

ภาคผนวก ข-31

การตรวจสอบ



NEW TATTON LIMITED PARTNERSHIP

Valve Function Test & Calibration Report

Customer: **Linde Thailand Public Co., Ltd.**
Plant: **HyCO-TAR22**

Job No. **2210-0163.1**
Report No. **CAL-NTT22-0014**
Date Entered: **11/29/2022**

Tag No. **17.HV-11001**

Manufacturer	SAMSON-VETEC	S/N	43068102
Valve Model	73.7R	Type	Segment rotary
Size x Port x Cv	3" x CV 254	Class	ANSI 900 RJ
Plug characteristic	LOG 30	Trim F.	Un-balanced
Body Material	A217 WCB	Trim	Stellited No.6
Gland Packing	MFGR's std.	Gasket	Graphite
Failure Position	<input type="radio"/> Fail Closed <input checked="" type="radio"/> Fail Open <input type="radio"/> Fail Hold <input type="radio"/> Other		
Actuator Model	R200	Maker	SAMSON-VETEC
Actuator Type	Spring-Diaphragm	act.size	-
Spring Range	0.4 - 1.2 Bar	Supply	4.0 Bar
Max/Min. Stopper	None	Stroke	0 - 75 Degree
Positioner maker	Samson	Input	4 - 20 mA
Model	3730-3	Type	I/P

Scope Of Work

- ☒ Overhaul body
- ☐ Overhaul actuator
- ☐ Re-gland packing
- ☒ Seat leakage test
- ☒ Body pressure test
- ☒ Calibration
- ☒ Function test



STD	FCI 70-2 CL. IV	AS FOUND	AS LEFT
Seat Leakage Test Table	Test Media	Air	Air
	Test Designation	P1	P1
	Test Pressure	4.0	4.0 Bar
	Supply air to Act	4.0	4.0 Bar
	Allowance	25.67	25.67 l/min
	Actual read	50	13.00 l/min
	Test Result	Failure	Passed

Performance Testing Table

Standard Value(s)			Reading Data (%)							
STD	Source	Opening	BEFORE				AFTER(AS Left)			
	(mA)	(%)	UP	Error	DOWN	Error	UP	Error	DOWN	Error
0	4	100	98.2	-1.8	98.2	-1.8	99.6	-0.4	99.6	-0.4
25	8	47.4	47.2	-0.2	47.2	-0.2	47.9	0.5	47.2	-0.2
50	12	20.3	20.0	-0.3	20.7	0.4	20.4	0.1	19.9	-0.4
75	16	10.7	10.5	-0.2	10.5	-0.2	12.9	2.2	12.9	2.2
100	20	0	-0.8	-0.8	-0.8	-0.8	-0.1	-0.1	-0.3	-0.3
Stroke Time (SEC.)			Shut-Open		14.9		Shut-Open		14.2	
			Open-Shut		6.8		Open-Shut		7.3	
Starting Point			19.200 mA				19.200 mA			
Opening Characteristic			<input checked="" type="checkbox"/> Linear <input type="checkbox"/> Customized							
			<input type="checkbox"/> EQ% <input type="checkbox"/> On-Off							
			<input type="checkbox"/> QO							

Actuator Leak Test		Body Pressure Test	
Test Media	Air	Test Media	Water
Test Press.	4.5 Bar	Test Press.	156.0 Bar
Period	2.0 Minute(s)	Period	5.0 Minute(s)
Result	Passed	Result	Passed

Part Replacement Table

Part name	Description	Q'ty
Gland packing	1108-651	1 set
Retainer/bottom gasket	1102-053	1 set
Gland packing	graphite ring (local)	4

Valve Accessories

- ☐ Booster Relay
- ☐ Quick Exhaust
- ☐ Prox./Limit Switches
- ☐ Min./Max.stopper
- ☐ Air Locked Device
- ☐ Feed Back Transmitter
- ☒ Solenoid Valve
- ☐ Speed Controller
- ☐ Switching Valve
- ☐ Handwheel

Work Activities

- ☒ External parts visual check
- ☒ Air tubing/fitting leak check
- ☒ Valve movement & travel check
- ☒ Function check
- ☒ Fail Safe Action check
- ☒ Cable connection tightness check
- ☒ Loop Test
- ☒ Sealed device's cover for waterproof

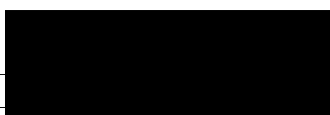
Reference Test Tools	Tester	Model	Serial No.	Cert.No.
	Fluke	789	26050104	E220016
	Fluke	789	29050009	E210094

Result Of Testing

All Function Test are correctly & passed

Note

Done By



11/29/2022

Checked By



11/29/2022

Loop Test By



11/29/2022

Feedback Transmitter Table

Feedback /IOUT Reading (mA)										ACCESSORIES	Maker	De-energized	Energized
IOUT		AS FOUND				AS LEFT					Norgren	<input checked="" type="radio"/> Valve CLOSE <input type="radio"/> Valve OPEN	<input type="radio"/> Valve CLOSE <input checked="" type="radio"/> Valve OPEN
STD	Command	UP	Error	DOWN	Error	UP	Error	DOWN	Error		SOV.model	From _____ To _____	From _____ To _____
0	4										8020899		
25	8												
50	12										Limit Switches Function Display	Position Close <input type="radio"/> YES <input type="radio"/> NO	
75	16											Position Open <input type="radio"/> YES <input type="radio"/> NO	
100	20												

Add recommend for further information

Picture of Inspection



A condition of valve body before clean.



A condition of valve body after clean.



A condition of plug-seat before clean & laping.



A condition of plug-seat are good after clean & laping.



All parts are good before assembly



A new spare parts of gland packing & gasket for replacement on this maintenance period.

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เอกสารสอบเทียบ



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Amphawan Tongpai

11/29/2022

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100	20								

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