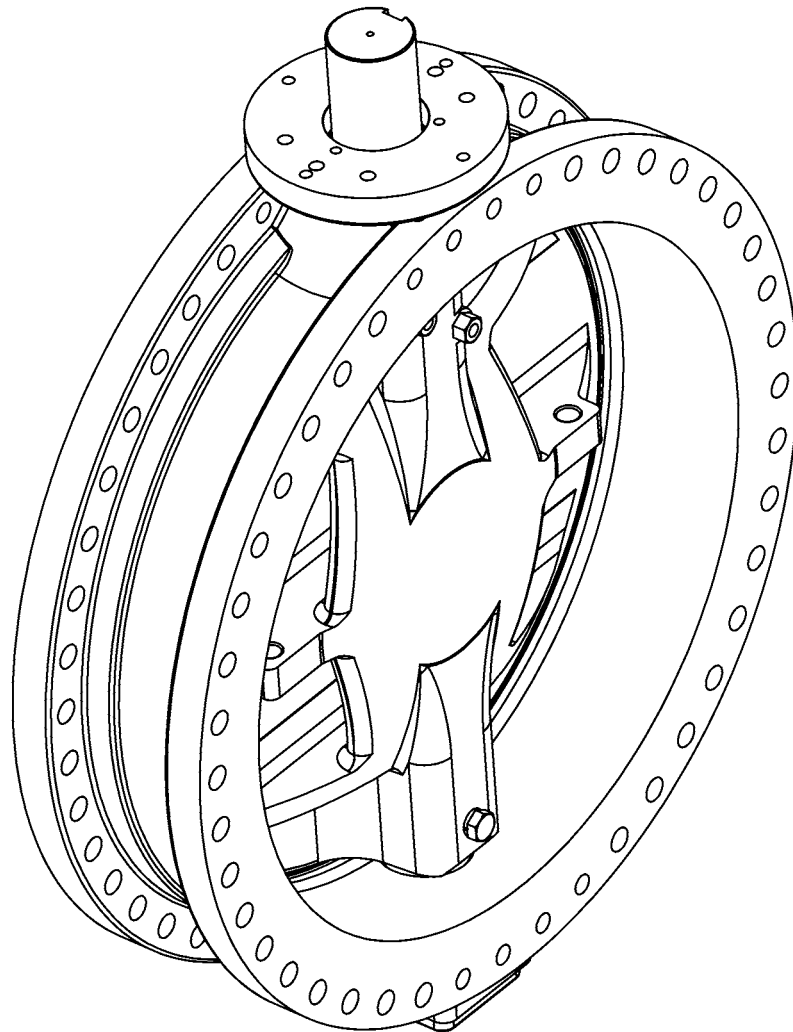




SEAT ADJUSTMENT KIT  
20-144" BAW AWWA  
BUTTERFLY VALVES  
WITH EPOXY-RETAINED SEAT



Instruction D10376  
September 2009

# DeZURIK

## Seat Adjustment Kit 20-144" BAW AWWA Butterfly Valves

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### Instructions

These instructions provide information about the Seat Adjustment Kit for 20" (250 F2 model only) and the 24"-144" BAW AWWA Butterfly Valves with epoxy-retained seats. They are for use by personnel who are responsible for installation, operation and maintenance of BAW AWWA Butterfly Valves.

### Safety Messages

All safety messages in the instructions are flagged with an exclamation symbol and the word Caution, Warning or Danger. These messages indicate procedures that must be followed exactly to avoid equipment damage, personal injury or death. Safety label(s) on the product indicate hazards that can cause equipment damage, personal injury or death.

Safety label(s) on the product indicate hazards that can cause equipment damage, personal injury or death. If a safety label becomes difficult to see or read, or if a label has been removed, please contact DeZURIK for replacement label(s).



#### **WARNING!**

**Personnel involved in the installation or maintenance of valves should be constantly alert to potential emission of pipeline material and take appropriate safety precautions. Always wear suitable protection when dealing with hazardous pipeline materials. Handle valves, which have been removed from service with suitable protection for any potential pipeline material in the valve.**

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### Inspection

Your Seat Adjustment Kit has been packaged to provide protection during shipment; however, it can be damaged in transport. Carefully inspect the unit for damage upon arrival and file a claim with the carrier if damage is apparent.

### Parts

Recommended spare parts are listed on the assembly drawing. These parts should be stocked to minimize downtime.

Order parts from your DeZURIK sales representative, or directly from DeZURIK. When ordering parts, please include the 7-digit part number and 4-digit revision number (example: **9999999R000**) located on the data plate attached to the valve assembly. Also include the part name, the assembly drawing number, the balloon number and the quantity stated on the assembly drawing.

### DeZURIK Service

DeZURIK service personnel are available to install, maintain and repair all DeZURIK products. DeZURIK also offers customized training programs and consultation services.

For more information, contact your local DeZURIK sales representative or visit our website at [www.dezurik.com](http://www.dezurik.com).

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### Seat Adjustment

Seat adjustment is accomplished by injecting epoxy between the rubber seat and the existing epoxy, forcing the seat tighter against the disc. Read the entire instructions before performing the epoxy injection.

#### **Equipment List**

- The epoxy injection kit consists of:
- Epoxy Resin and Catalyst
- Injection Gun
- 1/8" NTP Coupling
- Needles

#### **Setup**

1. Remove and discard the nozzle from the extension tube.
2. Install the 1/8" NPT coupling on the extension tube and install the needle on the opposite end of the coupling.
3. Install the extension tube on the grease gun and tighten all the fittings.
4. Remove the end of the grease gun with the extension tube.

#### **Preparing the Epoxy**

The ratio of catalyst to resin is 1 part catalyst to 7.7 parts resin by volume and 1 part catalyst to 9.5 parts resin by weight. Ensure everything is ready before combining the resin and the catalyst.



#### **WARNING!**

**The epoxy will begin to cure as soon as the catalyst is mixed into the resin. The pot life is 30 minutes. Do not mix epoxy until ready to use.**

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1. Check the expiration date on the epoxy kit.
2. If product is expired order replacement epoxy from DeZURIK (part number 1285429).
3. Open the 2641-40 resin and thoroughly stir contents—try to limit the amount of air stirred into resin.
4. Using clean containers, pour one unit of catalyst into one container and 7.7 units of resin into another container.



#### **WARNING!**

**When mixed, the epoxy causes a chemical reaction that generates heat and smoke. If the depth of the mixed epoxy is greater than 2", the heat from this reaction can start a fire. Mix the resin and catalyst only in a well-ventilated area and pour uncured epoxy into multiple containers to reduce depth of mixture.**

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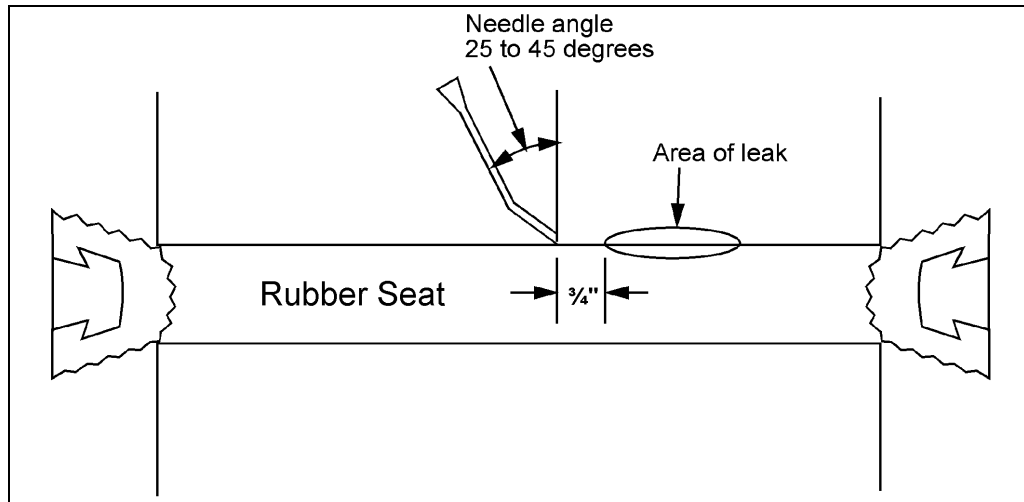
5. Take containers to point of use and combine the catalyst with the resin.
6. Stir the mixture by hand until completely blended—try to limit the amount of air stirred into resin.

**Seat Adjustment** *(Continued)*

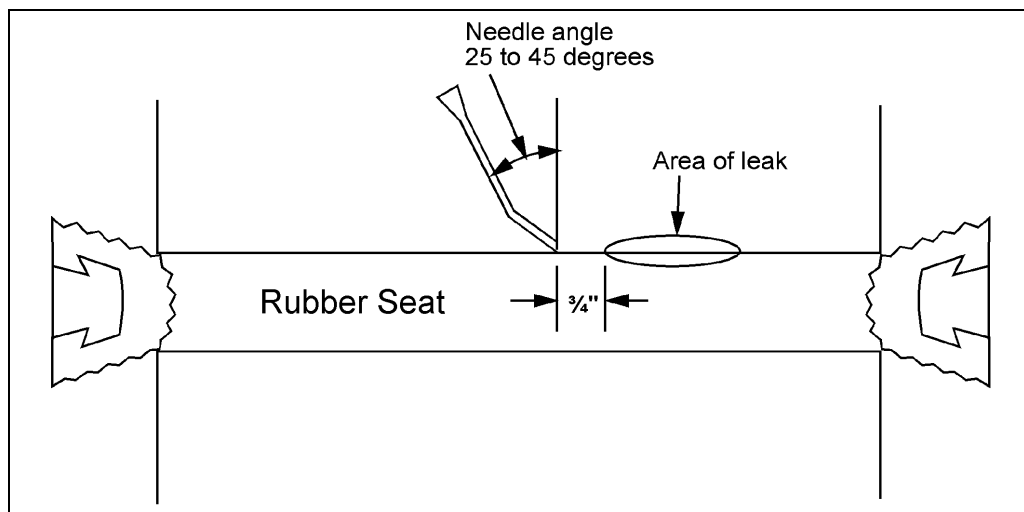
7. Pull the T-handle of the injection gun back and pour the mixture into the gun.
8. Put the end of the gun with the extension tube back on and tighten assembly.
9. Pump the handle until a small amount of epoxy comes out of the needle.

**Injecting the Epoxy**

1. Ensure valve is in the closed position and under pressure.
2. Select an injection site that is about  $\frac{3}{4}$ " to one side of leak. See Figure 1.

**Figure 1 - Selecting Injection Site**

3. Holding the needle insertion tool 25–45 degrees from perpendicular to the rubber seat, place the tip of the needle against the seat and as close to the body as possible.
4. Push the needle through the rubber seat until it stops against the original epoxy inside the rubber seat.

**Figure 2 - Needle in Position for Injecting Epoxy into Rubber Seat**

**Note:** The needle position needs to match figure 2 exactly, otherwise the rubber seat can block the flow of epoxy out of the needle.

### **Seat Adjustment** *(Continued)*

5. Inject the epoxy until the leak stops.

**Note:** If the leak doesn't stop, reposition the needle and try again.

6. Pump two extra strokes of the grease gun to ensure the epoxy seals the hole from the needle and withdraw the needle.

**Note:** Be sure to release the pressure on the gun before withdrawing the needle. A small amount of epoxy will come to the surface of the seat. Wipe as much off as possible before it cures.

7. With the disc in the closed position, allow the epoxy to cure for a minimum of four hours at room temperature — allow more time for cooler temperatures.

### **Waste Disposal**

Mixed epoxy can be disposed of in a regular manner, but unmixed resin and catalyst are considered hazardous waste.

1. Remove the needle from the valve, and dispose of properly.
2. Store any unused epoxy or resin properly, or dispose of the materials according to applicable hazardous materials regulations and procedures.