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	Reworking repaired valves	Page 1/3

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1 Purpose

This LESER Global Standard (LGS) provides instruction on reworking LESER safety valves. The required work steps and materials are described.

2 Scope

This document must be applied when reworking safety valves in agencies and subsidiaries of LESER GmbH & Co. KG.

3 References

LWN 313.32 to 313.40

4 Disclaimer

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5 Qualified fitting personnel

The reworking of LESER safety valves may only be performed by trained or qualified fitters. The qualifications must be obtained through the appropriate training measures.

6 General Information



- During all work on the working surfaces,
- Wear safety glasses.

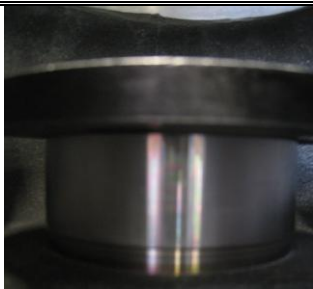

7 Reworking the of the working surfaces

When re-turning damaged working surfaces, comply with the specifications of LWN 313.32 to 313.40.

8 Re-lapping

8.1 Re-lapping seat and disc sealing surfaces

8.1.1 Lapping with the lapping stamp.

Illustrations	Description	Aids / Tools
 <p>Figure 8.1.1-1</p>	<p>The lapping stamp is to be used for reworking damage on the seat sealing surface. Lapping paste and oleic acid must be applied to the lapping stamp. Select the lapping paste depending on the degree of damage.</p> <p>The more severe the damage is, the coarser the lapping paste that is to be used at the beginning</p>	
 <p>Monocrystalline diamond powder Oleic acid</p> <p>Figure 8.1.1-2</p>	<p>Wet the disc with the monocrystalline diamond powder and the oleic acid.</p> <p>Four small points on the sealing surface of the disc must be used. Monocrystalline diamond powder is applied to 2 points and oleic acid to the other 2 points.</p>	

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Figure 8.1.1-3 Error! No sequence specified.

The seat and disc are re-lapped together. The seat and disc are lapped together so that better surface evenness of the disc is achieved. Lapping is performed by slight circular hand movements.

8.1.2 Re-lapping with a glass plate

Illustrations	Description	Aids / Tools
<p>Glass plate Figure 8.1.2-1</p>	<p>Re-lapping the seat with a glass plate results in greater surface evenness.</p>	

8.1.3 Re-lapping the nozzle and the disc

Illustrations	Description	Aids / Tools
<p>Nozzle Figure 8.1.3-1</p>	<p>Re-lapping of the nozzle and the disc is performed separately on a glass plate.</p> <p>Mix the monocrystalline diamond powder together with the oleic acid on the glass plate and then lap the nozzle and the disc. Lapping is performed by slight circular hand movements.</p>	

Alternate methods that ensure the same effect may be used.

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