

1HRHV 1412



**Valve Information:**

Manufacture	Crane/Pacific	
Size	24"	
Type	Parallel Disc Gate	
Pressure	2500 lb.	
Body Material	WCB	
Fig.#		
Seat Material.	HF	
Stem Material	410 stainless	
Disc Material	HF	
End connection	BW	
Electrical disconnect	Yes	Limitorque
Insulation	Yes	Was not removed
Scaffolding	No	
Gasket size	Pressure Seal	23.400x22.375x1.285x23deg
Packing	5 ring graphite w/ carbon spacer	5.750x4.500

**Problems found:**

1. Stem had severe galling in packing area which had transferred to the bushing in the breech
2. Stem had to be machined out of the carrier as a result of the threads galling resulting in much more difficult than normal

3. Seats were in good shape
4. Discs were in good shape w/ minor scratching
5. Packing area was in good shape

**Corrective action taken:**

1. Lap/polish seats
2. Skim cut & polish discs
3. Install new stem
4. Install new elevating nut in actuator
5. Skim cut breech seal ring area.
6. A clean up cut was made in the ID of the breech & back seat where the stem rides to allow for more clearance to prevent future galling. A carbon spacer was installed as well to help support the stem and take up extra space in the packing box
7. A new pressure seal was made
8. Install 5 ring packing set
9. Assemble



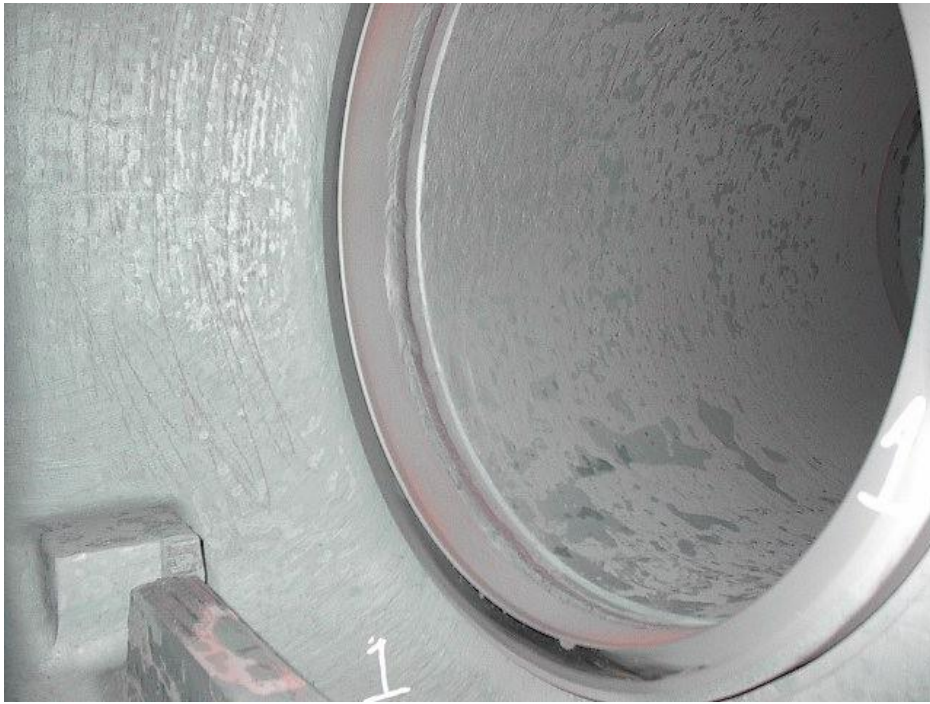
As found stem showing damage to packing area



As found discs



As found seat



Second as found seat



Backseat/breech ID before machining showing galling from stem



Breech packing area



Seat after lapping/polishing



Disc after skim cut/polish



New stems



New elevating nuts and studs



Stem and discs ready for assembly