

INSTRUCTION MANUAL

Keep this manual in a safe place for future reference

TLV THERMODYNAMIC STEAM TRAPS P SERIES

PowerDyne®

P46SRN / P46SRM
P65SRN



P46SRW



(Option)
BD2

Manufacturer

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Introduction

Before beginning installation or maintenance, please read this manual to ensure correct use of the product. Keep the manual in a safe place for future reference.

The inline repairable P Series steam traps with thermostatic air vent, P46SRN, P46SRM, P46SRW, P65SRN can be used without adjustment for medium capacity applications between 0.03 and 4.6 or 6.5 MPaG (5 and 650 or 925 psig), such as steam mains, tracers and coils. The traps discharge condensate at a temperature slightly lower than saturation temperature.

1 MPa = 10.197 kg/cm², 1 bar = 0.1 MPa

For products with special specifications or with options not included in this manual, contact TLV for instructions.

The contents of this manual are subject to change without notice.

1. Safety Considerations

- Read this section carefully before use and be sure to follow the instructions.
- Installation, inspection, maintenance, repairs, disassembly, adjustment and valve opening/closing should be carried out only by trained maintenance personnel.
- The precautions listed in this manual are designed to ensure safety and prevent equipment damage and personal injury. For situations that may occur as a result of erroneous handling, three different types of cautionary items are used to indicate the degree of urgency and the scale of potential damage and danger: DANGER, WARNING and CAUTION.
- The three types of cautionary items above are very important for safety; be sure to observe all of them, as they relate to installation, use, maintenance, and repair. Furthermore, TLV accepts no responsibility for any accidents or damage occurring as a result of failure to observe these precautions.



Indicates a DANGER, WARNING or CAUTION item.



DANGER

Indicates an urgent situation that poses a threat of death or serious injury.



WARNING

Indicates that there is a potential threat of death or serious injury.



CAUTION

Indicates that there is a possibility of injury, or equipment/product damage.



CAUTION


Install properly and DO NOT use this product outside the recommended operating pressure, temperature and other specification ranges.

Improper use may result in such hazards as damage to the product or malfunctions, which may lead to serious accidents. Local regulations may restrict the use of this product to below the conditions quoted.

DO NOT subject the trap to condensate loads that exceed its discharge capacity. Failure to observe this precaution may lead to condensate accumulation upstream of the trap, resulting in reduced equipment performance or damage to the equipment.

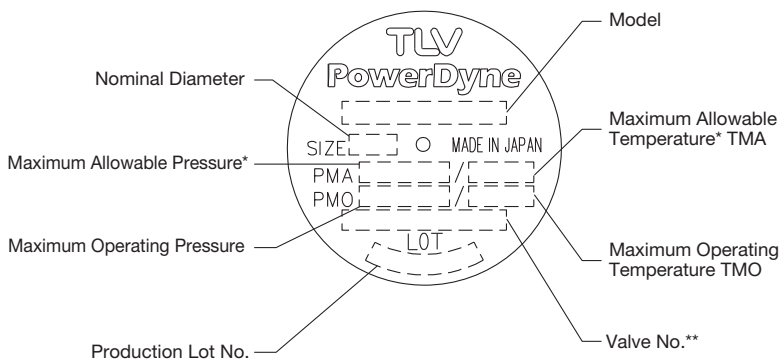
Take measures to prevent people from coming into direct contact with product outlets. Failure to do so may result in burns or other injury from the discharge of fluids.

Continued on next page

 CAUTION	<p>When disassembling or removing the product, wait until the internal pressure equals atmospheric pressure and the surface of the product has cooled to room temperature. Disassembling or removing the product when it is hot or under pressure may lead to discharge of fluids, causing burns, other injuries or damage.</p>
	<p>Be sure to use only the recommended components when repairing the product, and NEVER attempt to modify the product in any way. Failure to observe these precautions may result in damage to the product or burns or other injury due to malfunction or the discharge of fluids.</p>
	<p>Use only under conditions in which no freeze-up will occur. Freezing may damage the product, leading to fluid discharge, which may cause burns or other injury.</p>
	<p>Use under conditions in which no water hammer will occur. The impact of water hammer may damage the product, leading to fluid discharge, which may cause burns or other injury.</p>

2. Specifications

Refer to the product nameplate for detailed specifications.



Minimum Operating Pressure: 0.03 MPaG (5 psig)

Maximum Allowable Back Pressure: 80% of inlet pressure

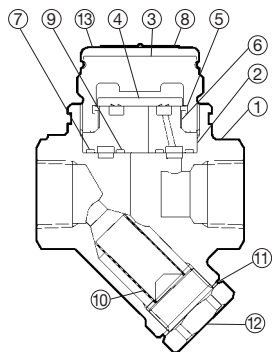
* Maximum allowable pressure (PMA) and maximum allowable temperature (TMA) are PRESSURE SHELL DESIGN CONDITIONS, **NOT** OPERATING CONDITIONS.

** Valve No. is displayed for products with options. This item is omitted from the nameplate when there are no options.



To avoid malfunctions, product damage, accidents or serious injury install properly and, DO NOT use this product outside the specification range. Local regulations may restrict the use of this product to below the conditions quoted.

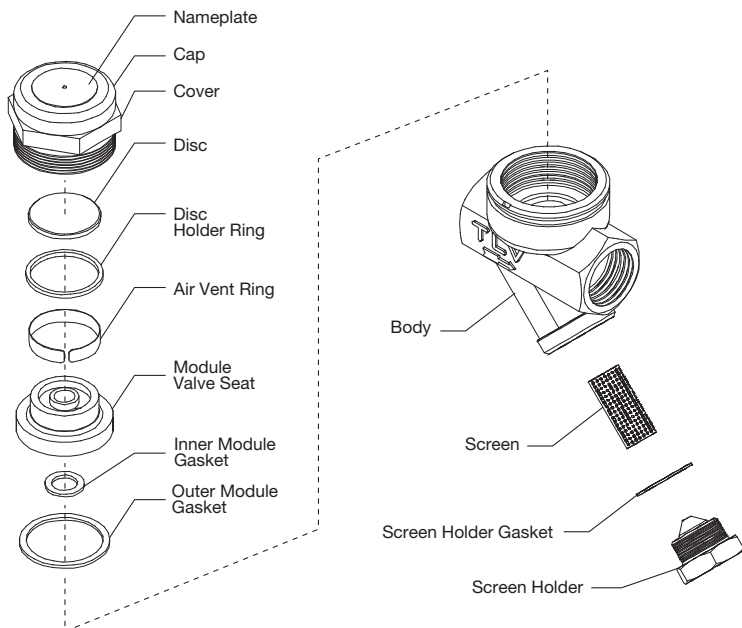
3. Configuration Aufbau Configuration



No.	Description	M*	R*
1	Body		
2	Module Valve Seat		✓
3	Cover		✓
4	Disc		✓
5	Disc Holder Ring		✓
6	Air Vent Ring (Bimetal)		✓
7	Outer Module Gasket	✓	✓
8	Nameplate		✓
9	Inner Module Gasket	✓	✓
10	Screen		✓
11	Screen Holder Gasket	✓	✓
12	Screen Holder		
13	Cap		✓
14	Flange (Not shown)		

* M = Maintenance Kit; R = Repair Kit; replacement parts are available only in their respective kits

4. Exploded View



5. Proper Installation



- Installation, inspection, maintenance, repairs, disassembly, adjustment and valve opening/closing should be carried out only by trained maintenance personnel.
- Take measures to prevent people from coming into direct contact with product outlets.
- Install for use under conditions in which no freeze-up will occur.
- Install for use under conditions in which no water hammer will occur.

NOTE: For socket weld connections, use electric welding with a single pass. As internal parts are not damaged by a single welding pass, there is no need to remove them before welding.

1. Before installation, be sure to remove all protective seals.
2. Before installing the trap, blow out the inlet piping to remove all dirt and oil.
3. The trap can be installed either horizontally or vertically, but make sure the arrow on the trap points in the direction of flow.
4. Install the trap in the lowest part of the pipeline or equipment so that condensate flows naturally into the trap by gravity. The inlet pipe should be as short and have as few bends as possible.
5. Support the pipes properly within 800 mm (2.5 ft) on either side of the trap.
6. Install a bypass valve to discharge condensate, and inlet and outlet valves to isolate the trap in the event of trap failure or maintenance.
7. Install a check valve at the trap outlet whenever more than one trap is connected to the condensate collection pipeline.
8. In order to avoid excessive back pressure, make sure the discharge pipes are large enough; (the outlet back pressure allowance should be no more than 80% of the inlet steam pressure).
9. We recommend unions to facilitate connection and disconnection of the screwed version.

6. Piping Arrangement

Check to make sure that the pipes connected to the trap have been installed properly.

1. Is the pipe diameter suitable, and has sufficient space been secured for maintenance?
2. Has the trap been installed with the arrow on the body pointing in the direction of flow?
3. Have maintenance valves been installed at the inlet and outlet? If the outlet is subject to back pressure, has a check valve been installed?
4. Is the inlet pipe as short as possible, with as few bends as possible, and installed so that the condensate will flow naturally down into the trap?
5. Has the piping work been done correctly, as shown in the table below?

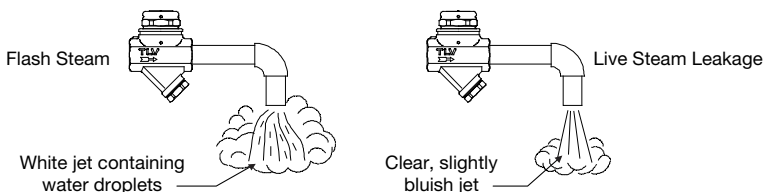
Requirement	Correct	Incorrect
Install a catchpot of the proper diameter.		<p>Diameter is too small.</p>
Make sure the flow of condensate is not obstructed.		<p>Diameter is too small and inlet protrudes into pipe.</p>
To prevent rust and scale from flowing into the trap, connect the inlet pipe 25 - 50 mm (1 - 2 in) above the base of the T-pipe.		<p>Rust and scale flow into the trap with the condensate.</p>
When installing on the blind end, make sure nothing obstructs the flow of condensate.		<p>Condensate collects in the pipe.</p>

7. Operational Check

A visual inspection can be carried out to aid in determining the necessity for immediate maintenance or repair, if the trap is open to atmosphere. If the trap does not discharge to atmosphere, use diagnostic equipment such as TLV TrapMan or TLV Pocket TrapMan (within their pressure and temperature measuring range).

Normal:	Condensate is discharged in a short blast followed by a longer period of no drainage. During the discharge, flash steam may be seen. A small amount of flash steam may be visible after the discharge.
Blocked: (Discharge Impossible)	No condensate is discharged. The trap is quiet and makes no noise. The surface temperature of the trap is low.
Blowing:	Live steam continually flows from the outlet, and there is a continuous metallic sound.
Steam Leakage:	Live steam is discharged through the trap outlet together with condensate, accompanied by a high-pitched sound.
Chattering:	The trap does not close properly. Steam is discharged from the trap in short rapid bursts.

(When conducting a visual inspection, flash steam is sometimes mistaken for steam leakage. For this reason, the use of a steam trap diagnostic instrument such as TLV TrapMan is highly recommended.)



8. Inspection and Maintenance

Operational inspections should be performed at least twice per year, or as called for by trap operating conditions. Steam trap failure may result in temperature drop in the equipment, poor product quality or losses due to steam leakage.



- Installation, inspection, maintenance, repairs, disassembly, adjustment and valve opening/closing should be carried out only by trained maintenance personnel.
- Before attempting to open the trap, close the inlet and outlet isolating valves and wait until the trap has cooled completely. Failure to do so may result in burns.
- Be sure to use the proper components and NEVER attempt to modify the product.

Parts Inspection Procedure	
Body, Cover	Check inside for damage, dirt, grease, oil film, rust or scale
Gaskets	Check for warping or damage
Screen	Check for clogging or corrosion
Disc	Check for damage or wear
Disc Holder Ring	Check for damage or wear
Air Vent Ring	Check for damage or wear
Module Valve Seat Surface	Check for damage or wear

Disassembly / Reassembly (to reassemble, follow procedures in reverse)		
Part & No.	Disassembly	Reassembly
Cover 3	Remove with a socket wrench	Coat threads with anti-seize; consult the table of tightening torques and tighten to the proper torque
Disc 4	Remove being careful not to scratch the polished seat surface	Set on valve seat with the seat surface (the lapped side) facing down toward the valve seat
Disc Holder Ring 5	Remove without bending	Set on the air vent ring and make sure that it does not sit on the valve seat surface
Air Vent Ring 6	Remove without bending, as it will not return to its proper shape	Reinsert without bending
Module Valve Seat 2	Remove being careful not to scratch the polished seat surface	Insert into the body levelly, being careful not to tilt it or to scratch the seat surface
Outer Module Gasket 7	Remove only if worn or damaged; clean the gasket housing	Replace with a new gasket if worn or damaged
Inner Module Gasket 9	Remove only if worn or damaged; clean the gasket housing	Replace with a new gasket if worn or damaged
Screen Holder 12	Remove with a socket wrench	Coat threads with anti-seize; consult the table of tightening torques and tighten to the proper torque
Screen Holder Gasket 11	Remove gasket and clean sealing surfaces	Replace with a new gasket, coat surfaces with anti-seize
Screen 10	Remove without bending	Reinsert without bending

Tightening Torque and Distance Across Flats

Part		Torque		Distance Across Flats	
		N·m	(lbf·ft)	mm	(in)
Cover	P46SRN, P46SRM, P65SRN	250	(185)	46	(1 ¹³ / ₁₆)
	P46SRW	320	(235)	55	(2 ⁵ / ₃₂)
Screen Holder		100	(73)	30	(1 ³ / ₁₆)

NOTE: - Coat all threaded portions with anti-seize.

1 N·m ≈ 10 kg·cm

- If drawings or other special documentation were supplied for the product, any torque given there takes precedence over values shown here.

9. Troubleshooting

If the expected performance is unachievable after installation of the trap, read chapter 5 and chapter 6 again and check the following points for appropriate corrective measures.

Problem	Cause	Remedy
No condensate is discharged (blocked) or discharge is poor	Screen is clogged with rust or scale	Clean
	Air vent ring (bimetal) is broken or worn, causing air-binding	Replace air vent ring
	Disc holder ring is broken or worn, causing air-binding	Replace disc holder ring
	Disc is sticking to valve seat (due to oil, etc.)	Clean
	Steam-locking has occurred	Perform a bypass blow-down, or close the trap inlet valve and allow the trap to cool. Correct piping if necessary.
	Trap capacity is insufficient	Change to trap of suitable capacity
	Differential pressure is low	Study inlet/outlet pressure, including rise in outlet pipe

Continued on next page

Problem	Cause	Remedy
Steam leakage or blowing (from valve seat)	Valve closure is obstructed by scale, etc.	Clean or replace screen
	Disc or valve seat is worn	Replace worn parts
	Air vent ring (bimetal) or disc holder ring is broken, obstructing valve closure	Replace air vent ring or disc holder ring
	Back pressure exceeds allowable value	Use within pressure range
	Trap is being used below minimum operating pressure	Use within pressure range
Valve chattering (Leakage)	Disc is sticking to top of cover (due to oil, etc.)	Clean
	Foreign matter or oil film on disc or valve seat	Clean
	Scratches on disc or valve seat	Replace disc or valve seat
Leakage from a location other than valve seat (via discharge, or from product body)	Disc or valve seat is worn	Replace disc or valve seat
	Bypass valve is damaged or open	Replace or close bypass valve
	Cover is loose or module gaskets are damaged	Tighten cover or replace module gaskets
	Cover is loose or sealing surface between cover and valve seat is damaged	Tighten or replace cover, or replace valve seat
	Inlet and discharge channels may be connected, due to erosion	Replace trap (study trap capacity)
Screen holder is loose or screen holder gasket is damaged	Tighten screen holder or replace screen holder gasket	

NOTE: When replacing parts with new, use the parts list on page 5 for reference, and replace with parts from the appropriate kit. Please note that replacement parts are only available as part of a replacement parts kit.

10. Optional Blowdown Valve BD2

The BD2 Blowdown Valve, installed in place of the screen holder, uses internal pressure to blow out condensate/steam, dirt and scale to the atmosphere.



CAUTION

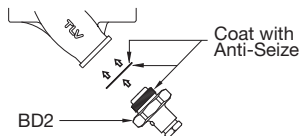
- Installation, inspection, maintenance, repairs, disassembly, adjustment and valve opening/closing should be carried out only by trained maintenance personnel.

- When disassembling or removing the product, wait until the internal pressure equals atmospheric pressure and the surface of the product has cooled to room temperature.
- Do not tighten the BD2 valve or the BD2 valve seat in excess of the appropriate tightening torque. Over-tightening may cause breakage to threaded portions, which may cause burns, other injuries or damage.

10.1 Reassembly of Blowdown Valve

1. Clean the trap, BD2 threads, and sealing surfaces, and apply a small amount of anti-seize.
2. Replace gasket.
3. Carefully place the gasket over the threaded portion, and position carefully so that it does not become off-center.
4. Fasten to the steam trap with the proper torque.

Reassembly Type



Torque (T) and Distance Across Flats (D)

	①	(T): 30 N·m (22 lbf·ft) (D): 17 mm (²¹ / ₃₂ "
	②	(T): 100 N·m (73 lbf·ft) (D): 30 mm (1 ³ / ₁₆ "

10.2 Operation Instructions for BD2

Note: Do not leave the vicinity while the blowdown valve is in the open position.



CAUTION

• Always wear eye protection and heat-resistant gloves when operating the blowdown valve. Failure to do so may result in burns or other injury.

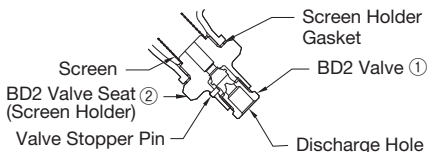
• When operating the blowdown valve, stand to the side well clear of the outlet to avoid contact with internal fluids that will be discharged. Operate the valve slowly and surely, taking care to avoid the area from which internal fluids are discharged and any fluids deflected off piping or the ground etc. Failure to do so may result in burns or other injury.

• Do not excessively loosen the BD2 valve when opening the blowdown valve. The valve stopper pin installed to prevent the BD2 valve from being removed may break and internal pressure may result in the BD2 valve being blown off, leading to injuries, damage and fluid discharge, causing burns.

1. With two wrenches, firmly hold the BD2 Valve Seat (Screen Holder) ② (30 mm, 1 $\frac{1}{16}$ ") in place while slowly opening the BD2 Valve ① (17 mm, $\frac{2}{32}$ ").

Be careful to avoid contact with fluid that will be discharged through the hole in the center of the blowdown valve as the valve opens.

2. Close the BD2 Valve ① and tighten to a torque of 30 N·m (22 lbf·ft), and confirm that there is no leakage. If leakage continues, dirt or scale may prevent the valve from sealing. Open and blow out again, then try to close once more.



11. Instructions for Plug / Holder Disassembly and Reassembly

The seal on the threaded plugs/holders found on TLV products is formed by a flat metal gasket. There are various installation orientations for the gaskets, such as horizontal, diagonal and downward, and the gasket may be pinched in the thread recesses during assembly.

Instructions for Disassembly and Reassembly

① Remove the plug/holder using a tool of the specified size (distance across flats).

② The gasket should not be reused. Be sure to replace it with a new gasket.

③ Clean the gasket surfaces of the plug/holder and the product body using a rag and/or cleaning agents, then check to make sure the surfaces are not scratched or deformed.

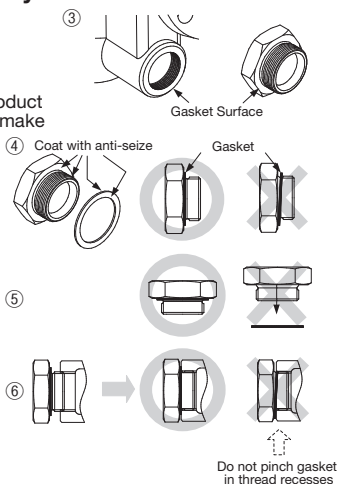
④ Coat both the gasket surface of the plug/holder and the threads of the plug/holder with anti-seize, then press the gasket onto the center of the gasket surface of the plug/holder, making sure the anti-seize affixes the gasket tightly to the plug/holder. Check to make sure the gasket is not caught in the recesses of the threads.

⑤ Hold the plug/holder upside down to make sure that the anti-seize makes the gasket stick to the plug/holder even when the plug/holder is held upside down.

⑥ Screw the plug/holder by hand into the product body while making sure that the gasket remains tightly affixed to the center of the gasket surface of the plug/holder. Make sure the entire gasket is making contact with the gasket surface of the product body. It is important at this point to make sure the gasket is not pinched in the thread recesses of the plug/holder.

⑦ Tighten the plug/holder to the proper torque.

⑧ Next, begin the supply of steam and check to make sure there is no leakage from the part just tightened. If there is leakage, immediately close the inlet valve and, if there is a bypass valve, take the necessary steps to release any residual pressure. After the surface of the product cools to room temperature, repeat the procedure beginning from step ①.



12. TLV® Express Limited Warranty

Subject to the limitations set forth below, TLV Corporation, a North Carolina corporation (“**TLV**”) warrants that products which are sold by it or TLV International, Inc., a Japanese corporation (“**TII**”), which products (the “**Products**”) are designed and manufactured by TLV Co., Ltd., a Japanese corporation (“**TLVJ**”), conform to the specifications published by TLV for the corresponding part numbers (the “**Specifications**”) and are free from defective workmanship and materials. With regard to products or components manufactured by unrelated third parties (the “**Components**”), TLV provides no warranty other than the warranty from the third party manufacturer(s).

Exceptions To Warranty

This warranty does not cover defects or failures caused by:

1. improper shipping, installation, use, handling, etc., by other than TLV or service representatives authorized by TLV; or
2. dirt, scale or rust, etc.; or
3. improper disassembly and reassembly, or inadequate inspection and maintenance by other than TLV or service representatives authorized by TLV; or
4. disasters or forces of nature; or
5. abuse, abnormal use, accidents or any other cause beyond the control of TLV; or
6. improper storage, maintenance or repair; or
7. operation of the Products not in accordance with instructions issued with the Products or with accepted industry practices; or
8. use for a purpose or in a manner for which the Products were not intended; or
9. use of the Products in a manner inconsistent with the Specifications; or
10. failure to follow the instructions contained in the TLV Instruction Manual for the Product.

Duration Of Warranty

This warranty is effective for a period of the earlier of: (i) three (3) years after delivery of Products to the first end user in the case of sealed SST-Series Products for use in steam pressure service up to 650 psig; (ii) two (2) years after delivery of Products to the first end user in the case of PowerTrap® units; or (iii) one (1) year after delivery of Products to the first end user in the case of all other Products. Notwithstanding the foregoing, asserting a claim under this warranty must be brought by the earlier of one of the foregoing periods, as applicable, or within five (5) years after the date of delivery to the initial buyer if not sold initially to the first end user.

ANY IMPLIED WARRANTIES NOT NEGATED HEREBY WHICH MAY ARISE BY OPERATION OF LAW, INCLUDING THE IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE AND ANY EXPRESS WARRANTIES NOT NEGATED HEREBY, ARE GIVEN SOLELY TO THE INITIAL BUYER AND ARE LIMITED IN DURATION TO ONE (1) YEAR FROM THE DATE OF SHIPMENT BY TLV.

Exclusive Remedy

THE EXCLUSIVE REMEDY UNDER THIS WARRANTY, UNDER ANY EXPRESS WARRANTY OR UNDER ANY IMPLIED WARRANTIES NOT NEGATED HEREBY (INCLUDING THE IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE), IS **REPLACEMENT**; PROVIDED: (a) THE CLAIMED DEFECT IS REPORTED TO TLV IN WRITING WITHIN THE APPLICABLE WARRANTY PERIOD, INCLUDING A DETAILED WRITTEN DESCRIPTION OF THE CLAIMED DEFECT AND HOW AND WHEN THE CLAIMED DEFECTIVE PRODUCT WAS USED; AND (b) THE CLAIMED DEFECTIVE PRODUCT AND A COPY OF THE PURCHASE INVOICE IS RETURNED TO TLV, FREIGHT AND TRANSPORTATION COSTS PREPAID, UNDER A RETURN MATERIAL AUTHORIZATION AND TRACKING NUMBER ISSUED BY TLV. ALL LABOR COSTS, SHIPPING COSTS, AND TRANSPORTATION COSTS ASSOCIATED WITH THE RETURN OR REPLACEMENT OF THE CLAIMED DEFECTIVE PRODUCT ARE SOLELY THE RESPONSIBILITY OF BUYER OR THE FIRST END USER. TLV RESERVES THE RIGHT TO INSPECT ON THE FIRST END USER'S SITE ANY PRODUCTS

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Exclusion Of Consequential And Incidental Damages

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Severability

Any provision of this warranty which is invalid, prohibited or unenforceable in any jurisdiction shall, as to such jurisdiction, be ineffective to the extent of such invalidity, prohibition or unenforceability without invalidating the remaining provisions hereof, and any such invalidity, prohibition or unenforceability in any such jurisdiction shall not invalidate or render unenforceable such provision in any other jurisdiction.

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