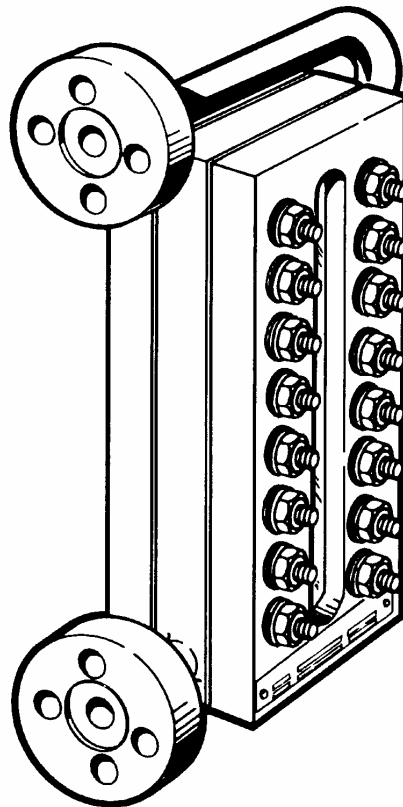


PENBERTHY®

Steam Water Gages

Series TSL and TSM



Installation, Operation and Maintenance Instructions

TABLE OF CONTENTS

Product Warranty	iii
1.0 About the Manual	1
2.0 Introduction	1
2.1 System Description	1,2
3.0 Available Models	2
3.1 Design Ratings at Maximum Operating Pressures	2
4.0 Inspection	3
4.1 Glass Inspection	3
4.2 User Rating Inspection	3
5.0 Installation	4
5.1 Piping Strain	4
5.2 Differential Thermal Expansion	4
5.3 Weight and Vibration	4
5.4 Mirror Viewing	4
5.5 Nut Retorquing	4,5,6
6.0 Operation	6
6.1 Hydrostatic Test	6
7.0 Maintenance	7
7.1 Maintenance Procedures	7,8
7.2 Troubleshooting	8
8.0 Removal - Disassembly - Reassembly	8
8.1 Disassembly	9
8.2 Inspection of Glass Seating Surfaces	10
8.3 Reassembly	10,11
9.0 Disposal at End of Useful Life	11
10.0 Telephone Assistance	12
11.0 Exploded Parts Drawing	13
TABLES AND FIGURES		page
Table 1	Design Ratings of TSL, TSL-F, TSM & TSM-F Gage	2
Table 2	Bolt Torque Values	5
Figure 1	Nut Tightening Sequence	5
Figure 2	Belleville Washer Position	5
Figure 3	Nut Loosening Sequence	9
Figure 4	Exploded Parts Drawing of TSL Transparent Gage	13
Figure 5	Exploded Parts Drawing of TSM Transparent Gage	13

PENBERTHY PRODUCT WARRANTY

Tyco Valves & Controls Prophetstown warrants its Penberthy products as designed and manufactured by TV&C Prophetstown to be free of defects in the material and workmanship for a period of one year after the date of installation or eighteen months after the date of manufacture, whichever is earliest. TV&C Prophetstown will, at its option, replace or repair any products which fail during the warranty period due to defective material or workmanship.

Prior to submitting any claim for warranty service, the owner must submit proof of purchase to TV&C Prophetstown and obtain written authorization to return the product. Thereafter, the product shall be returned to TV&C in Prophetstown, Illinois, with freight paid.

This warranty shall not apply if the product has been disassembled, tampered with, repaired or otherwise altered outside of TV&C Prophetstown factory, or if it has been subject to misuse, neglect or accident.

The responsibility of TV&C Prophetstown hereunder is limited to repairing or replacing the product at its expense. TV&C Prophetstown shall not be liable for loss, damage or expenses related directly or indirectly to the installation or use of its products, or from any other cause or for consequential damages. It is expressly understood that TV&C Prophetstown is not responsible for damage or injury caused to other products, buildings, personnel or property, by reason of the installation or use of its products.

THIS IS TV&C PROPHETSTOWN'S SOLE WARRANTY AND IN LIEU OF ALL OTHER WARRANTIES, EXPRESSED OR IMPLIED WHICH ARE HEREBY EXCLUDED, INCLUDING IN PARTICULAR ALL WARRANTIES OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE.

This document and the warranty contained herein may not be modified and no other warranty, expressed or implied, shall be made by or on behalf of TV&C Prophetstown unless made in writing and signed by the General Manager or Director of Engineering of TV&C Prophetstown.

INSTALLATION, OPERATION and MAINTENANCE MANUAL FOR PENBERTHY STEAM WATER GAGES SERIES TSL AND TSM

1.0 About the Manual

This manual has been prepared as an aid and guide for personnel involved in installation or maintenance. All instructions must be read and understood thoroughly before attempting any installation, operation or maintenance.

SAFETY INSTRUCTIONS

Penberthy does not have any control over the manner in which its liquid level gage is handled, installed or used. Penberthy cannot and will not guarantee that a liquid level gage is suitable or compatible for the user's specific application.



WARNING

Contained fluids may be pressurized and can unexpectedly exit vessel connections due to apparatus or material failure. Safety glasses should be worn when installing a liquid level gage. Failure to follow instructions could result in serious physical injury.

2.0 Introduction

Penberthy steam/water gages are used to allow direct visualization of liquid level in vessels, typically boiler drums. By peering through the glass, it is possible to monitor the level of the boiler water or condensate. Gages are available in varying lengths and configurations (end connect with stuffing box nipples and flanged side connect). Visual indication can be enhanced by using an illuminator (accessory), but it is critical that the PMMA wedge be kept at temperatures below 220°F [105°C].

2.1 System Description

Penberthy gages are comprised of eight basic components. Each component may vary slightly, depending on the desired physical and mechanical properties for the gage. Use the exploded parts view in Section 11.0 as additional reference material.

Chamber- provides a pressure retaining metallic channel for the liquid to enter and be viewed. Slot(s) are machined into the chamber to provide direct visualization of the liquid level.

Gaskets- seal the gap and prevent leakage between the chamber and the glass. Gaskets are available in graphite with 316 STS insert (as standard), Nobestos[®] and others by request.

Mica Shields- used to protect the glass from direct exposure to steam. Mica shields prolong the life of glass in steam/water use.

Glass- allows for visual observation of the process fluid in the chamber. Glass is only available in the transparent style because shields are used.

Cushion- acts as a protective buffer between the glass and the cover. For proper sealing, cushions must be as hard or harder than the gasket material.

Cover- protects the glass assembly from external hits and provides a flat, rigid surface that is used to evenly compress the gage assembly.

Belleville Washers- conical washers used to uniformly distribute bolt compression over the length of the cover and allow thermal expansion without increasing bolting stress.

Bolting- compresses the components between the covers and chamber.

3.0 Available Models

Penberthy series TSL, TSL-F, TSM and TSM-F liquid level gages are specifically designed for steam/water and heat transfer fluid applications. These gages are designed to be applied where the gage experiences dynamic thermal cycling.

3.1 Design Ratings at Maximum Operating Pressures

Gage Model	Maximum Pressure at Saturation
TSL & TSL-F	650 psig [4480 kPa] at 497°F [258°C]
TSM & TSM-F	1500 psig [10340 kPa] at 596°F [313°C]

Note: Temperature ratings follow saturated steam curve

Table 1

The maximum pressure and temperature ratings may deviate from the above table if the materials of construction are other than carbon steel. The rating will follow the saturated steam curve.

To determine the maximum allowable working pressure for a specific temperature within the design limits stated in the table, the user should refer to Penberthy application sheets, or when provided, the specifically stated design limits on a Penberthy product proposal.



Excessive mechanical and thermal stress can cause failure in the gage's structural integrity. Under no circumstances should these design ratings or application data be exceeded. Exceeding design ratings or application data may result in mechanical failure of gage components resulting in death, serious personal injury and property damage.

4.0 Inspection

Upon receipt of a steam/water gage, check all components carefully for damage incurred in shipping. If damage is evident or suspected, do not attempt installation. Notify carrier immediately and request damage inspection.

Penberthy's standard 1 section TSL & TSL-F gage consists of: (1) chamber, (2) gaskets, (2) Mica shields, (2) borosilicate flat glass, (2) rubber bands, (2) cushions, (2) covers, (24-28) nuts and Belleville washers, (1) nameplate and (12-14) studs, depending on the size.

Penberthy's standard 1 section TSM & TSM-F gage consists of: (1) chamber, (2) gaskets, (2) Mica shields, (2) borosilicate flat glass, (2) rubber bands, (2) cushions, (2) covers, (24-32) nuts, (72-96) Belleville washers, (1) nameplate and (12-16) studs, depending on the size.

4.1 Glass Inspection

The self stick caution tape was applied at the factory to protect the glass during shipping, handling and installation. Do not remove the tape from the glass until all installation procedures have been completed, except during receiving inspection to momentarily inspect glass for shipping damage. Glass that is not protected will be vulnerable to dust, grit, tools and any other objects which may scratch, chip or break the glass.



DO NOT use glass that is chipped or even slightly scratched. Glass surface defects weaken the glass, which may result in glass breakage and fluid loss under pressure resulting in serious personal injury and property damage.

4.2 User Rating Inspection

The user should confirm that:

1. the steam/water liquid level gage model and assembly number stamped on the nameplate conforms to the description on the user's purchase order,
2. the operating conditions described in the purchase order agree with the actual operating conditions at the installation site,
3. the actual operating conditions at the installation site are within the application data shown on the Penberthy Technical Data Bulletin or product proposal referred to above, and
4. the materials of construction of the liquid level gage are compatible with both the contained media and surrounding atmosphere in the specific application.

SAFETY INSTRUCTIONS

If the size, model or performance data of the liquid level gage as received does not conform with any of the criteria above, do not proceed with installation. Contact an authorized Penberthy distributor for assistance. The incorrect gage can result in unacceptable performance and potential damage to the gage.

5.0 Installation

Installation should only be undertaken by qualified, experienced personnel who are familiar with equipment of this type. They should have read and understood all of the instructions in this manual. The user should refer to Penberthy dimension sheets or Penberthy product proposal to obtain dimensional information for the specific size and model steam/water gage.

Penberthy recommends that all liquid level gage installations be provided with isolation gagecocks. Gagecock sets are designed to isolate the gages from the pressure vessel when it becomes necessary to drain or service the gages. ASME guidelines suggest OS&Y gagecocks with ball checks omitted or gagecocks with a vertically rising ball check in the lower gagecock and a leaky seat upper gagecock. The ball check shut-off is designed to retard leakage of the contained fluid in the event of gage glass breakage.

The number of different types of steam/water gage and gagecock installations is too great to adequately detail in an installation manual. It is, therefore, the user's responsibility to assure that the knowledgeable installation personnel plan and carry out the installation in a safe manner. The following procedures are some of the installation guidelines that should be employed.

5.1 Piping Strain

The gage should be mounted and connected so that it does not support any piping weight. Piping not properly supported, independent of the gage, may subject the gage to stresses that can cause leaks or glass breakage. Support brackets are available as an accessory.

5.2 Differential Thermal Expansion

High mechanical loads may be imposed on a gage by expanding and contracting pipes due to hot or cold service. Such mechanical loads on the gage must be minimized by the use of expansion loops in the system. Failure to allow for expansion or contraction can result in leaks or glass breakage.

5.3 Weight and Vibration

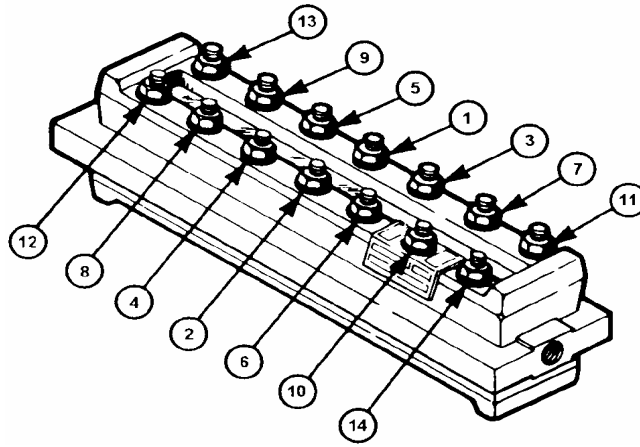
Gages over 100 pounds (45 kg) in weight or 4 feet (1.4 meters) in length should be supported with brackets: 1) to avoid imposing high mechanical loads on the connecting gagecocks and piping and 2) to prevent damage from vibration. Improper supporting of gages can cause leaks or glass breakage.

5.4 Mirror Viewing

For added safety, a system of indirect viewing by means of mirrors should be installed to protect personnel from the hazards of possible gage failure.

5.5 Nut Retorquing

Nut retorquing is vital to the operation of a liquid level gage because gaskets take permanent set under initial bolt loading at assembly. Tightening of nuts before installation to values specified in Table 2 is necessary to insure pressure retaining capabilities of liquid level gage to specific design ratings. The user must refer to the liquid level gage model and assembly number and to the purchase order or tag to determine materials of construction.



Nut Tightening Sequence
Figure 1

SAFETY INSTRUCTIONS

Before placing liquid level gage into initial operation, torque values must be verified. From factory testing to installation, gasketing may take “set” reducing closure force. Retorquing before operation reduces chance of leakage or gasket “blow out”.

--- DO NOT HOT TORQUE THESE GAGES ---

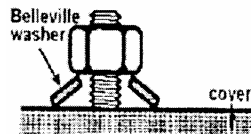
BOLT TORQUE VALUES

GAGE MODELS & GASKET MATERIAL	ft-lb [N·m]
TSL & TSL-F w/Grafoil® (standard)	20 to 25 [27 to 34]
TSL & TSL-F w/Non-asbestos (optional)	
TSM & TSM-F w/Grafoil® (standard)	25 to 30 [34 to 41]
TSM & TSM-F w/Non-asbestos (optional)	

Table 2

Belleville washers are used to reduce or eliminate the need to retorque nuts. This is especially important for gages subject to pressure and/or thermal cycling. The conical washers allow for material expansion and contraction while maintaining axial bolt loading and, therefore, compression on the gasket.

Model TSL & TSL-F gages require 1 washer per nut; model TSM & TSM-F gages require 3 washers per nut. Washers should be assembled with cupped side facing the gage cover. Refer to Figure 2 for proper washer assembly.



Belleville Washer Position
Figure 2

NOTE: the following procedure is to be done on only one side of the gage.

Using a torque wrench, tighten nuts in 5 ft-lb (7 N·m) increments following the "Z" pattern sequence in Figure 1, until the torque values shown in Table 2 for the specific steam/water gage are reached.

If bolting, gasketing or glass on any section of a multi-section gage is disturbed, all sections must be checked for integrity and retorqued as necessary.



Failure to comply with the proper torquing sequence or force value can lead to leakage, gasket blow-out or glass breakage resulting in gage failure, serious personal injury or property damage.

NOTE: Depending on gage size there may be less bolting than shown in Figure 1. Start at the center and follow "Z" pattern outward to the limit of bolting on a specific gage.

--- DO NOT HOT TORQUE THESE GAGES ---

6.0 Operation

Before initializing liquid level gage operation, check that all installation procedures have been completed. Use only qualified experienced personnel who are familiar with liquid level gage equipment and thoroughly understand the implications of the tables and all the instructions. Check to determine that all connections are pressure tight. Assure that nuts have been retorqued to their proper values as specified in Table 2. Remove self stick caution tape from the glass and inspect to be sure that glass is clean and free of any damage such as cracks, scratches, pits and chips.

6.1 Hydrostatic Test



Liquid level gage installations should be brought into service slowly to avoid excessive shock or stress on the gage. Rapid pressurization or sudden changes in temperature may cause glass breakage. To avoid excessive thermal shock or mechanical stress on glass, the connecting gagecocks should be opened slightly, and the gage temperature and pressure allowed to slowly equalize. If the gagecocks are equipped with ball checks, the gagecocks must be opened all the way after the pressure and temperature have equalized to permit operation of the automatic ball checks in the event of failure. Failure to follow the recommended operating procedures can result in death, severe personal injury and/or property damage.

Take all precautions necessary to handle the possibility of leakage during the test. Hydrostatically pressure test all installations to at least 100 psig [690 kPa] but less than the design pressure and correct any leakage before proceeding.

7.0 Maintenance



Use only qualified experienced personnel who are familiar with liquid level gage equipment and thoroughly understand the implications of the tables and all the instructions. DO NOT proceed with any maintenance unless the liquid level gage has been relieved of all pressure or vacuum, has been allowed to reach ambient temperature and has been drained or purged of all fluids. Failure to follow instructions can cause serious personal injury and property damage.

The rate at which components degrade is dependent upon a variety of conditions. Pressure, temperature, cycling and process media all influence the rate at which gage components deteriorate. Higher temperatures can accelerate the deterioration of gaskets, cushions, glass and metals. Acids and similar chemicals can break down the integrity of almost any material. Concentration of chemicals can accelerate the corrosion rate. Penberthy cannot create a blanket maintenance schedule for every application.

The end user is the most familiar with the process media and conditions and must be responsible for creating a maintenance schedule. The user must create maintenance schedules, safety manuals and inspection details for each liquid level gage. Realistic maintenance schedules can only be determined with full knowledge of the services and application situations involved. These will be based upon the user's own operating experience with their specific application.

If bolting, gasketing or glass on any section of a multi-section gage is disturbed, all sections must be checked for integrity and retorqued or repaired as necessary.

On all installations the following items should be regularly evaluated by the user for purposes of maintenance:

1. glass, for cleanliness and signs of damage or wear,
2. shields, for signs of clouding, wear or deterioration,
3. gage, for signs of leakage around gaskets or at connections and
4. gage, for signs of internal or external corrosion.

7.1 Maintenance Procedures

GLASS should be given regular and careful attention. Keep glass clean using a commercial glass cleaner and a soft cloth. Inspect the surface of the glass for any clouding, etching or scratching or physical damage such as bruises, checks or corrosion. Glass that is damaged is weakened and may break under pressure. Shining a light at approximately a 45° angle will aid in detecting some of these conditions. Typical damaged areas will glisten more brightly than the surrounding glass because the light is reflected.

Detection of any damage, problem areas or surface wear is sufficient evidence to take the liquid level gage out of service. DO NOT proceed with operation of the liquid level gage until the glass has been replaced with a glass replacement kit following the disassembly-reassembly instructions in Section 8.0.

SHEILDS showing any signs of clouding, wear or deterioration are an indication that the gage glass has been exposed, or could soon be exposed to the contained fluid. Immediately take liquid level gage out of service. DO NOT proceed with operation of the liquid level gage until shields and glass have been replaced by following the disassembly-reassembly instructions in Section 8.0.

GASKET LEAKS must be repaired immediately. DO NOT proceed with operation of a liquid level gage until gaskets have been replaced by following Section 8.0 disassembly-reassembly instructions.

CONNECTION LEAKS at a flanged or threaded connection should be corrected by tightening the bolting at the connection or by taking the liquid level gage out of service and wrapping the connection threads with Teflon[®] tape on all male pipe threads.

CORROSION may occur if the user has selected an improper material for the liquid level gage application. It is the responsibility of the user to choose a material of construction compatible with both the contained fluid and the surrounding environment. If internal or external corrosion is present, an investigation must immediately be performed by the user. It may be necessary to contact an authorized Penberthy distributor to better determine the origin of the corrosion.

7.2 Troubleshooting

Problem: glass becomes prematurely etched or clouded in service

Cause: fluid being handled is not compatible with the glass or shields

Solution: replace the glass and install shields that will not be affected by contained fluid

Problem: glass repeatedly breaks in service despite careful attention to maintenance procedures

Cause: thermal shock, hydraulic shock, mechanical loads, exceeding design ratings or a combination of these

Solution: check entire system to determine possible sources of loads. Check application to determine actual operating conditions and contact an authorized Penberthy distributor on how to proceed.

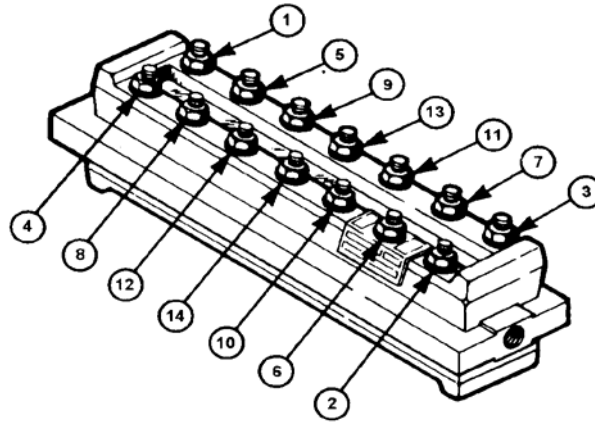
8.0 Removal - Disassembly - Reassembly



Unexpected bursts of pressurized fluid may occur. Use only qualified experienced personnel who are familiar with steam/water gage equipment and thoroughly understand the implications of the tables and all the instructions. DO NOT proceed with any maintenance unless the steam/water gage has been relieved of all pressure or vacuum, has been allowed to reach ambient temperature and has been drained or purged of all fluids. Failure to do so can cause serious personal injury and property damage.

8.1 Disassembly

Secure workbench longer than the liquid level gage, and sufficiently wide to lay out parts as they are removed.



Nut Loosening Sequence
Figure 3

1. Lay gage on bench
2. Hold gage firmly; loosen nuts starting at both ends of each section and then proceeding from both ends to the center of each section as shown in Figure 3.
3. Nut Loosening Sequence
 - remove nuts, Belleville washers, and nameplate
 - tap covers with rubber hammer as needed to loosen and remove
 - for belleville washer assemblies: to remove covers, studs may need to be removed by laying the assembly on its side and knocking the studs through the cover with a hammer and punch
 - remove cushions, glass, shields and gaskets
 - tap liquid chamber or remaining covers as necessary with rubber hammer to break loose and remove remaining components
 - remove, destroy and dispose of all glass, cushions, gaskets and shields. Under no circumstances should these components be re-used or installed on a gage.

NOTE: If size of gage is smaller than shown, follow spiraling sequence from the ends until all bolting is loosened.



Once used, cushions, gaskets and shields are permanently deformed by compression and if re-used, may cause leaks and high stress points resulting in glass breakage. Glass may contain hidden damage and internal stresses caused by previous usage. If re-used, the glass may break under pressure causing severe personal injury or property damage.

8.2 Inspection of Glass Seating Surfaces

Clean the glass seating surfaces on the liquid chamber and cover with a soft metal scraper (preferably brass) to remove all burrs, rust and remnants of the previous gaskets and cushions. Exercise extreme care to avoid gouging or scarring gasket and cushion seating surfaces.

Use a known flat piece of metal the same approximate length as the glass or a new piece of glass and a thickness gage to check flatness of each glass seating surface on liquid chamber and under cover. Surface must be flat within 0.002 inch (0.05 mm). If any one surface is found to be beyond a tolerance of 0.002 inch (0.05 mm), the entire gage must be disposed of and replaced. Gasket seating surface must have a final surface finish of 450 to 500 AARH.



Flatness of glass seating surfaces outside 0.002 inch (0.05 mm) tolerance specified is an indication of the gage having been overstressed through repeated exposure to mechanical, thermal or hydraulic shock during its previous service. Operation of a liquid level gage which has been overstressed will result in abnormal stresses on the glass which may cause glass to break. If surface finish is not in the 450-500 AARH range, gasket may extrude under pressure with resulting sudden release of pressure, leakage of contained fluid, serious personal injury or property damage.

Glass seating surfaces should NOT be machined to achieve seating tolerance. The chamber and cover are designed for a critical thickness to achieve the pressure/temperature ratings. Machining glass seating surfaces may result in non-compliance to the necessary critical thickness due to material removal.

8.3 Reassembly

If all glass seating surfaces are found to be within the 0.002 inch (0.05 mm) tolerance described in the previous section, proceed to obtain new glass, gaskets, cushions and shields and proceed to reassemble as follows (refer to exploded parts view in Section 11.0 if needed):

1. Clean threads on bolt and nuts to remove all paint, rust, and scale. Apply a light coat of oil to the threads.
2. Thread nuts on stud, place one (TSL & TSL-F) or three (TSM & TSM-F) Belleville washers under nut with pointed end toward the nut (see Figure 2), insert stud through each cover and lay out covers along the bench, side by side, with liquid chambers. Use chambers to space covers and line them up with vision slots.
3. Install one cushion inside each cover.



Separate installation instructions are supplied with replacement glass. All instructions supplied with the glass must be followed, as there are precautions to be taken when handling gage glass. Among the precautions is avoidance of bumping or sliding glass against any surface and inspection of individual pieces. Failure to follow any of the replacement gage glass installation instructions could result in glass breakage with resulting sudden release of pressure, severe personal injury or property damage.

4. Install rubber band around each piece of glass, then place glass centered inside

each cover.

5. Install shield and gasket on glass being careful to keep components centered.
6. Install covers in place on either side of the chamber being careful to maintain components aligned inside.
7. Install nameplate and appropriate number of Belleville washers (one TSL & TSL-F, three TSM & TSM-F) under each nut with pointed end toward the nut (see Figure 2). Tighten nuts with fingers.

NOTE: Depending on gage size there may be less bolting than shown in Figure 1. Start at the center and follow "Z" pattern outward to the limit of bolting on a specific gage.

NOTE: the following procedure is to be done on only one side of the gage.

8. Using a torque wrench, tighten nuts in 5 ft-lb (7 N·m) increments, following the sequence in Figure 1, until the torque values shown in Table 2 are reached.

--- DO NOT HOT TORQUE THESE GAGES ---

Refer to Section 5.0 for installation and Section 6.0 for operation of liquid level gage when returning to service.

9.0 Disposal at End of Useful Life

Penberthy gages are used in a variety of fluid applications. By following the appropriate federal and industry regulations, the user must determine the extent of preparation and treatment the gage must incur before its disposal. A Material Safety Data Sheet (MSDS) may be required before disposal services accept certain components.

Metal, glass and polymers should be recycled whenever possible. Refer to order and TV&C - Prophetstown Material Specification sheets for materials of construction.

10.0 Telephone Assistance

If you are having difficulty with your liquid level gage, contact your local Penberthy distributor. You may also contact the factory direct at (815) 537-2311 and ask for an applications engineer. So that we may assist you more effectively, please have as much of the following information available as possible when you call:

- Model #
- Name of the company from whom you purchased the liquid level gage
- Invoice # and date
- Process conditions (pressure, flow rates, tank shape, etc)
- A brief description of the problem
- Trouble shooting procedures that failed

If attempts to solve your problem fail, you may request to return your liquid level gage to the factory for intensive testing. You must obtain a Return Authorization (R.A.) number from TV&C Prophetstown before returning anything. Failure to do so will result in the unit being returned to you without being tested, freight collect. To obtain an R.A. number, the following information (in addition to that above) is needed:

- Reason for return
- Person to contact at your company
- "Ship To" address

There is a minimum charge for evaluation of non-warranty units. You will be contacted before any repairs are initiated should the cost exceed the minimum charge. If you return a unit under warranty, but is not defective, the minimum charge will apply.

Grafoil® is a registered trademark of Graftech

11.0 Exploded Parts Drawing

Recommended Spare Parts		
REF #	ITEM	MIN QTY
3	Stud	2 per sect
4	Nut	2 per sect
48	Glass	2
7	Gasket	2
8	Cushion	2
9	Shield	2

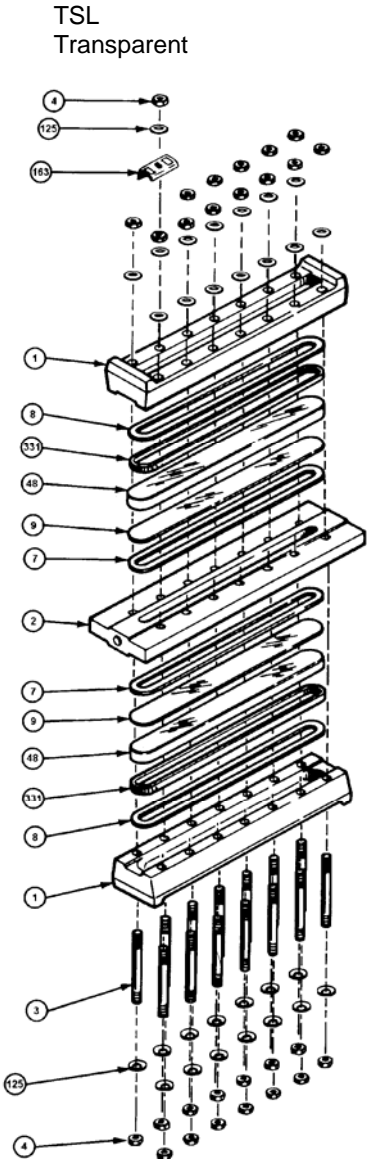


Figure 4

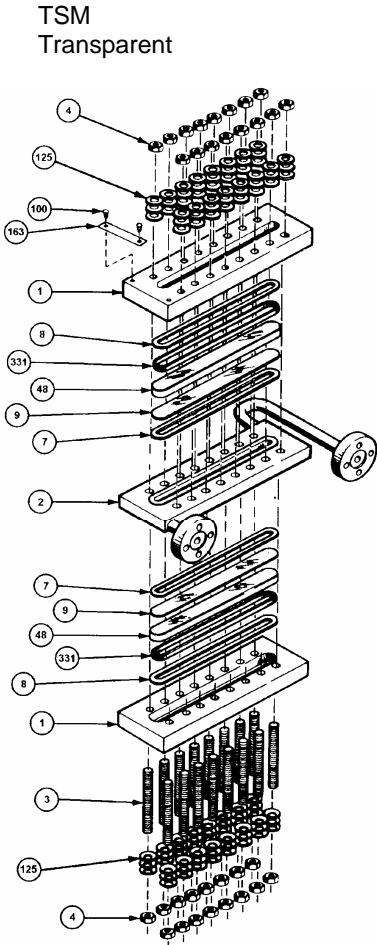


Figure 5

- 1 Cover
- 2 Chamber
- 3 Stud
- 4 Nut
- 7 Gasket
- 8 Cushion
- 9 Shield
- 38 Plug
- 48 Glass
- 100 Screw
- 125 Washer
- 163 Nameplate
- 331 Band

PENBERTHY

DECLARATION of CONFORMITY

In conformance with ISO/IEC Guide 22 - 96
SWG.DC r C

Manufacturer's Name: Tyco Valves & Controls
Manufacturer's Address: 320 Locust Street
Prophetstown, IL 61277-1147 U.S.A.


Product:

Type of Equipment: Observation and Gage Glass for Boilers
Equipment Class: Industrial Instrumentation
Model Designations: TSL, TSM

The product described above is in conformity with:

92/59/EEC	General product safety	1992
87/404/EEC	Simple pressure vessel	1987
89/392/EEC	Machinery	1989
EN 10213-1:4	Technical delivery conditions for steel castings	1996
ISO 7-1	Pipe threads where pressure-tight joints are made	1996
BS 10	Flanges and bolting for pipes, valves and fittings	1962
BS 21	Pipe threads for tubes and fittings where pressure tight	1985
BS 759	Valves, gages and other safety fittings for application	1984
BS 970 Part 1	Wrought steels for mechanical and allied engineering	1996
BS 970 Part 3	Wrought steel for mechanical and allied engineering	1991
BS 1501 Part 3	Steels for pressure purposes	1990
BS 1502	Steels for fired and unfired pressure vessels	1982
BS 1506	Carbon, low alloy and stainless steel bars and billets	1990
BS 1560	Circular flanges for pipes, valves and fittings	1989
BS 1640 Part 1	Steel butt-welding pipe fittings	1962
BS 1640 Part 2	Steel butt-welding pipe fittings	1962
BS 1965	Butt-welding pipe fittings	1963
BS 3076	Nickel and nickel alloys: bar	1989
BS 3463	Observation and gage glasses for pressure vessels	1975
BS 3602 Part 1	Steel pipes and tubes for pressure purposes	1987
BS 3605	Austenitic stainless steel pipes and tubes	1991
BS 3643	ISO metric screw threads	1981
BS 3799	Steel pipe fittings, screwed and socket-welding	1974
BS 4504	Circular flanges for pipes, valves and fittings	1989
ASME B&PV Code Section I	Rules for construction of power boilers	1995
ANSI/ASME B1.1	Unified screw inch threads un and unr thread form	1982
ANSI/ASME B1.20.1	Pipe threads, general purpose (inch)	1983
ANSI/ASME B16.5	Pipe flanges and flanged fittings	1988
ANSI/ASME B18.2.1	Square and hex nuts and screw inch series	1981
ANSI/ASME B18.2.2	Square and hex nuts	1972
ANSI/ASME B31.3	Process piping	1996

Date: 18 May 2004

Signature: 

Prophetstown, IL U.S.A.

Name: David J. Williams, C.Q.E.
Position: Quality Assurance Manager

Technical Construction File is available at stated address. Signatory is contact person.

NOTES

NOTES

tyco/Flow Control/ **Tyco Valves
& Controls**

Penberthy

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Printed in USA
Part No. 14917-009

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