Fisher™ 2625, 2625SST, and 2625NS Volume Boosters

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Introduction

Scope of Manual
This instruction manual provides installation, operation, maintenance, and parts information for Fisher 2625 Series (2625, 2625SST, and 2625NS) volume boosters (figure 1). Refer to separate instruction manuals for information regarding the valve body, actuator, and other accessories.

Do not install, operate, or maintain a 2625, 2625SST, or 2625NS volume booster without being fully trained and qualified in valve, actuator, and accessory installation, operation, and maintenance. To avoid personal injury or property damage, it is important to carefully read, understand, and follow all of the contents of this manual, including all safety cautions and warnings. If you have any questions regarding these instructions contact your Emerson sales office before proceeding.

Description
The 2625 and 2625SST are certified for use in Safety Instrumented System (SIS) applications. Certification is by EXIDA Consulting LLC, a global provider of functional safety and control system security. SIS certification is identified on the product by the EXIDA logo on the 2625 nameplate.
The 2625, 2625SST, and 2625NS volume boosters are used in conjunction with a positioner on a throttling control valve to increase stroking speed. The booster has a fixed deadband (controlled by the seat-to-seat dimension of the supply and exhaust plugs) which is factory set during assembly and testing. In addition, the booster incorporates soft-seat construction and an integral bypass restriction to eliminate positioner saturation problems that can occur with volume boosters that do not have these features. Adjustment of the integral bypass restriction is necessary for system stability. This adjustment does not affect the deadband of the booster, but does permit the control valve to respond to small input signal changes from the positioner without sacrificing steady-state accuracy.

It also allows the booster to deliver high-volume output for fast stroking when large, rapid input signal changes occur.

The volume booster is used to improve stroking speed. If precision valve control is required, the use of a positioner is recommended. If the volume booster is used for on/off control, the integral bypass restriction on the volume booster must be closed (turned fully clockwise).

To facilitate diagnostic testing, connectors and piping may be installed with each 2625, 2625SST, and 2625NS volume booster.

The 2625NS volume booster is designed for nuclear power applications. The 2625NS construction includes materials that provide superior performance at elevated temperature and radiation levels.

The O-rings in the 2625NS are EPDM (ethylene propylene) and the diaphragms are EPDM/meta-aramid. EPDM demonstrates superior temperature capability and shelf life over nitrile. The meta-aramid diaphragm fabric demonstrates improved strength retention at elevated temperature and radiation conditions.

**CAUTION**

Use a clean, dry, oil-free air supply with instruments containing EPDM components. EPDM is subject to degradation when exposed to petroleum based lubricants.

Under the 10CFR50, Appendix B, quality assurance program, the 2625NS volume booster is qualified “commercial grade dedicated”. These can be supplied as 10CFR, Part 21 items.

**Specifications**

Specifications for the 2625, 2625SST, and 2625NS volume booster are listed in table 1. Information for an individual unit as it comes from the factory appears on the product nameplate.

**Educational Services**

For information on available courses for 2625, 2625SST, and 2625NS volume boosters, as well as a variety of other products, contact:

Emerson Automation Solutions
Educational Services - Registration
Phone: 1-641-754-3771 or 1-800-338-8158
E-mail: education@emerson.com
emerson.com/fishervalvetraining
### Table 1. Specifications

#### Port Diameters\(^{(1)}\)

<table>
<thead>
<tr>
<th>Supply Port</th>
<th>Exhaust Port</th>
</tr>
</thead>
<tbody>
<tr>
<td>9.5 mm (0.375 inch) or 12.7 mm (0.5 inch)</td>
<td>2.4 mm (0.094 inch), 9.5 mm (0.375 inch) or 12.7 mm (0.5 inch)</td>
</tr>
</tbody>
</table>

#### Input Signal

Positioner output

#### Maximum Input Signal Pressure

10.3 bar (150 psig)

#### Input to Output Pressure Ratio

Fixed at 1 to 1

#### Supply Pressure Ranges\(^{(3)}\)

When used in conjunction with a positioner or other pneumatic accessory, always pipe the positioner and booster with one common supply through a Fisher 67D, 67DR, or MR95H regulator (see figure 3). A high-capacity filter, such as the Fisher 262K, should be installed in the supply line to the regulator. Supply pressure also must not exceed the maximum pressure rating of the actuator. Constructions are available in two maximum supply ranges.

- When Normally Used With Diaphragm Actuators: Up to 2.8 bar (40 psig)
- When Normally Used With Piston Actuators: Up to 10.3 bar (150 psig)

#### Nominal Deadband\(^{(4)}\)

Percent of Positioner Output Span\(^{(6)}\):
- 2.4 mm (0.094 inch) exhaust port: 2%
- 9.5 mm (0.375 inch) exhaust port: 3.5%
- 12.7 mm (0.5 inch) exhaust port: 5%

#### Operative Temperature Limits\(^{(3,4)}\)

**2625/2625SST**

- **Standard:** -40 to 71°C (-40 to 160°F)
- **High Temperature:** 0 to 121°C (32 to 250°C)

**2625NS**

- **Low Temperature\(^{(5)}\):** -60 to 65°C (-76 to 149°F)
- **2625S:** -40 to 93°C (-40 to 200°F)

### Maximum Flow Coefficients

See table 2

### Connections

- **Input Signal:** 1/4 NPT
- **Supply and Output Signal:** 3/4 NPT

### Hazardous Area Classification

Complies with the requirements of ATEX Group II Category 2 Gas and Dust

- **Ex h IIC Tx Gb**
- **Ex h IIIC Tx Db**

Maximum surface temperature (Tx) depends on operating conditions

- **Gas:** T4, T5, T6
- **Dust:** T85...T121

Meets Customs Union technical regulation TP TC 012/2011 for Groups II/III Category 2 equipment

### Safety Instrumented System Classification

SIL3 capable - certified by exida Consulting LLC

### Approximate Weight

- **Aluminum:** 2.3 kg (5 pounds)
- **Stainless Steel:** 4.8 kg (10.6 pounds)

### Declaration of SEP

Fisher Controls International LLC declares this product to be in compliance with Article 4 paragraph 3 of the PED Directive 2014/68/EU. It was designed and manufactured in accordance with Sound Engineering Practice (SEP) and cannot bear the CE marking related to PED compliance.

However, the product may bear the CE marking to indicate compliance with other applicable EC Directives.

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1. May be used in any combination.
2. Aluminum 2625 volume booster only.
3. The pressure/temperature limits in this document, and any applicable code or standard limitation should not be exceeded.
4. This term defined in ISA Standard S51.1
5. Low Temperature option only available with CUTR approval.
6. Zero psig to maximum supply.
Table 2. Maximum Flow Coefficients

<table>
<thead>
<tr>
<th>PORT SIZE COMBINATIONS</th>
<th>Supply Port</th>
<th>Exhaust Port</th>
<th>SUPPLY PORT COEFFICIENTS</th>
<th>EXHAUST PORT COEFFICIENTS</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>mm</td>
<td>Inch</td>
<td>mm</td>
<td>Inch</td>
</tr>
<tr>
<td>9.5</td>
<td>0.375</td>
<td></td>
<td>2.4</td>
<td>0.094</td>
</tr>
<tr>
<td></td>
<td>9.5</td>
<td>0.375</td>
<td>9.5</td>
<td>0.375</td>
</tr>
<tr>
<td></td>
<td>12.7</td>
<td>0.5</td>
<td>12.7</td>
<td>0.5</td>
</tr>
<tr>
<td>12.7</td>
<td>0.5</td>
<td></td>
<td>2.4</td>
<td>0.094</td>
</tr>
<tr>
<td></td>
<td>9.5</td>
<td>0.375</td>
<td>9.5</td>
<td>0.375</td>
</tr>
<tr>
<td></td>
<td>12.7</td>
<td>0.5</td>
<td>12.7</td>
<td>0.5</td>
</tr>
</tbody>
</table>

FIELDVUE™ DVC6200, DVC6200 SIS, DVC6200P, DVC6000, DVC6000 SIS, DVC6000P digital valve controllers

FIELDVUE DVC2000 digital valve controller
- Low Pressure Relay
  - 0.13
- High Pressure Relay
  - 0.19

Fisher 3570 valve positioner
- 0.25

Fisher 3582 valve positioner
- 0.25

- 0.37

Installation

**WARNING**
Always wear protective clothing, gloves, and eyewear when performing any maintenance procedures to avoid personal injury.
System damage may result if a volume booster is installed in a way that it can be physically damaged.
Personal injury or system damage may result when service conditions exceed booster or other equipment ratings. Exceeding the pressure specifications in table 1 may cause leakage, parts damage, or personal injury due to bursting of pressure-containing parts or explosion of accumulated gas.
Check with your process or safety engineer for any additional measures that must be taken to protect against process media.

**CAUTION**
Do not use sealing tape on pneumatic connections. This instrument contains small passages that may become obstructed by detached sealing tape. Thread sealant paste should be used to seal and lubricate pneumatic threaded connections.

**Note**
Do not use separate pressure supplies for the volume booster and associated positioner.
The volume booster may not exhaust immediately upon loss of a separate pressure supply. However, if the system is in a transient state at the time of pressure supply loss or if changes to the booster's input signal are sufficient to overcome the deadband, the booster will exhaust.
A loss of a pressure supply (either separate or common) to a 3582 or 3610J positioner will cause the positioners output pressure (booster’s input pressure) to decay.

Always pipe the positioner and the volume booster with one common supply. See figure 3 for typical installation examples. A 67D, 67DR, or MR95H regulator is required to provide sufficient capacity to supply both components. A high-capacity filter, such as the 262K, should be installed in the supply line to the 67D, 67DR, or MR95H regulator.
Mounting

The volume booster is typically nipple-mounted between the pneumatic supply source and the actuator, and may be used with piston or diaphragm actuators. Many actuators require larger casing or cylinder connections and modifications to allow the booster to deliver the higher volume output.

The booster may also be directly mounted to the actuator by using an actuator yoke mounting bracket (see figure 5) or casing mounting bracket.

Pressure Connections

**CAUTION**

Do not use sealing tape on pneumatic connections. This instrument contains small passages that may become obstructed by detached sealing tape. Thread sealant paste should be used to seal and lubricate pneumatic threaded connections.

The input signal connection is 1/4 NPT. The supply and output connections are 3/4 NPT (minimum pipe size recommended for nipple mounting is 1/2 NPT for 2625 and 3/4 NPT for 2625SST). Connections to the volume booster should be made as indicated in figure 2. Connections for two typical applications are shown in figure 3. Ensure that the piping is of proper size to meet the capacity demands of the booster and that you equip the actuator with properly sized input connections.

Figure 2. Volume Booster Sectional View
Diagnostic Connections

To support diagnostic testing of valve/actuator/positioner packages, install connectors and hardware between the 2625, 2625SST, or 2625NS volume booster and the actuator. Typical connector installations are shown in figure 3.

The hardware used includes a 3/4 NPT pipe nipple, pipe tee, and pipe bushings with an 1/8 NPT pipe bushing for the connector. The connector consists of an 1/8 NPT body and body protector.

See separate instructions for diagnostic connections to the positioner.
Supply Pressure

Supply pressure must be clean dry air or noncorrosive gas. A high capacity filter, such as the 262K is recommended for use with the 2625 volume booster.

**CAUTION**

Use a clean, dry, oil-free air supply with instruments containing EPDM components. EPDM is subject to degradation when exposed to petroleum based lubricants.

**WARNING**

If a flammable or hazardous gas is to be used as the supply pressure medium, personal injury, property damage or equipment damage could result from fire or explosion of accumulated gas or from contact with hazardous gas. The optional pipe away vent construction should be used in applications using a flammable or hazardous gas as the supply pressure medium. This option will allow the flammable or hazardous gas to be collected or remotely vented to a safe location.

Exhaust Ports

Exhaust to the atmosphere is through exhaust ports in the side of the unit. Keep the exhaust ports free of any obstructions or foreign materials that might clog them.

The optional pipe away vent construction exhausts though a single 1/2 NPT port on the side of the unit. Remote vent piping can be installed in this port to route the booster exhaust to a desired remote vent or collection location.

Operating Information

The only operating requirement of the volume booster is the adjustment of the bypass restriction for stable actuator performance. Although systems with different characteristics may require different adjusting techniques, the following adjustment procedure is recommended when using the actuator for throttling control.

**Note**

When sizing the booster, select the lowest $C_g$ that will meet the stroking speed specifications. Oversizing the booster in a closed loop may lead to stability problems, thus requiring the bypass to be opened so far that the booster will never operate.

Prior to operation, turn the bypass restriction adjusting screw (figure 2) four turns counterclockwise from the fully closed position. With the actuator in operation, slowly turn the restriction clockwise until the booster operates in response to large changes in the input signal, yet allows small changes to move the actuator without initiating booster operation.

If the actuator is to be used for on-off control, the restriction should be closed (turned fully clockwise).
Principle of Operation

Refer to figures 3 and 2.

Because of the restriction, large input signal changes register on the booster input diaphragm sooner than in the actuator. A large, sudden change in the input signal causes a pressure differential to exist between the input signal and the output of the booster. When this occurs, the diaphragms move to open either the supply port or the exhaust port, whichever action is required to reduce the pressure differential. The port remains open until the difference between the booster input and output pressures returns to within the deadband limits of the booster. With the bypass restriction adjusted for stable operation, signals having small magnitude and rate changes pass through the bypass restriction and into the actuator without initiating booster operation. Both the supply and exhaust ports remain closed, preventing unnecessary air consumption and possible saturation of positioner relays.

Maintenance

⚠️ WARNING

Always wear protective clothing, gloves, and eyewear when performing any maintenance procedures to avoid personal injury.

Maintenance requires taking the volume booster out of service periodically. To avoid personal injury or equipment damage, disconnect or bypass any pressure lines to the booster, and vent any pressure locked in the unit before you begin maintenance.

Check with your process or safety engineer for any additional measures that must be taken to protect against process media.

Diaphragm Assembly Replacement

Key numbers refer to figure 4.

1. Remove the six cap screws (key 15) from the perimeter of the spring case assembly (key 3), and lift off the assembly, taking care you do not lose the input spring (key 8) or the spring seat (key 9).
2. Remove the upper diaphragm (key 6), diaphragm spacer (key 2), diaphragm assembly (key 5), (which includes the lower diaphragm), and the O-rings (key 14). Inspect these parts for damage and replace if necessary.
3. Replace the O-rings (key 14) after coating with lubricant (key 21). Then replace the diaphragm assembly (key 5), diaphragm spacer (key 2), and the upper diaphragm (key 6).

Note

To ensure proper operation of the bypass restriction, make certain that the holes in the diaphragm and the bypass restriction are in line with the holes in the diaphragm spacer (key 2).

4. Install the spring case assembly (key 3) on the upper diaphragm (key 6). Make sure the spring seat (key 9) and the upper spring (key 8) are installed in the spring case assembly (key 3). Press on the bottom of the spring seat with the...
your finger. If the spring seat (key 9) does not move freely in the spring case assembly (key 3), remove the spring seat (key 9), and apply lubricant (key 23). Reinstall the spring seat (key 9) in the spring case assembly (key 3).

**CAUTION**

To avoid damage to the diaphragms, do not overtighten the screws.

5. Replace the six cap screws (key 15) and tighten them in a crisscross manner.

**Valve Assembly Replacement**

**CAUTION**

The distance between the exhaust port seat line on the upper valve (key 7C) and the supply port seat line on the lower valve and stem (key 7B) is critical to ensure the deadband requirements of the volume booster. This distance is set at the factory and is not field adjustable. If replacement is necessary, use the proper factory authorized repair kit listed in the parts section below. All components of the repair kits are factory set and tested and are not field adjustable.

For key numbers refer to figure 4.

**Figure 4. Volume Booster Assembly Drawing**
1. Remove the six cap screws (key 15) from the perimeter of the spring case assembly (key 3) and lift off the assembly, taking care you do not lose the upper spring (key 8) or the spring seat (key 9).

2. Remove the upper diaphragm (key 6), the diaphragm spacer (key 2), the diaphragm assembly (key 5), (which includes the lower diaphragm), and the O‐rings (key 14).

3. Unscrew the valve assembly (key 7) from the body. The seat ring (key 7A) has a 1-1/2 inch hex for removal.

4. Apply lubricant (key 21) to the O‐ring (key 7D), lubricant (key 23) to the lower valve and stem (key 7B), and sealant (key 20) to the thread of the seat ring (key 7A).

5. Install the valve assembly (key 7) into the body (key 1)—making sure the lower valve and stem (key 7B) engages over the lower spring (key 10)—and into the bottom plug (key 4).

6. Install the diaphragm assembly (key 5) onto the upper valve (key 7C).

7. Install the diaphragm spacer (key 2) onto the body (key 1).

---

**Note**

To ensure proper operation of the bypass restriction, make certain that the holes in the diaphragm and the bypass restriction are in line with the holes in the diaphragm spacer (key 2).

---

8. Make sure the O‐rings (key 14) are installed in the diaphragm spacer (key 2) and coated with lubricant (key 21).

9. Install the upper diaphragm (key 6).

10. Install the spring case assembly (key 3) on the upper diaphragm (key 6). Make sure the spring seat (key 9) and upper spring (key 8) are installed in the spring case assembly. Press on the bottom of the spring seat with your finger. If the spring seat does not move freely in the spring case assembly, remove the spring seat, apply lubricant (key 23), and reinstall in the spring case assembly.

---

**CAUTION**

To avoid damage to the diaphragms, do not overtighten the screws.

---

11. Replace the six cap screws (key 15) and tighten them in a crisscross manner.

### Installation of Diagnostic Connections

See figure 3 for part names and order of installation.

1. Before you assemble the pipe nipple, pipe tee, pipe bushings, actuator piping, and connector body, apply sealant to all threads.

2. Turn the pipe tee to position the connector body and body protector for easy access when doing diagnostic testing.
Parts Ordering

Whenever corresponding with your Emerson sales office about this equipment, mention the serial number of the volume booster. This serial number can be found on the nameplate (key 16, figure 4).

⚠️ WARNING

Use only genuine Fisher replacement parts. Components that are not supplied by Emerson should not, under any circumstances, be used in any Fisher instrument. The use of components not manufactured by Emerson may void your warranty, might adversely affect the performance of the instrument, and could cause personal injury and property damage.

Parts Kits

<table>
<thead>
<tr>
<th>Description</th>
<th>Part Number</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>2625</strong></td>
<td></td>
</tr>
<tr>
<td>Repair kits for diaphragms</td>
<td></td>
</tr>
<tr>
<td>[Kit contains keys 5, 6, 13, 14]</td>
<td></td>
</tr>
<tr>
<td>For boosters with 3/32 inch exhaust</td>
<td>R2625D33212</td>
</tr>
<tr>
<td>For boosters with 3/8 inch exhaust</td>
<td>R2625D38012</td>
</tr>
<tr>
<td>For boosters with 1/2 inch exhaust</td>
<td>R2625D12012</td>
</tr>
<tr>
<td>Repair kits for valve assemblies</td>
<td></td>
</tr>
<tr>
<td>[Kit contains key 7]</td>
<td></td>
</tr>
<tr>
<td>For boosters with 3/8 inch supply</td>
<td>R2625V38012</td>
</tr>
<tr>
<td>For boosters with 1/2 inch supply</td>
<td>R2625V12012</td>
</tr>
<tr>
<td><strong>2625SST</strong></td>
<td></td>
</tr>
<tr>
<td>Repair kits for diaphragms</td>
<td></td>
</tr>
<tr>
<td>[Kit contains keys 5, 6, 13, 14]</td>
<td></td>
</tr>
<tr>
<td>For SST boosters with 3/8 inch exhaust</td>
<td>R2625SD3812</td>
</tr>
<tr>
<td>For SST boosters with 1/2 inch exhaust</td>
<td>R2625SD1212</td>
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<td>Repair kits for valve assemblies</td>
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<tr>
<td>For SST boosters with 3/8 inch supply</td>
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<tr>
<td>For SST boosters with 1/2 inch supply</td>
<td>R2625SV1212</td>
</tr>
<tr>
<td><strong>2625 and 2626SST</strong></td>
<td></td>
</tr>
<tr>
<td>Repair kits for springs</td>
<td></td>
</tr>
<tr>
<td>[Kit contains keys 8, 9, 10]</td>
<td></td>
</tr>
<tr>
<td>2.8 bar (40 psig) Maximum Supply</td>
<td>R2625S40012</td>
</tr>
<tr>
<td>10.3 bar (150 psig) Maximum Supply</td>
<td>R2625S15012</td>
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*Recommended spare parts

Parts List (figure 4)

<table>
<thead>
<tr>
<th>Key</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Body</td>
</tr>
<tr>
<td>2</td>
<td>Diaphragm Spacer</td>
</tr>
<tr>
<td>3</td>
<td>Spring Case Assembly</td>
</tr>
<tr>
<td>4</td>
<td>Body Cap</td>
</tr>
<tr>
<td>5</td>
<td>Diaphragm Assembly</td>
</tr>
<tr>
<td></td>
<td>For 2625</td>
</tr>
<tr>
<td></td>
<td>With blocked exhaust</td>
</tr>
<tr>
<td></td>
<td>With 2.4 mm (0.094 inch) exhaust</td>
</tr>
<tr>
<td></td>
<td>With 9.5 mm (0.375 inch) exhaust</td>
</tr>
<tr>
<td></td>
<td>With 12.7 mm (0.5 inch) exhaust</td>
</tr>
<tr>
<td></td>
<td>For 2625SST</td>
</tr>
<tr>
<td></td>
<td>With 9.5 mm (0.375 inch) exhaust</td>
</tr>
<tr>
<td></td>
<td>With 12.7 mm (0.5 inch) exhaust</td>
</tr>
<tr>
<td></td>
<td>For 2625NS</td>
</tr>
<tr>
<td></td>
<td>With 9.5 mm (0.375 inch) exhaust</td>
</tr>
<tr>
<td></td>
<td>With 12.7 mm (0.5 inch) exhaust</td>
</tr>
</tbody>
</table>

Note

Contact your Emerson sales office for Part Ordering information.
Key Description

6* Upper Diaphragm
   For 2625 and 2625SST
   For 2625NS

7* Valve Assembly (includes keys 7A, 7B, 7C, 7D, and 7E)

7A* Seat Ring
   9.5 mm (0.375 inch) supply port
   12.7 mm (0.5 inch) supply port

7B* Lower Valve and Stem
   For 2625 and 2625SST
   For 2625NS

7C* Upper Valve
   For 2625 and 2625SST
   For 2625NS

7D* Valve O-Ring
   For 2625 and 2625SST
   For 2625NS

7E Hex Nut

8 Upper Spring

9 Spring Seat

10 Lower Spring

11 Restriction

12 Hex Nut

13* O-Ring
   For 2625 and 2625SST
   For 2625NS

Key Description

14* O-Ring (2 req'd)
   For 2625 and 2625SST
   For 2625NS

15 Cap Screw (6 req'd)
   Standard
   With 1/2 NPT vent connection

16 Nameplate

17 Drive Screw (2 req'd)

20 Anti-seize sealant

21 Lubricant, silicone sealant

22 Thread locking adhesive, mild strength

23 PTFE petroleum-based lubricant (see note immediately below)

Note
PTFE petroleum-based lubricant is only for use with 2625 and 2625SST.
For 2625NS use a medium grade silicone-based lubricant.

26 Mounting Bracket
   For yoke mounting (see figure 5 and 6)
   For casing mounting (see figure 7)
   (Use two brackets, stacked, for seismic mounting)

Diagnostic Connections

FlowScanner™ diagnostic system hook-up
   Includes pipe tee, pipe nipple, pipe bushings, connector body, and body protector.

   For diaphragm actuator
   For piston actuator

*Recommended spare parts
Figure 5. Volume Booster with Yoke Mounting Bracket

ATTACH THIS SURFACE TO ACTUATOR YOKE

YOKE MOUNTING BRACKET (KEY 26)

Figure 6. Stainless Steel Volume Booster with Yoke Mounting Bracket

YOKE MOUNTING BRACKET (KEY 26)
Figure 7. Stainless Steel Volume Booster with Case Mounting Bracket
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