NAVSEA
STANDARD ITEM

FY-15

ITEM NO: 009-54
DATE: 30 JUL 2010
CATEGORY: II

1. SCOPE:

1.1 Title: Bolted Bonnet Steam Valve; repair (in-line)

2. REFERENCES:

2.1 T9074-AS-GIB-010/271, Requirements for Nondestructive Testing Methods

2.2 MIL-STD-2035, Nondestructive Testing Acceptance Criteria

2.3 S9253-AD-MMM-010, Maintenance Manual for Valves, Traps, and Orifices (Non-Nuclear), User's Guide and General Information

3. REQUIREMENTS:

3.1 Matchmark valve parts.

(V) "INSPECT PARTS FOR DEFECTS"

3.2 Disassemble, clean free of foreign matter (including paint), and inspect parts for defects.

(I) "LIQUID PENETRANT INSPECT"

3.2.1 Accomplish liquid penetrant inspection of seats (including back seat), discs or gate in accordance with 2.1.

3.2.1.1 Acceptance criteria shall be in accordance with Paragraph 7 of 2.2, except hairline cracks in hard-faced areas of seats and discs or gate are acceptable provided the valve does not show evidence of leakage.

3.3 Repair valve as follows:

3.3.1 Straighten stem to within 0.002-inch total indicator reading. Polish stem to a 32 Root-Mean-Square finish in way of packing surface and remove raised edges and foreign matter.

3.3.2 Chase and tap exposed threaded areas.

3.3.3 Clean and spot-in bonnet to body gasket mating surfaces.

3.3.4 Machine, grind, or lap and spot-in gate or discs to seats (including back seat) to obtain a 360-degree continuous contact.

(I) or (V) "INSPECT CONTACT" (See 4.3)

3.3.4.1 Inspect contact using blueing method.

3.3.4.2 Transfer line for gate valve shall not exceed 3/16-inch in width and shall appear within the lower 75 percent of the gate seating surface.

3.3.4.3 Transfer line for globe valve shall not exceed 1/16-inch in width.

(I)(G) "VERIFY LEVEL I PARTS AND CLEANLINESS"

3.4 Assemble valve, installing new gaskets in accordance with the manufacturer's specifications, and new fasteners in accordance with Attachment A.

3.4.1 Install new valve stem packing conforming to MIL-P-24503/24583 combination in accordance with Chapter 6 of 2.3.

4. NOTES:

4.1 Operational test of valve will be specified in Work Item.

4.2 Repair of valve operating gear will be specified in Work Item.

4.3 The paragraph referencing this note is considered an (I) if the valve is Level I. If the valve is not Level I, the paragraph is considered a (V).

ATTACHMENT A

VALVE BODY MATERIAL

	1/ Alloy Steel	Carbon Steel	2/ Nonferrous
3/ Studs and Bolts to MIL-DTL-1222	Grade B-16	Grade B-16	Phosphor Bronze - Any Grade Silicon Bronze - Any Grade Nickel Copper - Class A 4/
Nuts to MIL-DTL-1222	Grade 4 or 7	Grade 4 or 7	Phosphor Bronze - Any Grade Silicon Bronze - Any Grade Nickel Copper - Class A or Class B 5/
Socket Head Cap Screws	FF-S-86	FF-S-86	

1/ Alloy steel is of Composition A - 2-1/4 percent Chromium, one percent Molybdenum, Composition B - 1-1/4 percent Chromium, 1/2 percent Molybdenum, and Composition C - Carbon Molybdenum.

2/ Nonferrous Alloy except Aluminum.

3/ Studs shall be Class 2 or 3 fit on the nut end and Class 5 fit on the stud and, except that a Class 3 fit with a thread locking compound may be used where temperatures do not exceed 250 degrees Fahrenheit. The thread locking compound shall conform to ASTM D 5363. Check Class 3 fit stud ends in accordance with SAE-J2270.

4/ Fasteners of Nickel Copper Aluminum shall be the only type used on sea chest and hull valves.

5/ Nuts of Nickel Copper Alloy, conforming to QQ-N-281 Class A or B, or Nickel Copper Aluminum conforming to QQ-N-286 shall be the only type used on sea chest and hull valves.