



WELDING INSTRUCTIONS

VB-20 series

Manual Ball Valves

07-2020



www.tecval.es

C/Berlin, 1 Nave 4 Pol.Can Torrella
08233-VACARISSES
Barcelona (Spain)

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Mr. Joan Viñas (Technical Manager)

Mr. Joan Ferran (General Director)

Mr. Narcís Ferran (Sales Manager)

WELDING INSTRUCTIONS

VB-20 series

Manual Ball Valves

1 Open the valve.



2 Remove this bolt.



3 Loosen the remaining bolts.



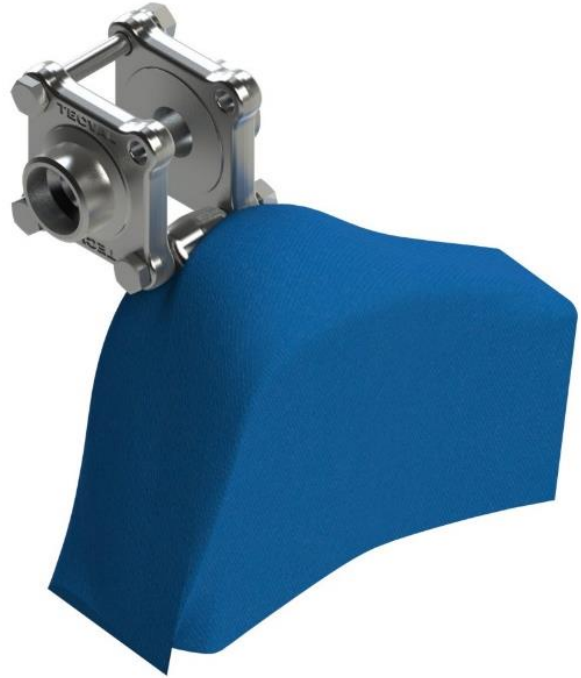
4 Swing out the center body.



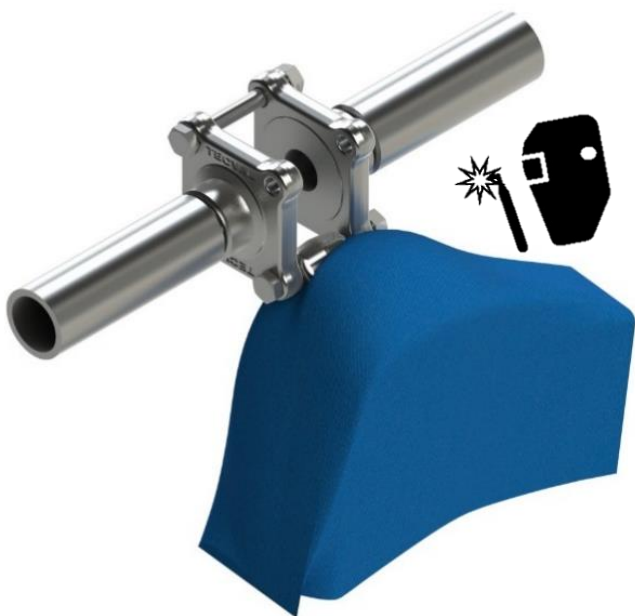
5 Remove O'Ring and seats.



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
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