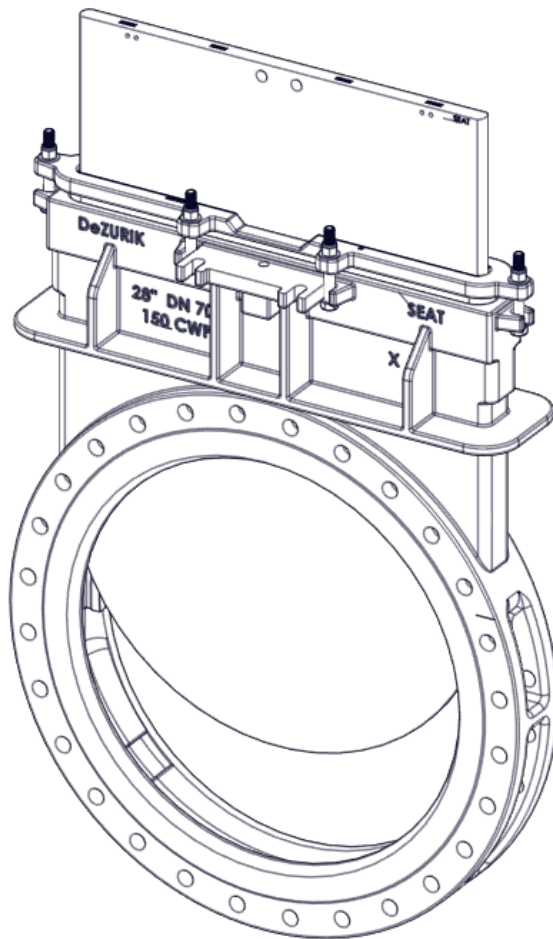




**DeZURIK**  
**22", 26"-48"**  
**(550, 650-1200mm)**  
**KGC ES or HD**  
**KNIFE GATE VALVES**



Instruction D11015  
May 2018

# DeZURIK

## 22", 26"-48" (550, 650-1200mm) KGC ES or HD KNIFE GATE VALVES

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### Instructions

These instructions are intended for personnel who are responsible for the installation, operation and maintenance of your KGC knife gate valve, including models KGC-ES, KGC-HD, KGC-GV, KGC-MV and KGC-SV in size 22" and 26"-48" (550 and 650-1200mm).

### Safety Messages

All safety messages in the instructions are flagged with the word Caution, Warning or Danger. These messages 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. If a safety label becomes difficult to see, or if a label has been removed, please contact DeZURIK for replacement.

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#### **WARNING**

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

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### Inspection

Your KGC knife gate valve has been packaged to provide protection during shipment. 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 representative or visit our website at [www.dezurik.com](http://www.dezurik.com).

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### Description

KGC knife gate valves are bonnetless valves with a cast steel or stainless steel body and gate, and an all-metal or resilient-faced seat. The KGC knife gate valve is available in 2-48" (50-1200mm) sizes. This manual covers 22, 26-48" (550 and 650-1200mm) sizes. A choice of several actuators and accessories is available.

### Handling



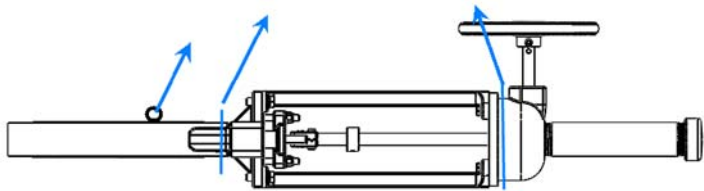
#### **WARNING!**

**A potential hazard exists with handling valves. Failure to handle valves properly may cause a valve to shift, slip or fall causing serious injury or death and/or equipment damage.**

*The points below are for reference purposes only, use safe and proper lifting and support techniques. DO NOT lift valves with any adjoining pipe or other equipment attached. Lift with properly rated lifting equipment. Follow jurisdictional safety requirements.*

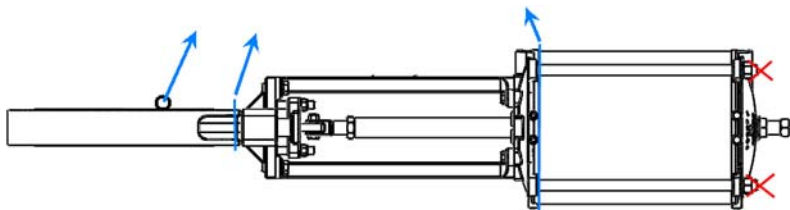
Suggested lifting points are as shown below to lift valve assemblies that are in a horizontal orientation. Eye bolts in flange through holes can be used to lift the valve body or, for 2" through 12" valves, a sling can be strapped around the top of the valve body.

For valves with bevel gear actuators, a sling or chain can be wrapped around the bevel gear actuator body, between the mounting plate and the input shaft housing. This would be in conjunction with lifting from the valve body as well. See Figure 1.



**Figure 1— Knife Gate Valve with Bevel Gear Actuator, Horizontal Lifting**

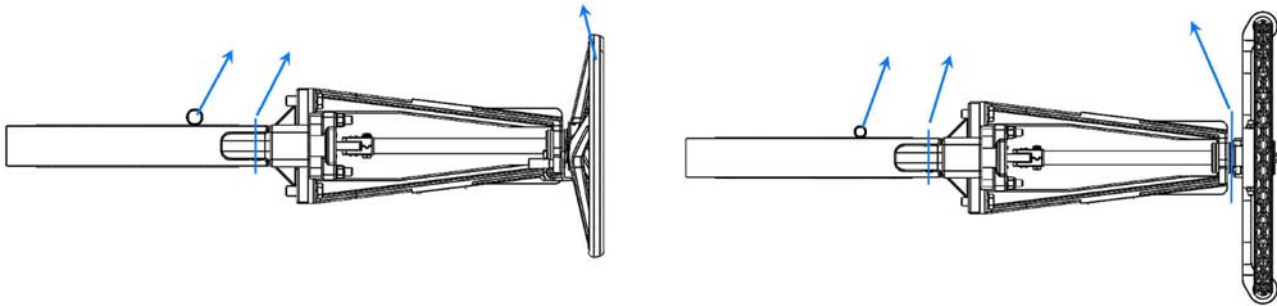
For valves with pneumatic cylinder actuators, a sling can be wrapped around the cylinder, near the cylinder head (piston rod end). This would be in conjunction with lifting from the valve body. Utilize caution to not bump, dent or damage the cylinder tube. DO NOT utilize the cylinder tie-rod ends to lift. See Figure 2.



**Figure 2, Knife Gate Valve with Pneumatic Cylinder Actuator, Horizontal Lifting**

Handling *continued*

For valves with handwheel actuators, a sling or chain can be wrapped through the rim of the handwheel. For chainwheel actuators, a sling can be wrapped in the area between the yoke/legs and the chainwheel/guide assembly. This would be in conjunction with lifting from the valve body as well. See Figure 3.

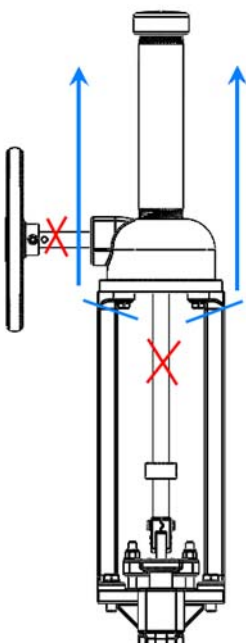


**Figure 3, Knife Gate Valve with Handwheel or Chainwheel Actuator, Horizontal Lifting**

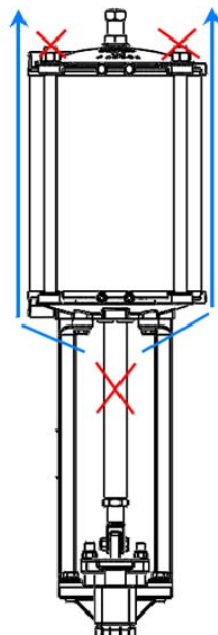
Suggested lifting options are as shown below to lift valve assemblies that are in a vertical orientation. For valves with bevel gear actuators, wrap slings or chains around the top of each leg. Use caution not to put any side load on the bevel gear input shaft or on the valve's threaded stem. See Figure 4.

For valves with pneumatic cylinder actuators, wrap slings around the top of each leg. Use caution to not bump, dent or damage the cylinder tube and avoid any side load on the cylinder piston rod. DO NOT utilize the cylinder tie-rod ends to lift. See Figure 5.

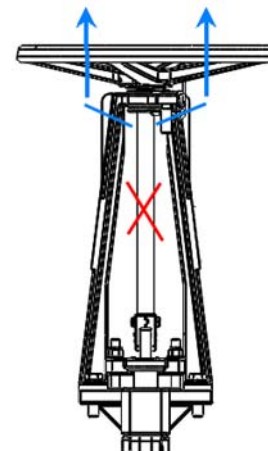
For valves with handwheel or chainwheel actuators, wrap slings or chains around the top of the each leg or yoke side. Use caution to not put any side load on the valve's threaded stem. See Figure 6.



**Figure 4- Knife Gate Valve with Bevel Gear Actuator, Vertical Lifting**



**Figure 5- Knife Gate Valve with Pneumatic Cylinder Actuator, Vertical Lifting**



**Figure 6- Knife Gate Valve with Handwheel or Chainwheel Actuator, Vertical Lifting**

# DeZURIK

## 22", 26"-48" (550, 650-1200mm) KGC ES or HD KNIFE GATE VALVES

### Installation

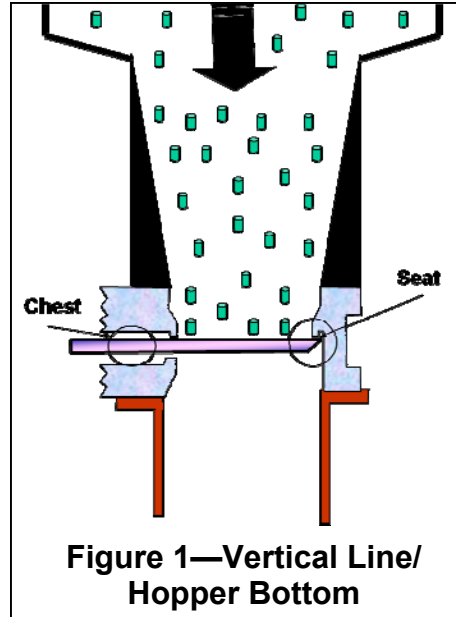
Install the valve between ASME Class 125 or Class 150 pipeline flanges, or other flanges that match valve end connection. Flange gaskets are required. Before installation, remove foreign material such as weld spatter, oil, grease, and dirt from the valve and pipeline.

### Normal Installations

Install the valve so that the side marked "SEAT" is on the lower pressure side of the valve when the valve is closed; the pipeline pressure will then help seal the valve in the closed position.

### Cyclone or Gravity (Dry) Service Installations

When installing the valve in a vertical pipeline (such as a hopper bottom, gravity flow, or other dry service application), install the SEAT side of the valve facing upstream as shown in Figure 1. Installing the valves with the seat side upstream prevents process media buildup in the seat and chest area of the valve. This orientation also allows the seat to act as an integral deflection cone, protecting the seat from wear.



### General Guidelines

Observe the following points to prevent distortion of the valve body and gate when the flange bolts are tightened:

- Align the mating pipeline flanges.
- Select the length of the flange bolts so that the bolts used in the blind holes near the chest area of the valve do not bottom out when tightened. We recommend using studs with nuts in the blind holes.
- Tighten the flange bolts evenly, in a crisscross pattern. Refer to Table A for recommended flange bolt/stud torques.

**Table A: Recommended Flange Bolt/ Stud Torque Range in ft-lbs (non-lubricated)**

Valve Size	ASME Gasket Types	
	Rubber with Soft Fabric Filler, and 1/8" Thick Hard	Soft Elastomer Gasket Shore Durometer < 75A
22" (550mm)	161 - 177	131 - 144
26" (650mm)	181 - 199	151 - 166
28" (700mm)	178 - 196	149 - 164
30" (750mm)	198 - 218	168 - 185
32" (800mm)	269 - 296	228 - 251
36" (900mm)	289 - 318	248 - 273
42" (1050mm)	343 - 377	298 - 328
48" (1200mm)	358 - 394	315 - 347

**Note:** Torque ranges are based on ASME Pressure Vessel Code Calculations and lab test data. These torques are only for the listed gasket types. For other gasket types listed in ASME, consult DeZURIK.

After installing the valve, pressurize pipeline and ensure the packing is not leaking. If the packing leaks, adjust the packing as described on the next page.

## Operation

The gate in the valve is positioned by the valve actuator. The actuator moves the gate over the valve port in the closed position, and withdraws the gate from the seat in the open position. Refer to the Actuator Instructions for adjustment and maintenance requirements for the actuator.

## Lubrication

The valve does not require lubrication. Refer to the Actuator Instructions for lubrication requirements for the actuator.

## Packing

The gate packing is contained and compressed by the packing gland. See Figure 2 for component identification.

**Note:** The packing gland is slightly loosened prior to shipping. This is done to increase the life of the packing during extended storage.

## Adjustment

If packing leaks, tighten the adjustment nuts on top of the packing gland. Tighten the nuts evenly and gently - just enough to stop the leak. Over tightening will cause excessive operating forces, and will decrease the life of the packing.

Drawings

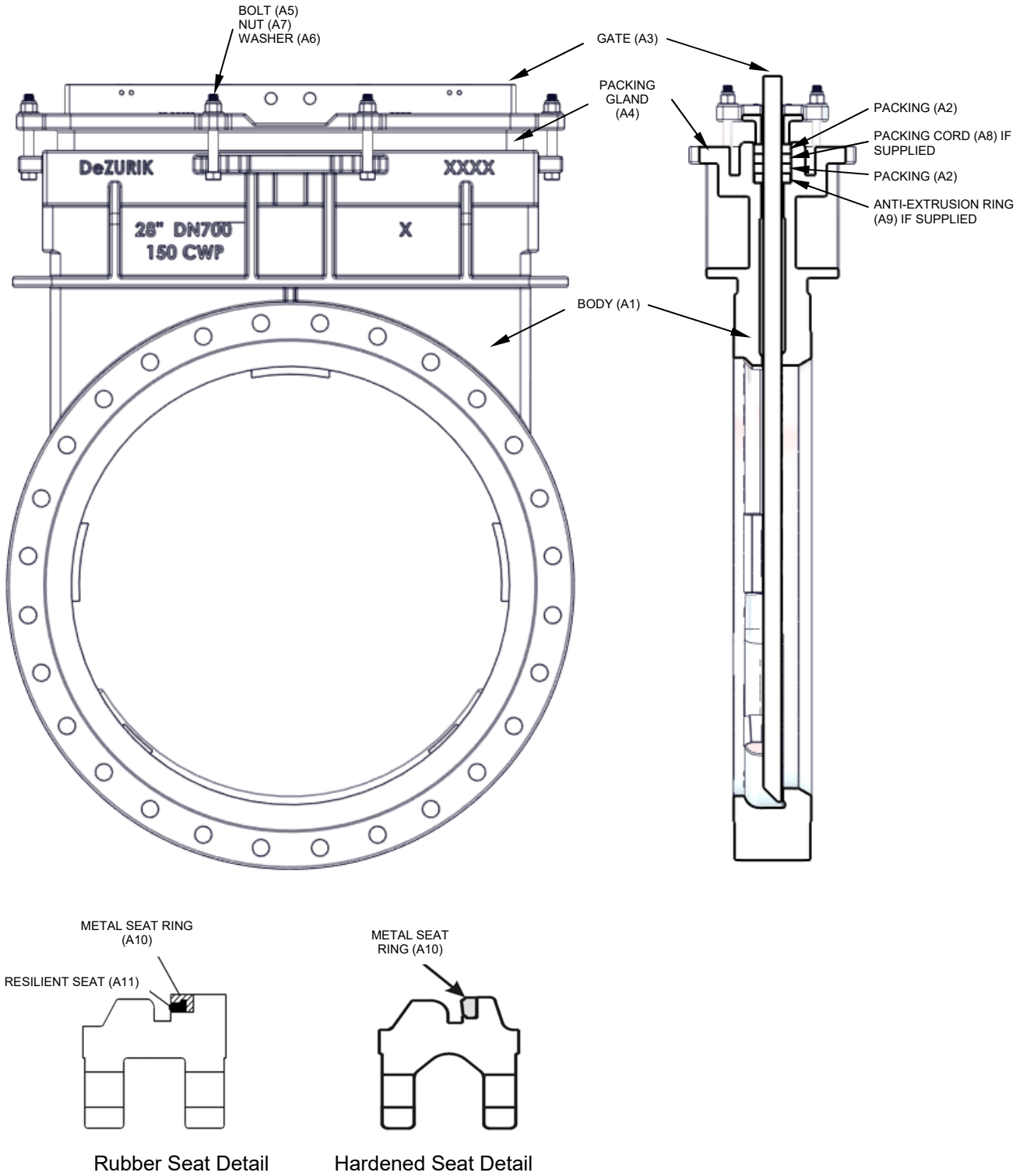


Figure 2—Component Identification



## Packing Replacement

### *Removing the Old Packing*



**WARNING!**

Pipeline pressure can cause personal injury or equipment damage. Relieve pipeline pressure before removing gate stem and packing gland nuts.

- 
1. Relieve the pressure in the pipeline and close the valve.



**WARNING!**

Accidental operation of power actuator can cause personal injury or equipment damage. Disconnect and lock out power to actuator before servicing.

- 
2. If the actuator is powered, disconnect and lock out power to prevent accidental operation of the actuator.
  3. Remove the two screws and nuts near the top of the gate and disengage the stem from the gate by stroking the actuator (not the valve) to the open position.
  4. Remove the gland nuts (A7), bolts (A5), washers (A6) and packing gland (A4).
  5. Remove the used packing (A2), packing cord (A8) if supplied, and anti-extrusion ring (A9) if supplied, from the packing chamber.

# DeZURIK

## 22", 26"-48" (550, 650-1200mm) KGC ES or HD KNIFE GATE VALVES

### Installing the New Packing

Packing (A2) strip length and quantity are shown in Table B. Ensure the inside and outside edges of each ring are packed against the gate and packing chamber, so that each strip is compressed flat and evenly.

Do not compress the packing any more than needed to stop leaks.

1. Ensure the gate (A3) is fully closed and centered in the body before packing.
2. If used, place the anti-extrusion ring (A9) or scraper ring in the bottom of the packing chamber.

**Note:** Ensure that the anti-extrusion ring fits tightly around the gate and that there is approximately 1/32-1/16" clearance around the packing chamber.

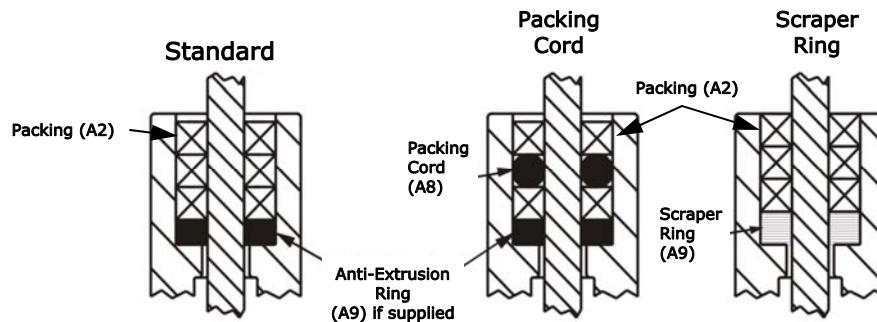
3. Assemble and pack the rings one at a time, with the ends together, but not overlapped

**Note:** Stagger the joints, on the long side of the packing chamber. For packing rings, we recommend using a square-ended wood or plastic tool, driven by a hammer or mallet. Do not use a sharp tool to pack the rings.

4. For packing systems with the packing cord (A8), assemble and pack one row of packing (A2) and then insert the packing cord (A8). Assemble and pack the last row of packing. See detail below:

**Table B: Packing Ring and Packing Cord Length and Quantity**

Valve Size	Square Size	Length, inches	Quantity	Qty Cord
22" (550mm)	5/8"	49.50"	3 with anti-extrusion ring 2 with cord 3 w/o cord	1
26" (650mm)		57.50"		
28" (700mm)		61.50"		
30" (750mm)	3/4"	66.25"		
32" (800mm)		70.39"		
36" (900mm)		79.00"		
42" (1050mm)		91.82"		
48" (1200mm)		104.25"		



**Figure 3—Packing Ring Detail**

For all packing types, push excess packing toward the side opposite the seat.

**Reassembling Valve**

1. Replace the packing gland (A4), bolts (A5), washer (A6) and nuts (A7). Tighten the nuts evenly and finger tight, plus 1/2 turn.
2. Reconnect the stem to the gate with the two screws and nuts.
3. If the actuator is a powered actuator, reconnect power to the actuator.
4. Pressurize the pipeline and inspect packing for leakage.
5. If packing leaks, tighten the adjustment nuts (A7) on top of the packing gland (A4). Tighten the nuts evenly and gently - just enough to stop the leak. Over tightening will cause excessive operating forces, and will decrease the life of the packing.

**Replacing the Rubber Seat**

See Figure 2 for component identification.

**WARNING!**

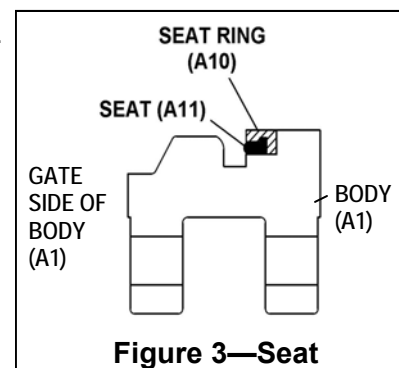
**Pipeline pressure can cause personal injury or equipment damage. Relieve pipeline pressure before removing gate stem and packing gland nuts.**

1. Relieve the pressure in the pipeline and close the valve.

**WARNING!**

**Accidental operation of power actuator can cause personal injury or equipment damage. Disconnect and lock out power to actuator before servicing.**

2. If the actuator is powered, disconnect and lock out power to prevent accidental operation of the actuator.
3. Remove the two screws and nuts near the top of the gate and disengage the stem from the gate.
4. Remove the pipeline flange bolts and flange from the side of the valve body opposite the word "SEAT". As an alternative, remove both flanges, and remove the valve from the pipeline.
5. Remove the actuator yoke and actuator from the valve.
6. Remove the gland nuts (A7), washers (A6), and packing gland (A4).
7. Remove the gate (A3) from the body.
8. Remove the packing (A2) from the packing chamber.
9. Remove the seat ring and seat; lightly grind away the tack weld at the bottom 6 o'clock position between the seat ring (A10) and the body (A1). Then, push the seat ring (A10) with the seat (A11) toward the center of the valve and remove the seat through the packing chamber.
10. Install the new replaceable seat:
  - a. Note the gate side and body side of the seat as shown in Figure 3.
  - b. Install the new seat (A11) onto the seat ring (A10) with the seat contour fitting into the groove in the ring.
  - c. Insert the seat ring (A10) with the seat (A11) through the packing chamber.
  - d. Press the seat ring (A10) into the body (A1) until it rests against the shoulder in the body.
  - e. Tack weld the seat ring (A10) in the same location as the previous tack weld. Make sure the seat is tight to the bottom of its pocket before welding.



### Seat Replacement *Continued*

#### Reassembling the Valve

1. Reassemble the gate (A3) in the body with the beveled edge facing away from the resilient seat. See Figure 2.
2. Place the gate in the fully closed position.
3. Reassemble the packing, as described in "Installing New Packing".
4. Reassemble the packing gland (A4), washers (A6), nuts (A7) and bolts (A5). Tighten the nuts evenly and finger tight, plus 1/2 turn.
5. Reassemble the yoke and actuator on the valve.
6. Reconnect the stem to the gate with the two screws and locknuts.
7. Reassemble the pipeline flange and flange bolts, or reassemble the valve in the pipeline if the valve was removed. Refer to the requirements in the "Installation" section.
8. If the actuator is a powered actuator, reconnect power to the actuator.
9. Pressurize the pipeline and inspect the valve for leaks.
10. If the packing leaks, tighten the adjustment nuts (A7) on top of the packing gland (A4). Tighten the nuts evenly and slowly, just enough to stop the leakage. Over tightening will cause excessive operating forces, and will decrease the life of the packing.

## Replacing the Gate

See Figure 2 for component identification.



#### **WARNING!**

**Pipeline pressure can cause personal injury or equipment damage. Relieve pipeline pressure before removing gate stem and packing gland nuts.**

---

1. Relieve the pressure in the pipeline and close the valve.



#### **WARNING!**

**Accidental operation of power actuator can cause personal injury or equipment damage. Disconnect and lock out power to actuator before servicing.**

---

2. If the actuator is powered, disconnect and lock out power to prevent accidental operation of the actuator.
3. Remove the pipeline flange bolts, and remove the valve from the pipeline.
4. Remove the actuator, actuator yoke, packing gland (A4), and packing (A2) from the valve.
5. Remove and inspect the gate (A3). If the gate appears to be scratched or galled due to too-long flange bolts in the chest area of the body, check for body damage in the tapped flange holes and within the chest cavity. Carefully check the seat for damage. Repair or replace the body, as appropriate.

Gate Replacement ***Continued***

6. Remove and inspect the seat components.
7. Replace or reinstall the seat components as described in step 10 in the "Seat Replacement" section.
8. Place the new gate (A3) in the body, in the fully closed position.
9. Replace or reinstall the packing (A2) as described in "Installing New Packing".
10. Replace the yoke and actuator on the valve.
11. Adjust the actuator, yoke, and packing gland so that the valve actuates smoothly full stroke in both directions, and so that there is no evidence of binding or scratching on the gate when the gate is visible in the fully open position.
12. Reinstall the valve in the pipe line —see "Installation" section.
13. If the actuator is a powered actuator, reconnect power to the actuator.
14. Pressurize the pipeline and inspect the valve for leaks.
15. If the packing leaks, tighten the adjustment nuts (A7) on top of the packing gland (A4).

**Note:** Tighten the nuts evenly and slowly, just enough to stop the leakage. Over tightening will cause excessive operating forces, and will decrease the life of the packing.

## Purge Port Option

When purge port options are ordered as illustrated, the intent is that the installer will connect purge lines.

**WARNING!**

**If pipeline is under pressure with purge port plugs in place, release line pressure before removing plugs. Serious or fatal injury may occur if line is under pressure.**

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Installation:

1. Remove all purge plugs after valve has been installed in line and before line is pressurized.
2. Connect proper purge line to the ports.
3. Pressurize purge lines and check for leaks.
4. Pressurize pipe line.

See Figure 4 for Purge Port sizes and locations.

Purge Port Options

VALVE SIZE		
INCH	MM	A
22	550	3/4"
26	650	3/4"
28	700	3/4"
30	750	3/4"
32	800	3/4"
36	900	3/4"
42	1050	3/4"
48	1200	3/4"

NOTE:

1. VALVE TO HAVE PURGE CONNECTIONS IN THIS AREA WHEN ORDERED BY CATALOG CHARACTERISTIC PCA OR PSC
2. VALVE TO HAVE PURGE CONNECTIONS IN THIS AREA WHEN ORDERED BY CATALOG CHARACTERISTIC PSA OR PSC

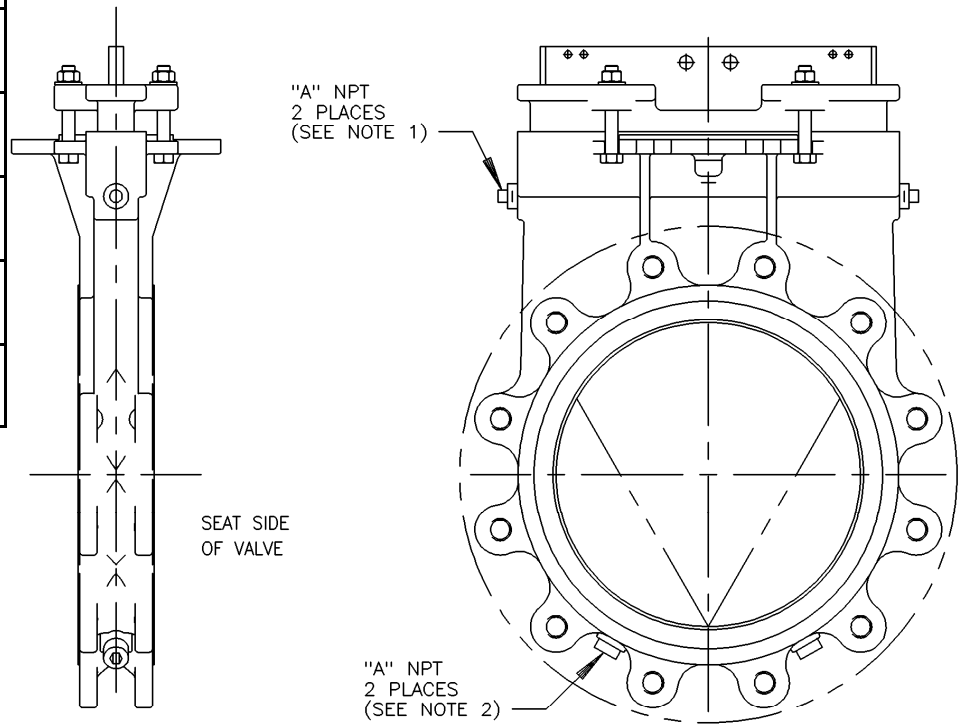


Figure 4—Purge Port Sizes and Locations

## Troubleshooting

<b>Condition</b>	<b>Possible Causes</b>	<b>Corrective Action</b>
Packing leaks, with no evidence of galling on gate	Packing is loose	Adjust packing gland
	Packing is worn or torn	Replace packing
Packing leaks and gate is galled	Packing is worn or torn	Replace packing and gate, check seat for damage
Valve leaks when fully closed, with no evidence of galling on gate	Seat is worn or torn	Replace seat
Valve leaks when fully closed and gate is galled	Seat is worn or torn	Replace gate and seat