test / IT: Impact Test / PT: Penetrant Test / VI: Visual Inspection

All tests according to EN 10204-3.1 certification

TESTS			
FINAL TESTS	PRESSURE	DURATION	VALIDATION
BODY PRESSURE TEST	PN x 1,5 s/ EN 12-266	30 min.	2 flat bottoms (blind flanges) US and DS, obturator opened, maintain stable pressure at PN x 1.5.
LEAK TEST	PN x 1,1 s/ EN 12-266	15 min.	1 flat bottom US, obturator closed, maintain stable pressure at PN x 1.1.
CYLINDER PRESSURE TEST	PN x 1,5	30 min.	Maintain stable pressure during 30 minutes with obturator opened / closed.
PERFORMANCE TEST	Pressure		Operate the valve 3 times with continuous movement and no stops. Verify stroke and opening/closing time.
DIMENSIONAL VERIFICATION	IMS Standard		According to drawing and inspection protocol.
PAINTING VERIFICATION	IMS Standard		Verify leak and adherence (on request).

US: Upstream / DS: Downstream

COATING			
PRE-PREPARATION SURFACES ACCORDING TO ISO	PROCEDURE	COATS	COLOR
WATER CONTACT	POLYAMIDE PRIMER – POLYAMIDE FINISH FIBRE REINFORCEMENT	40 µm + 160 µm	BLACK RAL - 9005
AIR CONTACT	POLYAMIDE PRIMER – POLYURETHANE FINISH	30 µm + 70 µm	BLUE RAL – 5015
OIL CONTACT	POLYAMIDE PRIMER – POLYAMIDE FINISH	40 µm + 30 µm	WHITE
MACHINED SURFACES	TEMPORARY PROTECTION	20 µm	TECTYL-506

SIZES AND PRESSURES RANGE	
ND 50 – ND 500	NP 10 – NP 150
OTHER SIZES AND PRESSURES ON REQUEST	
DESIGN ADAPTED TO ANY DN AND PN VALUE	