

**A1 Test Facility
at
NASA Stennis Space Center**

**Industrial Water Valve Package
Diffuser Butterfly Valves**

**July 2, 2013
Revision 0**

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NASA-RPT-STD-8070-0001

**SURFACE CLEANLINESS STANDARD FOR
FLUID SYSTEMS FOR ROCKET ENGINE TEST
FACILITIES OF THE NASA ROCKET
PROPULSION TEST PROGRAM**

1.3 SUBMITTALS

The following shall be submitted to the Contracting Officers Representative (COR) in sufficient detail to show full compliance with the specification:

Data

The Contractor shall furnish design calculations covering performance features of the valve and actuator package. Design calculations for the valve shall be submitted with the shop drawings. These are due no later than three weeks after award of the contract. Design calculations shall include:

Actuator Sizing (specifically a force balance showing the valve can perform under full differential pressure)
Calculations showing piping pieces and spools are ASME B31.3 compliant.

Drawings

Shop Fabrication Drawings shall be submitted of each valve and of each shop assembly component as needed for the assembly of the valve, due at the conclusion of the contract. Shop drawings shall show the location and details of:

all dimensions and details of construction
lifting points
center of gravity (of complete valve assembly)
support design requirements (as needed)
bill of Materials

Schedules

A copy of Fabrication time and test and inspection schedules shall be submitted no later than three weeks after award of contract.

Statements

The Contractor shall submit the following items within three weeks after award of contract:

Hydrostatic Leak Check Procedures
Functional Test Procedures
Painting Specifications and Procedures (if applicable)

Reports

Prior to shipment, the Contractor shall submit a copy of the following items:

Mill Test Reports for all metallic components
Hydrostatic Test Report including test set-up configuration and log of time versus pressure
Functional Test Report
Cleaning Certification Report
Complete listing of all materials for soft goods.

1.4 REQUIREMENTS

Each valve shall be designed, fabricated, tested, cleaned and delivered in accordance with the detailed requirements of this specification and the attached data sheets. The requirements specified herein are minimum requirements. The Contractor shall take whatever additional measures are necessary in his design, fabrication, inspection and testing to produce a valve, which will satisfactorily pass the tests specified herein without damage. Where specific requirements are set forth, and where such specific requirements depart from requirements or alternatives contained in any documents referenced herein, the specific requirements contained herein shall govern and take precedence. The general requirements for each type of valve are provided within the body of this specification with specific requirements for each valve type provided in data sheets located in the appendices.

1.5 QUALITY ASSURANCE

The Contract Administrator and Government reserve the right to inspect all work at all times during and upon completion of fabrication and to witness any or all tests. The Contractor shall cooperate fully to enable the SSC COTR or Government designated representative to be present at the performance of any or all tests and any other activity as specifically requested. The Contractor shall furnish all equipment and materials for all tests except where specially stated otherwise. The Contractor shall notify the COTR fourteen calendar (14) calendar days prior to performance of any and all tests.

As a minimum, the following hold points shall apply:

Item No.	Surveillance	Type
1	Government review and approval of actuator sizing calculations	Verification
2	Hydrostatic test	Witness
3	Functional leak test at Maximum Operating Pressure	Witness
4	Review of radiographs	Verification

1.6 WELDING PROCEDURE AND WELDING OPERATOR QUALIFICATIONS

Welding procedure and welders qualifications shall be performed in accordance with Section IX of the ASME Boiler and Pressure Vessel Code.

1.7 GUARANTEE

All equipment to be furnished under this specification shall be guaranteed against defective materials, design, and workmanship for a period of one year from receipt of the valve. Upon receipt of notice of failure of any part of the guaranteed equipment during the guarantee period, new replacement parts shall be furnished and installed promptly by the Contractor at no additional cost. The Contractor shall acknowledge his responsibility under these guarantee provisions by letter, stating the inclusive dates of the guarantee period for which the equipment and materials referred herein are guaranteed.

1.8 PAINTING

Painting shall be in accordance with NASA-STD-5008B.

1.9 TESTING

All valves shall be hydrostatically tested to 1.5 times the MAWP and held for 10 minutes. The hydrostatic test pressure and test date shall be permanently marked on the valve body.

All valves shall be functionally tested per the attached data sheet.

1.10 CLEANING AND PACKAGING

Valves shall be cleaned to the level indicated on the data sheet per NASA RPT STD 8070-0001. After cleaning and verification of clean level, valves shall be packaged in accordance with NASA RPT STD 8070-0001.

1.11 END-TO-END DIMENSIONS

The required end-to-end (face-to-face) dimensions may be longer than that of the valve. In this event, a spool piece must be provided to make up the difference. This spool piece will be constructed of ASTM A53 Tp S Gr A Schedule 40 or ASTM A106 Gr A or Gr B Schedule 40 carbon steel. The nominal diameter of the pipe spool and the flanges welded to it will be the same as the valve. The spool will be cleaned in the same manner to the same level as the valve.

-- End of Section --

APPENDIX A
BUTTERFLY VALVES FOR WATER SERVICE

24" Butterfly Valve Data Sheet

- Nominal Size: 24"
- Valve Type: Butterfly
- Maximum Allowable Working Pressure/Design Pressure: 720 psig
- Maximum Operating Pressure: 350 psig
- Temperature Rating: +20 °F to +120 °F
- Materials of Construction:
 - Body: Carbon Steel
 - Shaft/Disc: 304 SS, 316 SS
 - Seals: Graphite, spring energized PTFE and PTFE chevron type packing or live loaded Teflon rope packing.
 - Seat: Ultra High Molecular Weight Polyethylene or similar material, metal-to-metal also allowed.
 - Guides: Copper Alloys, Bronze Alloys, Nickel-Copper Alloys
- End Connections: 24" 300# RF Serrated ANSI Flange
- Face-to-Face Dimension: 37" A spool piece should be provided to make up any gap between contractor's valve and 37" end-to-end requirement. Spool shall be ASTM A53 Tp S Gr A Schedule 40 pipe with similar connections as the valve.
- Service Fluid Compatibility: Raw or Industrial Water
- Service Fluid: Industrial Water
- Cleanliness Level: Visibly Clean
- Valves manufactured for water service shall have material certifications traceable by manufacturer's serial number.
- Minimum Required Cv: 18,000
- Actuator Type: Pneumatic actuator
- Stroke Time: 1 - 10 seconds to close (variable range)
- Stroke Time: 1 - 10 seconds to open (variable range with spring assist to close)
- Fail Position: Fail Closed
- External Operating environment of valve will be +20°F to +120°F and 100% relative humidity
- Valve will be subject to deluge water spray
- Valve must have lifting lugs.
- No metric threads are allowed
- All welds must meet ASME Boiler and Pressure Vessel Code, Div. 1 sections II, V, VIII, IX. Welds must be backed with Argon only, no Nitrogen.
- The Government reserves the right to inspect any or all component piece parts for cleanliness and workmanship prior to assembly with advanced two week notice.
- Valve must be hydrostatically proof tested to 1.5 times design pressure rating and held for a minimum of 10 minutes.
- Valve shall be permanently marked in the following way:
 - Manufacturer
 - Model #
 - Serial #
 - Nominal Size
 - MAWP
 - Temperature Rating
 - Max Cv
 - Proof Test Type / Pressure / Date
 - Weight
 - Flow Direction Arrow
- Manufacturer must supply any special tools needed for disassembly or reassembly of valve
- Manufacturer shall supply two (2) sets of spare softgoods with delivery of valve. A softgood set shall be defined as any and all non-metallic parts, plastic parts, parts recommended to be changed every time the valve is reassembled, and parts that experience severe wear.

Industrial Water Valve Package: Diffuser Butterfly Valves

- Valve shall be internally leak tested in primary direction of flow with potable water at Maximum Operating Pressure for no less than 3 minutes. Acceptable leakage is no more than 0.5 mL per minute per inch of nominal valve size.
- Along with valve, delivery shall include detailed drawings of valve, test procedures, and material certifications for both metal parts and soft goods.
- Valve shall be provided with pneumatic actuator with the following specifications:
- All actuators shall be constructed of carbon steel or stainless steel. Aluminum and non-metallic pressure containing parts are not permitted. Valve actuator tubing and tube fittings shall be made of a 300 series stainless steel, except that type 303 stainless steel is not permitted. All carbon steel external surfaces shall be coated with a fully bonded, abrasion resistant, and water-tight paint or coating system in accordance with requirements specified in NASA-STD-5008B . Insulating spacers, barriers, grommets shall be utilized to prevent contact between dissimilar metals in locations where moisture entry and accumulation is possible.

The actuating medium will be air or nitrogen gas at a nominal supply pressure of 100 psig. Upon complete loss of actuating pressure, the spring shall be capable of stroking the valve to its fail position with a differential pressure across the seat equal to the valve's maximum operating pressure, where this differential pressure opposes the actuator motion. Valve opening/closing time shall be varied within the time ranges provided via a variable orifice metering valve on the actuator exhaust port.

Pneumatic supply and vent connections on the cylinder shall be 1/2" to 3/4" FNPT or shall be 1/2" to 3/4" SAE AS5202 straight threaded connectors. Actuator shall be double acting with spring assist to failure position and sized and configured such that it can cycle the valve from full open to full close and vice versa within the maximum allowed stroke range specified above and with a differential pressure across the seat equal to the valve's maximum operating pressure, where this differential pressure opposes the actuator motion.

Solenoid valves shall be constructed of stainless steel. Solenoid valves shall operate on 24-28 VDC, less than 2 Amps. Solenoids shall be rated for minimum 350 PSIG service in dry, oil free nitrogen or compressed air. Solenoid valves shall be constructed to pull in with a minimum voltage of 18 VDC.

Actuator shall be functionally tested to maximum allowable working pressure (MAWP). Test pressure and date shall be stamped on the actuator housing.

Two limit switches are required, one is to indicate the fully open valve position and the other is to indicate the fully closed valve position. Limit switches shall be magnetic proximity type and approved for Class 1, Div. 2, Group B per the National Electric Code.

With the exception of the control solenoid valves, all electrical components and all wiring, including control and instrumentation wiring, mounted to the valve assembly, shall conform to the requirements of the National Electric Code, Article 500, "Hazardous Locations", for Class I, Div. 2, Group B locations.

Actuator shall have visual indicator showing valve is open or closed.

APPENDIX B1

NASA-STD-5008B

PROTECTIVE COATING OF CARBON STEEL, STAINLESS STEEL, AND
ALUMINUM ON LAUNCH STRUCTURES, FACILITIES AND GROUND SUPPORT
EQUIPEMENT

APPENDIX B2

NASA RPT-STD-8070-0001

SURFACE CLEANLINESS STANDARD FOR FLUID SYSTEMS
FOR ROCKET ENGINE TEST FACILITIES
OF THE NASA ROCKET PROPULSION TEST PROGRAM