

**To:** *Heads of Fisher LP Equipment Distributors*

**From:** Curtis Bagby

**cc:** Jim Griffin, Larry Gidney, Ed Varney, Bryan Steger

**Date:** February 24, 2010

**Subject: PRODUCT SERVICE BULLETIN  
AMMONIA SERVICE OF H722-265, H732-265, H5112-265,  
H531-265, H541-265 AND H822-3, H832-3, H8112-3 SET AT 265 PSIG**

### Background

The relief valves covered by this notice are the Fisher Series H722-265, H732-265, H5112-265, H531-265, H541-265 AND H822-3, H832-3 and H8112-3 set at 265 psig. Fisher has received a small number of relief valves returned for a slow valve seat leak exhibited after use in ammonia service. Valve seat leaks will result in loss of product to atmosphere. Depending upon your customer's specific application, these performance problems could adversely affect their operation or system reliability.

### Action Required

Designate a person in your organization to coordinate this Product Service Bulletin and forward this name to Bryan Steger, phone +1 (214) 491-3420, email [Bryan.Steger@Emerson.com](mailto:Bryan.Steger@Emerson.com)

For valves in your inventory covered by this notice, please notify all your staff that these valves should not be sold into Ammonia service until the o-rings are retrofitted with neoprene o-rings and the valves are marked so they can be identified as being retrofitted. (add an "A" to the label in the serial number pad on H722, H732, H822, H832 valves and after the type number on H5112 and H8112 valves: H5112-265A, per the attached stamping instructions)

Units in the field can be rebuilt by customers with a rebuild kit. The part numbers of the neoprene rebuild kits are H722-NEORB for the H722 and H822-3 valves, H7352-NEORB for the H732, H832-3, H5112 and H8112-3 valves. Fisher will provide these kits free of charge for valves inside the warranty period. **Valves not leaking at this time are not required to be replaced.** To facilitate repair in the field, please place a no charge order for the neoprene rebuild kits. Uninstalled valves may also be





**Fisher LP-Gas Equipment**

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returned to the factory to be retrofitted. To facilitate returns please contact Bryan Steger for an RGA number with the type number, quantity and date of manufacture of valves to be returned for rework.

Orders in backlog at Fisher for valves impacted by this notice are on Engineering Hold until an evaluation is completed. For orders required prior to the hold release of relief valves with a 265 set point, Fisher requests customers to use the ASME approved version of the relief valve with neoprene seat using type numbers, H822N-3, H832N-3 and H8112N-3. During this transition period new pricing will be implemented for these valves per the attached sheet.

We apologize for this situation and appreciate your efforts. If you have any questions, please call Ed Varney at +1 (972) 548-3109, Bryan Steger at +1 (214) 491-3420 or Curtis Bagby at +1 (972) 548-3122.

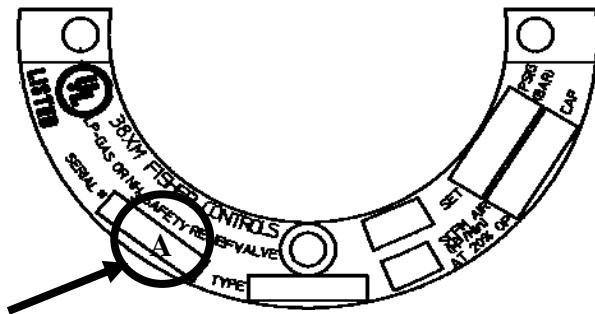
Curtis Bagby  
Vice President  
Fisher LP-Gas Equipment



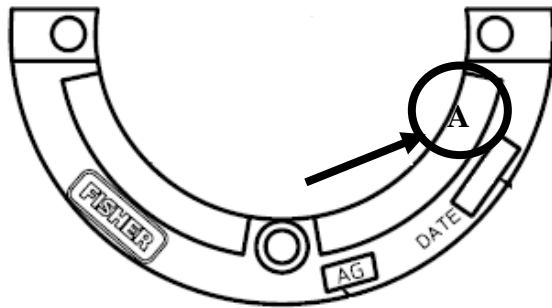
[www.FISHERregulators.com/lp](http://www.FISHERregulators.com/lp)

**Instruction Sheet for Stamping H722-265, H732-265, H5112-265,  
H531-265, H541-265 and H822-3, H832-3, H8112-3 Relief Valves  
Ammonia Product Service Bulletin Stamping Instructions  
February 2010**

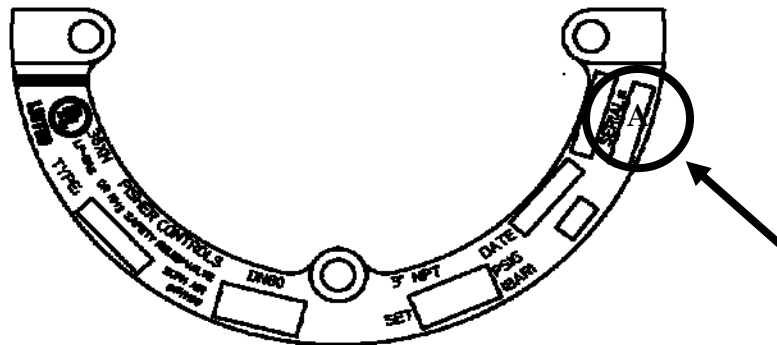
After the relief valve is retrofitted with the new o-rings, the valves should be marked so it can be identified as being retrofitted. On the H722, H822, H732 and H832 relief valves stamp the nameplate on the top of the valve with an "A" in the serial number pad as show in figures below. On the H5112, H8112, H531 and H541 relief valves stamp an "A" after the type number that is stamped on the relief valve body so it looks like this, H5112-265A.



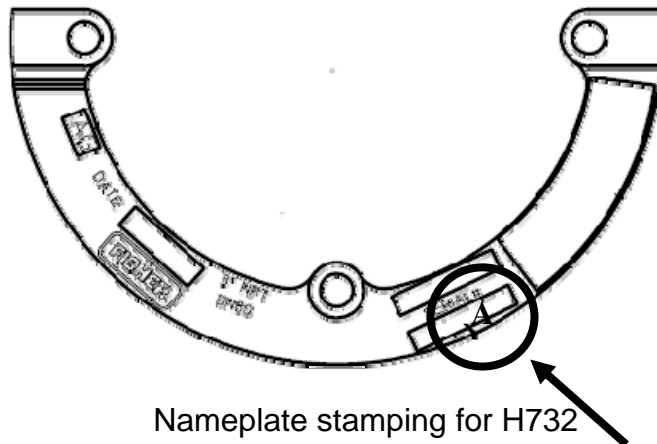
H722 Nameplate Stamping



H822 Nameplate Stamping



Nameplate stamping for H732



Nameplate stamping for H732