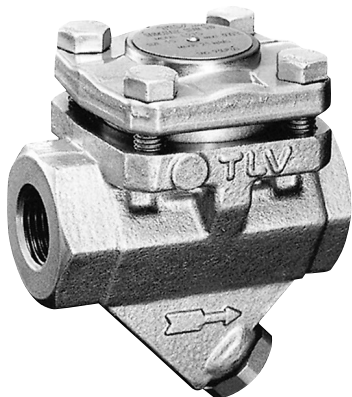


INSTRUCTION MANUAL

Keep this manual in a safe place for future reference

TLV BALANCED PRESSURE THERMOSTATIC STEAM TRAPS L SERIES

L21S L32S
L21SC L32SC



(Option
BD2)

Manufacturer

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EAC



Introduction

Before you begin please read this manual to ensure correct usage of the product. Please keep it in a safe place for future reference.

The L Series steam traps L21S, L32S and L21SC, L32SC with check valve can be used without adjustment for medium capacity applications and pressures up to 2.1, or 3.2 MPaG (300 or 450 psig). These models are suitable for steam-using equipment that discharges condensate at temperatures slightly below saturation temperature, such as tracer lines and light process equipment.


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.
	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.

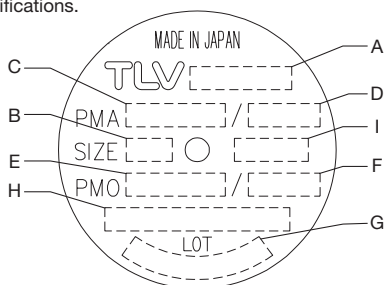
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 CAUTION	<p>Be sure to use only the recommended components when repairing the product, and NEVER attempt to modify the product in any way. Failure to observe these precautions may result in damage to the product or burns or other injury due to malfunction or the discharge of fluids.</p>
	<p>Do not use excessive force when connecting threaded pipes to the product. Over-tightening may cause breakage leading to fluid discharge, which may cause burns or other injury.</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.

- A Model
- B Nominal Diameter
- C Maximum Allowable Pressure*
- D Maximum Allowable Temperature* TMA
- E Maximum Operating Pressure
- F Maximum Operating Temperature TMO
- G Production Lot No.
- H Valve No.**
- I Type of X-element



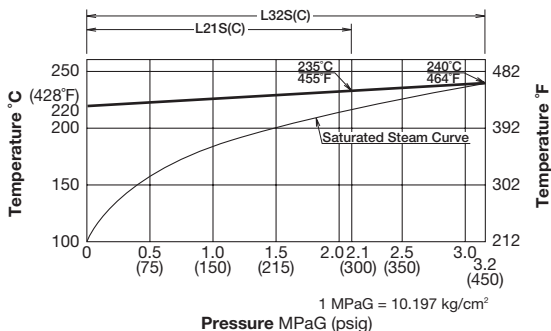
* Maximum allowable pressure (PMA) and maximum allowable temperature (TMA) are PRESSURE SHELL DESIGN CONDITIONS, **NOT** OPERATING CONDITIONS.

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



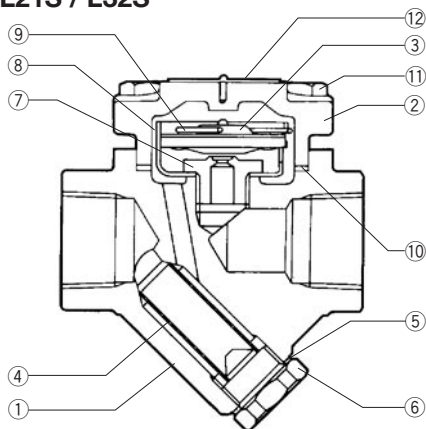
To avoid malfunctions, product damage, accidents or serious injury, install properly and DO NOT use this product outside the specification range. Local regulations may restrict the use of this product to below the conditions quoted.

2.1 Maximum Operating Temperature

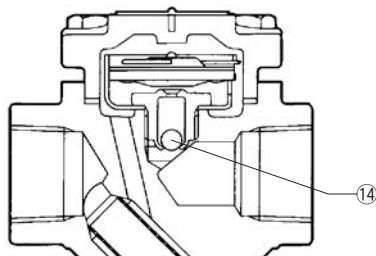


3. Configuration Aufbau Configuration

L21S / L32S



L21SC / L32SC

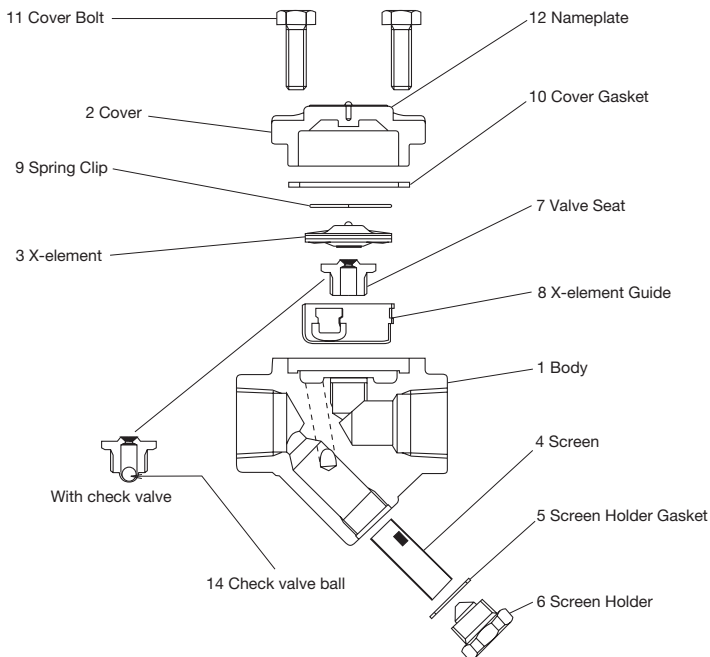


Check valve type

No.	Description	M*	R*	No.	Description	M*	R*
1	Body			8	X-element Guide		✓
2	Cover			9	Spring Clip		✓
3	X-element	✓		10	Cover Gasket	✓	✓
4	Screen	✓		11	Cover Bolt		
5	Screen Holder Gasket	✓	✓	12	Nameplate		
6	Screen Holder			13	Flange (not shown)		
7	Valve Seat		✓	14	Check Valve Ball		✓

* Maintenance Parts and Repair Parts:
 (M) Maintenance Kit, (R) Repair Kit. Replacement parts are available only in their respective kits.

4. Exploded View



Tightening Torque and Distance Across Flats		
Part & No.	N·m (lbf·ft)	mm (in)
Cover Bolt 11	35 (25)	13 (1/2)
Valve Seat 7	35 (25)	19 (3/4)
Screen Holder 6	60 (43)	22 (7/8)

1 N·m \approx 10 kg·cm

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

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.
- Do not use excessive force when connecting threaded pipes.
- Install for use under conditions in which no freeze-up will occur.
- Install for use under conditions in which no water hammer will occur.

1. Horizontal installation (nameplate showing up) is recommended, vertical installation is possible. The arrow on the trap must point in the direction of flow. **DO NOT** install trap on its side or upside down.
2. Before installing the steam trap, blow out the inlet piping to remove all dirt and oil.
3. Install a bypass valve, and inlet and outlet valves for maintenance or trap failure situations.
4. Install the trap in the lowest part of the pipeline or equipment so the condensate flows into the trap by gravity. The inlet pipe should be as short and have as few bends as possible.
5. Install a check valve at the trap outlet of L21S, L32S whenever the condensate discharge pipe leads to a tank or recovery line; or whenever the condensate collection pipeline is connected to more than one trap.
6. Support the pipes within 0.8 meters (2.5 ft) on either side of the trap.
7. In order to avoid excessive back pressure (the outlet back pressure should be no more than 90% of the inlet steam pressure), make sure the discharge pipes are large enough;
8. The use of unions is recommended to facilitate connection of the screwed version.

6. Piping Arrangement

Requirement	Correct	Incorrect
Install a catchpot of the proper diameter.		Diameter is too small.
Make sure the flow of condensate is not obstructed.		Diameter is too small and inlet protrudes into pipe.
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.		Rust and scale flow into the trap with the condensate.
When installing on the blind end, make sure nothing obstructs the flow of condensate.		Condensate collects in the pipe.

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

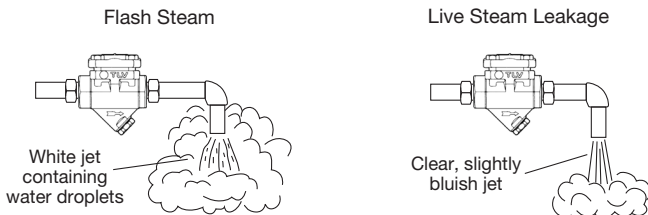
1. Is the pipe diameter suitable?
2. Has the trap been installed with the arrow on the body pointing in the direction of flow?
3. Has sufficient space been secured for maintenance?
4. Have maintenance valves been installed at inlet and outlet? If the outlet is subject to back pressure, has a check valve been installed? (only with L21S, L32S).
5. 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?
6. Has the piping work been done with the proper methods as shown in the table above?

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 measurement range).

Normal:	Condensate is discharged intermittently with flash steam and the sound of flow can be heard.
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 may be a high-pitched whistling sound.
Steam Leakage:	Live steam is discharged through the trap outlet together with the condensate and there may be a high-pitched whistling sound.

(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. Faulty steam traps may result in losses due to steam leakage. Follow the instructions below for disassembly and reassembly when cleaning or repair is necessary.



- 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 isolation valves and wait until the trap has cooled to room temperature. Failure to do so may result in burns or injury.
- Be sure to use the proper components and NEVER attempt to modify the product.

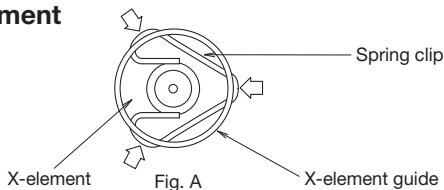
Parts Inspection Procedure	
Gaskets	Check for warping or damage
Screen	Check for clogging or corrosion damage
X-element	Check for rust, scale, oil film, wear or damage
Valve Seat	Check for rust, scale, oil film, wear or damage
Body, Cover	Check inside for rust and scale

Continued on the next page

Disassembly/Reassembly (to reassemble, follow procedures in reverse)		
Part & No.	During Disassembly	During Reassembly
Cover Bolt 11	Use a socket wrench to remove	Coat threads with anti-seize and tighten to the proper torque (page 4)
Cover 2	Lift up the cover and clean the sealing surface	Make sure there are no pieces of old gasket left on the sealing surface and reinstall the cover
Cover Gasket 10	Remove the gasket and clean the sealing surface	Replace with a new gasket, do not apply anti-seize
Spring Clip 9	Use appropriate pliers to squeeze and remove	Use appropriate pliers and insert the spring clip into the slots in the X-element guide (figure A)
X-element 3	Remove from the X-element guide with appropriate pliers grasping the ball at the top of the element	Reinstall, making sure the X-element is not upside down and without catching on the X-element guide
Valve Seat 7	Use a socket wrench to remove	Coat threads with anti-seize and tighten to the proper torque (page 4)
X-element Guide 8	Remove without bending	Fix with Valve Seat and make sure the X-element can be inserted smoothly
Screen Holder 6	Use a socket wrench to remove	Coat threads with anti-seize, then tighten to the proper torque (page 4)
Screen Holder Gasket 5	Remove the gasket and clean the sealing surface	Replace with a new gasket, apply anti-seize to both surfaces
Screen 4	Remove without bending	Insert without bending

Proper Installation of X-element

Install the spring clip securely in the X-element guide as shown.



9. Troubleshooting

If the expected performance is unachievable after installation of the steam trap, read the "Proper Installation" and "Piping Arrangement" chapters again, and check the following table for the appropriate corrective measures to be taken.

Problem	Cause	Remedy
No condensate is discharged (blocked) or discharge is poor	X-element is stuck to the valve seat	Clean
	Valve seat is clogged	Clean
	Screen is clogged with rust or scale	Clean
	Trap operating pressure exceeds maximum specified operating pressure	Study inlet pressure
	Differential pressure is insufficient	Study inlet / outlet pressure
Steam leakage or blow-off	Valve closure is obstructed by rust, etc	Clean (inspect screen as well)
	X-element is worn or damaged	Replace X-element
	Valve seat is worn or damaged	Replace valve seat or cover
	Improper installation	Correct the installation
Leakage from other location	Severe vibration of trap	Reinforce trap piping supports
	Cover is loose or gaskets are worn or damaged	Tighten cover or replace gasket

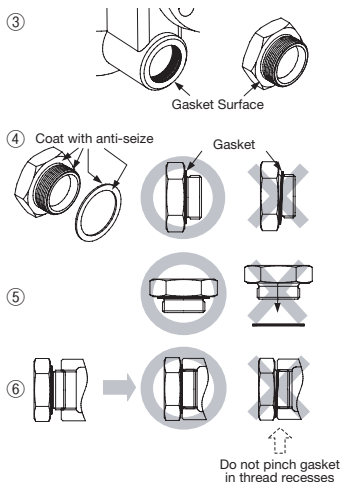
NOTE: When replacing parts with new, use the parts list on page 3 for reference, and replace with parts from the Maintenance Kit or Repair Kit.

10. 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.



11. 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.



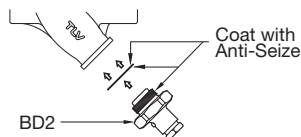
CAUTION

- 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.

11.1 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

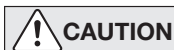


Torque (T) and Distance Across Flats (D)

	① (T): 30 N·m (22 lbf-ft) (D): 17 mm ($2\frac{1}{32}$ "
	② (T): 60 N·m (43 lbf-ft) (D): 22 mm ($\frac{7}{8}$ "

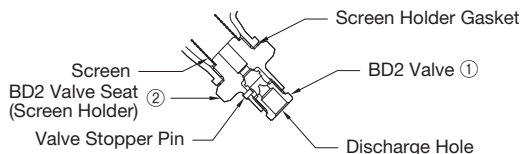
11.2 Operation Instructions for BD2

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 (22 mm, $\frac{7}{8}$ " in place while slowly opening the BD2 valve ① (17 mm, $2\frac{1}{32}$ "). 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.



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, TLV CO., LTD., a Japanese corporation (“TLVJ”) or TLV International, Inc., a Japanese corporation (“TII”), (hereinafter the “Products”) are designed and manufactured by 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), if any.

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 Acts of God; 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. use of the Products with Hazardous Fluids (fluids other than steam, air, water, nitrogen, carbon dioxide and inert gases (helium, neon, argon, krypton, xenon and radon)); or
11. 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 CLAIMED TO BE DEFECTIVE BEFORE ISSUING A RETURN MATERIAL AUTHORIZATION. SHOULD SUCH INSPECTION REVEAL, IN TLV'S REASONABLE DISCRETION, THAT THE

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Exclusion of Other Warranties

THIS WARRANTY IS IN LIEU OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, AND ALL OTHER WARRANTIES, INCLUDING BUT NOT LIMITED TO THE IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE, ARE EXPRESSLY DISCLAIMED.

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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