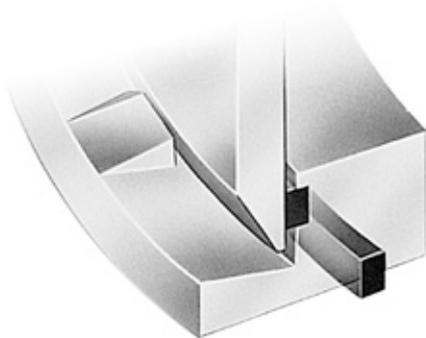




KEYSTONE KNIFE GATE VALVES

FIGURE 952

RTFE and FKM seat replacement instructions for DN 50 - 600 (NPS 2 - 24)
Figure 952 knife gate valves



RTFE seat illustrated

RTFE SEAT REPLACEMENT

Seats are bonded into a groove in the valve body.

1. Cut through seat (4) and remove from valve body using a narrow bladed chisel or screwdriver.
2. Remove all burrs and sharp edges from seat groove in body (1) and ensure it is free of any oil or dirt or bonding residues.
3. With a clean rag or brush, wipe seat groove clean. Then apply Cyberbond bonding agent (2241) in a small (1 mm [$\frac{1}{16}$ "]) continuous bead. Avoid excessive adhesive as it could remain in groove, causing seat to warp or build up on seating face, resulting in valve leakage.
4. Check replacement seat (4) is not damaged and place into groove. Apply pressure to displace excess bonding agent.
5. Wipe off excess adhesive from seating face.
6. Apply a light film of petroleum jelly or lubricant to gate to cover seating face.
7. Insert gate (2) into valve body (1) in the fully closed position so that it covers seat fully.
8. Apply a light clamping pressure (approx. 5 kg (10 lbs) on DN 50 - 200 (NPS 2 - 8) valves and approx. 15 kg (30 lbs) on DN 250 - 600 (NPS 10 - 24) valves) to center of gate ensuring load is applied to total seat surface. Maintain for 1 hour.
9. Remove gate (2) and clean thoroughly.
10. Check seat is even and that no bonding agent residues are on it.
11. Seat fitting is now complete.
12. Refer valve assembly and installation instructions.

FKM SEAT REPLACEMENT

FKM seats are retained in a dovetail groove in the valve body.

1. Cut through seat (4) and remove from valve body using a narrow bladed chisel or screwdriver.
2. Remove all burrs and sharp edges from seat groove in body (1).
3. With a clean rag or brush, wipe seat groove and ensure it is free of any oil or dirt.
4. Check replacement seat (4) is not damaged and place into groove. Check seat is evenly entrapped by the dovetail groove.
5. Seat fitting is now complete.
6. Refer valve assembly and installation instructions.

STORAGE

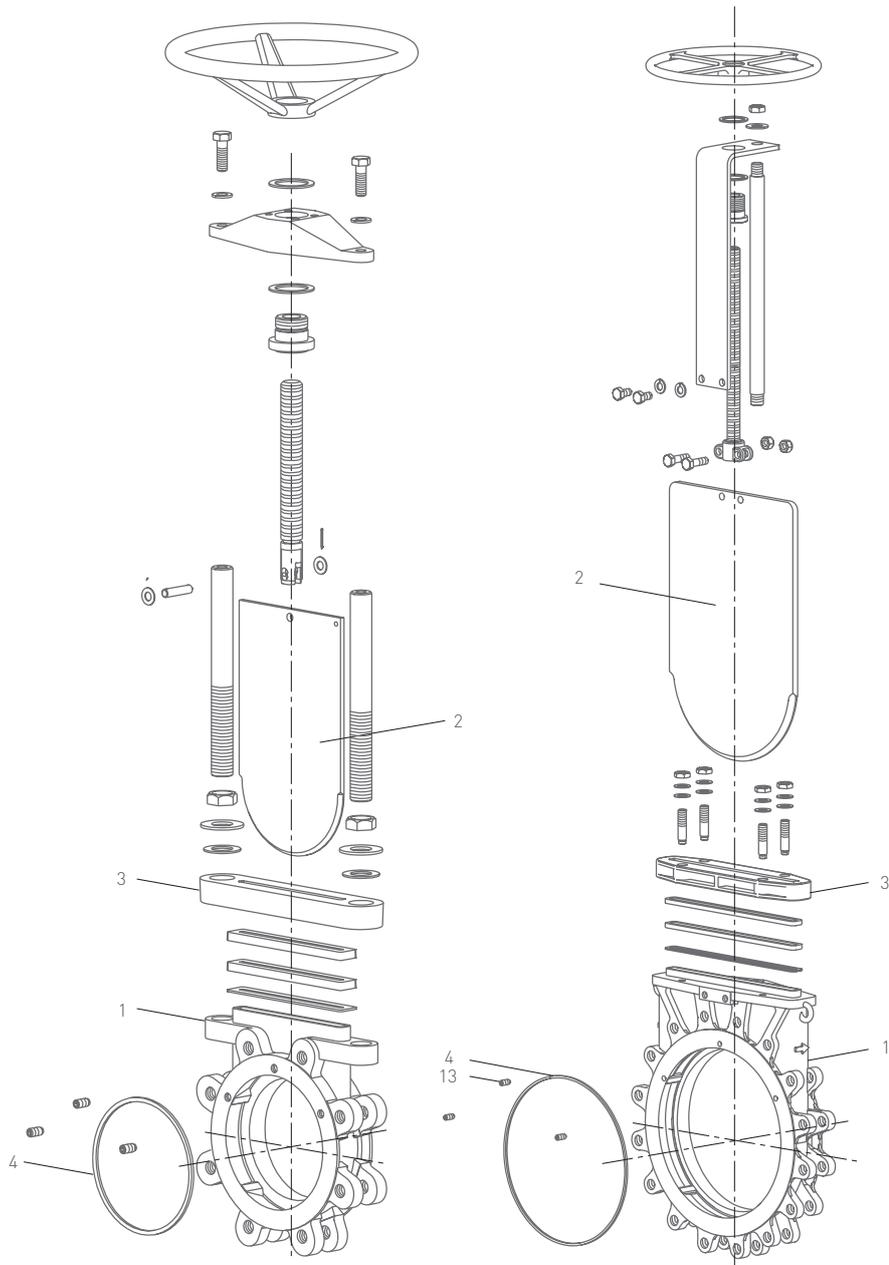
Seats should be stored on a shelf away from sharp or heavy objects that may cause damage.

GENERAL NOTES

If the valve is leaking downstream and seat is damaged or badly worn, it should be replaced. To replace seats the valve needs to be removed from the pipeline and disassembled (refer instructions).

KEYSTONE KNIFE GATE VALVES

FIGURE 952



Note: DN 50 - 200 (NPS 2 - 8) valve illustrated.

Note: DN 250 - 600 (NPS 10 - 24) valve illustrated.

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