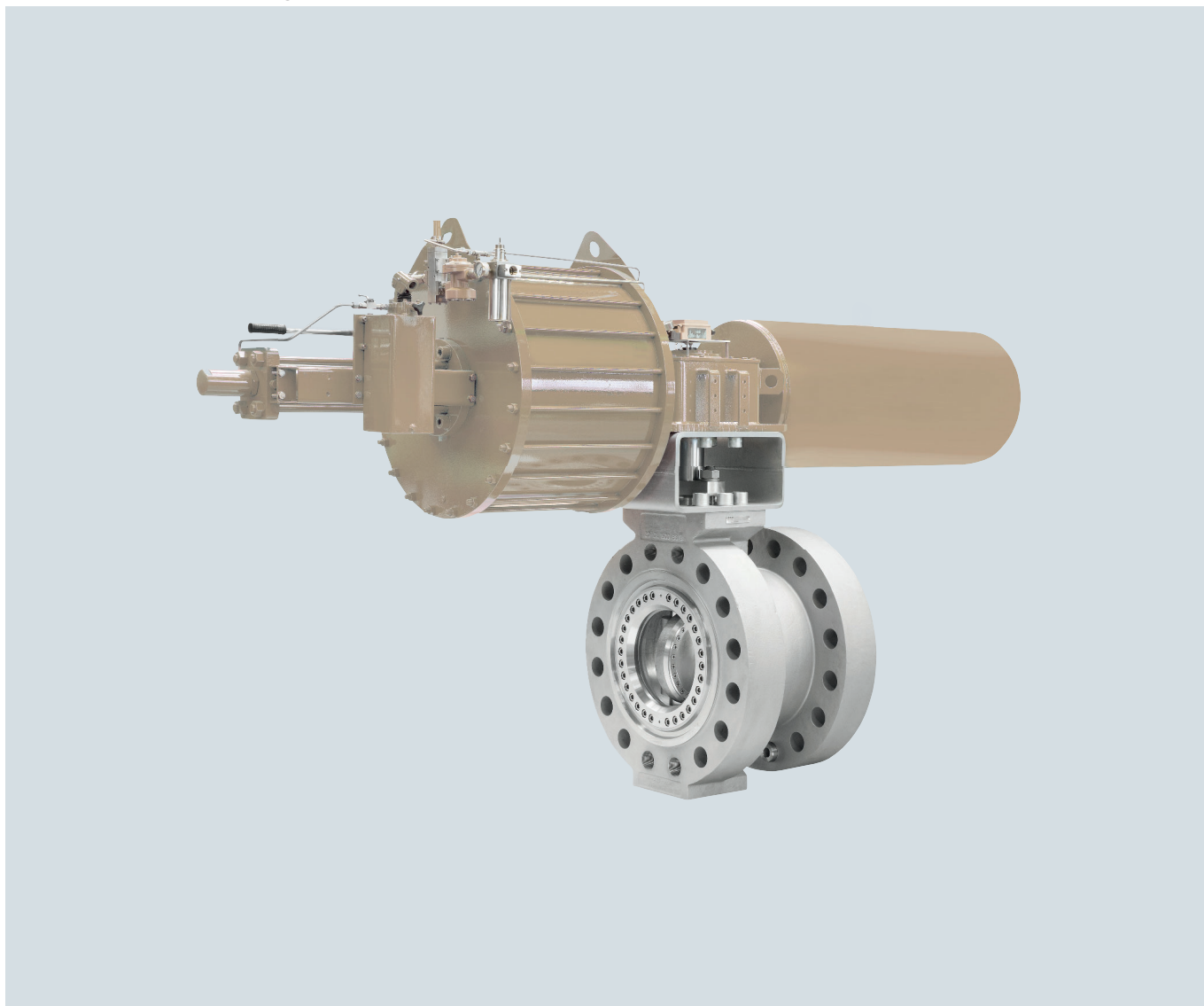


MOUNTING AND OPERATING INSTRUCTIONS



EB LTR 43

Translation of the original manual



**Control and shut-off valve type LTR 43 in the standard version
to combine with actuators**

October 2024 edition



Note regarding this installation and operating manual

This Installation and Operating Manual (EB) provides guidance for safe assembly and operation.

The notes and instructions in this EB are binding when handling SAMSON LEUSCH devices. The figures and illustrations in this EB are examples and must therefore be considered as such.

- ⇒ For safe and correct use, read this EB carefully prior to use and keep it for later reference.
- ⇒ In the case of questions that go beyond the scope of this Installation and Operating Manual (EB), please contact the nearest SAMSON office.
- ⇒ This manual only applies to the butterfly valve itself, the respective additional manual applies for the mounted actuator.

Definition of signal words

DANGER

Hazardous situations that lead to death or serious injuries

WARNING

Situations that can lead to death or serious injuries

NOTE

Property damage and malfunctions

Info

Additional information

Tip

Recommended action

Content

1	Safety instructions and safety measures	1-1
1.1	Notes regarding possible severe personnel injury	1-2
1.2	Notes regarding possible personnel injury	1-3
1.3	Notes regarding possible property damage	1-4
1.4	Warning notes on the device	1-4
2	Markings on the device	2-1
2.1	Control and shut-off valve type plate	2-1
2.2	Actuator type plate	2-1
2.3	Material markings	2-1
3	Design and principle of operation	3-1
3.1	Variants	3-2
3.2	Additional optional components on the valve	3-2
3.3	Control-related additional equipment	3-3
3.4	Technical data	3-3
4	Shipment and on-site transport	4-1
4.1	Accepting delivery	4-1
4.2	Unpacking the valve	4-1
4.3	Transporting and lifting the valve	4-1
4.3.1	Transporting the valve	4-1
4.3.2	Lifting the valve	4-1
4.4	Storing the valve	4-2
5	Installation	5-1
5.1	Installation conditions	5-1
5.2	Preparing for assembly	5-2
5.3	Assembling the butterfly valve	5-2
5.3.1	Assembling the butterfly valve and actuator	5-2
5.3.2	Installing the actuator in the pipe	5-3
5.4	Checking the assembled actuator	5-4
5.4.1	Pressure and leak test	5-5
5.4.2	Checking the rotary movement	5-6
5.4.3	Checking the fail-safe position	5-6
6	Start-up	6-1
7	Operation	7-1
7.1	Working in automatic mode	7-1
7.2	Working in manual mode	7-1
7.3	Working with the manual gear	7-1
8	Malfunction	8-1
8.1	Detecting and rectifying errors	8-1
8.2	Carrying out emergency measures	8-1

Content

9 Servicing	9-1
9.1 Periodic tests	9-2
9.2 Preparing maintenance work	9-2
9.3 Maintenance work	9-2
9.3.1 Maintenance work on the attachments	9-2
9.3.2 Maintenance work on the actuator	9-2
9.3.3 Maintenance work on the butterfly valve in an installed condition	9-2
9.3.4 Maintenance work on the butterfly valve in a removed condition	9-5
9.4 Assembling and commissioning the actuator after maintenance work	9-5
9.5 Design of the sealing system	9-5
9.5.1 Butterfly valve LTR 43-2 and LTR 43-9.2	9-5
9.5.2 Butterfly valve LTR 43-3	9-5
9.5.3 Butterfly valve LTR 43-4 and LTR 43-9.4	9-6
9.5.4 Butterfly valve LTR 43-9.9	9-6
10 Decommissioning	10-1
11 Removal	11-1
11.1 Removing the butterfly valve with an assembled actuator from the pipe	11-1
11.2 Disassembling the actuator	11-2
12 Repairs	12-1
12.1 Sending devices to SAMSON LEUSCH	12-1
13 Disposal	13-1
14 Certificates	14-1
15 Annex	15-1
15.1 Tightening torques, lubricant and tools	15-1
15.1.1 Tightening torques	15-1
15.1.2 Lubricant	15-3
15.1.3 Tools	15-3
15.2 Service	15-3
15.3 Spare parts	15-3
15.3.1 Series LTR43-2, LTR43-9.2	15-4
15.3.2 Series LTR43-3	15-5
15.3.3 Series LTR43-4, LTR43-9.4	15-6
15.3.4 Series LTR43-9	15-7

1 Safety instructions and safety measures

Intended use

The SAMSON LEUSCH control and shut-off butterfly valve type LTR 43 is designed for use in combination with an actuator for the regulation of the volume flow, pressure and temperature of fluid, gaseous or vaporous media.

- The butterfly valve and its drive are designed for precisely defined conditions (e.g. operating pressure, utilised medium, temperature).

Therefore the operator must make sure that the butterfly valve is only used when the conditions of use comply with the design criteria defined in the order.

If the operator would like to use the butterfly valve in other applications or environments, they must contact SAMSON LEUSCH.

- SAMSON LEUSCH shall not be held liable for damage that result from non-compliance with the intended use, as well as for damage that results from external forces or external influences.
- Limits of use, areas of use and possible uses can be found in the technical data and on the type plate.

Reasonably foreseeable misuse

The butterfly valve is not suited for the following areas of use:

- Use outside of the technical data and the limits defined by the design.
- Use outside of the limited defined by the attachments installed on the butterfly valve.

Furthermore, the following activities are considered unintended use:

- Use of third-party spare parts
- Performance of maintenance and repair work that is not described

Qualification of operating personnel

The butterfly valve may only be installed in observance of the recognised rules of technology, commissioned, serviced and repaired by specialist personnel.

- Specialist personnel in terms of this installation and operating manual are persons who, on the basis of their vocational education, knowledge and experience and knowledge of the relevant standards, are capable of evaluating the assigned tasks and identifying possible hazards.
- In the case of valves with an explosion-protection version, personnel must have been trained or instructed or be authorised to work on explosion-protected devices in plants at risk of explosion.

Personal protective equipment

SAMSON LEUSCH recommends obtaining information regarding the hazards resulting from the medium in use, for example using the GESTIS substance database.

Depending on the medium that is used and/or the respective activity, the following protective equipment, among others, may be necessary:

- Protective garments, protective gloves and eye protection when using hot, cold, aggressive and/or corrosive media
- Hearing protection when working in the vicinity of the butterfly valve
- Industrial safety helmet
- Safety harness, if there is a danger of falling (e.g. if working unsecured at a height)
- Safety shoes, e.g. with protection against static discharge
- Request additional protective equipment from the plant operator.

Changes and other modifications

Changes, conversions and other modifications to the valve are not authorised by SAMSON LEUSCH. They are made at your own risk and can lead to safety risks, for example, that cause the valve to no longer fulfil the prerequisites required for its use.

Protective devices

If the butterfly valve switches to a defined fail-safe position when the pneumatic energy fails, it depends on the utilised butterfly valve, see the corresponding actuator documentation. In the case of combinations of a butterfly valve with single-acting actuators, the butterfly valve automatically switches to a certain fail-safe position in case of a pneumatic energy failure, see Chapter 3. The fail-safe position corresponds to the effective direction and is indicated on the type plate.

Warning of residual risks

To prevent personal injury or property damage, the operator and operating personnel must use suitable measures to prevent the hazards that can result from the flow medium and operating pressure as well as the signal pressure and moving parts.

- Therefore, the operator and operating personnel must observe all the hazard information, warning information and information in this installation and operating manual.
- Hazards that result from the specific work conditions at the area of butterfly valve use must be determined in an individual risk assessment and made avoidable by corresponding instructions from the operator.

Obligation of the operator to exercise diligence

The operator is responsible for proper operation as well as compliance with the safety regulations.

- The operator is responsible for providing operating personnel with this installation and operating manual as well as the applicable documents and to provide instructions on proper operation.
- Furthermore, the operator must ensure that operating personnel and third parties are not endangered.
- The operator is responsible that the limit values for the valve defined in the technical data are not undershot or exceeded.

Safety instructions and safety measures

- The start-up and shut-down processes are a part of the operating process and as such, are not a part of these installation and operating instructions. SAMSON LEUSCH cannot make a statement about these processes, as the operational details (e.g. differential pressures and temperatures) differ individually and are only known to the operator.

Obligation of operating personnel to exercise diligence

Operating personnel must be familiar with this installation and operating manual and the applicable documents and comply with the indicated hazard information, warning information and other information. Furthermore, operating personnel must be familiar with the applicable regulations concerning occupational safety and accident prevention and observe them.

Applicable standards and directives

The valve fulfils the requirements of the following European Directives:

- 2014/68/EU Pressure Equipment Directive
- 2006/42/EC Machinery Directive
- 2014/35/EU Low Voltage Directive
- 2014/30/EC Electromagnetic Compatibility
- 2014/34/EU Equipment and protective systems intended for use in potentially explosive atmospheres

In the case of valves provided with a CE marking, the Declaration of Conformity provides information about the conformity assessment procedure that was used, see Chapter 14.

Non-electrical valves do not have their own potential ignition sources pursuant to the ignition hazard assessment in compliance with EN ISO 80079-36, even in the case of seldom occurring operational failures, and therefore are not subject to Directive 2014/34/EU.

⇒ For the connection to the equipotential bonding system, observe Paragraph 6.4 of EN 60079-14, VDE 0165-1.

– NACE

As regards the use or application of materials according to NACE MR0175 / ISO15156 as well as NACE MR0103 (materials in an environment containing H₂S) the designation of the standard in the material or test certificates does not indicate suitability for use of the butterfly valve.

This depends additionally on the operating and environmental parameters, to which generally only the plant operator has access. Therefore the suitability for use of such butterfly valves must always be checked by the plant manufacturer/operator.

– SIL

The suitability for use of butterfly valves in (SIL) protective circuits must be documented in separate agreements.

The below requirements are described in standards (e.g. VDI 2180, EN 61508, EN 61511) and in the applicable SAMSON Group Manual (Functional safety for control valves, rotary plug valves, ball valves and control butterfly valves; WA 236).

– Oxygen

Butterfly valve types LTR 43-9.2, LTR 43-9.4 and LTR 43-9.9 are suitable for use in applications in which the oxygen content of the operating media is greater than or equal to 35% (Vol.). All parts coming into contact with the medium are cleaned oil and grease free and the butterfly valve is protected by means of a specific protective packaging against dirt and environmental influences.

All maintenance and repair work must be carried out in an oil and grease-free environment (clean room).

The utilised tools as well as personal equipment must comply with the cleanliness requirements.

The required cleanliness of the butterfly valve must be ensured through suitable measures prior to reinstallation.

For butterfly valves to be used in oxygen applications, when ordering spare parts, it must be specifically indicated that they are for "OXYGEN USE" and the corresponding measures must be observed.

Applicable documents

The following general and order-related documents apply in addition to this installation and operating manual:

- EB (Installation and operating manual) for the installed actuator
- EB for attachments (positioner, solenoid valve etc.)
- MI-LTR 43-2-SR, MI-LTR 43-3-SR, MI-LTR 43-4-SR or MI-LTR 43-9.9 SR spare seat/seal ring (applies only for the supply of seal or rep kits)
- Data sheet ► T LW20010
- Technical data sheet ► LW-10006 Torque SB (STD)
- Technical data sheet ► LW-10007 Torque SB TA Luft
- Technical data sheet ► LW-10017 Torque DE HP
- Technical data sheet ► LW-10018 Risk assessment of residual hazards resulting from valves with an actuator when used as intended
- Manual ► WA 236
- Copy of the order-related type plate
- Order-related dimensional drawing (if agreed)

1.1 Notes regarding possible severe personnel injury

The following list indicates only generally-applicable information. The respective chapters can contain hazard information that, due to context, is provided in addition or is formulated slightly differently.

DANGER

Danger due to falling of suspended loads!

- ⇒ Do not stand under suspended loads.
- ⇒ Secure the transport paths.

⚠ DANGER**Risk of bursting due to pressurised devices and components!**

Butterfly valves and pipes are pressure equipment that can burst if handled improperly. Projecting, flying components, fragments and released pressurised medium can cause injuries or even death.

- ⇒ Observe the maximum permissible pressure the butterfly valves and plant.
- ⇒ Empty the medium from the concerned plant parts and butterfly valve.

Danger due to escaping medium as a result of unsuitable flange seals

Leaks caused by unsuitable flange seals can cause operating medium to escape. Flange leaks can cause fatal injury to personnel and damage the environment.

- ⇒ Use suitable flange seals.
- ⇒ Request special dimensions from SAMSON LEUSCH.

1.2 Notes regarding possible personnel injury

The following list indicates only generally-applicable warning information. The respective chapters can contain warning information that, due to context, is provided in addition or is formulated slightly differently.

⚠ WARNING**Danger of burning due to hot or cold components and pipes!**

Butterfly valves and pipes can become very hot or very cold during operation and cause burns upon contact.

- ⇒ Let the components and pipes cool down or warm up
- ⇒ Wear protective garments and protective gloves.

Hearing damage and deafness due to a high sound level!

Noise emissions depend on the version of the valves, the plant equipment as well as the utilised medium. During operation, medium-related noise emissions may be generated depending on the plant conditions. In addition, there may be a short-term high sound pressure level when a pneumatic actuator or pneumatic attachment is suddenly ventilated without noise-reducing elements. Both can damage hearing.

- ⇒ Wear hearing protection when working in the vicinity of the actuator.

Danger of injury due to incorrect lifting without lifting equipment!

When lifting the valve without lifting equipment, injuries may occur, especially in the torso area, depending on the weight of the valve.

- ⇒ Observe the occupational health and safety regulations applicable at the installation site.

Overturning of the lifting equipment and damage to the load lifting equipment by exceeding the lifting capacity!

- ⇒ Only use approved lifting equipment and load lifting equipment whose lifting capacity corresponds at least to the weight of the valve and the packaging if applicable.

⚠ WARNING**Danger of crushing due to moving parts!**

The butterfly valve contains moving parts (e.g. shaft and wedge-lock-washer) that can lead to crushing if reaching into it.

- ⇒ During operation, do not reach into the bracket between the butterfly valve and the actuator.
- ⇒ Before working on the valve, interrupt and lock the pneumatic energy and the control signal.
- ⇒ Do not allow the jamming of objects in the bracket to hinder the rotation of the shaft.
- ⇒ In the case of a blocked shaft, contact SAMSON LEUSCH through the nearest SAMSON office.

Danger of injury due to escaping exhaust air!

During operation, when regulating or when opening and closing the butterfly valve, exhaust air can escape, for example from the actuator.

- ⇒ Install the valve such that the actuator does not ventilate at eye level.
- ⇒ Use suitable silencers and plugs.
- ⇒ Wear eye protection when working in the vicinity of the actuator.

Danger of injury due to preloaded springs!

Valves that are equipped with preloaded actuator springs are under mechanical tension. The marking on the actuator type plate indicates whether a spring return is available and the fail-safe position. The marking on the type plates is described in the instruction manuals for the actuators.

- ⇒ Release the compression from the preloaded springs before working on the actuator, see the corresponding actuator documentation.

Danger of injury due to moving parts with spring-loaded actuators

Spring-loaded actuators may only be pressurised when installed in the pipe and not to perform work on the valve outside of the pipe. There is risk of fatal injury if the pneumatic energy suddenly fails and the valve disc moves automatically to the fail-safe position by means of spring force.

For devices that have a spring-loaded actuator with a "fail open" fail-safe position, the control and shut-off valve must be installed in the open position, for example by removing the pipe.

The sealing surfaces may not be damaged during this operation.

Danger of injury due to static charge

- ⇒ If there is a risk of static charge of the butterfly valve, the operator must ensure, to avoid it, that a suitable ground connection is installed in the provided position.

Danger of injury due to residual medium in the butterfly valve!

When working on the butterfly valve, residual medium can escape and, depending on the medium properties, cause injuries (e.g. scalding, chemical burns).

- ⇒ If possible, empty the medium from the concerned plant parts and control and shut-off valve.
- ⇒ Wear protective garments, protective gloves and eye protection.

⚠ WARNING

Danger of injury due to pressurised components and escaping medium!

⇒ Do not loosen pressurised components.

Danger of injury due to incorrect operation, use or installation caused by illegible information on the butterfly valve!

Over time, imprints or impressions on the valve can soil the adhesives and signs or make them illegible for other reasons so that dangers are not recognised and necessary operational messages cannot be followed. Danger of injury can occur.

- ⇒ Keep all relevant markings on the device legible at all times.
- ⇒ Damaged, missing or faulty signs or adhesives must be replaced immediately.

Functional impairment of the butterfly valve due to oil leaking from the hand pump!

⇒ Observe the agreed and documented actuator/valve alignment.

Dangers due to use of the butterfly valve as an end fitting!

During normal operation, in particular with gaseous, hot and/or hazardous media, spraying medium can cause hazards.

- ⇒ A blind flange must be assembled on the free connecting pieces or the butterfly valve must be secured against unauthorised actuation.
- ⇒ If a butterfly valve is used as an end fitting in a pressurised line is opened, this may only be done with extreme caution so that the escaping medium does not cause any damage.

Danger due to incorrect installation when used as an end fitting!

- ⇒ The butterfly valves of types LTR 43-2 and LTR 43-9.9 are not to be used as end fittings.
- ⇒ The wafer-type butterfly valves of all LTR 43 types are only designed for installation between two mating flanges and are therefore not suitable for use as end fittings.
- ⇒ If the valve is intended for use as an end fitting, clarify the operating and ambient conditions with LEUSCH in advance.

1.3 Notes regarding possible property damage

! NOTE

Damage to the butterfly valve due to contamination (e.g. solid particles) in the pipes!

The plant operator is responsible for cleaning the pipes in the plant.

⇒ Rinse the pipes prior to commissioning.

Damage to the butterfly valve due to unsuitable medium properties!

The butterfly valve is designed for a medium with certain properties.

⇒ Only use a medium that corresponds to the design criteria.

Damage to the butterfly valve and leakage due to excessively high or low tightening torques!

The butterfly valve components must be tightened with specific torques. Excessively tightened components are subject to increased wear. Insufficiently tightened components can cause leakage.

⇒ Comply with the specified tightening torques, see Chapter "15.1.1 Tightening torques"

! NOTE

Damage to the butterfly valve due to unsuitable tools!

Unsuitable tools can damage the valve.

⇒ Suitable commercially available tools are needed to work on the butterfly valve, see Chapter "15.1.3 Tools".

Damage to the butterfly valve due to unsuitable lubricants!

The functionality of the butterfly valve is ensured only by using a certain lubricant. Unsuitable lubricants can corrode and damage the surface.

⇒ The butterfly valve material requires suitable lubricants, see Chapter "15.1.2 Lubricants".

Medium contamination due to unsuitable lubricants and contaminated tools and components!

⇒ If required, for example for oxygen applications, keep the butterfly valve and utilised tools free from solvents and greases.

⇒ Only use suitable lubricant, see Chapter "15.1.2 Lubricant"

1.4 Warning notes on the device

Warning of moving parts.



Figure 1-1: Example of the warning information

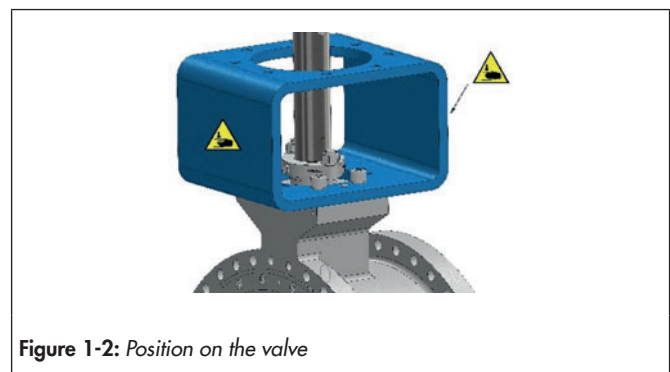


Figure 1-2: Position on the valve

There is a risk of crushing due to the rotation of the shaft, especially during fast rotation movements, when reaching into the bracket as long as the pneumatic energy is connected to the actuator, see ► LW 10018, Paragraph 1.3.7.

2 Markings on the device

2.1 Control and shut-off valve type plate

The butterfly valves are marked with a metal type plate that is fastened to the butterfly valve or, if required, in another suitable location of the valve (e.g. extension, bridge).

Conformity with the Pressure Equipment Directive is confirmed when the type plate bears the CE symbol with the ID number of the notified body.

The plate provides the following information:

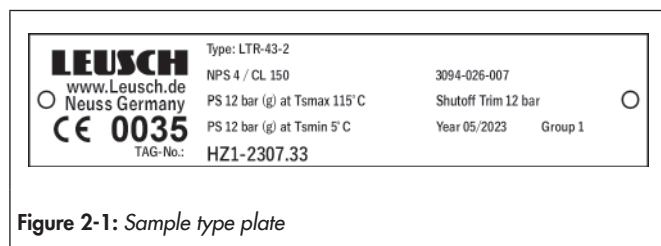


Figure 2-1: Sample type plate

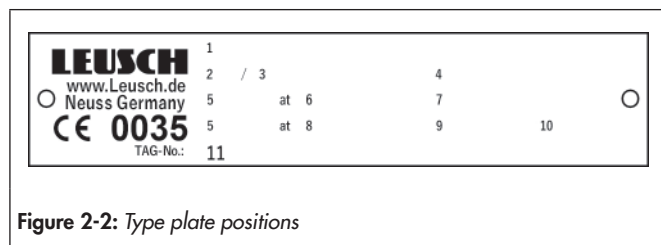


Figure 2-2: Type plate positions

The preferable pressure force direction is marked by a direction arrow that is integrated in the butterfly valve body or is fastened as a metal label on the body in a suitable position. Further information can be provided on additional metal labels.

2.2 Actuator type plate

See the corresponding documentation.

2.3 Material markings

The material markings for bodies and wedge-lock-washers are cast into or stamped onto the respective components.

Table 2-1: Meaning of the positions on the type plate

Pos.	Meaning of the marking position
1	Butterfly valve type
2	Nominal size (DN or NPS)
3	Nominal pressure level (PN or CL)
4	Order number
5	Permissible pressure (PS)
6	Permissible maximum temperature (TSmax.)
7	Maximum permissible differential pressure on the shut-off trim (P shut-off trim)
8	Permissible minimum temperature (TSmin)
9	Year and month of manufacture (Date)
10	Fluid group
11	Test point no. if available (Tag no.)

The current type plates are attached to the final documentation for each order.

3 Design and principle of operation

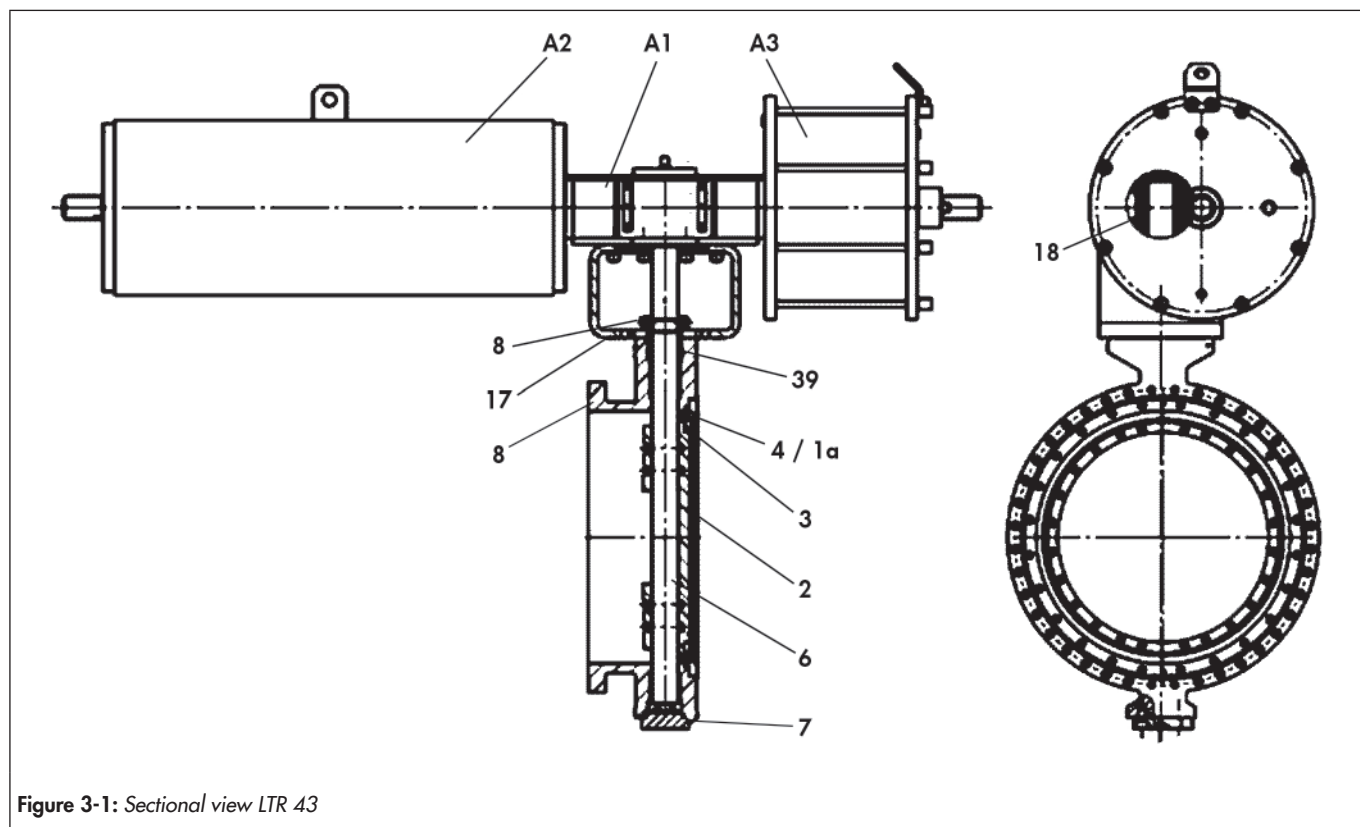


Figure 3-1: Sectional view LTR 43

Table 3-1: Parts list

Pos.	Designation
1	Body
2	Disc
3	Seal ring
4	Seat
6	Shaft
7	Cover
8	Gland

Pos.	Designation
17	Bracket
18	Coupling
39	Packing
A1	Centre console actuator
A2	Spring cylinder actuator
A3	Pneumatic cylinder actuator

The LTR 43 is a triple-eccentric control and shut-off butterfly valve. It is preferably combined with pneumatic actuators in the "rack and pinion" or "scotch-yoke" version, or can also be combined with electric or hydraulic actuators as well as manual gears.

The designed butterfly valve is available in different series for almost all applications and specifications for the control and shut-off of fluids.

The series differ in the structure of the sealing system. The following paragraph provides an example in order to explain the functionality of the valve. In the case of a special design or in combination with a different auxiliary energy, the functionality may differ slightly.

The butterfly valve body (1) either contains an installed replaceable seat (4) or it is integrated fixed in the body (1a). The respective seal ring (3) that is fastened to a disc (2) is connected with the actuator via a shaft (6). The actuator itself is fixed to the valve body by means of a bracket (17).

Adjusting the signal pressure that acts on the drive pistons (A3) changes the position of the wedge-lock-washer with respect to the seat, and therefore the flow rate. The springs (A2) installed in pneumatic actuators move the wedge-lock-washer with the seal ring into the respective fail-safe position if the pneumatic energy fails. The seal between the body and the shaft is guaranteed by the packing rings (39) pressed by a stuffing box (8).

Design and principle of operation

The butterfly valve reaches its maximum tightness when it is operated according to the preferable pressure force direction (FTC) when installed in the pipe system. The preferable pressure force direction is indicated by an arrow on the side of the body.

Fail-safe positions

If the butterfly valve switches to a defined fail-safe position when the pneumatic energy fails, it depends on the utilised butterfly valve, see the corresponding actuator documentation.

The position of the wedge-lock-washer is indicated by two red dots just above the stuffing box. When the butterfly valve is closed, the imaginary connection axis is the red marks at a right angle to the flow direction. When the actuator shaft rotates clockwise, the butterfly valve closes (clockwise to close).

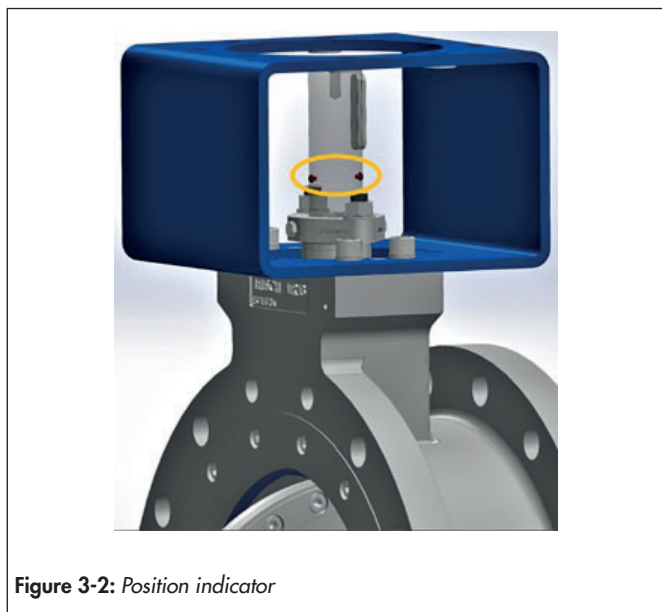


Figure 3-2: Position indicator

Actuator closed by springs (FS)

Upon reduction of the signal pressure or failure of the pneumatic energy, the springs move the actuator shaft clockwise and close the butterfly valve.

The butterfly valve opens when the signal pressure increases, acting against the force of the springs.

Actuator opened by springs (FÖ)

Upon reduction of the signal pressure or failure of the pneumatic energy, the springs move the actuator shaft counterclockwise and open the butterfly valve.

The butterfly valve closes when the signal pressure increases, acting against the force of the springs.

3.1 Variants

For very high or very low temperatures, the butterfly valve can be provided with a body extension and, for example, insulated with a cold-box cover.

Various variants and special designs, such as a heating jacket body, sealing gas connections, exterior bearing points, oxygen versions, TA-Luft seals, etc. are available upon request.

3.2 Additional optional components on the valve

Body extension

For operating or design temperatures below -60 °C (-76 °F) or above 350 °C (662 °F), the valves are equipped standard with a body extension (insulation part), see Chapter "5.2 Preparing for assembly".

Grip protection

In the case of conditions of use that require a high level of safety (e. g. if the valve is freely accessible to untrained specialist personnel), grip protection must be provided to exclude the risk of crushing due to moving parts (actuator shaft). The decision whether to use grip protection is the responsibility of the plant operator and depends on the risk potential of the individual plants and their respective conditions.

Noise reduction

Trims with flow dividers can be used to reduce noise emissions.

Fixed assembly plates on the actuator for control accessories.

For optimal accessibility and maintenance, the actuator accessories can be fit on a central plate as the operator level, depending on the application.

Weather protection equipment

To protect the valve function against the risk of pitting due to the entry of foreign material (e.g. sand) between the stuffing box and the shaft, additional cover plates can be attached to the bracket upon customer request.

To protect the actuator accessory (e.g. solenoid valve, positioner) against the sun, rain and other environmental influences, additional protective devices can be attached upon customer request.

Fire-resistant insulation

Upon customer request, the fire resistance of the valve with respect to the installation environment can be increased by means of individually customised fire protection equipment.

! WARNING

Danger of burns due to heated components!

Additional optional components can become very hot during operation and cause burns upon contact.

⇒ *Let components and pipes cool down.*

⇒ *Wear protective garments and protective gloves.*

3.3 Control-related additional equipment

For valves such as rotary actuators, the following accessories are available, for example, either individually or in combinations:

- Positioner
- Limit switch
- Solenoid valves
- Filter - reducing station
- Jacket heater

Other additional equipment is possible according to specifications on request.

3.4 Technical data

The type plates of the butterfly valve and actuator provide information about the butterfly valve version, see Chapter 2.1 and the actuator documentation.

Conformity

The butterfly valve type LTR 43 complies with the essential international standards, and is in particular both CE and EAC compliant.

Temperature range

Depending on the version, the butterfly valve is designed for a temperature range from -196 to $+550$ °C. The temperature range can be expanded using adapted material as well as an insulation and body extension.

Leakage class

The following leakage classes are available upon agreement and according to customer specifications:

- DIN EN 12266 Part 1 - Testing of metallic valves / ISO 5208 [Leakage class A – G]
- ANSI FCI 70-2 Control Valve Seat Leakage / DIN EN 60534-4 (Leakage class I-VI)
- Others upon agreement

Noise emissions

SAMSON LEUSCH cannot make a general statement about noise emission. Noise emissions depend on the version of the butterfly valve, the plant equipment as well as the utilised medium.

Dimensions and weights

The dimensions and weights can be found on the technical data sheet ► T LW20010 or on the order-related dimensions sheet of the valve.

4 Shipment and on-site transport

The work described in this chapter may only be performed by specialist personnel qualified to perform the corresponding task.

4.1 Accepting delivery

Perform the following steps after receiving the goods:

1. Check the scope of supply. Compare the data on the butterfly valve type plate with the delivery note. For details about the type plate, see Chapter "2 Markings on the device".
2. Check the supply for transport damage. Report transport damage through the nearest SAMSON office to SAMSON LEUSCH and the transport company, see the delivery note.
3. Select suitable lifting equipment and load handling devices according to the weight and dimensions of the valve to be transported and lifted, see the transport documentation and Chapter "3.4 Technical data".

4.2 Unpacking the valve

Observe the following procedures:

- ⇒ Unpack the valve directly before lifting for installation into the pipe.
- ⇒ Check the valve for damage.
- ⇒ Use suitable transport equipment for on-site transport.
- ⇒ Only remove the protective caps on the butterfly valve inlet and outlet directly before installation into the pipe. They protect the butterfly valve against damage by preventing the entrance of foreign material.
- ⇒ Dispose of the packaging according to local regulations.

4.3 Transporting and lifting the valve

⚠ DANGER

Danger due to falling of suspended loads!

- ⇒ Do not stand under suspended loads.
- ⇒ Secure the transport paths

⚠ WARNING

Overturning of the lifting equipment and damage to the load lifting equipment by exceeding the lifting capacity!

- ⇒ Only use approved lifting equipment and load lifting equipment whose lifting capacity corresponds at least to the weight of the valve and the packaging if applicable.

Danger of injury due to tipping of the valve!

- ⇒ Observe the centre of gravity of the valve.
- ⇒ Secure the valve against tipping and twisting.

⚠ WARNING

Danger of injury due to incorrect lifting without lifting equipment!

When lifting the valve without lifting equipment, injuries may occur, especially in the torso area, depending on the weight of the valve.

- ⇒ Observe the occupational health and safety regulations applicable at the installation site.

! NOTE

Damage to the valve due to improper fastening of the sling!

The lifting eye/eyebolts on the actuators are used only for actuator assembling and disassembling as well as for lifting the actuator without the butterfly valve. These fastening points are not intended for lifting the complete valve.

- ⇒ When lifting the valve, make sure that the entire load is carried by the sling that is fastened to the butterfly valve body.
- ⇒ Do not fasten the load-bearing sling to the actuator, hand wheel or other components.
- ⇒ Observe the conditions for lifting, see Chapter 4.3.2.
- ⇒ Do not use the control air lines, accessories or other components with safety functions for suspension or damage them.

4.3.1 Transporting the valve

The transport notes from the packaging (e.g. wooden box) must be followed. The valve can be transported using lifting equipment such as a crane or a forklift.

- ⇒ Comply with the transport conditions.

Transport conditions

- ⇒ Protect the valve against external influences, such as impacts.
- ⇒ Do not damage the corrosion protection (paint, surface coating). Report any damage immediately and remedy it after consultation.
- ⇒ Protect the pipes and any attachments from damage.
- ⇒ Protect the valve against moisture and dirt.
- ⇒ When the valve is in the standard version, the permissible transport temperature is from -20 to +65 °C.

4.3.2 Lifting the valve

When installing the valve in the pipe, suitable lifting equipment should be used, such as a crane or a forklift. Use suitable tested slings and suitable fastening to make sure that the surfaces and contact surfaces are not damaged, and that no other damage occurs to the valve (e.g. actuator accessories, piping, sealing elements).

Conditions for lifting

- ⇒ Use a hook with a safety clamp as the suspension element, see Figure 4-1, so that the sling cannot slip off the hook during lifting and transport.
- ⇒ Secure the sling against shifting and slipping off.
- ⇒ Fasten the sling such that it can be removed again after installation in the pipe.
- ⇒ Avoid swinging and tipping the valve. Pay attention to the centre of gravity!
- ⇒ In the case of interruptions in work, do not leave the lifting equipment suspended in the air for a long period of time.

⚠ WARNING

Danger due to incorrect lifting and transport!

The lifting points for the lifting slings shown on the schematic drawing serve as examples for most valve variants. On site the conditions for lifting and transporting the butterfly valve can change however.

- ⇒ The operator makes sure that the butterfly valve is lifted and transported safely.



Figure 4-1: Sample lifting points for butterfly valves



Figure 4-2: Sample lifting points for valve

Version: Horizontal alignment

1. Use suitable tested slings and suitable fastening to lift the valve using suitable lifting equipment.
2. Lift the valve carefully. Check if the load lifting equipment holds.
3. Move the valve at a constant speed to the installation site.
4. Install the valve in the pipe, see chapter "5 Installation".
5. Remove the lifting slings after successful installation.

i Info

Upon request, SAMSON LEUSCH can provide comprehensive transport and lifting instructions. Contact SAMSON LEUSCH through the nearest SAMSON office.

4.4 Storing the valve

! NOTE

Damage to the valve due to improper storage!

- ⇒ Comply with the storage conditions.
- ⇒ Avoid long storage periods.
- ⇒ In the case of deviating storage conditions and long storage, contact SAMSON LEUSCH through the nearest SAMSON office.

i Info

SAMSON LEUSCH recommends checking the valve and the storage conditions regularly during a longer storage period.

Storage conditions

- ⇒ Protect the valve in its original packaging in a covered location in a clean and dry environment against external influences, such as impacts.
- ⇒ Secure the valve in the storage position against slipping or tipping over.
- ⇒ Do not damage the corrosion protection (paint, surface coating). Remedy any damage immediately.
- ⇒ Protect the valve against moisture and dirt and store at a relative humidity of <75 %. Prevent condensation in damp rooms. Use a desiccant or heater.
- ⇒ Make sure that the surrounding area is free of acids or other corrosive and aggressive media.
- ⇒ The permissible storage temperature for valves is from –20 to +65 °C.
- ⇒ No components may be placed on the valve.

Special storage conditions for elastomer

Example of elastomer: Actuator seals

- ⇒ To maintain the shape and avoid the formation of cracks, do not suspend or bend elastomers.
- ⇒ SAMSON LEUSCH recommends a storage temperature of 15 °C for elastomers.
- ⇒ Store elastomers separately from lubricants, chemicals, solutions and fuels.

5 Installation

The work described in this chapter may only be performed by specialist personnel qualified to perform the corresponding task. Observe chapter 4.3 for transport to the installation site.

5.1 Installation conditions

Operator level

The operator level for the actuator is the front view on all operating elements of the actuator from the perspective of operating personnel.

The plant operator must make sure that operating personnel can carry out all work after the butterfly valve is installed safely and can access it easily from the operator level.

Pipe routing

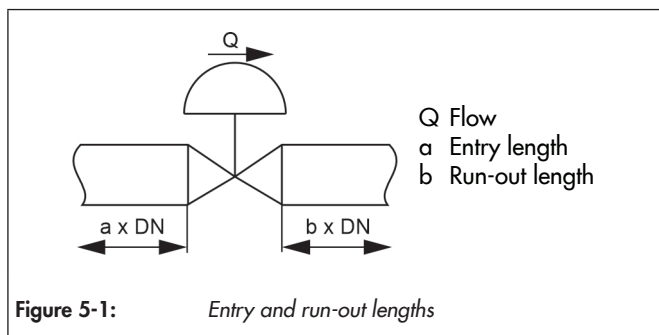


Table 5-1: Entry and run-out lengths

Medium state	Butterfly valve conditions	Installation length a	Run-out length b
Gaseous	$Ma \leq 0.3$	2	4
	$0.3 \leq Ma \leq 0.7$	2	10
Vaporous	$Ma \leq 0.3$ ¹⁾	2	4
	$0.3 \leq Ma \leq 0.7$ ¹⁾	2	10
	Wet steam (Condensation percentage >5%)	2	20
Fluid	Cavitation free / $w < 10$ m/s	2	4
	Sound cavitation / $w \leq 3$ m/s	2	4
	Sound cavitation / $3 < w < 5$ m/s	2	10
	Critical cavitation / $w \leq 3$ m/s	2	10
	Critical cavitation / $3 < w < 5$ m/s	2	20
Flashing	-	2	20
Multi-phase	-	10	20

¹⁾ no wet steam

The entry and run-out lengths depend on various variables and process conditions and are provided as a recommendation, see Table 5-1.

If the lengths recommended by SAMSON LEUSCH are significantly undershot, contact SAMSON LEUSCH.

The guidelines applicable on site apply for the installation of the butterfly valve in the pipe.

Install the butterfly valve so there is low vibration and no mechanical tension, use a support if necessary. Observe the sections "Installation orientation" and "Support and mounting" in this chapter.

Install the actuator so there is enough space to replace the actuator and butterfly valve as well as to perform maintenance and repair work.

Installation position

The recommended installation position of the damper type LTR 43 must be selected so that the damper shaft is always aligned parallel to the ground.

In the event of deviations from this installation position, consult LEUSCH.

! WARNING

Functional impairment of the actuator due to oil leaking from the hand pump in case of an incorrect installation position!

⇒ Observe the agreed and documented actuator and butterfly valve alignment.

Support and mounting

The plant manufacturer is responsible for the selection and implementation of a suitable support or mounting for the installed actuator as well as the pipe.

Attachments

When connecting the attachments, make sure that they can be operated from the operator level safely and with easy access.

Venting

Vents are screwed into the exhaust air connections of pneumatic and electropneumatic devices to ensure that the generated exhaust air can be released to the outside (protection against overpressure in the device). Furthermore, vents allow the intake of air (protection against underpressure in the device).

⇒ Ventilation must be oriented such that operating personnel is not endangered. The operator must evaluate the hazard due to noise and prevent it using suitable measures.

5.2 Preparing for assembly

⚠ DANGER

Danger due to escaping medium resulting from unsuitable flange seals!

Leaks caused by unsuitable flange seals can cause operating medium to escape. Flange leaks can cause fatal injury to personnel and damage the environment.

- ⇒ The butterfly valves of series LTR43-2 and LTR43-9.9 have special dimensions, if applicable. It is indicated in the order confirmation or the dimension sheet if special dimensions are required.
- ⇒ Special dimensions can be requested from SAMSON LEUSCH. Contact SAMSON LEUSCH through the nearest SAMSON office.

Danger of injury due to moving parts with spring-loaded actuators!

Spring-loaded actuators may only be pressurised when installed in the pipe and not to perform work on the butterfly valve outside of the pipe. There is risk of fatal injury if the pneumatic energy suddenly fails and the valve disc moves automatically to the fail-safe position by means of spring force.

- ⇒ Install butterfly valves that have a spring-loaded actuator with the "fail open" fail-safe position in the open position. Remove the pipe if necessary.
- ⇒ Do not damage the sealing surface.

! NOTE

Employees or third parties may not be endangered.

Any applicable legal regulations of the country of destination must also be observed.

Actuators of series LTR 43-2, LTR 43-4 and LTR 43-9 have an interrupted flange sealing surface on one side.

For sealing surfaces according to EN 1092-1 B1 and B2 as well as ASME B16.5 RF and ASME B16.47 RF, it must be ensured that the flat seals are suitable according to EN 1514-1 and/or ASME B16.21.

Other seals.

For other seals, such as spiral or grooved gaskets, the standardised dimensions may not be suitable.

- ⇒ Contact SAMSON LEUSCH for suitable special dimensions.
- ⇒ Upon request, SAMSON LEUSCH can supply these seals.

Damage to the butterfly valve due to incorrect insulation!

Insulate butterfly valves with a body extension with medium temperatures below -60 °C or above 350 °C only up to the maximum permissible height.

- ⇒ In the case of high temperature applications, insulate only the lowest third of the insulation part.
- ⇒ In the case of low temperature applications, insulate only the lowest two thirds of the entire length.
- ⇒ In the case of cold-box applications, insulate the cold-box cover up to the lower edge. If the insulation part is insulated at an impermissibly high level, it can lose its function!

i Info

The plant operator is responsible for cleaning the pipes in the plant.

Ensure the following conditions prior to assembly:

- The actuator is clean.
- The actuator and all attachments inclusive of the pipes are not damaged.
- The data on the type plate (type, nominal size, material, nominal pressure and temperature range) matches the plant conditions and conditions of use. For details about the type plate, see Chapter "2 Markings on the device".
- Additional optional components are installed or prepared to the point as required prior to the assembly of the actuator, see Chapter "3.2 Additional optional components on the actuator".
- Sufficient installation space is available.
- The pipe connections must be aligned plane-parallel, flush and tension-free.
- Measures for avoiding contact with hazardous media were found.
- All welding requirements have been met.

Perform the following preparation steps for assembly:

- Get the material and tools ready that are required for assembly.
- If the butterfly valve and actuator are already assembled together, check the screw connections for the correct tightening torques, see Chapter "15.1.1 Tightening torques" or ► LW-10017, Annex 15.2. Components can loosen up during transport.

5.3 Assembling the butterfly valve

The tasks are listed below that are necessary for assembly and prior to the commissioning of the butterfly valve.

Make sure before assembly that all necessary preparations are made, see Chapter 5.2.

5.3.1 Assembling the butterfly valve and actuator

The SAMSON LEUSCH actuators are delivered in working order. In individual cases, the actuator and butterfly valve are delivered separately and must be assembled.

The tasks are listed below that are necessary for assembly and prior to the commissioning of the actuator.

! DANGER**Danger and damage due to retrofitting an actuator unit!**

The subsequent fitting of an actuator unit can pose a danger to the user and cause damage to the pipe system.

- ⇒ The torque, rotation direction, actuation angle and adjustment of the "OPEN" and "CLOSED" end stops must be adapted to the butterfly valve.

! WARNING**Danger and damage due to use of an electrical actuator!**

- ⇒ It must be ensured that the actuator in the "CLOSED" and "OPEN" position is turned off by the limit switch signal.
- ⇒ If shut-off takes place in an intermediate position due to the signal of the torque switch, this signal should be used in addition for an error message. The fault must be remedied as soon as possible, see Chapter "8 Faults".
- ⇒ For further instructions, see the electrical actuator documentation.

Danger of injury due to preloaded springs!

Butterfly valves that are equipped with preloaded actuator springs are under mechanical tension. The marking on the actuator type plate indicates whether a spring return is available and the fail-safe position. The marking on the type plates is described in the instruction manuals for the actuators.

- ⇒ Release the compression from the preloaded springs before working on the actuator, see the corresponding actuator documentation.

Danger and damage due to high external loads on an actuator unit!

Actuators are not "stepladders".

- ⇒ Loads may not be applied to the actuators as they can damage or destroy the butterfly valve.

Danger and damage due to heavy actuator units!

Actuators that are heavier than the weight of the butterfly valve can pose a danger to the user and cause damage to the pipe system.

- ⇒ These actuators must be supported if they generate a bending stress on the butterfly valve due to their size and/or installation situation.

! NOTE**Damage due to incorrectly installed end stops.**

The actuator end stops must be adjusted such that the seat is not overrun, see the corresponding actuator documentation.

Damage to the butterfly valve due to the incorrect actuator assembly!

Triple eccentric butterfly valves must always be closed clockwise!

- ⇒ Observe the turning direction when assembling an actuator.

! NOTE**Damage to the butterfly valve due to the incorrect setting of the end stops!**

The actuating device is adjusted to the operating data specified in the order.

Any change to the "OPEN" and "CLOSED" end stops preset by SAMSON LEUSCH is only permissible upon consultation and approval.

5.3.2 Installing the actuator in the pipe

! NOTE**Premature wear and leakage due to insufficient support or mounting!**

- ⇒ Use sufficient supports or mountings in suitable points.

- ⇒ Fasten the actuator with suitable lifting equipment and pay attention to the centre of gravity of the actuator, see chapter "4.3.2 Lifting the actuator". Data regarding the centre of gravity can be requested from SAMSON LEUSCH through the nearest SAMSON office.

! NOTE**Swivel and/or tipping danger**

When using manual auxiliary actuations, observe the corresponding documentation to bring the actuator into the closed position.

- ⇒ Remove the protective elements on the butterfly valve prior to installation.
- ⇒ Check the closed position. Make sure that no parts of the wedge-lock-washer protrude beyond the plane-parallel sealing surfaces.
- ⇒ In the case of noise-reducing versions of the wedge-lock-washer that protrudes past the sealing surfaces, the order-related dimension sheet must be observed.
 - To ensure that there is a collision-free installation, suitable measures must be taken.
- ⇒ Lift the actuator at the installation site using suitable lifting equipment, see Chapter 4.3.2. When doing so observe the flow direction of the actuator. It is marked with direction arrows on the side of the valve body.
- ⇒ Install the actuator, depending on the version, in the pipe as follows:

- **Version with flange connection**
Install the butterfly valve tension-free in the pipe after previously installing supports or mountings, if necessary. It must be ensured that suitable flange seals are used, see chapter 5.2. Use bolts (no screws) and nuts to assemble the flange with blind threads on the bodies. The bolts must be screwed in to the thread base.
- **Versions with welded ends**

⚠ DANGER

Danger of explosion when welding due to residual medium in the pipe!

⇒ Observe the specifications from Chapter 5.2.

- Weld the actuator tension-free in the pipe after previously installing supports or mountings, if necessary.
- ⇒ Provide a ground connection if necessary.

⚠ WARNING

Danger of injury due to static charge

⇒ If there is a risk of static charge of the butterfly valve, the operator must ensure, to avoid it, that a suitable ground connection is installed in the provided position.

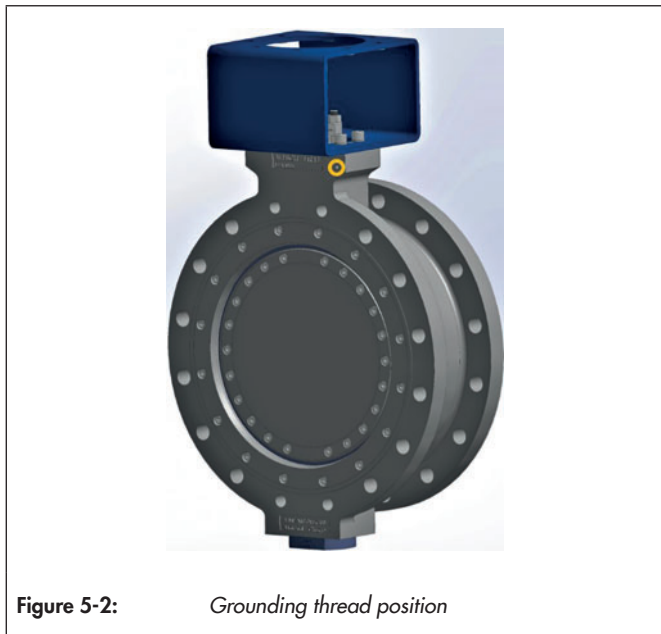


Figure 5-2: Grounding thread position

5.4 Checking the assembled actuator

⚠ DANGER

Risk of bursting due to pressurised devices and components!

Butterfly valves and pipes are pressure equipment that can burst if handled improperly. Projecting, flying components, fragments and released pressurised medium can cause injuries or even death.

Before working on the actuator:

- ⇒ Depressurise the concerned plant parts and butterfly valves, inclusive of the actuator. Also discharge the residual energy.
- ⇒ Empty the medium from the concerned plant parts and butterfly valve.

⚠ WARNING

Danger of injury due to escaping exhaust air!

During operation, when regulating or when opening and closing the butterfly valve, exhaust air can escape, for example from the actuator.

⇒ Wear eye protection when working near the actuator.

Danger of injury due to pressurised components and escaping medium!

⇒ Do not loosen pressurised components.

Hearing damage and deafness due to a high sound level!

During operation, medium-related noise emissions may be generated depending on the plant conditions. In addition, there may be a short-term high sound pressure level when a pneumatic actuator or pneumatic attachment is suddenly ventilated without noise-reducing elements. Both can damage hearing.

⇒ Wear hearing protection when working in the vicinity of the actuator.

Danger of crushing due to moving parts!

The actuator contains moving parts (e.g. shaft and wedge-lock-washer) that can lead to crushing if reaching into it.

- ⇒ During operation, do not reach into the bracket between the butterfly valve and the actuator.
- ⇒ Before working on the actuator, interrupt and lock the pneumatic energy and the control signal.
- ⇒ Do not allow the jamming of objects in the bracket to hinder the rotation of the shaft.
- ⇒ In the case of a blocked shaft, contact SAMSON LEUSCH through the nearest SAMSON office.

Danger of injury due to preloaded springs!

Butterfly valves that are equipped with preloaded actuator springs are under mechanical tension. The marking on the actuator type plate indicates whether a spring return is available and the fail-safe position. The marking on the type plates is described in the instruction manuals for the actuators.

⇒ Release spring force before working on the actuator, see the corresponding actuator documentation.

NOTE

If the actuator is delivered separately from the butterfly valve or if it must be disassembled, actuator assembly may be carried out only by personnel trained by SAMSON LEUSCH.

Perform the following tests to test the function of the actuator prior to commissioning or recommissioning:

5.4.1 Pressure and leak test

NOTE

Damage to the butterfly valve due to a sudden pressure increase and resulting high flow speed must be avoided!

⇒ Observe the data on the type plate.

Damage to the butterfly valve due to excessively high or low tightening torques!

The butterfly valve components must be tightened with specific torques, see Chapter "15.1.1 Tightening torques".

Excessively tightened components are subject to increased wear. Insufficiently tightened components can cause leakage.

⇒ Observe the specified tightening torques.

The plant operator is responsible for performing the leak test and selecting the test procedure. The leak test must comply with the national and international standards and regulations applicable at the installation site!

During the pressure test and leak test from the outside, the butterfly valve wedge-lock-washer must be brought into the open position.

Tip

Upon request, the After Sales Service can provide you with support for the planning and implementation of a leak test specific to your plant. Contact the nearest SAMSON office.

The tightness of the packing, bonnet, flange and optional body extension must be checked.

In the case of impermissible leakage, proceed as follows:

Tighten the packing (8)

⇒ Tighten the stuffing box nuts (56) alternately and evenly using the specified torques, see Chapter "15.1.1 Tightening torques" or ► LW-10006 or ► LW-10007. Avoid tilting

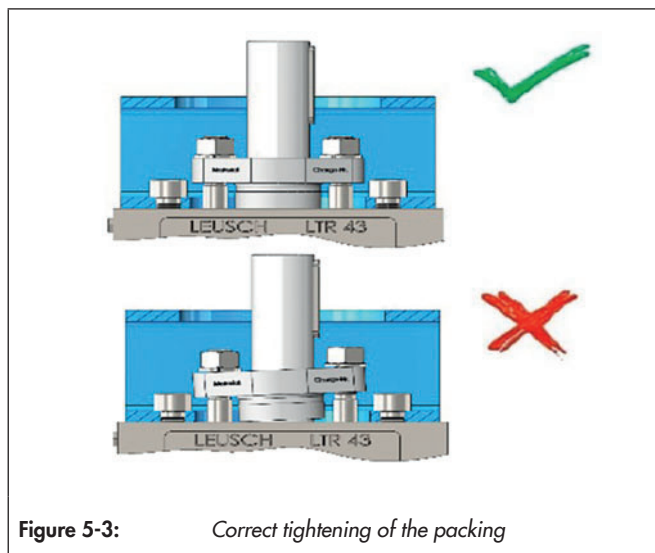


Figure 5-3: Correct tightening of the packing

- ⇒ Open and close the actuator completely multiple times, if possible.
- ⇒ Repeat steps 1 and 2 until the required tightness is achieved.

NOTE

Functional impairment of the butterfly valve due to increased friction resulting from an excessively tightened stuffing box!

- ⇒ Make sure that the actuator shaft is able to move smoothly after tightening the stuffing box.
- ⇒ If the adjustable packing is not correctly sealed, contact SAMSON LEUSCH through the nearest SAMSON office.

Tighten the bonnet (7)

- ⇒ Tighten the bonnet screws (53) with the specified tightening torque, see Chapter "15.1.1 Tightening torques" or ► LW-10017, Annex 15.2.
- ⇒ In the case of insufficient tightness, contact SAMSON LEUSCH through the nearest SAMSON office.

Tightening the flange

- ⇒ Tighten the flange screws with the specified torque.
- ⇒ If the seal is not sufficient, the flanges and flange seals must be checked for damage and replaced if necessary.

Optional body extension (15) (insulation part)

- ⇒ Tighten the nuts (63) with the specified tightening torque, see Chapter "15.1.1 Tightening torques" or ► LW-10017, Annex 15.2.
- ⇒ In the case of insufficient tightness, contact SAMSON LEUSCH through the nearest SAMSON office.

5.4.2 Checking the rotary movement

The rotary movement of the actuator shaft must be even (smooth).

5.4.3 Checking the fail-safe position

It must be checked if the actuator moves to the fail-safe position indicated on the actuator type plate, see Chapter “3 Design and principle of operation”.

6 Start-up

The work described in this chapter may only be performed by specialist personnel qualified to perform the corresponding task.

WARNING

Danger of burning due to hot or cold components and pipe!

The actuator and pipe can become very hot or very cold during operation and cause burns upon contact.

- ⇒ Let the components and pipes cool down or warm up.
- ⇒ Wear protective garments and protective gloves.

Danger of injury due to pressurised components and escaping medium!

- ⇒ Pressurised components may not be loosened.

Hearing damage and deafness due to a high sound level!

During operation, medium-related noise emissions may be generated depending on the plant conditions. In addition, there may be a short-term high sound pressure level when a pneumatic actuator or pneumatic attachment is suddenly ventilated without noise-reducing elements. Both can damage hearing.

- ⇒ Wear hearing protection when working in the vicinity of the actuator.

Danger of crushing due to moving parts

The actuator contains moving parts (e.g. shaft and wedge-lock-washer) that can lead to crushing if reaching into it.

- ⇒ During operation, do not reach into the bracket between the butterfly valve and the actuator.
- ⇒ Before working on the actuator, interrupt and lock the pneumatic energy and the control signal.
- ⇒ Do not allow the jamming of objects in the bracket to hinder the rotation of the shaft.
- ⇒ In the case of a blocked shaft, contact SAMSON LEUSCH through the nearest SAMSON office.

Danger of injury due to escaping exhaust air!

During operation, when regulating or when opening and closing the butterfly valve, exhaust air can escape, for example from the actuator.

- ⇒ Wear eye protection when working in the vicinity of the actuator.

- ⇒ for electrical components, the IP and Ex markings/data are correct.
- ⇒ the limit values indicated on the type plate, such as the max. permissible pressure PS of the valve, minimum/maximum temperature TS, see Chapter "2 Markings on the device", are not exceeded due to the operating conditions ($P < PS$, $TS_{min.} < T < TS_{max.}$).

Furthermore, the pressure-temperature assignment must be observed according to EN 12516-1, EN 1092-1 and ASME B16.34.

The actuator must be operated by expert and instructed personnel. Furthermore, the operator must ensure that employees and third parties are not endangered. The nationally applicable regulations of the country of destination must be observed when operating the actuator.

Changes to the factory settings for the actuator (e.g. end stops) and accessories (e.g. filter regulator, booster, controller etc.) are not permissible and may be made on an individual basis only upon approval of the manufacturer by qualified and expert personnel.

The system must be started-up and shut-down so that the temperature increase/decrease or sudden pressure increases do not result in impermissible increases in voltage.

During start-up operation, the actuator must be continuously observed and checked for possible leakage.

During normal operation, the actuator may only be operated if all actuator components are functional and not deactivated or changed with regard to its intended effect.

Operation of the actuator in a continuous throttle position (no opening angle) can lead to increased wear of the sealing elements (seat/seal ring) and require more frequent maintenance intervals.

Commissioning/recommissioning

The actuator may only be commissioned after the operator has ensured that

- ⇒ the actuator has been inspected to ensure its proper condition in relation to installation and safe function, see Chapter "5 Assembly".
- ⇒ the parts in contact with the media are suitable for the intended use, see chapter "1 Safety instructions and safety measures".
- ⇒ The actuators and accessories (if installed) are connected according to manufacturer instructions and the actuator functions correctly according to the control commands.

7 Operation

As soon as the commissioning/recommissioning work is complete without any defects, see Chapter "6 Start-up", the actuator is ready for operation.

DANGER

Danger due to jerky operation of the actuator!

The failure to observe these warnings can cause extreme danger for persons or damage to the pipe system.

- ⇒ Do not open and close the butterfly valve suddenly to prevent pressure surges and/or a temperature shock in the pipe system.

WARNING

Danger of burning due to hot or cold components and pipe!

Butterfly valves and pipes can become very hot or very cold during operation and cause burns upon contact.

- ⇒ Let the components and pipes cool down or warm up.
- ⇒ Wear protective garments and protective gloves.

Danger of injury due to pressurised components and escaping medium!

- ⇒ Pressurised components may not be loosened.

Hearing damage and deafness due to a high sound level!

During operation, medium-related noise emissions may be generated depending on the plant conditions. In addition, there may be a short-term high sound pressure level when a pneumatic actuator or pneumatic attachment is suddenly ventilated without noise-reducing elements. Both can damage hearing.

- ⇒ Wear hearing protection when working in the vicinity of the actuator.

Danger of crushing due to moving parts

The actuator contains moving parts (e.g. shaft and wedge-lock-washer) that can lead to crushing if reaching into it.

- ⇒ During operation, do not reach into the bracket between the butterfly valve and the actuator.
- ⇒ Before working on the actuator, interrupt and lock the pneumatic energy and the control signal.
- ⇒ Do not allow the jamming of objects in the bracket to hinder the rotation of the shaft.
- ⇒ In the case of a blocked shaft, contact SAMSON LEUSCH through the nearest SAMSON office.

Danger of injury due to escaping exhaust air!

During operation, when regulating or when opening and closing the butterfly valve, exhaust air can escape, for example from the actuator.

- ⇒ Wear eye protection when working in the vicinity of the actuator.

After commissioning and reaching the operating temperature, it may be necessary to retighten the screw connections on the body parts with the corresponding tightening torques, see +Chapter "15.1.1 Tightening torques" or ► LW-10017, Annex 15.2.

If an actuator leaks, see chapter "8 Malfunction".

7.1 Working in automatic mode

For actuators with additional manual adjustment, bring them into a neutral position recommended by the manufacturer. Further information can be found in the respective component instructions.

Butterfly valves that were delivered from the factory with an actuator are precisely adjusted. The user is responsible for any changes they make.

7.2 Working in manual mode

For actuators with manual adjustment, the butterfly valve can be opened and closed manually if the pneumatic energy fails. Further information can be found in the respective component instructions.

7.3 Working with the manual gear

For butterfly valves with manual adjustment, they can be opened and closed manually. Further information can be found in the respective component instructions.

8 Malfunction

When rectifying the faults, chapter "1 Safety instructions and safety measures" must be observed.

8.1 Detecting and rectifying errors

Type of fault	Cause	Measure	Note
Leaks in the passage	Wedge-lock-washer not in the closed position	Check the end stops on the actuator and/or gear (sealing paint undamaged) Contact SAMSON LEUSCH through the nearest SAMSON office for further measures	Note 1: Check the position marking on the shaft, see Chapter 3. Note 2: Check the position display on the actuator Note 3: Rinse the butterfly valve and pipes
	Seat/seal ring damaged	Replace the seat/seal ring	Contact SAMSON LEUSCH through the nearest SAMSON office with regard to a repair kit
Leaks in the flange seal	Seal damaged	Replace the seal	Use a suitable seal, see Chapter 4.4
	Insufficient surface pressure on the seal	Tighten the flange screws	Observe the maximum permissible tightening torques
	Flange sealing surface damaged	Rework the flange sealing surface	Coordinate rework with SAMSON LEUSCH
Leaks in the shaft sealing (packing)	Packing worn	Tighten the stuffing box nuts	Observe the max. permissible tightening torques, see Chapter 15.2
	Packing insufficiently preloaded	Tighten the stuffing box nuts	Observe the max. permissible tightening torques, see Chapter 15.2
	Packing defective	Replace the packing	See chapter 9.3.3
Leaks in the body cover	Seal insufficiently preloaded	Retighten the bonnet screws.	Observe the max. permissible tightening torques, see Chapter 15.2
	Seal defective	Replace the seal.	See chapter 9.3.3
Difficulty of actuator shaft movement	Packing improperly preloaded	Release and and realign the gland	Depressurise the butterfly valve, see Chapter 10
	Insufficient tightening torque	Check the pneumatic energy.	
	Actuator insufficiently supported	Use construction measures to support the weight of the actuator	
	Dirt in the bearing area	Contact SAMSON LEUSCH through the nearest SAMSON office	
Actuator functionality limited	Actuator or control faulty	Contact SAMSON LEUSCH through the nearest SAMSON office.	

In the case of faults that are not listed in the table, contact the After Sales Service at SAMSON LEUSCH. In this case, contact the nearest SAMSON office.

8.2 Carrying out emergency measures

The system operator is responsible for emergency measures. In the case of an actuator fault, observe the measures in Chapter 8.1.

In case of an actuator fault:

- ⇒ Close off the pipe upstream and downstream of the actuator so that no medium flows through the actuator.
- ⇒ Troubleshoot the error, see chapter 8.1.
- ⇒ Rectify the fault that can be fixed as indicated in the instructions provided in this installation and operating manual.

Contact SAMSON LEUSCH through the nearest SAMSON office for additional errors.

Recommissioning after faults

See chapter 6

9 Servicing

The work described in this chapter may only be performed by specialist personnel qualified to perform the corresponding task.

The following documents are required in addition for the maintenance of the actuator:

- Instructions for actuators and attachments

DANGER

Risk of bursting due to pressurised devices and components!

Butterfly valves and pipes are pressure equipment that can burst if handled improperly. Projecting, flying components, fragments and released pressurised medium can cause injuries or even death.

Before working on the actuator:

- ⇒ Depressurise the concerned plant parts and actuators. Also discharge the residual energy.
- ⇒ Empty the medium from the concerned plant parts and butterfly valve.

WARNING

Danger of burning due to hot or cold components and pipe!

The actuator and pipe can become very hot or very cold during operation and cause burns upon contact.

- ⇒ Let the components and pipes cool down or warm up.
- ⇒ Wear protective garments and protective gloves.

Danger of injury due to pressurised components and escaping medium!

- ⇒ Pressurised components may not be loosened.

Hearing damage and deafness due to a high sound level!

During operation, medium-related noise emissions may be generated depending on the plant conditions. In addition, there may be a short-term high sound pressure level when a pneumatic actuator or pneumatic attachment is suddenly ventilated without noise-reducing elements. Both can damage hearing.

- ⇒ Wear hearing protection when working in the vicinity of the actuator.

Danger of crushing due to moving parts

The actuator contains moving parts (e.g. shaft and wedge-lock-washer) that can lead to crushing if reaching into it.

- ⇒ During operation, do not reach into the bracket between the butterfly valve and the actuator.
- ⇒ Before working on the actuator, interrupt and lock the pneumatic energy and the control signal.
- ⇒ Do not allow the jamming of objects in the bracket to hinder the rotation of the shaft.
- ⇒ In the case of a blocked shaft, contact SAMSON LEUSCH through the nearest SAMSON office.

WARNING

Danger of injury due to escaping exhaust air!

During operation, when regulating or when opening and closing the butterfly valve, exhaust air can escape, for example from the actuator.

- ⇒ Wear eye protection when working in the vicinity of the actuator.

Danger of injury due to preloaded springs!

Actuators that are equipped with preloaded actuator springs are under mechanical tension. The marking on the actuator type plate indicates whether spring return is available and the fail-safe position. The marking on the type plates is described in the instruction manuals for the actuators.

- ⇒ Release the compression from the preloaded springs before working on the actuator, see the corresponding actuator documentation.

Danger of injury due to residual medium in the butterfly valve!

When working on the butterfly valve, residual medium can escape and, depending on the medium properties, cause injuries (e.g. scalding, chemical burns).

- ⇒ If possible, empty the medium from the concerned plant parts and butterfly valve.
- ⇒ Wear protective garments, protective gloves and eye protection.

Damage to the butterfly valve due to unsuitable lubricants!

The functionality of the butterfly valve is ensured only by using a certain lubricant. Unsuitable lubricants can corrode and damage the surface.

- ⇒ Only use lubricants recommended by SAMSON LEUSCH, see Chapter "15.1.2 Lubricants".

NOTE

Damage to the butterfly valve due to the subsequent fitting of the actuator!

- ⇒ If the actuator is delivered separately from the butterfly valve or if it must be disassembled, observe the corresponding assembly instructions.

Damage to the butterfly valve due to excessively high or low tightening torques!

The butterfly valve components must be tightened with specific torques, see Chapter "15.1.1 Tightening torques". Excessively tightened components are subject to increased wear. Insufficiently tightened components can cause leakage.

- ⇒ Observe the tightening torques.

Info

The actuator was checked by SAMSON LEUSCH prior to delivery.

- Certain test results certified by SAMSON LEUSCH are no longer valid when performing maintenance work on the actuator. This includes the test for seat leakage and the leak test (outer tightness).
- If maintenance and repair work is performed without approval from the After Sales Service of SAMSON LEUSCH, the product guarantee will be voided.
- For spare parts, only use original parts from SAMSON LEUSCH that correspond to the original specification.

9.1 Periodic tests

Depending on the conditions of use, the actuator must be checked at defined intervals in order to take remedial measures prior to possible malfunctions. The plant operator is responsible for preparing a suitable test plan in consideration of the documentation of the utilised components.



After Sales Service can provide you with support for creating a test plan specific to your plant. Contact the nearest SAMSON office.

SAMSON LEUSCH recommends the following inspections that can be carried out during operation:

Test	Measures in the case of a negative test result
Check the butterfly valve for exterior damage (e.g. corrosion).	Remedy any damage immediately, if possible. If required, decommission the actuator, see chapter 10.
Check the imprints and impressions on the actuator, adhesives and signs for legibility and completeness.	Request a replacement for damaged, missing or faulty signs or adhesives and replace them. Clean text that is illegible due to dirt.
Check the butterfly valve for leaks from the outside.	Tighten the packing, see Chapter 5.1.1. Tighten the screw connections on the bonnet and extension, see Chapter 5.1.1 or replace the corresponding seals. Check the flange connection (tightening torques) and replace the seals on the flange connection if necessary, see Chapter 9.4.
Check the actuator, attachments and their piping for leaks.	Proper tightening of the pipe connections. In the case of defective components, contact SAMSON LEUSCH through the nearest SAMSON office.
Check the inner tightness of the butterfly valve.	Rinse the plant part with the butterfly valve open, to remove any dirt and/or deposited foreign material from between the seat and the seal ring. Check the end position to the closed position and adjust if necessary. Replace the seat and seal ring, see Chapter 9.3.4

Test	Measures in the case of a negative test result
Check the rotary movement of the actuator for a smooth, rotating movement.	Check the packing for correct tightening torque and tighten correctly if necessary, see Chapter 5.1.1.
	Check the functionality/energy supply of the actuator and the attachments and take suitable measures if necessary.
	If the actuator shaft is blocked, contact SAMSON LEUSCH immediately through the nearest SAMSON office.
	Decommission the actuator, see chapter 10. Then determine the cause and remedy it, see Chapter 8.1.
If required, check the fail-safe position of the actuator (partial stroke/full stroke test).	Contact SAMSON LEUSCH through the nearest SAMSON office.

9.2 Preparing maintenance work

- ⇒ Get the material and tools ready that are required for the maintenance work.
- ⇒ Identify the components that should be checked or serviced.
- ⇒ If components are to be replaced, it is recommended to contact SAMSON LEUSCH through the nearest SAMSON office.
- ⇒ Decommission the actuator, see chapter “10 Decommissioning”.
- ⇒ Interrupt the pneumatic energy to the actuator (deenergise and depressurise).

9.3 Maintenance work

9.3.1 Maintenance work on the attachments

Observe the documentation for the corresponding attachments.

9.3.2 Maintenance work on the actuator

Observe the documentation for the corresponding actuator.

9.3.3 Maintenance work on the butterfly valve in an installed condition

At least one SAMSON LEUSCH Seal Kit is required to perform this work.

SAMSON LEUSCH recommends the procurement of a corresponding rep-kit, see Chapter “15.3 Spare parts”.

9.3.3.1 Replacing the packing

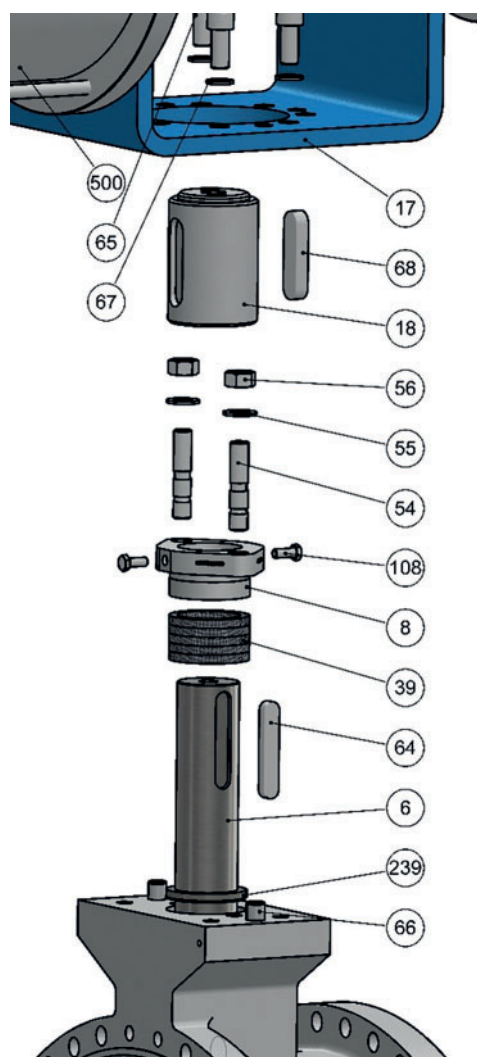


Figure 9-1: Packing replacement

Table 9-1: Parts list

Pos.	Designation
6	Shaft
8	Gland
17	Bracket
18	Coupling
39	Packing
54	Stud bolt
55	Washer
56	Nut
59	Spring washer

Pos.	Designation
64	Key
65	Screw
66	Pin
67	Wedge-lock-washer
68	Key
108	Screw
239	Support ring
500	Actuator

- ⇒ Secure the actuator (500) with a crane, see the corresponding actuator documentation.
- ⇒ Mark the installation position of the actuator.
- ⇒ Release only the screws (65) and wedge-lock-washers (67) between the bracket (17) and the butterfly valve.
- ⇒ Lift the actuator with the crane and put it down in a safe place.
- ⇒ Disassemble the coupling (18) and secure the key(s) (68) in it to prevent it from falling out.
- ⇒ Remove the key(s) (64).
- ⇒ Remove the nuts (56) and wedge-lock-washers (55) or spring washers (59). When reassembling the spring washer set, observe the correct sequence and alignment.
- ⇒ Release the screws (108) until the stuffing box can be pulled off.
- ⇒ Disassemble the gland (8) and remove the packing ring (39) carefully with a suitable tool. (The support ring (239) remains in the body.)
- ⇒ Remove any residues in the packing area and clean it.
- ⇒ Apply a thin layer of approved lubricant in the packing area, see Chapter "15.1.2 Lubricants"

WARNING

Damage to the butterfly valve due to unsuitable lubricants!

The functionality of the butterfly valve is ensured only by using a certain lubricant. Unsuitable lubricants can corrode and damage the surface.

- ⇒ Only use lubricants recommended by SAMSON LEUSCH, see Chapter "15.1.2 Lubricants".

- ⇒ In the case of increased requirements on the outer tightness (TA-Luft), see Chapter "15.1.1 Tightening torques" or ► LW-10007.
- ⇒ Insert the new packing rings (39) one after the other. If available, it must be ensured that the trimmed edges are offset with respect to each other.
- ⇒ Assemble the gland (8), nuts (56) and wedge-lock-washers (55) or spring washers (59).

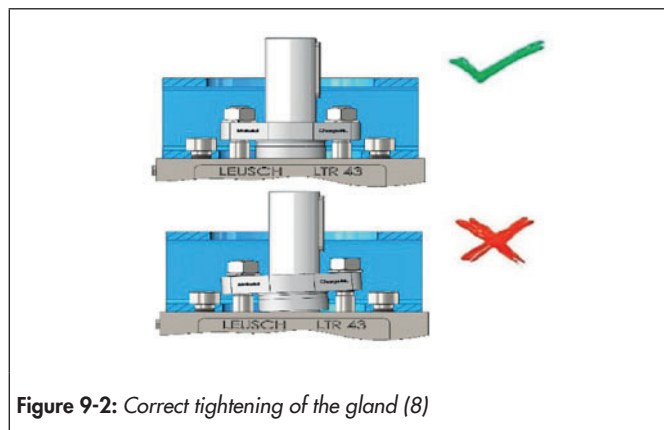


Figure 9-2: Correct tightening of the gland (8)

- ⇒ Tighten the nuts (56) alternately with slight manual force. Make sure that the stuffing box does not tilt with respect to the shaft.
- ⇒ Assemble the key(s) (68).
- ⇒ Tighten the nuts (56) in a criss-cross pattern with the specified torques, see Chapter 15.1.1 or ► LW-10006 (STD) or ► LW-10007 (TA-Luft).
- ⇒ Assemble the actuator in the marked installation position.
- ⇒ Check the tightness of the packing (39) and the functionality of the actuator, see chapter "5.4 Checking the assembled actuator". If the packing leaks, tighten the nuts (56) in a criss-cross pattern in small steps. If there is still leakage, contact SAMSON LEUSCH through the nearest SAMSON office.

9.3.3.2 Replacing the gasket cover

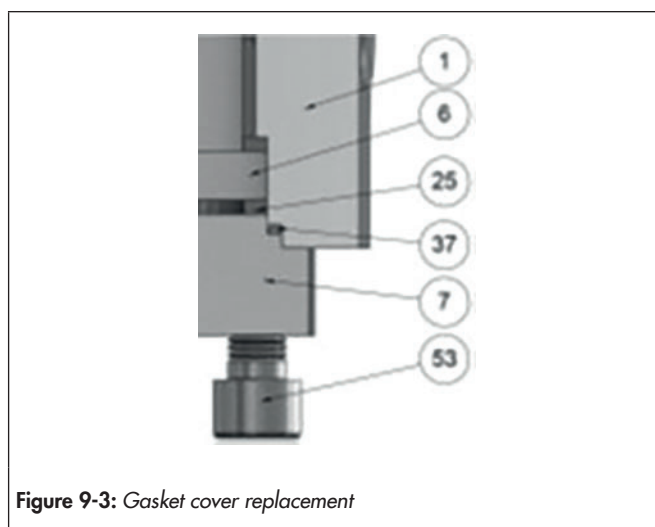


Figure 9-3: Gasket cover replacement

Table 9-2: Parts list

Pos.	Designation
1	Body
6	Shaft
7	Bonnet
25	Thrust ring
37	End cap seal
53	Screw

- ⇒ Release and remove the screws (53), see Figure 9 3.
- ⇒ Disassemble the bonnet (7) and remove the old cover sealing (37). During disassembly, make sure that the thrust ring (25) does not fall out.
- ⇒ Remove the residues and check for damage.
- ⇒ Apply a thin layer of approved lubricant on the new gasket cover (37) and thrust ring (25) and position them on the bonnet (7) and install.

- ⇒ First tighten the screws (53) cross-wise with slight manual force. Then tighten with the specified tightening torque, see Chapter "15.1.1 Tightening torques" or ► LW-10017 Annex 15.2.
- ⇒ Check the butterfly valve for any leaks in this area prior to commissioning. If there is still leakage, contact SAMSON LEUSCH through the nearest SAMSON office.

9.3.4 Maintenance work on the butterfly valve in a removed condition

Observe Chapter 11 for actuator disassembly.

SAMSON LEUSCH recommends a rep-kit for the performance of this work, see Chapter "15.3 Spare parts".

Replacing the seat and seal ring

The series differ in the design of the sealing system, see Chapter 9.6.

The procedure for replacing the seat and seal ring is described in separate documentation, see the "Applicable documents" in Chapter 1. The specific series is identified on the type plate, see Chapter "2 Markings on the device". For series LTR 43-2 and LTR 43-9.9, the seat and seal ring must always be replaced in pairs.

9.4 Assembling and commissioning the actuator after maintenance work

The assembly and commissioning of the actuator takes place according to the specifications in Chapter "5 Assembly" and "6 Commissioning".

9.5 Design of the sealing system

The following figures describe the constructive design of the sealing system of the different LTR43 butterfly valve series.

9.5.1 Butterfly valve LTR 43-2 and LTR 43-9.2

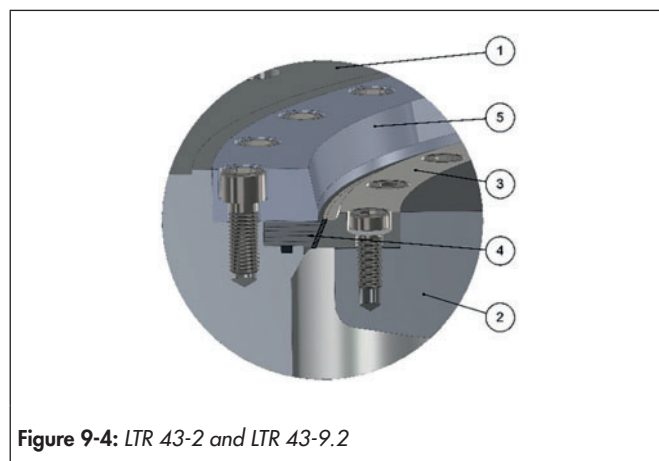


Figure 9-4: LTR 43-2 and LTR 43-9.2

Table 9-3: Parts list for LTR 43-2 and LTR 43-9.2

Pos.	Designation
1	Body
2	Wedge-lock-washer
3	Seal ring
4	Seat
5	Retaining ring

9.5.2 Butterfly valve LTR 43-3

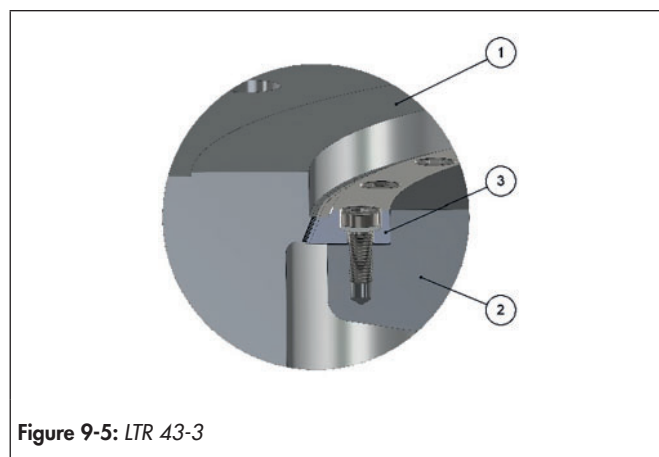


Figure 9-5: LTR 43-3

Table 9-4: Parts list for LTR 43-3

Pos.	Designation
1	Body
2	Wedge-lock-washer
3	Seal ring

9.5.3 Butterfly valve LTR 43-4 and LTR 43-9.4

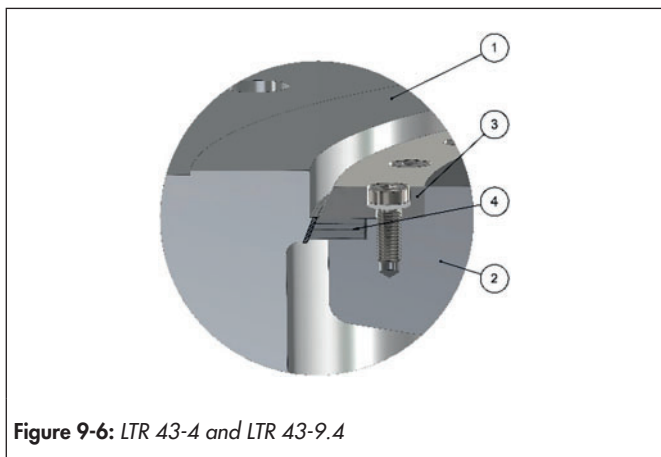


Table 9-5: Parts list for LTR 43-4 and LTR 43-9.4

Pos.	Designation
1	Body
2	Wedge-lock-washer
3	Clamping ring
4	Seal ring

9.5.4 Butterfly valve LTR 43-9.9

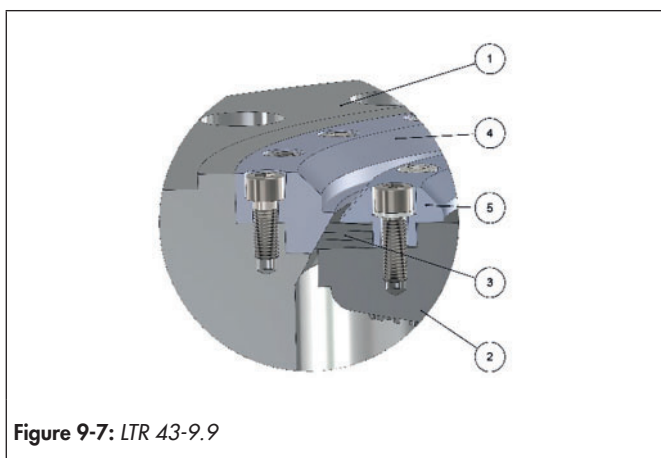


Table 9-6: Parts list for LTR 43-9.9

Pos.	Designation
1	Body
2	Wedge-lock-washer
3	Seal ring
4	Seat
5	Clamping ring

10 Decommissioning

The work described in this chapter may only be performed by specialist personnel qualified to perform the corresponding task.

! DANGER

Risk of bursting due to pressurised devices and components!

Butterfly valves and pipes are pressure equipment that can burst if handled improperly. Projecting, flying components, fragments and released pressurised medium can cause injuries or even death.

Before working on the actuator:

- ⇒ Depressurise the concerned plant parts and actuators. Also discharge the residual energy.
- ⇒ Empty the medium from the concerned plant parts and butterfly valve.

! WARNING

Danger of burning due to hot or cold components and pipe!

The actuator and pipe can become very hot or very cold during operation and cause burns upon contact.

- ⇒ Let the components and pipes cool down or warm up.
- ⇒ Wear protective garments and protective gloves.

Danger of injury due to pressurised components and escaping medium!

- ⇒ Pressurised components may not be loosened.

Hearing damage and deafness due to a high sound level!

During operation, medium-related noise emissions may be generated depending on the plant conditions. In addition, there may be a short-term high sound pressure level when a pneumatic actuator or pneumatic attachment is suddenly ventilated without noise-reducing elements. Both can damage hearing.

- ⇒ Wear hearing protection when working in the vicinity of the actuator.

Danger of crushing due to moving parts!

The actuator contains moving parts (e.g. shaft and wedge-lock-washer) that can lead to crushing if reaching into it.

- ⇒ During operation, do not reach into the bracket between the butterfly valve and the actuator.
- ⇒ Before working on the actuator, interrupt and lock the pneumatic energy and the control signal.
- ⇒ Do not allow the jamming of objects in the bracket to hinder the rotation of the shaft.
- ⇒ If the shaft is blocked, contact SAMSON LEUSCH through the nearest SAMSON office.

Danger of injury due to escaping exhaust air!

During operation, when regulating or when opening and closing the butterfly valve, exhaust air can escape, for example from the actuator.

- ⇒ Wear eye protection when working in the vicinity of the actuator.

! WARNING

Danger of injury due to residual medium in the butterfly valve!

When working on the butterfly valve, residual medium can escape and, depending on the medium properties, cause injuries (e.g. scalding, chemical burns).

- ⇒ If possible, empty the medium from the concerned plant parts and butterfly valve.
- ⇒ Wear protective garments, protective gloves and eye protection.

Danger of injury due to preloaded springs!

Actuators that are equipped with preloaded actuator springs are under mechanical tension. The marking on the actuator type plate indicates whether a spring return is available and the fail-safe position. The marking on the type plates is described in the instruction manuals for the actuators.

- ⇒ Release the compression from the preloaded springs before working on the actuator, see the corresponding actuator documentation.

! NOTE

If the actuator is delivered separately from the butterfly valve or if it must be disassembled, the corresponding assembly instructions must be observed.

To decommission the actuator for maintenance work or for disassembly, perform the following steps:

- ⇒ Depressurise the pipes and butterfly valves and remove residual medium from the pipe.
- ⇒ Shut off the pneumatic energy and lock it, to deenergise and depressurise the actuator.
- ⇒ Let the pipe and butterfly valve components cool down or warm up.

11 Removal

The work described in this chapter may only be performed by specialist personnel qualified to perform the corresponding task. The After Sales Service of SAMSON is glad to provide on-site consultation and support. Contact the nearest SAMSON office.

WARNING

Danger of burning due to hot or cold components and pipe!

The actuator and pipe can become very hot or very cold during operation and cause burns upon contact.

- ⇒ Let the components and pipes cool down or warm up.
- ⇒ Wear protective garments and protective gloves.

Danger of crushing due to moving parts

- ⇒ Before working on the actuator, interrupt and lock the pneumatic energy and the control signal and release the spring tension in the actuator if necessary.
- ⇒ Do not allow the jamming of objects in the bracket to hinder the rotation of the shaft.
- ⇒ If the shaft is blocked, contact SAMSON LEUSCH through the nearest SAMSON office.

Danger of injury due to residual medium in the butterfly valve!

When working on the butterfly valve, residual medium can escape and, depending on the medium properties, cause injuries (e.g. scalding, chemical burns).

- ⇒ Empty the medium from the concerned plant parts and butterfly valve.
- ⇒ Wear protective garments, protective gloves and eye protection.

Danger of injury due to preloaded springs!

Actuators that are equipped with preloaded actuator springs are under mechanical tension. The marking on the actuator type plate indicates whether a spring return is available and the fail-safe position. The marking on the type plates is described in the instruction manuals for the actuators.

- ⇒ Release the compression from the preloaded springs before working on the actuator, see the corresponding actuator documentation.

NOTE

If the actuator is delivered separately from the butterfly valve or if it must be disassembled, the corresponding assembly instructions must be observed.

Prior to disassembly, make sure that the following conditions are met:

- ⇒ The actuator is decommissioned, see chapter 10.
- ⇒ When using manual auxiliary actuations, observe the corresponding documentation to bring the actuator into the closed position.
- ⇒ Check the closed position.

- ⇒ To ensure collision-free removal, suitable measures must be taken, see Chapter 5.3.2. In the case of noise-reducing versions of the wedge-lock-washer that also protrude past the overall length, the order-related dimension sheet must be observed.

11.1 Removing the butterfly valve with an assembled actuator from the pipe

- ⇒ Fasten the actuator with suitable lifting equipment and pay attention to the centre of gravity of the actuator, see chapter "4.3 Transporting and lifting the actuator".

NOTE

Swivel and/or tipping danger

- ⇒ If necessary, release and remove the supports or mountings.
- ⇒ Remove the actuator, depending on the version, from the pipe as follows:

Version with flange

- ⇒ Loosen the flange connection properly.
- ⇒ Disassemble the screws and seals and store them appropriately.

Versions with welded ends

DANGER

Danger of explosion due to residual medium!

There may be explosive residual medium in the pipe or butterfly valve.

- ⇒ Use suitable measures to prevent the risk of explosion.

- ⇒ Separate the pipe in the middle of both welding seams of the actuator.

NOTE

Cutting hazard on sharp-edged cut surfaces!

- ⇒ Avoid touching the cut surfaces.
- ⇒ Wear safety gloves and corresponding protective clothing.

- ⇒ Lift the actuator carefully out of the installation site using suitable lifting equipment, see Chapter "4.3.2 Lifting the actuator".
- ⇒ Check the closed position.
- ⇒ Place the actuator in a safe position on suitable ground and secure it to prevent it from tipping.

 **DANGER**

Danger of injury due to a spring-loaded opening actuator

The uncontrolled swinging movement of the wedge-lock-washer can be dangerous.

⇒ *Do not stay in danger zone.*

- ⇒ Mark or document the installation position of the actuator.
- ⇒ For the transport and storage of the actuator, observe Chapter "4 Shipment and on-site transport".

11.2 Disassembling the actuator

- ⇒ Secure the actuator with the crane.
- ⇒ Mark or document the installation position of the actuator.
- ⇒ Only the screws (65) between the bracket and butterfly valve may be loosened.
- ⇒ Lift the actuator with the crane and put it down in a safe place.

12 Repairs

If the actuator is no longer compliant or if it does not work at all, it is defective and must be repaired or replaced.

NOTE

Damage to the actuator due to improper repairs!

- ⇒ Only have repair work performed by qualified and trained personnel.
 - ⇒ If required, SAMSON LEUSCH can be contacted through the nearest SAMSON office.
-

12.1 Sending devices to SAMSON LEUSCH

Defective actuators can be sent to SAMSON LEUSCH for repair.

When returning devices to SAMSON LEUSCH, proceed as follows:

- ⇒ Decommission the actuator, see chapter 10, and disassemble it, see Chapter 11.
 - ⇒ Decontaminate the butterfly valve. Remove residual medium completely.
 - ⇒ Fill out the declaration regarding contamination. The form can be downloaded from <https://www.samsongroup.com/de/service-support/after-sales-service/retouren/>.
 - ⇒ Contact the nearest SAMSON office concerning the formalities. A list of SAMSON offices is available at <https://www.samsongroup.com/de/>.
-

Info

Further information about sending in devices or regarding returns can be found at <https://www.samsongroup.com/de/service-support/after-sales-service/retouren/>.

13 Disposal

- ⇒ For disposal, observe the local, national and international regulations.
- ⇒ Do not dispose of old components, lubricant and hazardous materials with domestic waste.

14 Certificates

The declaration of conformity is available on the following pages:

- Declaration of conformity according to Pressure Equipment Directive 2014/68/EU and according to AD 2000 regulations, see Page 14-2.
- Declaration of conformity according to Pressure Equipment Directive 2014/68/EU and according to EN 16668 and EN 1349, see page 14-3.
- Declaration of conformity for completed machinery according to Machinery Directive 2006/42/EC for butterfly valve LTR 43, see page 14-4.
- Declaration of installation for partly completed machinery according to Machinery Directive 2006/42/EC for butterfly valve LTR 43, see page 14-5

The printed certificates correspond to the status at the time of printing. Further optional certificates are available upon request.

DECLARATION OF CONFORMITY

Pressure Equipment Directive 2014/68/EU



The manufacturer	LEUSCH GmbH Industrial Valves , 41472 Neuss, Germany
declares for the listed products:	Butterfly valves series LTR43 with packing and adjustable stuffing box <ul style="list-style-type: none"> • with pneumatic/ electric/ hydraulic actuator • with free shaft end for subsequent mounting of an actuator • with gearbox and handwheel
<p>1. The valves are pressure accessories within the meaning of the Pressure Equipment Directive 2014/68/EU and conform with the requirements of this directive.</p> <p>2. They may only be operated observing the installation and operating instructions ► EB LTR43.</p> <p>Commissioning of the units is only permitted when the valve is connected to both sides of the pipeline and a risk of injury is thus excluded.</p> <p>(See ► EB LTR43, Chapter 1 for butterfly valves intended for dead-end service)</p>	

Applied standards:

AD2000	Regulations for pressurized valve body parts
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Type description and technical features:

LEUSCH data sheet ► T LW20010 NOTE: This declaration applies to all valve types listed in the data sheet.

Applied conformity assessment procedure:

Conforming to Annex III of the Pressure Equipment Directive 2014/68/EU, Module H


Name of notified body:

Identification number of the notified body:

TÜV Rheinland Service GmbH Am Grauen Stein 51101 Köln	0035
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Modifications to valves which have an effect on the technical data of the valve or on the intended use (see ► **EB LTR43**, Chapter 1) and which substantially change the valve make this declaration invalid.

Neuss, 4th April 2023


 Bernd Jenner
 Chief Executive Officer

DECLARATION OF CONFORMITY

Pressure Equipment Directive 2014/68/EU



The manufacturer	LEUSCH GmbH Industrial Valves , 41472 Neuss, Germany
declares for the listed products:	<p>Butterfly valves series LTR43 with packing and adjustable stuffing box</p> <ul style="list-style-type: none"> • with pneumatic/ electric/ hydraulic actuator • with free shaft end for subsequent mounting of an actuator • with gearbox and handwheel
<p>1. The valves are pressure accessories within the meaning of the Pressure Equipment Directive 2014/68/EU and conform with the requirements of this directive.</p> <p>2. They may only be operated observing the installation and operating instructions ► EB LTR43.</p> <p>Commissioning of the units is only permitted when the valve is connected to both sides of the pipeline and a risk of injury is thus excluded.</p> <p>(See ► EB LTR43, Chapter 1 for butterfly valves intended for dead-end service)</p>	

Applied standards:

EN16668	Industrial valves – Requirements and testing for metallic valves as pressure accessories
EN1349	Industrial process control valves

Type description and technical features:

LEUSCH data sheet ► T LW20010

NOTE: This declaration applies to all valve types listed in the data sheet.

Applied conformity assessment procedure:

Conforming to Annex III of the Pressure Equipment Directive 2014/68/EU, Module H

Name of notified body:

Identification number of the notified body:

TÜV Rheinland Service GmbH Am Grauen Stein 51101 Köln	0035
--	------

Modifications to valves which have an effect on the technical data of the valve or on the intended use (see ► EB LTR43, Chapter 1) and which substantially change the valve make this declaration invalid.

Neuss, 4th April 2023


Bernd Jenner
Chief Executive Officer

DECLARATION OF CONFORMITY

Machinery Directive 2006/42/EC



The manufacturer	LEUSCH Industrial Valves , 41472 Neuss, Germany
declares for the listed products that:	<p>Control and shut-off butterfly valve series LTR43</p> <ul style="list-style-type: none"> • with a quarter-turn actuator series AT-RP • with a quarter-turn actuator series AT-HD • with a different rotary actuator <p>PREREQUISITE: the unit was designed and assembled by LEUSCH GmbH. The serial number on the valve refers to the entire unit.</p>
<p>1. they comply with all applicable requirements stipulated in Machinery Directive 2006/42/EC.</p> <p>2. in the delivery state, the valve with actuator is considered to be a completed machine as defined in the above mentioned directive.</p> <p>Commissioning of these unit is only permitted when the valve is connected to both sides of the pipeline and a risk of injury is thus excluded.</p>	

Referenced standards:

- a) VCI, VDMA, VGB: "Leitfaden Maschinenrichtlinie (2006/42/EG) – Bedeutung für Armaturen", May 2018 [German only]
- b) VCI, VDMA, VGB: "Zusatzdokument zum Leitfaden Maschinenrichtlinie (2006/42/EG) – Bedeutung für Armaturen", May 2018 [German only], based on DIN EN ISO 12100:2011-03

Product description and technical features:

Butterfly valve for liquid or gaseous media, particularly for high requirements in oil-, gas- or chemical applications, automated with a single or double-acting piston actuator for rotating trims.

For product descriptions refer to:

LEUSCH data sheet for valve series LTR43 ▶ T LW20010
 data sheet for actuator series AT-RP ▶ T.D.S. No: 2.1.1.0 – 2.1.1.17 (4th Generation Upgrade Series)
 data sheet for actuator series AT-HD ▶ Catalogue No: HD-E-04/M (Metric technical catalogue)
 mounting and operating instruction for series LTR43 ▶ EB LTR43
 mounting and operating instruction for actuator series AT-RP ▶ EB AT-RP-4GU
 mounting and operating instruction for actuator series AT-RP-X01 ▶ EB AT-RP-X01
 mounting and operating instruction for actuator series AT-HD ▶ EB AT-HD
 mounting and operating instructions for different rotary actuators

Valve accessories (e.g. positioners, limit switches, solenoid valves, lock-up valves, supply pressure regulators, volume boosters and quick exhaust valves) are classified as machinery components and do not fall within the scope of the Machinery Directive as specified in § 35 and § 46 of the above mentioned guide to the Machinery Directive.

Modifications to valves which have an effect on the technical data of the valve or on the intended use (see ▶ EB LTR43, Chapter 1) and which substantially change the valve make this declaration invalid.

Neuss, 4th April 2023



Bernd Jenner
Chief Executive Officer

Declaration of Incorporation

Machinery Directive 2006/42/EC



The manufacturer	LEUSCH GmbH Industrial Valves, 41472 Neuss, Germany
declares for the listed products that:	Butterfly valve series LTR43 <ul style="list-style-type: none"> • with free shaft end (without actuator) • not intended for a defined actuated system
<p>1. in the delivery state, i.e. prepared for the assembly of a quarter-turn actuator (no clearly defined actuator system) are considered "partly completed machinery" in the sense of the Machinery Directive (2006/42/EC).</p> <p>Machines are to be considered as partly completed machines if the manufacturer has not defined all necessary specifications including type, connectors, forces, torques, etc.</p> <p>Commissioning of these unit is only permitted when the valve is connected to both sides of the pipeline and a risk of injury is thus excluded.</p>	

Referenced standards:

- a) VCI, VDMA, VGB: "Leitfaden Maschinenrichtlinie (2006/42/EG) – Bedeutung für Armaturen", May 2018 [German only]
- b) VCI, VDMA, VGB: "Zusatzdokument zum Leitfaden Maschinenrichtlinie (2006/42/EG) – Bedeutung für Armaturen", May 2018 [German only], based on DIN EN ISO 12100:2011-03

Product description and technical features:

Butterfly valve for liquid or gaseous media, particularly for high requirements in oil-, gas- or chemical applications.

For product descriptions refer to:

LEUSCH-data sheet for series LTR43 ▶ T LW20010

mounting and operating instruction for series LTR43 ▶ EB LTR 43

Valve accessories, e.g. positioners, limit switches, solenoid valves, lock-up valves, supply pressure regulators, volume boosters or quick exhaust valves are classified as machinery components and do not fall within the scope of the Machinery Directive as specified in § 35 and § 46 of the mentioned guideline.

Modifications to valves which have an effect on the technical data of the valve or on the intended use (see ▶ EB LTR43, Chapter 1) and which substantially change the valve make this declaration invalid.

Neuss, 4th April 2023


 Bernd Jenner
 Chief Executive Officer

15 Annex

15.1 Tightening torques, lubricant and tools

15.1.1 Tightening torques

15.1.1.1 Bonnet, seat, seat ring, clamping ring, retaining plate, shaft, extension and bracket

Table 15-1: The tightening torques apply for materials A2-70, 1.4980, Monel K500 and 1.4462

Thread size	Max. torque [Nm] for screws according to DIN 7984 (low head), see Figure 1	Max. torque [Nm] for screws according to ISO 4762 (high head), see Figure 2
M6	7.3	9.1
M8	17.5	21.8
M10	35	44
M12	60	75
M16	144	180
M20	296	370
M24	486	608
M27	336	421
M30	457	571
M33	623	779

The values in the table according to technical data sheet
 ► LW-10017, Annex 15.2, apply for lubricated threads



15.1.1.2 Stuffing box nuts (standard)

Values in the following table according to technical data sheet
 ► LW-10006

Table 15-2: PN 10 / 16 / 25 and cl150 (max. 28 bar)

Nominal size		Stuffing box	Ø shaft	Graphite packing M _{min.} [Nm]	PTFE packing M _{min.} [Nm]	Max. permissible M _{max.} [Nm]
NPS	DN					
3	80	M10	20	6	8	35
4	100	M10	20	6	8	35
6	150	M12	25	14	18	60
8	200	M12	25	14	18	60
10	250	M12	30	16	20	60
12	300	M12	35	18	23	60
14	350	M16	40	27	34	144
16	400	M16	50	33	41	144
18	450	M16	50	33	41	144
20	500	M20	60	48	60	296
24	600	M20	70	75	94	296
28	700	M20	70	75	94	296
30	750	M20	70	75	94	296
32	800	M20	80	85	106	296
36	900	M20	80	85	106	296
40	1000	M24	100	125	156	486

Table 15-3: PN 40 and cl300 (max. 55 bar)

Nominal size		Stuffing box	Ø shaft	Graphite packing M _{min.} [Nm]	PTFE packing M _{min.} [Nm]	Max. permissible M _{max.} [Nm]
NPS	DN					
3	80	M10	20	6	8	35
4	100	M12	25	14	18	60
6	150	M12	30	16	20	60
8	200	M12	35	18	23	60
10	250	M16	40	27	34	144
12	300	M16	50	33	41	144
14	350	M20	60	48	60	296
16	400	M20	70	75	94	296
18	450	M20	70	75	94	296
20	500	M20	80	85	106	296
24	600	M24	100	125	156	486
28	700	M33	110	Upon request		
30	750	M24	120			
32	800	M30	130			
36	900	M30	130			
40	1000	M30	130			

Table 15-4: PN 63 (cl400) (max. 70 bar)

Nominal size		Stuffing box	Ø shaft	Graphite packing M _{min.} [Nm]	PTFE packing M _{min.} [Nm]	Max. permissible M _{max.} [Nm]
NPS	DN					
3	80	M12	25	14	18	60
4	100	M16	30	21	27	144
6	150	M16	35	24	30	144
8	200	M20	40	34	42	296
10	250	M16	50	33	41	144
12	300	M20	60	48	60	296
14	350	M20	70	75	94	296
16	400	M27	80	115	143	336
18	450	M27	80	115	143	336
20	500	M30	100	156	195	432
24	600	M24	120	Upon request		
28	700	M30	130			
30	750					
32	800					
36	900					
40	1000					

Table 15-5: PN 100 and cl600 (max. 110 bar)

Nominal size		Stuffing box	Ø shaft	Graphite packing M _{min.} [Nm]	PTFE packing M _{min.} [Nm]	Max. permissible M _{max.} [Nm]
NPS	DN					
3	80	M12	25	21	26	60
4	100	M16	30	31	39	144
6	150	M16	35	35	44	144
8	200	M20	40	49	62	296
10	250	M16	50	48	60	144
12	300	M20	60	70	88	296
14	350	M20	70	111	138	296
16	400	M27	80	168	210	336
18	450	M27	80	168	210	336
20	500	M30	100	229	287	432
24	600	M24	120	Upon request		
28	700	M30	130			
30	750					
32	800					
36	900					
40	1000					

15.1.1.3 Stuffing box nuts (TA-Luft)

Values in the following table according to technical data sheet
▶ LW-10007

Table 15-6: PN 10 / 16 / 25 and cl150

Nominal size		Stuffing box	Ø Shaft	Pure graphite packing		Other packings	
NPS	DN			T _{presealed} [Nm]	Torque [Nm]	T _{presealed} [Nm]	Torque [Nm]
3	80	M10	20	25	19	21	12
4	100	M10	20	25	18	21	12
6	150	M12	25	56	42	47	28
8	200	M12	25	56	42	47	28
10	250	M12	30	65	49	54	33
12	300	M12	35	74	55	61	37
14	350	M16	40	108	81	90	54
16	400	M16	50	130	98	109	65
18	450	M16	50	130	98	109	65
20	500	M20	60	191	143	159	96
24	600	M20	70	302	226	252	151
28	700	M24	70	302	226	252	151
30	750	M20	70	302	226	252	151
32	800	M20	80	340	255	283	170
36	900	M20	80	340	255	283	170
40	1000	M24	100	498	374	415	249

Table 15-7: PN 40 and cl300

Nominal size		Stuffing box	Ø Shaft	Pure graphite packing		Other packings	
NPS	DN			T _{presealed} [Nm]	Torque [Nm]	T _{presealed} [Nm]	Torque [Nm]
3	80	M10	20	25	19	21	12
4	100	M12	25	56	42	47	28
6	150	M12	30	65	49	54	33
8	200	M12	35	74	55	61	37
10	250	M16	40	108	81	90	54
12	300	M16	50	130	98	109	65
14	350	M20	60	191	143	159	96
16	400	M20	70	302	226	252	151
18	450	M20	70	302	226	252	151
20	500	M20	80	340	255	283	170
24	600	M24	100	498	374	415	249
28	700	M33	110	Upon request			
30	750	M24	120				
32	800	M30	130				
36	900	M30	130				
40	1000	M30	130				

Table 15-8: PN 63 / 100 and cl600

Nominal size		Stuffing box	Ø Shaft	Pure graphite packing		Other packings	
NPS	DN			T-presealed [Nm]	Torque [Nm]	T-presealed [Nm]	Torque [Nm]
3	80	M12	25	56	42	47	28
4	100	M16	30	85	64	71	42
6	150	M16	35	96	72	80	48
8	200	M16	40	134	101	112	67
10	250	M16	50	130	98	109	65
12	300	M20	60	191	143	159	96
14	350	M20	70	302	226	252	151
16	400	M27	80	458	344	382	229
18	450	M27	80	458	344	382	229
20	500	M30	100	625	469	521	313
24	600	M24	120	Upon request			
28	700	M30	130				
30	750						
32	800						
36	900						
40	1000						

15.1.2 Lubricant

Depending on the application and suitability, the following lubricants are approved by the manufacturer:

- Metaflux 70-85 Lubricating metal paste (standard)
- Gleitmo 595 (technical gases)
- Gleitmo 595 with BAM approval (oxygen)

The plant operator is responsible for the use of other lubricants.

15.1.3 Tools

Suitable tools are required to work on the valve. Unsuitable tools can damage the valve

15.2 Service

For maintenance and repair work as well as malfunctions or defects, contact the nearest SAMSON office for support.

The After Sales Service can be reached at the following e-mail address: info-leusch-de@samsongroup.com

Addresses for SAMSON AG and LEUSCH GmbH

The addresses for SAMSON AG and LEUSCH GmbH as well as their representatives and service locations are available online at www.samsongroup.com.

Necessary data

Provide the following information in the case of questions and for troubleshooting:

- Order and item number
- Type, TAG no., nominal size and version of the actuator or component (see the type plate).
- Current operating data
- Actuator signal pressure
- Installation situation in the pipe

15.3 Spare parts

! NOTE

If additional repairs or the replacement of further individual parts is required for the safe use of the butterfly valves, contact SAMSON LEUSCH through the nearest SAMSON office.

The following spare part kits are available:

- **Seal Kit** contains all soft seals and the stuffing box packing
- **Rep Kit** contains a seal kit including seal ring and seat (series related)

SAMSON LEUSCH recommends spare part kits for “Commissioning” and for “2-year operation”, see Chapter:

- “15.3.1 Series LTR43-2, LTR43-9.2” Control and shut-off valves, series LTR43-2 and LTR43-9.2
- “15.3.2 Series LTR43-3” Control and shut-off valve, series LTR43-3
- “15.3.3 Series LTR43-4, LTR43-9.4” Control and shut-off valves, series LTR43-4 and LTR43-9.4
- “15.3.4 Series LTR43-9” Control and shut-off valve, series LTR43-9

15.3.1 Series LTR43-2, LTR43-9.2

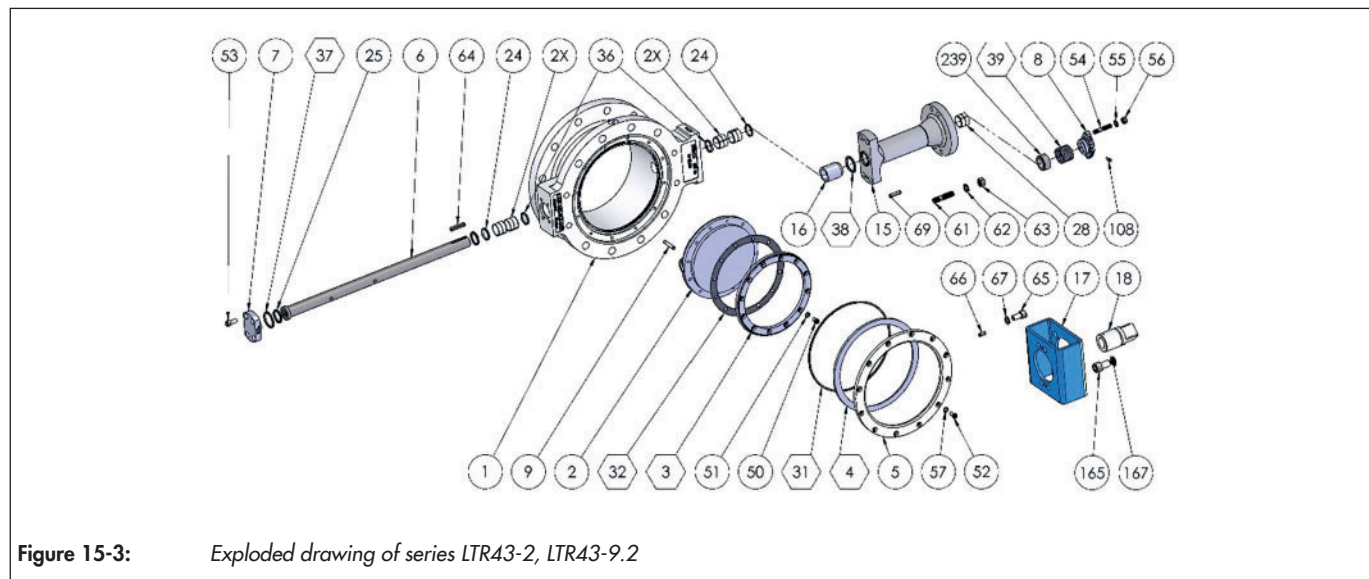


Figure 15-3: Exploded drawing of series LTR43-2, LTR43-9.2

Table 15-9: Parts list for series LTR43-2, LTR43-9.2

Pos.	Designation
1	Body
2	Disc
3*	Seal ring
4*	Seat
5	Retaining ring
6	Shaft
7	Cover
8	Gland
9	Pin
15	Extension
16	Extension spacer
17	Bracket
18	Coupling
2X	Bearing
24	Spacer ring
25	Thrust ring
28	Bearing
31*	Gasket body
32*	Gasket disc
36	Bearing protector
37*	Gasket cover
38*	Gasket extension

Pos.	Designation
39*	Packing
50	Screw
51	Wedge-lock-washer
52	Screw
53	Screw
54	Stud bolt
55	Washer
56	Nut
57	Wedge-lock-washer
61	Stud bolt
62	Wedge-lock-washer
63	Nut
64	Key
65	Screw
66	Pin
67	Wedge-lock-washer
69	Pin
108	Screw
165	Screw
167	Wedge-lock-washer
239	Support ring

* Recommended spare parts

15.3.2 Series LTR43-3

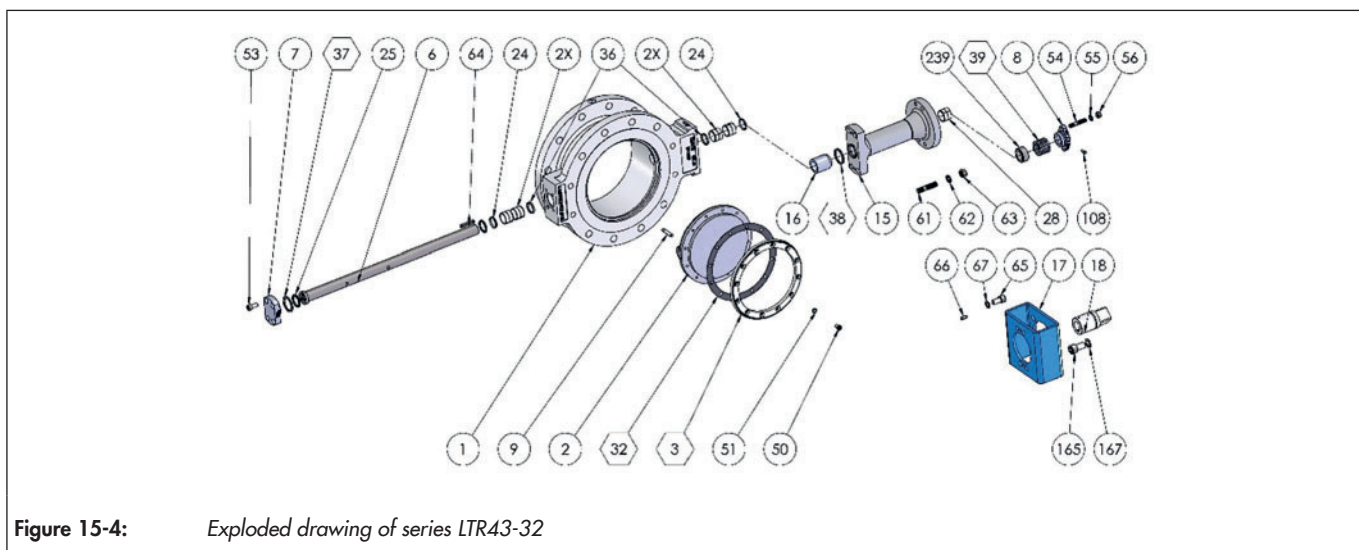


Figure 15-4: Exploded drawing of series LTR43-32

Table 15-10: Parts list for series LTR43-3

Pos.	Designation	Pos.	Designation
1	Body	39*	Packing
2	Disc	50	Screw
3*	Seal ring	51	Wedge-lock-washer
6	Shaft	53	Screw
7	Cover	54	Stud bolt
8	Gland	55	Washer
9	Pin	56	Nut
15	Extension	61	Stud bolt
16	Extension spacer	62	Wedge-lock-washer
17	Bracket	63	Nut
18	Coupling	64	Key
2X	Bearing	65	Screw
24	Spacer ring	66	Pin
25	Thrust ring	67	Wedge-lock-washer
28	Bearing	69	Pin
31*	Gasket body	108	Screw
32*	Gasket disc	165	Screw
36	Bearing protector	167	Wedge-lock-washer
37*	Gasket cover	239	Support ring
38*	Gasket extension		

* Recommended spare parts

15.3.3 Series LTR43-4, LTR43-9.4

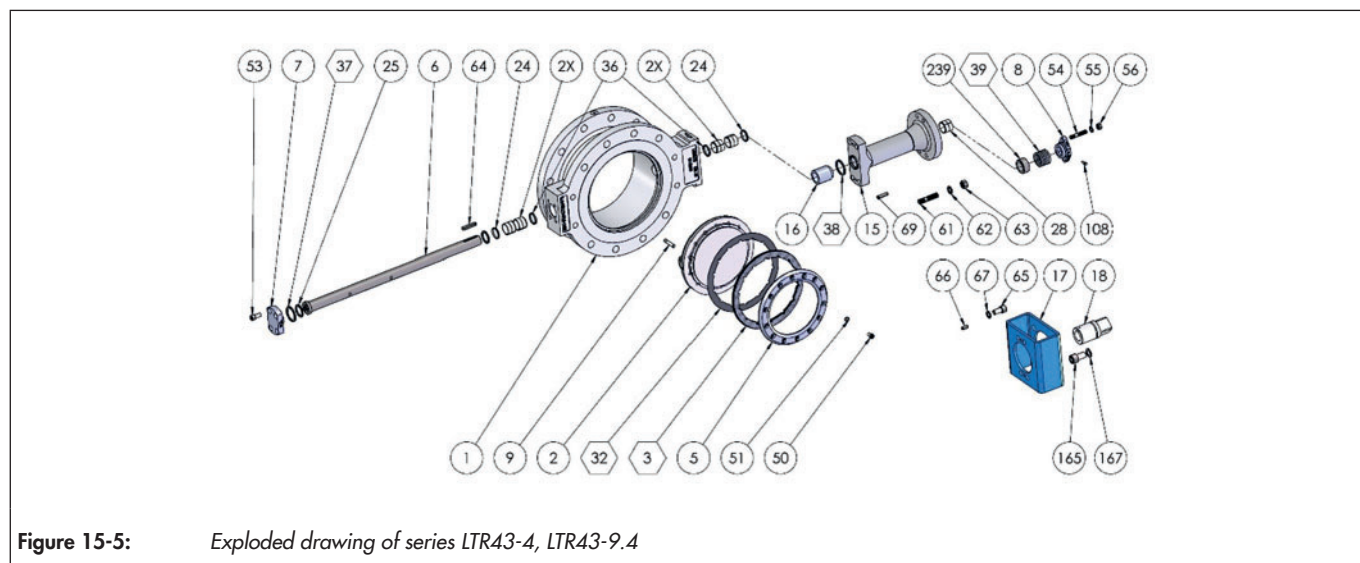


Figure 15-5: Exploded drawing of series LTR43-4, LTR43-9.4

Table 15-11: Parts list for series LTR43-4, LTR43-9.4

Pos.	Designation
1	Body
2	Disc
3*	Seal ring
5	Retaining ring
6	Shaft
7	Cover
8	Gland
9	Pin
15	Extension
16	Extension spacer
17	Bracket
18	Coupling
2X	Bearing
24	Spacer ring
25	Thrust ring
28	Bearing
32*	Gasket disc
36	Bearing protector
37*	Gasket cover
38*	Gasket extension

Pos.	Designation
39*	Packing
50	Screw
51	Wedge-lock-washer
52	Screw
53	Screw
54	Stud bolt
55	Washer
56	Nut
61	Stud bolt
62	Wedge-lock-washer
63	Nut
64	Key
65	Screw
66	Pin
67	Wedge-lock-washer
69	Pin
108	Screw
165	Screw
167	Wedge-lock-washer
239	Support ring

* Recommended spare parts

15.3.4 Series LTR43-9

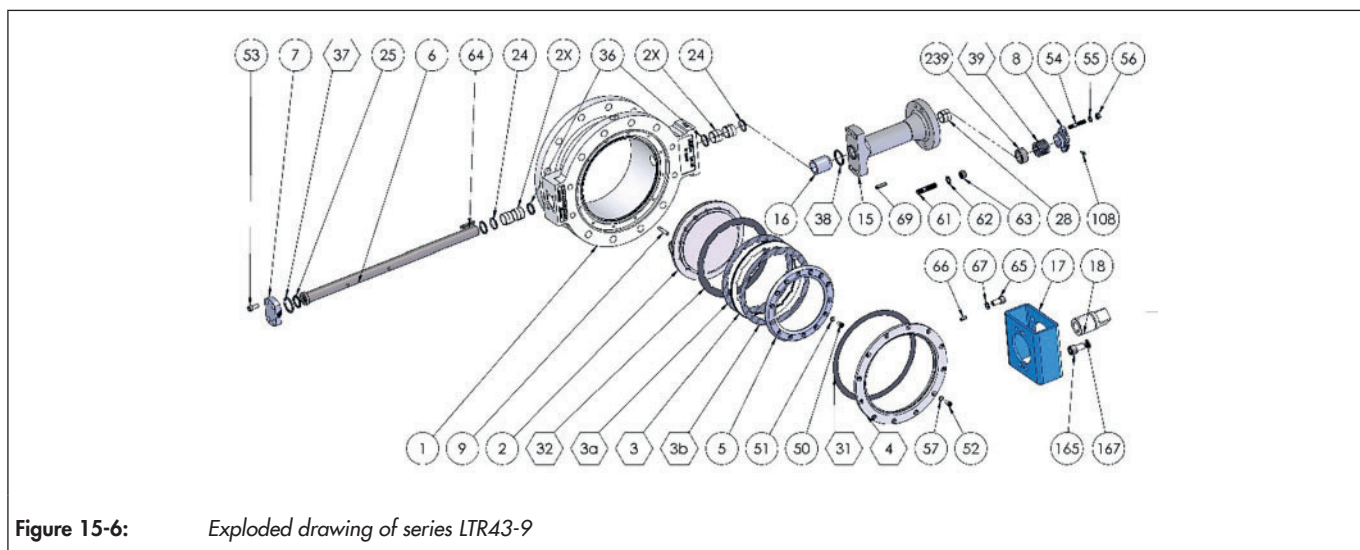


Figure 15-6: Exploded drawing of series LTR43-9

Table 15-12: Parts list for series LTR43-9

Pos.	Designation
1	Body
2	Disc
3*	Seal ring
4	Seat
5	Retaining ring
6	Shaft
7	Cover
8	Gland
9	Pin
15	Extension
16	Extension spacer
17	Bracket
18	Coupling
2X	Bearing
24	Spacer ring
25	Thrust ring
28	Bearing
32*	Gasket disc
36	Bearing protector
37*	Gasket cover
38*	Gasket extension

Pos.	Designation
39*	Packing
50	Screw
51	Wedge-lock-washer
52	Screw
53	Screw
54	Stud bolt
55	Washer
56	Nut
61	Stud bolt
62	Wedge-lock-washer
63	Nut
64	Key
65	Screw
66	Pin
67	Wedge-lock-washer
69	Pin
108	Screw
165	Screw
167	Wedge-lock-washer
239	Support ring

* Recommended spare parts



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