



WELDING INSTRUCTIONS

VB-20 series

Actuated Ball Valves

07-2020



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WELDING INSTRUCTIONS

VB-20 series

Actuated Ball Valves

1 Open the valve.



2 Remove these bolts.



3 Remove Actuator + Connector.



4 Loosen the remaining bolts.



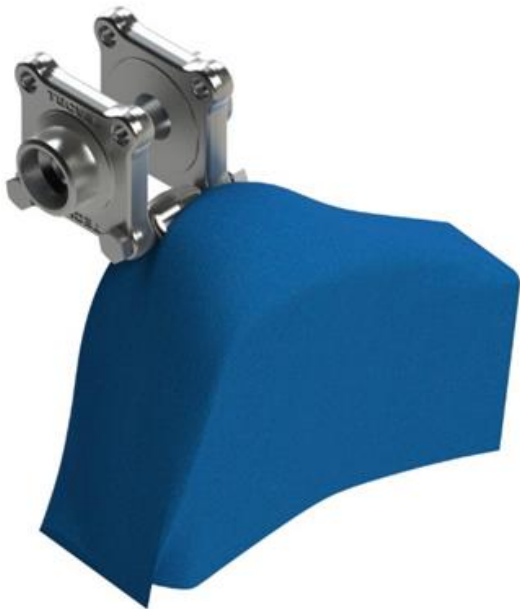
5 Swing out the center body.



6 Remove O'Ring and Seats.



7 Warp center body.



8 Welding.



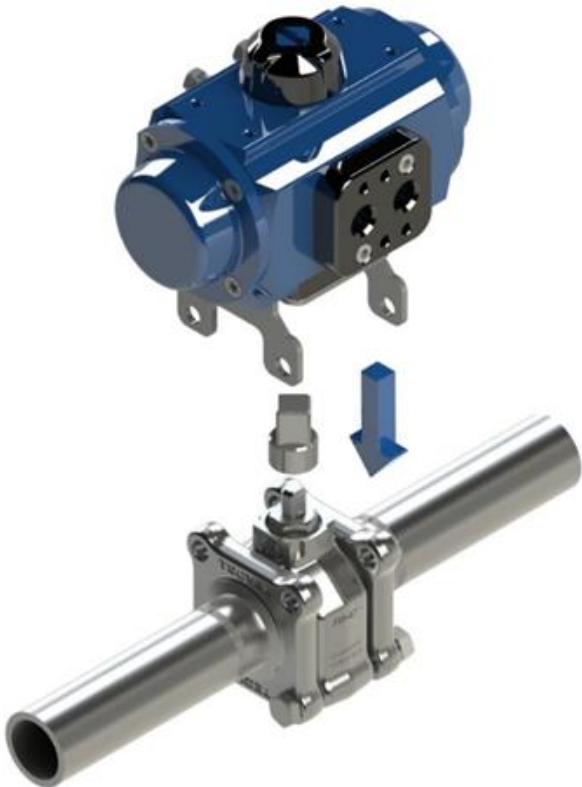
9 Cooling processes. Reassemble O'ring Seat.



10 Swing Back Center Body.



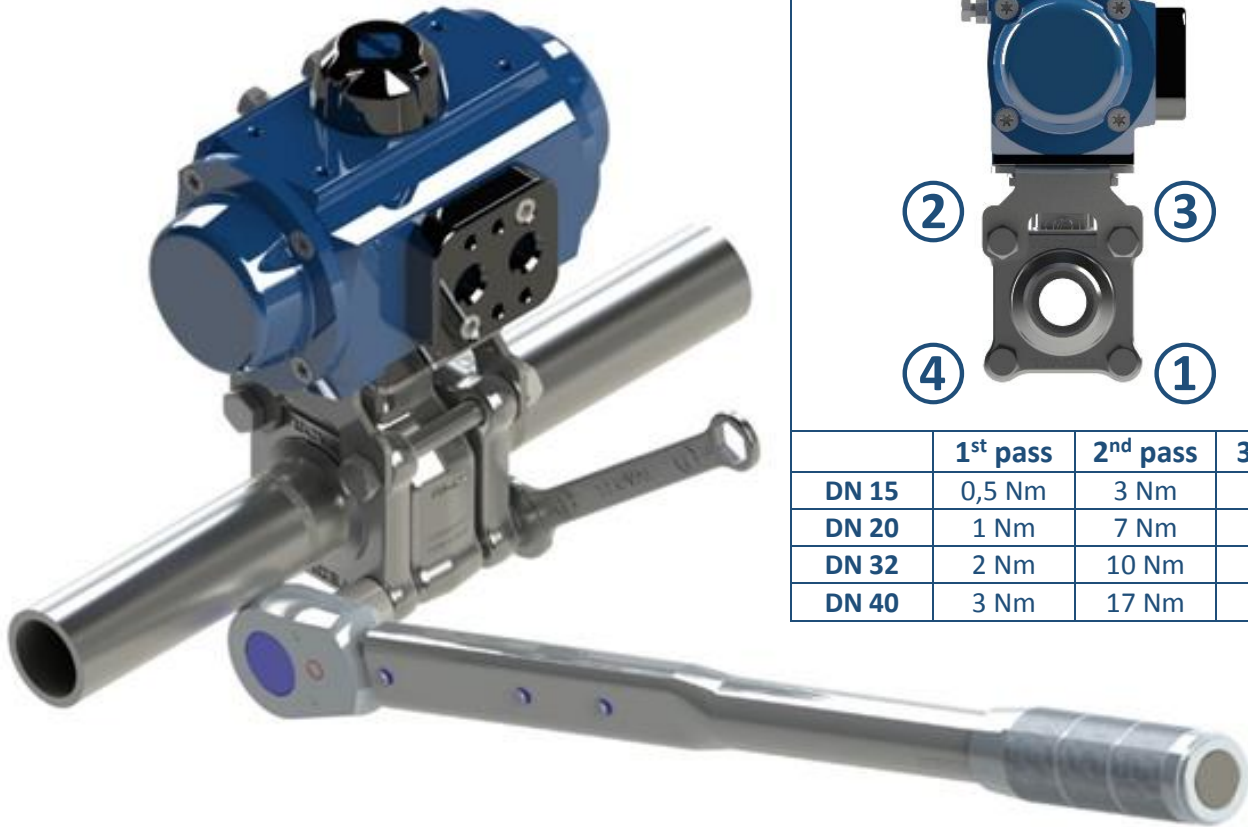
11 Insert Actuator + Connector.



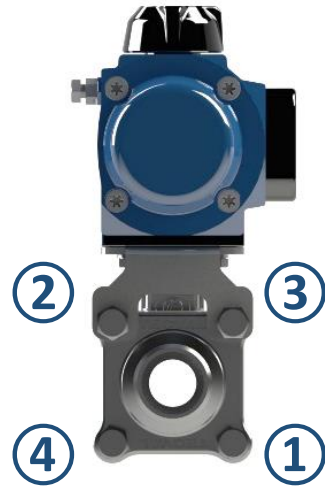
12 Insert Fasteners.



13 Torque body bolts.



Tightening order



	1 st pass	2 nd pass	3 rd pass
DN 15	0,5 Nm	3 Nm	10 Nm
DN 20	1 Nm	7 Nm	25 Nm
DN 32	2 Nm	10 Nm	35 Nm
DN 40	3 Nm	17 Nm	55 Nm