

NAVSEA  
STANDARD ITEM

**FY-24**

ITEM NO: 009-54  
DATE: 25 OCT 2022  
CATEGORY: II

1. SCOPE:

1.1 Title: Bolted Bonnet, Globe, Globe Angle, and Globe Stop Check Valve In-Line Repair; accomplish

2. REFERENCES:

2.1 S9068-CJ-STM-010/CH-075, Fasteners

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

2.3 MIL-STD-2035, Nondestructive Testing Acceptance Criteria

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

3. REQUIREMENTS:

3.1 Matchmark each valve part.

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

3.2.1 The removal of body bound studs only to determine the condition of threads is not required.

(I) or (V) "TORQUE TEST"

3.2.2 Torque test each body-bound stud in accordance with sections 075-8.6.3.2(d) of 2.1.

(I) "LIQUID PENETRANT INSPECT"

3.2.3 Accomplish liquid penetrant inspection of each seat (including back seat), discs or gate in accordance with 2.2.

3.2.3.1 Acceptance criteria must be in accordance with Paragraph 7 of 2.3, 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 each exposed threaded area.

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

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 must not exceed 3/16-inch in width and must appear within the lower 75 percent of the gate seating surface.

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

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

3.4 Assemble valve installing new each packing, each gasket, and each fastener for those removed 3.2 in accordance with the manufacturer's specification or instruction.

3.4.1 Pack each feedwater, each condensate, and each steam valve with, valve stem packing conforming to MIL-P-24503/ MIL-DTL-24583 combination in accordance with Chapter 6 of 2.4.

3.4.2 Pack each valve of each system other than feedwater, condensate, and steam with valve stem packing conforming to *MIL-P-24396*, type B.

#### 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).