

# HABONIM

## N31 & N32 Series Installation, Operating & Maintenance

### Flanged Control Ball Valves

Series N31 – Class 150

Series N32 – Class 300

### Series included:

N31P, N31X, AFN31P,

N32P, N32X, AFN32P

### Sizes included:

1/2" - 8" (DN15 – DN200)

#### 1. GENERAL

This Installation, Operating & Maintenance manual presents the instructions required for safe use of Habonim Flanged ball control valves type N31& N32 series. This manual refers to reduced bore only. Before using any of these series valves, read the entire IOM carefully and make sure you understand everything. Where in doubt, please consult with Habonim engineering team.

#### **WARNINGS & SAFETY INSTRUCTIONS**

Habonim cannot anticipate all of the situations a user may encounter while installing and using Habonim valves. The user **MUST** know and follow all applicable industry specifications on the safe installation and use of these valves. Misapplication of the product may result in injuries or property damage. Refer to Habonim product catalogues, product brochures and installation, operating and maintenance manuals for additional product safety information or contact Habonim.

1. Keep hands and objects away from the valve ports at all times. Actuated valves could be accidentally operated, resulting in serious injury or valve damage.
2. Before removing a valve from the line, always make sure the line has been depressurized and drained. Cycle the valve a few times to relieve any pressure that could be trapped in the body cavity.
3. Utmost caution must be taken when handling a valve that has toxic, corrosive, flammable or a contaminant nature media flowing through its pipeline. The following safety precautions are recommended when dismantling valves with hazardous media:
  - a. Wear eye shield, protective headgear, clothing, gloves and footwear.
  - b. Have available running water.
  - c. Have a suitable fire extinguisher when media is flammable.
4. Do not try to operate a valve that exhibits any sign of leakage. Isolate the valve and either repair or replace it.
5. Do not use or substitute non Habonim components or parts in Habonim valves and assemblies.



DEDICATED TO INNOVATION

Kfar Hanassi, Upper Galilee 12305 Israel  
Tel: 972 - 4 - 6914911  
Fax: 972 - 4 - 6914902  
E-Mail: [habonim@habonim.co.il](mailto:habonim@habonim.co.il)  
[www.habonim.com](http://www.habonim.com)

## 2. LIMITATIONS

The correct selection of materials of construction, seats and seals, internal valve components and pressure/temperature ratings determines the safe use of the valves and the particular performance requirements for the application. This information can be found on the nameplate welded to the valve body.

It is not possible to cover all installation and maintenance instructions for service of the valves, as the extent of applications that these valves can be used in, is large. It is the user's responsibility to use the valves as recommended and in accordance with the pressure and temperature limits as stated on this tag. Where in doubt, please consult with Habonim engineering team.

Unstable fluids or gases are prohibited for use in Habonim valves.

### CAUTION:

The valves should be used in a well designed, adequately protected system to **ensure that external and internal pressure and temperature limits do not exceed the valve limits.**

The valve rating is defined as the lower rating of the seat and valve body.

Valve surface temperature may become extremely hot or cold due to operating conditions. Prevent any type of direct contact with the valve that may cause harm or injury. Avoid direct contact with the valve by wearing protective gloves.

The valves should be used in a well designed, adequately supported piping system such that it will not be subjected to undue forces, stresses or shock loads during service.

The valves are not designed to operate during or after earthquakes or under fatigue conditions. It is the responsibility of the owner to determine if fatigue conditions exist.

**Do not allow dust layers to build up on the equipment.**

**The process fluid temperature shall not exceed the ignition temperature of the dust.**

## 3. STORAGE

Prior to storage, inspect the valve for shipping damage. Keep all protective packaging, flange covers attached to the valves during storage. It is recommended to keep the valves in a clean and dry environment until ready for use.

Carbon Steel valves have a "black oxide" and oil dipped finish. This nontoxic process is performed to retard rusting during storage. It is not a substitute for paint or other means of protective coating to be applied to the valve once installed.

Stainless steel valves have their natural finish and do not require additional protection once installed.

## 4. OPERATING INSTRUCTIONS

Habonim Valves provide tight shut off when used under normal conditions and in accordance with Habonim's published pressure/temperature chart.

On manual operated valves, the valve operation is done by turning

the valve handle 90°. A 90° turn counter clockwise is for opening, while 90° turn clockwise is for closing the valve. On manual operated valves, the open position is when the stem flats or handle are parallel with the pipeline, and the closed position is when handle or stem flats are perpendicular to the pipeline. On valves above 2", the indication is by a groove on the square headed shaft.

Control valves are **unidirectional**, and will have a flow direction arrow welded to the body and separate assembly instructions.

A silicone-based lubricant is applied to assist valve break in. The lubricant, if unacceptable, may be removed by a solvent wash.

If a shut-off valve is installed for end of line service, it must be ensured that it is closed with a blind end connection and the valve is secured against being opened unintentionally.

**WARNING:** Never look into the valve bore while the valve is in a flowline. Pressure and fluids could escape from the valve causing harm or injury.

To prevent leakage, malfunctions resulting from internal wear or seal degradation, the user must establish a preventive maintenance and inspection program. This program must include:

- a. Inspection of parts to detect loss of wall thickness which may result in decreased pressure capacity (see para. 2 for acceptable reduction of wall thickness).
- b. Routine replacement of seals and inspection for proper operation (See para. 7 for maintenance instructions).

Valve operating torques, as published in the Habonim literature, are the normal expected maximum break-out torques. These torques have been confirmed by laboratory testing of each valve under controlled conditions. Highly viscous or abrasive media, frequency of operation and temperature fluctuations could cause an increase in valve torque.

## 5. INSTALLATION

The installation procedure for ball valves is critical to ensure both long life and satisfying performance. Valves stored on site, awaiting installation, should be kept in their original packing, in dry conditions, where damage will not occur (see **para. 3**). Before carrying out the installation, it is important to follow the basic procedures described below:

### 5.1 General

- 5.1.1. Carefully unpack the valve and check valve nameplate for identification of materials (see **Figure 2**).
- 5.1.2. Remove any special packing materials surrounding the valve.
- 5.1.3. Check the valve for the flow direction indication mark. Appropriate care must be taken, to install the valve for proper flow orientation.
- 5.1.4. Inspect the valve interior through the end ports to determine it is clean and free from foreign matter according to ASME G93-03E1.
- 5.1.5. Cycle the valve and inspect any functionally significant features.

- 5.1.6. Read all the literature and note any special warning tags or plates attached to the valve.
- 5.1.7. Before installation, check to insure that the ball is in the fully open position in order to prevent possible damage to the ball and seats. The valve performance depends on its original conditions. At any stage do not leave the valve in the partially open position.

**5.2 Flanged End Valves**

- 5.2.1. Valves with flanged ends should be treated as a single unit and should not be dismantled when installing to pipeline.
- 5.2.2. Before installing the valves, make sure that the flanges on the mating pipe are free from excessive grit, dirt or burrs, and that there is no mechanical damage to the flanges on the pipe.
- 5.2.3. When inserting the flange bolts, make sure the bolts are correct size to hold pressure and axial forces.

**6. MAINTENANCE**

HABONIM valves have a long and reliable life, and maintenance is seldom required. When maintenance is necessary, valves can be refurbished on site.

To extend valve performance and reduce possible plant problems, the following procedures should be followed:

- 6.1. If leakage around the stem is noticed, check the stem nut torque according to value in **Table 1**. If the leak continues, tighten the gland nut about a 1/6-turn as a routine maintenance procedure. This will compensate for any wear or settling of the gland packing.
- 6.2. **Caution:** Excessive tightening of the stem nut can result in accelerated seal wear and high valve operating torque.
- 6.3. If the valve is removed from the line and disassembled, replacement of all seats and seals is recommended using the appropriate Habonim Repair kit. Examine all metallic sealing surfaces such as ball, stem, and the surfaces on the end connectors that contact the seats for wear, corrosion or damage.
- 6.4. Only Habonim's authorized spare parts should be used. Repair kits from Habonim consist of the following:

**V-Ball Type:**

- 2 x seat ring
- 1 x stem packing
- 2 x stem thrust seal
- 1 x body seals

**V-Port Type:**

- 1 x soft seat ring (upstream seat)
- 1 x stem packing
- 2 x stem thrust seal
- 1 x body seals
- 1 x back seat seal

- 6.5. In addition to repair kits, other spare parts are available from Habonim, such as: valve balls, stems for V Port, glands, V-Port seat and nuts. Should additional parts be required, it is

recommended that the complete valve be replaced.

- 6.6. When ordering repair kits, please provide the valve size and full figure number code and series, engraved on the valve ID tag.

**7. DISASSEMBLY**

**The following instructions are for off-line disassembly of valves sizes 1/2" to 2" (DN15-DN50)**

- 7.1. Cycle the valve with the line pressure fully relieved before attempting to remove the valve from the pipeline, to insure pressure has been discharged from the valve cavity.
- 7.2. Rotate the valve handle to the "open" position (see para. 5 for valve handle position).
- 7.3. With the valve in the "open" position, loosen all flange bolts.
- 7.4. Remove all flange bolts, so the valve can slide out from its installed position and be brought out of the pipe line (see **figure 3**).
- 7.5. Pull out the body from between the line flanges.
- 7.6. Hold valve body on a vice with the flange entry face up and remove the body plug from the valve end using an appropriate Hex key (see table 2 for Hex key dimensions).
- 7.7. Remove and discard the seat ring and body seal. Be careful not to damage the sealing surfaces.
- 7.8. Turn handle to the "closed" position and slide the ball out from the body. Set the ball aside in a clean and secure area for reuse.
- 7.9. Remove the handle nut, serrated washer, handle, locking clip, stem nut, disk springs and follower. Place all removed components, in a clean and secure area.
- 7.10. Push the stem down into the body cavity and remove it (do not damage the body core). Discard the stem thrust seal and gland packing, care taken not to scratch or nick the stem bore area of the body. Clean the stem and stem bore area.
- 7.11. Remove the second seat ring from the valve body.

**8. ASSEMBLY**

**The following instructions are for off-line assembly of valves sizes 1/2" to 2". (DN15-DN50)**

- 8.1. Place a soft seat in the valve body with the round profile facing the core cavity.
- 8.2. Lubricate the new stem thrust seal, bearing and packing, with appropriate lubricant (Molykote 33 - thin smear). Place the stem thrust seal on the stem.
- 8.3. Insert the stem in horizontal position into the body center section, with the threaded side first and carefully guide it up through the stem bore.
- 8.4. Holding the stem up, insert the new packing over the stem and into the stem bore. Place the follower and two disk springs onto the stem. The first spring's convex facing down, and the second spring convex facing up.
- 8.5. Thread the stem nut onto the stem. Tighten the stem nut to the torque figures (**Table 1**).

- 8.6. Place the locking clip on the stem nut by adjusting the orientation of the nut (in the clockwise direction).
- 8.7. If required, place the handle, serrated washer and thread the handle nut on the stem. Tighten the handle nut, while holding the handle.
- 8.8. Close the body plug hand tight until it is fully stopped
- 8.9. Mark a straight line that cross the plug and the valve flange facing.
- 8.10. In the next steps the line marked on the flange facing will be our indication for proper assembly.
- 8.11. Remove the plug from the valve body.
- 8.12. Bring the handle to the closed position to insert the ball.
- 8.13. For V-Port valves, refer to items 8.14 to 8.15
- 8.14. For V-Ball valves, refer to items 8.16 to 8.17
- 8.15. Place the ball in the valve body until the stem tongue is engaged, and turn the handle so the valve is at open position, to prevent the ball from falling out.
- 8.16. Place the new metal seat and body seal, in the body in the proper orientation of the pin welded to cavity and seat.
- 8.17. Place the ball in the valve body until the stem tongue is engaged, in a way that the V cut sharp edge should face left on NC valve, or right on NO valve. (Looking from down stream side)
- 8.18. Place the new body seal and new seat ring in the body.
- 8.19. Close the body plug until the marked lines in section 8.8 are straight.
- 8.20. Ease back the body assembly between line flanges, taking care not to score faces or damage seals, and reinstall body bolts.
- 8.21. To prevent galling of threads of bolts or nuts, lubricate threads with an anti-galling compound.  
**Slide appropriate gaskets between the valve flange and the line flange**
- 8.22. Tighten evenly the flange bolts.
- 8.23. Leave the valve in the open position for line flushing.

**9. DISASSEMBLY**

The following instructions are for off-line disassembly of valves sizes 3” to 8”. (DN80-DN200)

- 9.1. Cycle the valve with the line pressure fully relieved before attempting to remove the valve from the pipeline, to insure pressure has also been discharged from the valve cavity.
- 9.2. Loosen all flange bolts. Before removing the valve, allow the fluid to drain from the valve ports.
- 9.3. Remove all but one flange bolt on both sides of valve, so the valve can swing away from its installed position and be brought out of the pipe line. Make sure there is no load on the flange before removing the remaining bolts and valve. If needed, use a lever to release the bolts.
- 9.4. Clamp the valve in a vice or connect the valve back flange to a fixture to support it before removing the valve insert.

- 9.5. Bring the valve to the closed position.
- 9.6. Remove all insert retaining screws from around the body, to release the plug.
- 9.7. To assist removal of parts, tap on the ball from the other valve end port using a wooden or plastic mallet. Support the insert and the ball to prevent them from falling out of the body. Pull out the seat from the insert, taking care not to damage the sealing surfaces. Set the insert and the ball aside in clean secure area for reuse.
- 9.8. Remove the body seal. Be careful not to damage the sealing surfaces.
- 9.9. Pull out the second seat from the valve cavity, taking care not to damage the sealing surfaces of the valve.
- 9.10. Remove the wrench bolt, wrench pipe, wrench head, gland nut, indicator stop plate and gland. Place all components removed, in clean secure area.
- 9.11. Push the stem down into the body and remove it. Discard the stem thrust ring, bearing and gland packing, care taken not to scratch or nick the packing bore area of the body. Clean the stem and packing bore area. There is no need to remove the stem location ring.

**10. ASSEMBLY**

The following instructions are for off-line assembly of valves sizes 3” to 8”

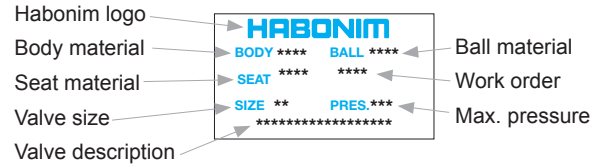
- 10.1. Place a seat in the valve body with the round profile facing the core cavity.
- 10.2. Lubricate the new stem thrust seal, bearing and packing, with appropriate lubricant (Molykote 33 - thin smear). Place the stem thrust seal on the stem.
- 10.3. Insert the stem in horizontal position into the body center section, with the threaded side first and carefully guide it up through the stem bore.
- 10.4. Holding the stem up, insert the new packing over the stem and into the stem bore. Place the bearing, follower and two disk springs onto the stem. The first spring’s convex facing down, and the second spring convex facing up.
- 10.5. Thread the stem nut onto the stem. Tighten the stem nut to the torque figures (Table 1).
- 10.6. Place the locking clip on the stem nut by adjusting the orientation of the nut (in the clockwise direction).
- 10.7. If required, place the handle, serrated washer and thread the handle nut on the stem. Tighten the handle nut, while holding the handle.
- 10.8. Bring the handle to the closed position to insert the ball.
- 10.9. For V-Port valves, refer to items 10.12 to 10.13
- 10.10. For V-Ball valves, refer to items 10.14 to 10.15
- 10.11. Place the ball in the body center section until the stem tongue is engaged, and turn the handle so the valve is at open position, to prevent the ball from falling out.
- 10.12. Place the new body seal and new seat ring in the body

- 10.13. Place the ball in the valve body until the stem tongue is engaged, in a way that the V cut sharp edge should face left on NC valve, or right on NO valve. (Looking from down stream side)
- 10.14. Place the new body seal and new seat ring in the body.
- 10.15. Close the body plug, until it is flush with the valve flange.
- 10.16. Tighten the insert retaining screws using an appropriate key
- 10.17. Ease back the body assembly between line flanges, taking care not to score faces or damage seals, and reinstall body bolts.
- 10.18. To prevent galling of threads of bolts or nuts, lubricate threads with an anti-galling compound.
- 10.19. Tighten the flange bolts to the torque.
- 10.20. Leave the valve in the open position for line flushing.

**FIGURE 1**

**Valve Marking and Labeling**

All valves marking is on a nameplate which is spot welded to the valve body. Valves for the European market and above 1” carry the CE mark with the information required by the PED.



**TABLE 1**  
**Stem Nut Tightening Torque**

Reduced Bore	Nut Thread	*PTFE Seal		Graphite Seal	
		Nm	in.lb	Nm	in.lb
1/2"	3/8"-24UNF	4	35	6	53
3/4"	3/8"-24UNF	4	35	6	53
1"	7/16"-20UNF	9	80	11	97
1 1/2"	9/16"-20UNF	13	115	16	140
2"	9/16"-20UNF	13	115	16	140
3"	1"-14UNS	60	530	72	637
4"	1"-14UNS	60	530	72	637
6"	1 1/2" - 12 UNF	120	1060	145	1280
8"	1 1/2" - 12 UNF	120	1060	145	1280

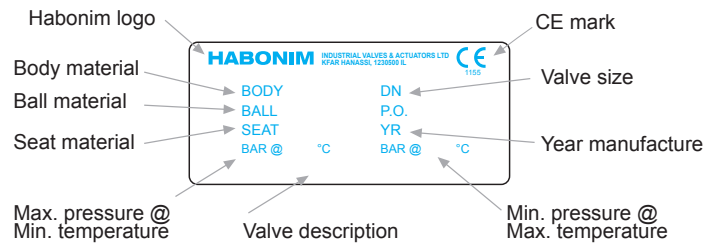
\* These torque figures are applicable on other stem seal materials such as glass filled PTFE, UHMWPE and TFM.

**IMPORTANT:**

An excessively tightened stem nut can cause excessive packing wear and increase stem torque.

**TABLE 2**

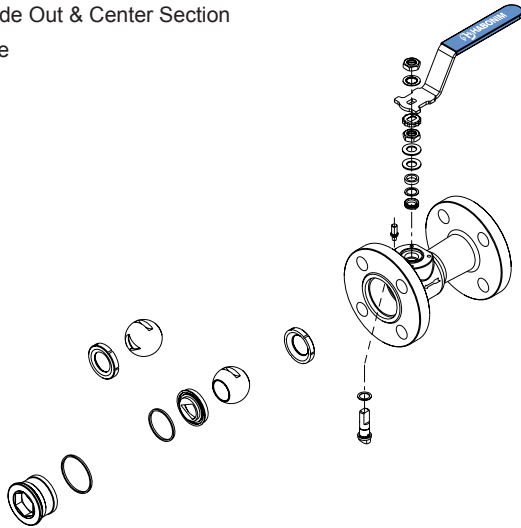
Size	Hexagonal Key Size	
	mm	Inch
1/2"	12.6	0.49
3/4"	15.7	0.62
1"	25.4	1.00
1 1/2"	35.7	1.40
2"	45.7	1.80



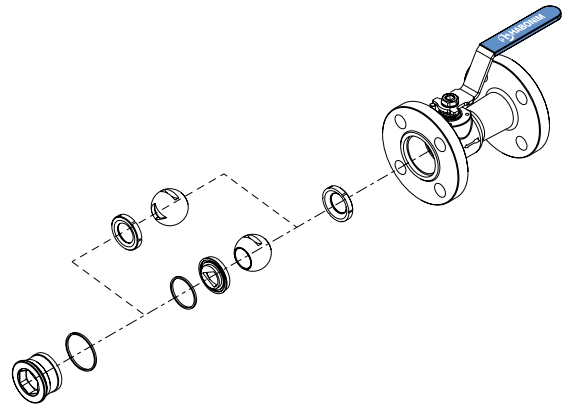
**FIGURE 2**  
**Valve slide out direction and maintenance**

**N31/N32 Series - 1/2"~2" (DN15-DN50)**

**Step 1 – Slide Out & Center Section Maintenance**

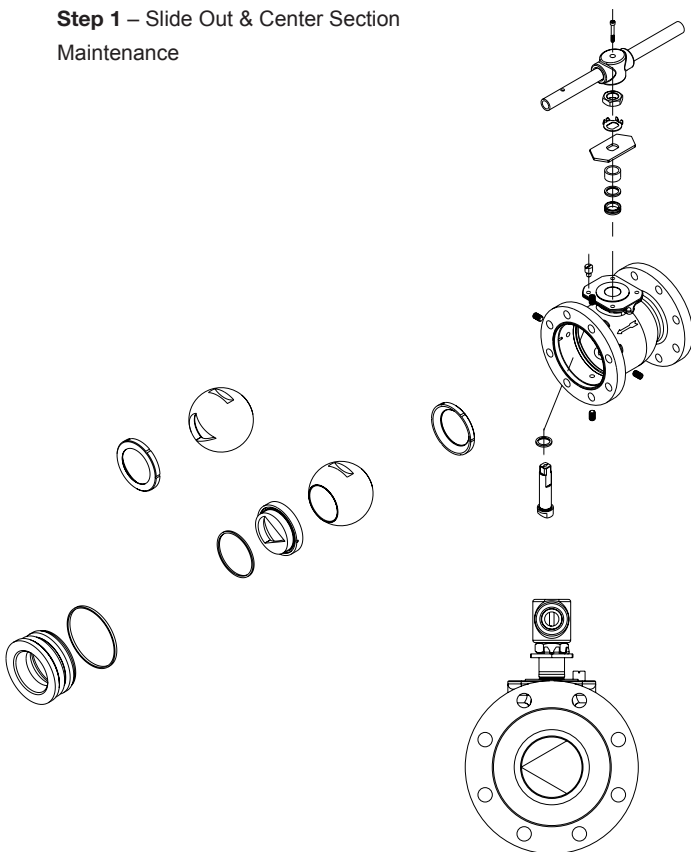


**Step 2 – Stem Maintenance**

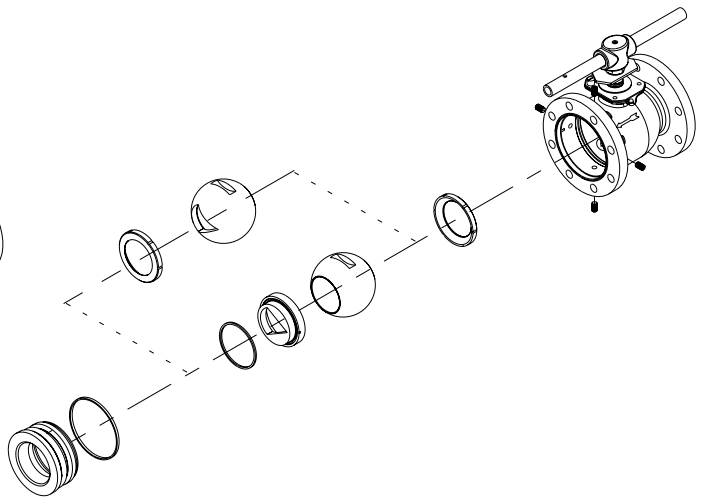


**N31/N32 Series - 3"~8" (DN80~DN200)**

**Step 1 – Slide Out & Center Section Maintenance**



**Step 2 – Stem Maintenance**

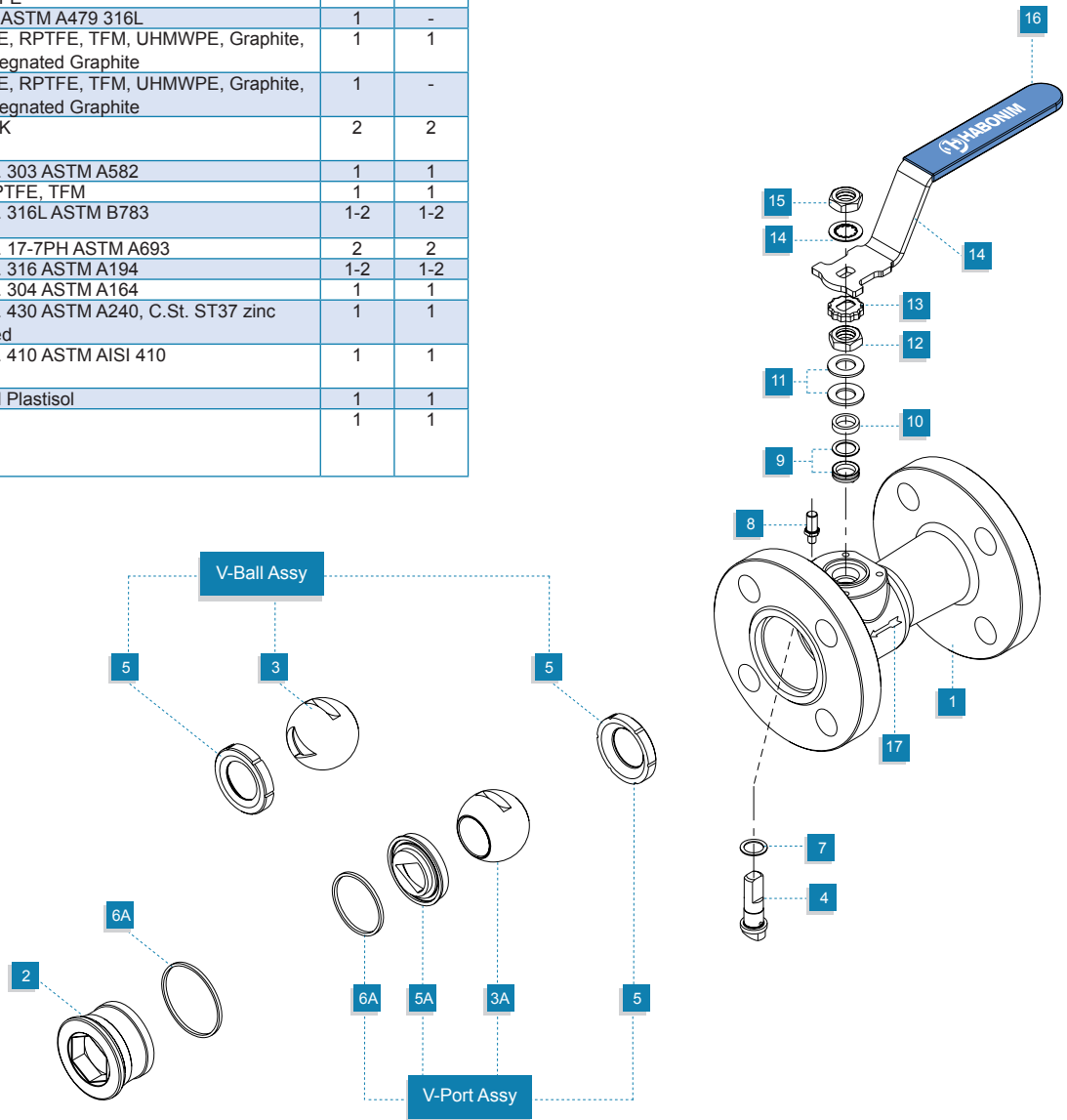


**ATTENTION:**

Prior to servicing the valve, bring it to the open position making sure to release line pressure and drain all trapped media from the valve cavity.

**N31/N32 Series – ½” ~ 2” (DN 15 to DN50)**

Item	Description	Material Specification	Qty.	
			V-Port	V-Ball
1	Body	ASTM A216 WCB, ASTM A351 CF8M, ASTM A494 CX-2MW, ASTM A351 CN7M, ASTM A351 CK3MCuN, ASTM A105, ASTM A479 316, ASTM B574 N06022, ASTM B473 N08020, ASTM A479 S31254, ASTM A350 LF2	1	1
2	Insert	ASTM A216 WCB, ASTM A351 CF8M, ASTM A494 CX-2MW, ASTM A351 CN7M, ASTM A351 CK3MCuN, ASTM A105, ASTM A479 316, ASTM B574 N06022, ASTM B473 N08020, ASTM A479 S31254, ASTM A350 LF2	1	1
3	Ball	ASTM A351 CF8M, ASTM A351 CF3M, ASTM A494 CX-2MW, ASTM A351 CN7M, ASTM A351 CK3MCuN, ASTM A105, ASTM A479 316, ASTM B574 N06022, ASTM B473 N08020, ASTM A479 S31254	1	1
4	Stem	ASTM A479 316, ASTM A564 630 (17-4PH), ASTM B574 N06022, ASTM B473 N08020, ASTM A479 S31254	1	1
5	Seat	PTFE, RPTFE, CF PTFE, PEEK, TFM, UHMWPE, VESPEL, PVDF, DELRIN, PCTFE	1	2
5A	Metal Seat	S.St ASTM A479 316L	1	-
6	Body Seal	PTFE, RPTFE, TFM, UHMWPE, Graphite, Impregnated Graphite	1	1
6A	Back Seat Seal	PTFE, RPTFE, TFM, UHMWPE, Graphite, Impregnated Graphite	1	-
7	Stem Thrust Seal	PEEK	2	2
8	Stop Pin	S.St. 303 ASTM A582	1	1
9	Stem Packing	CF PTFE, TFM	1	1
10	Follower	S.St. 316L ASTM B783	1-2	1-2
11	Disc Spring	S.St. 17-7PH ASTM A693	2	2
12	Stem Nut	S.St. 316 ASTM A194	1-2	1-2
13	Tab Washer	S.St. 304 ASTM A164	1	1
14	Handle	S.St. 430 ASTM A240, C.St. ST37 zinc plated	1	1
15	Serrated Washer	S.St. 410 ASTM AISI 410	1	1
16	Sleeve	Vinyl Plastisol	1	1
17	Arrow Flow Plate (not shown)	S.St	1	1

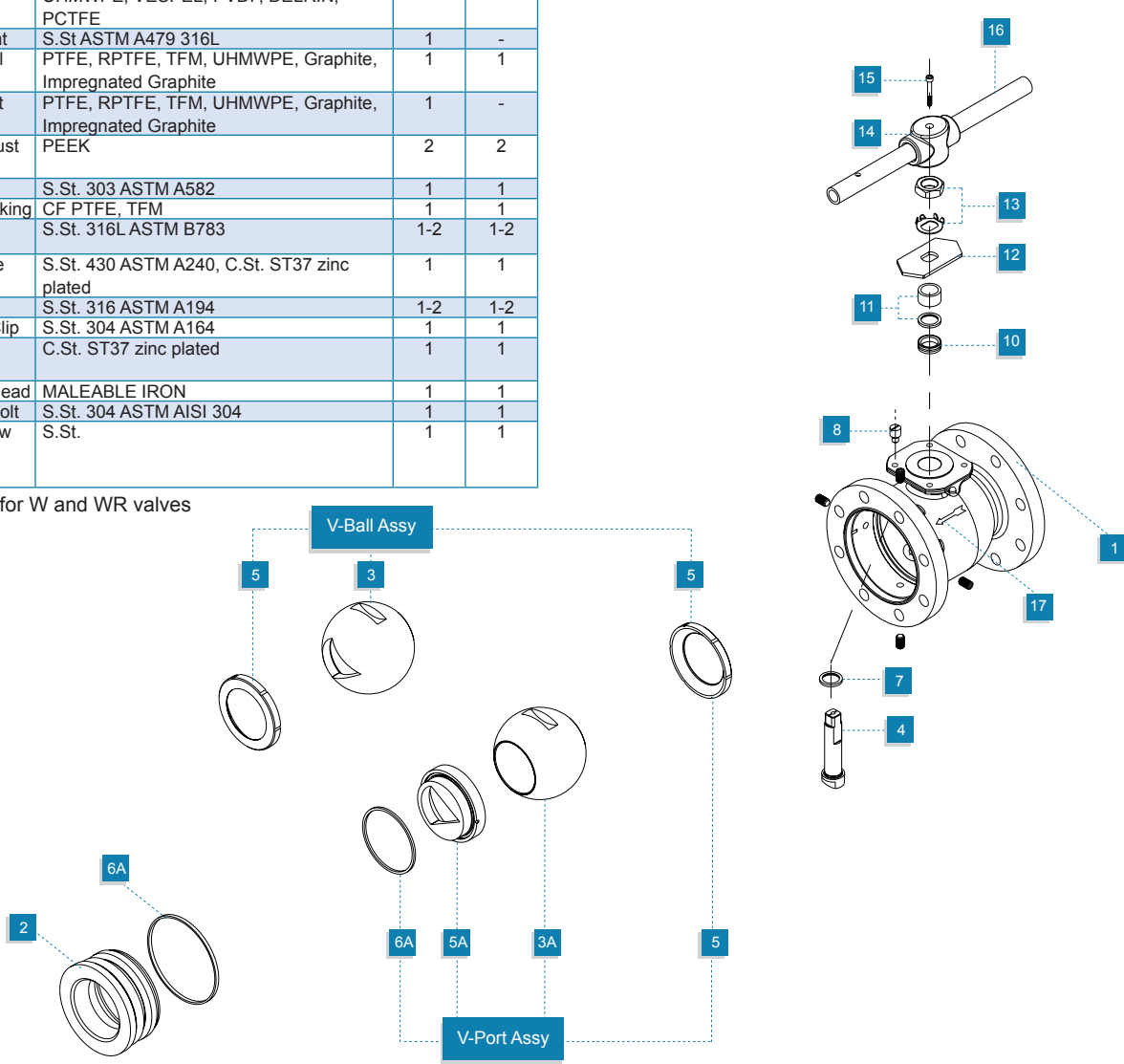




**N31/N32 Series – 3” ~ 8” (DN80 to DN200)**

Item	Description	Material Specification	Qty.	
			V-Port	V-Ball
1	Body	ASTM A216 WCB, ASTM A351 CF8M, ASTM A494 CX-2MW, ASTM A351 CN7M, ASTM A351 CK3MCuN, ASTM A105, ASTM A479 316, ASTM B574 N06022, ASTM B473 N08020, ASTM A479 S31254, ASTM A350 LF2	1	1
2	Insert	ASTM A216 WCB, ASTM A351 CF8M, ASTM A494 CX-2MW, ASTM A351 CN7M, ASTM A351 CK3MCuN, ASTM A105, ASTM A479 316, ASTM B574 N06022, ASTM B473 N08020, ASTM A479 S31254, ASTM A350 LF2	1	1
3	Ball	ASTM A351 CF8M, ASTM A351 CF3M, ASTM A494 CX-2MW, ASTM A351 CN7M, ASTM A351 CK3MCuN, ASTM A105, ASTM A479 316, ASTM B574 N06022, ASTM B473 N08020, ASTM A479 S31254	1	1
4	Stem	ASTM A479 316, ASTM A564 630 (17-4PH), ASTM B574 N06022, ASTM B473 N08020, ASTM A479 S31254	1	1
5	Seat	PTFE, RPTFE, CF PTFE, PEEK, TFM, UHMWPE, VESPEL, PVDF, DELRIN, PCTFE	1	2
5A	Metal Seat	S.St ASTM A479 316L	1	-
6	Body Seal	PTFE, RPTFE, TFM, UHMWPE, Graphite, Impregnated Graphite	1	1
6A	Back Seat Seal	PTFE, RPTFE, TFM, UHMWPE, Graphite, Impregnated Graphite	1	-
7	Stem Thrust Seal	PEEK	2	2
8	Stop Pin	S.St. 303 ASTM A582	1	1
9	Stem Packing	CF PTFE, TFM	1	1
10	Follower	S.St. 316L ASTM B783	1-2	1-2
11	Stop Plate	S.St. 430 ASTM A240, C.St. ST37 zinc plated	1	1
12	Stem Nut	S.St. 316 ASTM A194	1-2	1-2
13	Locking Clip	S.St. 304 ASTM A164	1	1
14	Wrench Handle	C.St. ST37 zinc plated	1	1
15	Wrench Head	MALEABLE IRON	1	1
16	Wrench Bolt	S.St. 304 ASTM AISI 304	1	1
17	Arrow Flow Plate (not shown)	S.St.	1	1

\* Not applicable for W and WR valves



In accordance with our policy to strive for continuous improvement of the product, we reserve the right to alter the dimensions, technical data and information included in this IOM when required.