



WELDING INSTRUCTIONS

VB-20 series

Manual Ball Valves

07-2020



www.tecval.es

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WELDING INSTRUCTIONS

VB-20 series

Manual Ball Valves

1 Open the valve.



2 Remove this bolt.



3 Loosen the remaining bolts.



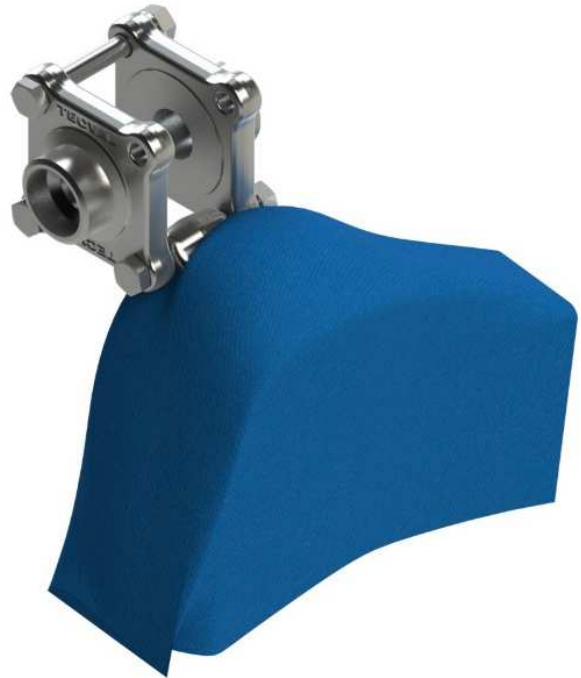
4 Swing out the center body.



5 Remove O'Ring and seats.



6 Warp center body.



7 Welding.



8 Cooling processes. Reassemble O'ring Seat



9 Swing back the center body.



10 Insert bolt.



11 Torque body bolts.



Tightening order



1 st pass	2 nd pass	3 rd pass
0,5 Nm	7 Nm	25 Nm