

REPLACING O-RING SEALS FOR INTEGRAL BONNET O, 1, 18, 20 & 26 SERIES NEEDLE VALVES

MS-INS-FB-OR
July, 1998
CP Revision B

Kit Contents:

- O-Ring(s)
- Lubricant(s)
- Material Safety Data Sheet(s)
- Back-Up Ring
- Instruction Sheet

WARNING: Before servicing any installed valve, you must
 • depressurize system
 • cycle valve

WARNING: Residual material may be left in the valve and system

NOTE: It is important to refer to the exploded view drawing while following the maintenance instructions.

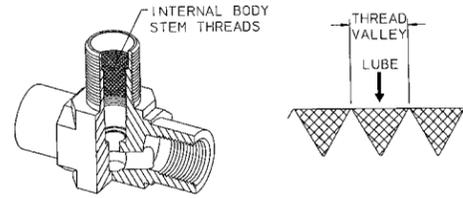
DISASSEMBLY

1. Unscrew the packing nut from the valve body.
2. With the handle, retract the stem from the valve body.
3. Loosen the set screw and remove the handle. Set aside for later use.
4. Remove the packing nut and set aside.
5. Remove the upper gland, back-up ring, o-ring seal and lower gland from the stem. Discard back-up ring and o-ring seal as new ones are provided in kit.
6. Clean all parts thoroughly.

REASSEMBLY

7. Lubricate the internal body stem threads, filling the "valley" of the threads with MS-LT-WL7 or MS-LT-WL13 lubricant as provided. All metal stem tips should be lubricated. Soft stem tips do not need lubricant.

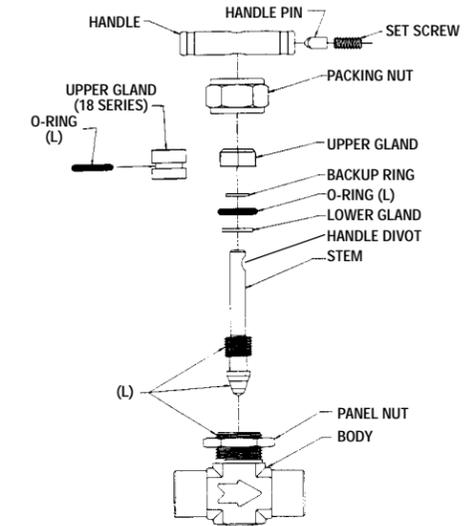
©1994, 1998 Swagelok Marketing Co.



8. Lubricate the top 2 or 3 outer valve body threads with MS-LT-WL7 or MS-LT-WL13 lubricant as provided.
9. Screw the stem into the valve body.
10. Lubricate the o-ring seal(s) with the MS-LT-1 or MS-LT-3 lubricant as provided.
NOTE: For "18" Series assemblies, slide the thinnest o-ring onto the upper gland. Proceed to step #12.
11. Slide the lower gland, o-ring seal, back-up ring and upper gland onto the stem. Push down until the o-ring seal is snug.
12. Finger tighten the packing nut onto the valve body.
13. Place the handle on the stem and tighten the set screw inside the handle against the handle divot.
14. Fully close the valve and then retract the stem 2 or 3 turns before torquing the valve.
15. Torque the packing nut according to the following chart.

Valve Material	Packing Nut Hex Size		Torque Value (in.-lbs)
	in.	mm.	
Stainless Steel & Alloy 400	9/16	14.3	25
	5/8	15.9	40
	7/8	22.2	130
Brass & Steel	1-1/8	28.6	200
	9/16	14.3	15
	5/8	15.9	20
	7/8	22.2	65
	1-1/8	28.6	100

18 SERIES INTEGRAL BONNET (O-RING SEAL)



L - LUBRICATED AREA

Swagelok
www.swagelok.com