



MILWAUKEE VALVE

Installation, Operation & Maintenance Instructions 41 Series Ball Valves – Socket-weld Ends

Installation

1. The 41 Series ball valve is a bi-directional valve and may be installed in either direction unless otherwise indicated by an arrow on the valve's body and/or a tag on the valve.
2. Install the valve in the partially open position.
3. Clean the valve's socket ends and check the pipe for burrs. To ensure proper fit, insert the pipe into the valve until it stops. Back the pipe out approximately 1/16-inch to allow for expansion. Weld end preparation should be in accordance with applicable welding practices and procedures.
SEE CARD ATTACHED TO VALVE.
4. Only trained and qualified welders using proper welding technique, procedure and filler material for the valve and pipe should perform welding. Take all necessary safety measures into account after reading this procedure in its entirety. Do not set welder higher than recommended settings.
DO NOT OVERHEAT.
5. For each end, place a wet rag or cloth around the pipe (not the valve), close to the weld line as practical, to act as a heat sink and draw heat away from the valve. Minimize heat into the valve by alternating ends being welded between passes, allowing cool time between passes, and any other steps consistent with good welding practice.
ALLOW AMPLE TIME FOR THE VALVE TO COOL.
6. Check valve for proper operation by cycling the valve from open to close several times. Tighten packing gland approximately 1/8 turn if visible stem leakage is detected.

Operation

The 41 Series ball valve is a quarter-turn valve with smooth operation and tight shut-off. Its operation is simple. The valve's ball orifice (port) is parallel to the valve's handle position. If the handle is parallel to the pipeline, then the valve is in the open position. Rotating the handle 90° will close the valve.

Maintenance

The 41 Series ball valve requires very little maintenance. Caution should be taken to ensure that the pipeline's pressure, temperature, and media falls within the compatibility of the body, trim and sealing capabilities of the valve. The media should be free of debris, which may damage the "soft" seats of the valve. Only routine maintenance of the packing gland is required. See Step 6.