

Safety Warning — LP-Gas Pressure Relief Valves

Purpose

In its continuing quest for safety, Engineered Controls International, Inc. is publishing safety warning bulletins explaining the hazards associated with the use, misuse and aging of *ECII®/ RegO® Products*. LP-Gas dealer managers and service personnel must realize that the failure to exercise the utmost care and attention in the installation, inspection and maintenance of these products can result in personal injury and property damage.

The National Fire Protection Association Pamphlet #58 “Storage and Handling of Liquefied Petroleum Gases” states: “In the interests of safety, all persons employed in handling LP-Gases shall be trained in proper handling and operating procedures.” *ECII®* Warning Bulletins are useful in training new employees and reminding older employees of potential hazards.

This Warning Bulletin should be provided to all purchasers of ECII® / RegO® Products and all personnel using or servicing these products. Additional copies are available from Engineered Controls International, Inc. and your Authorized ECII®/ RegO® Products Distributor.

WARNING

What You Must Do:

- Read This Entire Warning
- Install Properly
- Inspect Regularly
- Replace In 10 Years or Less

Scope

This bulletin applies to pressure relief valves installed on stationary, portable and cargo containers and piping systems utilized with these containers. This bulletin is not intended to be an exhaustive treatment of this subject and does not cover all safety practices that should be followed in the installation and maintenance of LP-Gas systems. Each LP-Gas employee should be provided with a copy of NPGA Safety Pamphlet 306 “LP-Gas Regulator and Valve Inspection and Maintenance” as well as the NPGA “LP-Gas Training Guidebooks” relating to this subject.

Warnings should be as brief as possible. If there is a simple warning, it is:

Inspect pressure relief valves regularly. Replace unsafe or suspect valves immediately. Use common sense.

Install Properly

Consult NFPA Pamphlet #58 and/or any applicable regulations governing the application and use of pressure relief valves. Make sure you are thoroughly trained before you attempt any valve installation, inspection or maintenance.

Proper installation is essential to the safe operation of pressure relief valves. When installing *ECII®/ RegO®* pressure relief valves, consult warning # 8545-500 which accompanies each valve. Check for damage and proper operation after valve installation. Check that the valve is clean and free of foreign material.

Pipeaways and deflectors may be required by local codes, laws and regulations depending on the installation. Use only *ECII®/ RegO®*

adapters on *ECII®/ RegO®* relief valves. Adapters not designed specifically for piping away *ECII®/ RegO®* relief valves, such as those with 90° turns or reduced internal diameters, will decrease flow dramatically. These should never be used as they can cause the relief valve to chatter and eventually destroy itself.

The addition of deflectors, pipeaway adapters and piping will restrict the flow. To properly protect any container, the total system flow must be sufficient to relieve pressure at the pressure setting of the relief valve in accordance with all applicable codes.

Inspect Regularly

A pressure relief valve discharges when some extraordinary circumstance causes an over pressure condition in the container. If a pressure relief valve is known to have discharged, the relief valve, as well as the entire system, should be immediately and thoroughly inspected to determine the reason for the discharge. In the case of discharge due to fire, the valve should be removed from service and replaced.

Relief valves should be inspected each time the container is filled but no less than once a year. If there is any doubt about the condition of the valve, it must be replaced.

Eye protection must be worn when performing inspection on relief valves under pressure. Never look directly into a relief valve under pressure or place any part of your body where the relief valve discharge could impact it. In some cases a flashlight and a small mirror are suggested to assist when making visual inspections.

To Properly Inspect A Pressure Relief Valve, Check For:

1. **A rain cap.** Check protective cap located in valve or at end of pipeaway for a secure fit. Protective caps help protect the relief valve against possible malfunction caused by rain, sleet, snow, ice, sand, dirt, pebbles, insects, other debris and contamination. **REPLACE DAMAGED OR MISSING CAPS AT ONCE AND KEEP A CAP IN PLACE AT ALL TIMES.**
2. **Open weep holes.** Dirt, ice, paint and other foreign particles can prevent proper drainage from the valve body. **IF THE WEEP HOLES CANNOT BE CLEARED, REPLACE THE VALVE.**
3. **Deterioration and corrosion on relief valve spring.** Exposure to high concentrations of water, salt, industrial pollutants, chemicals and roadway contaminants could cause metal parts to fail. **IF THE COATING ON THE RELIEF VALVE SPRING IS CRACKED OR CHIPPED, REPLACE THE VALVE.**

Replace Pressure Relief Valves In 10 Years Or Less

The safe useful life of pressure relief valves can vary greatly depending on the environment in which they live.

Relief valves are required to function under widely varying conditions. Corrosion, aging of the resilient seat disc and friction all proceed at different rates depending upon the nature of the specific environment and application. Gas impurities, product misuse and improper installations can shorten the safe life of a relief valve.

Predicting the safe useful life of a relief valve obviously is not an exact science. The conditions to which the valve is subjected will vary widely and will determine its useful life. In matters of this kind, only basic guidelines can be suggested. For example, the Compressed Gas Association Pamphlet S-1.1 Pressure Relief Device Standards — Cylinders, section 9.1.1 requires all cylinders used in industrial motor fuel service to have the cylinder's pressure relief valves replaced by new or unused relief valves within twelve years of the date of manufacture of cylinder and within each ten years thereafter. *The LP-Gas dealer must observe and determine the safe useful life of relief valves in his territory.* The valve manufacturer can only make recommendations for the continuing safety of the industry.

4. **Physical damage.** Ice accumulations and improper installation could cause mechanical damage. **IF THERE ARE ANY INDICATIONS OF DAMAGE, REPLACE THE VALVE.**
5. **Tampering or readjustment.** Pressure relief valves are factory set to discharge at specified pressures. **IF THERE ARE ANY INDICATIONS OF TAMPERING OR READJUSTMENT, REPLACE THE VALVE.**
6. **Seat leakage.** Check for leaks in the seating area using a non-corrosive leak detection solution. **REPLACE THE VALVE IF THERE IS ANY INDICATION OF LEAKAGE.** Never force a relief valve closed and continue to leave it in service. This could result in damage to the valve and possible rupture of the container or piping on which the valve is installed.
7. **Corrosion and contamination.** **REPLACE THE VALVE IF THERE ARE ANY SIGNS OF CORROSION OR CONTAMINATION ON THE VALVE.**
8. **Moisture, foreign particles or contaminants in the valve.** Foreign material such as paint, tar or ice in relief valve parts can impair the proper functioning of the valves. Grease placed in the valve body may harden over time or collect contaminants, thereby impairing the proper operation of the relief valve. **DO NOT PLACE GREASE IN THE VALVE BODY, REPLACE THE VALVE IF THERE ARE ANY INDICATIONS OF MOISTURE OR FOREIGN MATTER IN THE VALVE.**
9. **Corrosion or leakage at container connection.** Check container to valve connection with a non-corrosive leak detection solution. **REPLACE THE VALVE IF THERE IS ANY INDICATION OF CORROSION OR LEAKAGE AT THE CONNECTION BETWEEN THE VALVE AND CONTAINER.**

CAUTION: Never plug the outlet of a pressure relief valve. Any device used to stop the flow of a properly operating pressure relief valve that is venting an overfilled or overpressurized container - raises serious safety concerns!

WARNING: Under normal conditions, the useful safe service life of a pressure relief valve is 10 years from the original date of manufacture. However, the safe useful life of the valve may be shortened and replacement required in less than 10 years depending on the environment in which the valve lives. Inspection and maintenance of pressure relief valves is very important. Failure to properly inspect and maintain pressure relief valves could result in personal injuries or property damage.

For Additional Information Read:

1. CGA Pamphlet S-1.1 Pressure Relief Standards — Cylinders, Section 9.1.1.
2. ECII® Catalog L-500.
3. ECII® Warning # 8545-500.
4. NPGA Safety Pamphlet 306 "LP-Gas Regulator and Valve Inspection and Maintenance" and "LP-Gas Training Guidebooks".
5. NFPA # 58, "Storage and Handling of Liquefied Petroleum Gases".
6. NFPA # 59, "LP-Gases at Utility Gas Plants".
7. ANSI K61.1 Safety Requirements for Storage and Handling of Anhydrous Ammonia.

RegO® Pressure Relief Valves

Requirements for Pressure Relief Valves

Every container used for storing or hauling LP-Gas and anhydrous ammonia must be protected by a pressure relief valve. These valves must guard against the development of hazardous conditions which might be created by any of the following:

- Hydrostatic pressures due to overfilling or the trapping of liquid between two points.
- High pressures resulting from exposure of the container to excessive external heat.
- High pressures due to the use of incorrect fuel.
- High pressures due to improper purging of the container.

Consult NFPA Pamphlet #58 for LP-Gas and ANSI #K61.1 for anhydrous ammonia, and/or any applicable regulations governing the application and use of pressure relief valves.

Operation of Pressure Relief Valves

Pressure relief valves are set and sealed by the manufacturer to function at a specific “start-to-discharge” pressure in accordance with regulations. This set pressure, marked on the relief valve, depends on the design requirement of the container to be protected by the relief valve. If the container pressure reaches the start-to-discharge pressure, the relief valve will open a slight amount as the seat disc begins to move slightly away from the seat. If the pressure continues to rise despite the initial discharge through the relief valve, the seat disc will move to a full open position with a sudden “pop”. This sharp popping sound is from which the term “pop-action” is derived.

Whether the relief valve opens a slight amount or pops wide open, it will start to close if the pressure in the container diminishes. After the pressure has decreased sufficiently, the relief valve spring will force the seat disc against the seat tightly enough to prevent any further escape of product. The pressure at which the valve closes tightly is referred to as the “re-seal” or “blow-down” pressure. Generally, the re-seal pressure will be lower than the start-to-discharge pressure. The re-seal pressure can be, and in most cases is, adversely affected by the presence of dirt, rust, scale or other foreign particles lodging between the seat and disc. They interfere with the proper mating of the seat and disc and the pressure in the container will usually have to decrease to a lower pressure before the spring force embeds foreign particles into the resilient seat disc material and seals leak-tight. The degree by which the presence of dirt decreases the re-seal pressure, is, of course, dependent on the size of the interfering particles.

Once particles have been trapped between the disc and seat, the start-to-discharge pressure is also affected. For example, the pressure relief valve will start-to-discharge at some pressure lower than its original start-to-discharge pressure. Again, the pressure at which the valve will start to discharge is dependent on the size of the foreign particles.

In the case of a pressure relief valve that has opened very slightly due to a pressure beyond its start-to-discharge setting, the chances of foreign material lodging between the seat and disc is negligible although the possibility is always present. If the relief valve continues to leak at pressures below its start-to-discharge setting it must be replaced.

Relief valves which have “popped” wide open must also be checked for foreign material lodged between the seat and disc, as well as for proper reseating of the seat and disc. Continued leakage at pressures below the start-to-discharge setting indicate the relief valve must be replaced.

The pressure at which a pressure relief valve will start to discharge should never be judged by the reading of the pressure gauge normally furnished on the container.

The reasons for this are two-fold:

- If the relief valve is called upon to open, the resulting discharge produces an increased vaporization of the product in the container with the result that the liquid cools to a certain extent and the vapor pressure drops. A reading taken at this time would obviously not indicate what the pressure was when the relief valve opened.
- The pressure gauges usually on most containers provide somewhat approximate readings and are not intended to provide an indication of pressure sufficiently accurate to judge the setting of the relief valve.

Repair and Testing

RegO® Pressure Relief Valves are tested and listed by Underwriters Laboratories, Inc., in accordance with NFPA Pamphlet #58. Construction and performance of RegO® Pressure Relief Valves are constantly checked at the factory by U.L. inspectors. Therefore, testing of RegO® Pressure Relief Valves in the field is not necessary.

Never attempt to repair or change the setting of RegO® Pressure Relief Valves. Any changes in settings or repairs in the field will void the UL® listing and may create a serious hazard.

While the functioning of a pressure relief valve appears to be relatively simple, the assembly and test procedure used to manufacture these RegO® products is rather complex. Highly specialized test fixtures and specially trained personnel are necessary to attain proper relief valve settings. These fixtures and personnel are available only at the factory.

Any pressure relief valve which shows evidence of leakage, other improper operation or is suspect as to its performance must be replaced immediately using approved procedures.

Pipe-Away Adapters

Pipe-away adapters are available for most RegO® Pressure Relief Valves, where it is required or desirable to pipe the discharge above or away from the container. Each adapter is designed to sever if excessive stress is applied to the vent piping – thus leaving the relief valve fully operative.

Weep hole deflectors are available on larger relief valves. These deflectors provide protection against flame impinging on adjacent containers which could occur from ignition of LP-Gas escaping through the relief valve drain hole when the valve is discharging.

Selection of RegO® Pressure Relief Valves For ASME Containers

The rate of discharge required for a given container is determined by the calculation of the surface area of the container as shown in “Chart A” for LP-Gas and “Chart B” for anhydrous ammonia. See page D9.

Setting - The set pressure of a pressure relief valve depends upon the design pressure of the container. Refer to NFPA Pamphlet #58 for more information.

Selection of RegO® Pressure Relief Valves for DOT Containers

To determine the proper relief valve required for a given DOT con-

tainer, refer to the information shown with each pressure relief valve in the catalog. This information will give the maximum size (pounds water capacity) DOT container for which the relief valve has been approved.

Setting - The standard relief valve setting for use on DOT cylinders is 375 PSIG.

Ordering RegO® Pressure Relief Valves

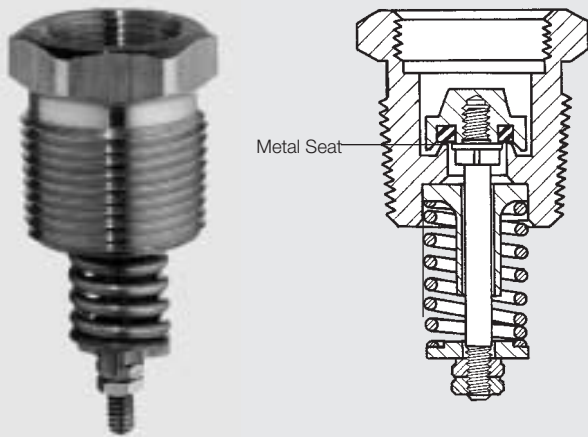
When ordering RegO® Pressure Relief Valves, be sure you are certain that it will sufficiently protect the container as specified in the foregoing information, NFPA Pamphlet #58 and any other applicable standards or specifications.

All adapters, protective caps and deflectors must be ordered separately, unless specified otherwise.

Part Number Explanation

Products carrying an "A" or "AA" prefix contain no brass parts and are suitable for NH₃. Hydrostatic relief valves carrying an "SS" prefix are of stainless steel construction and are suitable for use with NH₃. The products are also suitable for use with LP-Gas service except relief valves carrying an "AA" prefix. These are of partial aluminum construction and are listed by U.L. for NH₃ service only.

Safety Information — Relief Valves Don't Last Forever



RegO® Relief Valve for lift truck containers

The internal spring is protected from external contamination but the other external parts must be protected with a cap. Circular rubber seat disc ring seats on brass shoulder approximately 3/64" wide.

This article was prepared by the engineers of RegO® products, after technical consultation with valve manufacturers and other industry sources. Its purpose is to alert and remind the LP-Gas industry of the importance of proper maintenance of pressure relief valves. It applies most particularly to separate relief valves with emphasis on lift truck and motor fuel containers where the hazards of contamination are greatest.

Since the beginning of our industry, manufacturers of equipment and distributors of LP-Gas have worked diligently to provide a safe environment for employees and consumers. The history of the industry testifies to the success of their efforts.

But the industry is now entering its sixth decade and equipment installed years ago is failing because of age. Every year, additional equipment will fail unless it is replaced. Pressure relief valves are no exception. The valve manufacturers and LP-Gas dealers are naturally concerned about this situation.

Causes of Relief Valve Failure

A relief valve is designed to have a safe useful life of many years, but that life will vary greatly depending on the environment in which it "lives." To attempt to estimate the safe useful life of a relief valve and the effect of environment on its performance, a brief discussion of the materials used and the nature of its performance should be helpful.

Relief valve bodies are generally made of brass or steel. Springs are made from various spring wires which are plated or painted, or made of stainless steel. Valve seat discs are made of synthetic rubber compounds which will remain serviceable in an atmosphere of LP-Gas. Relief valve stems, guides, etc. are generally made from

brass or stainless steel.

Relief valves, over the years, may not function properly in several ways:

- They may leak at pressures below the set pressure.
- They may open and fail to properly reseal.
- They may open at higher than the set pressure.

These failures to function properly are due primarily to four "environmental" conditions:

1. Corrosion of metal parts (particularly springs) which result in the component parts failing to perform.
2. Deterioration of the synthetic rubber seat disc material.
3. Clogging or "cementing" of the movable relief valve components so that their movement is restricted.
4. Debris on the valve seat after the relief valve opens, effectively preventing the valve from reseating.

Corrosion is caused by water, corrosive atmospheres of salt and industrial pollutants, chemicals, and roadway contaminants. High concentrations can attack the metal parts vigorously. No suitable metals are totally resistant to such corrosion.

Synthetic rubber and seat disc materials can also be attacked by impurities in the gas and corrosive atmospheres, particularly those with sulphur dioxide. There are no suitable rubber materials which resist all contaminants.

"Cementing" of relief valve parts has been caused by normal industrial atmospheres containing particles of dirt, iron oxide, metal chips, etc. combined with water, oil, or grease. Ice collecting in recessed valves could cause relief valves to fail to open. Paint and tar in relief valves also cause failure to function properly.

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Safety Information — Relief Valves Don't Last Forever

Debris on valve seats which prevents reseating can occur whenever the valve collects material in the relief valve opening which is not blown out when the relief valve opens.

Inspection of Relief Valves

Unfortunately many of the above problems may not be easily observed because of the compact nature of some relief valve designs.

A casual visual inspection of a relief valve may not necessarily disclose a potential hazard. On the other hand, a visual inspection will often disclose leakage, corrosion, damage, plugging and contamination.

If additional light is required, a flashlight should be used.

If there is any doubt about the condition of the valve, or if there is a suspicion that the valve has not been protected by a cap for some time, it should be replaced before refilling the container.

Eye protection must be used when examining relief valves under pressure.

Smaller Relief Valves

The industry's requirement for a small full-flow safety relief valve challenged design engineers some years ago:

- The valve must be leakproof before operating and must reseat leakproof each time after each operation. The only known satisfactory seat disc materials to accomplish this have been special synthetic rubber compounds.
- Valve discharge settings are relatively high and require high spring loads to keep the valve closed.
- Because of the small interior diameter of the valve, the round metal seating area is small.

All of these parameters may result in the development of a significant indentation in the rubber seat disc after some years. The seat disc may have a tendency to cling to the metal seat. This may result in the relief valve not opening at the set pressure as the seat disc ages.

Tests have been conducted on small LP-Gas relief valves of all the U.S. valve manufacturers. Valves over 10 years old were removed from service and tested to determine at what pressure the valves discharged. In many of the valves, the pressure required to open the valve exceeded the set pressure.

Because of the critical importance of proper functioning of relief valves, common sense and basic safety practice dictate that small relief valves should be replaced in about 10 years.

Some larger relief valves on bulk storage tanks can be replaced with rebuilt valves obtained from the manufacturers. Small relief valves cannot be rebuilt economically, thus, new valves are required. Most LP-Gas dealers find it impractical and costly to test relief valves and field repairing of relief valves is not sanctioned by the manufacturers, Underwriter's Laboratories, or ASME.

Use of Protective Caps

Many of the problems that cause inoperative relief valves could be prevented if proper protective caps were kept in place *at all times*.

Collection of debris would be prevented. Contamination caused by corrosive atmospheres would be reduced. Water collection in the valves would be eliminated. Relief valves protected with caps from the time of installation in the container would obviously have a much longer safe useful life, but they still should be replaced at some time because of the gradual deterioration of the rubber seat disc due to age alone.

NFPA 58 requires that protective caps must be kept in place as a protective cover on some relief valves. This is a mandatory requirement on several types of relief valves. The fact that use of caps may make inspection more time consuming should not be viewed as a reason for either not using the caps, or not making required periodic inspections.

In the event a relief valve has been used without the required cap, the relief valve should be thoroughly inspected and the required cap placed on the relief valve. If damage is noted to the relief valve, it should be replaced and the replacement valve should be capped.

Relief valves with pipe-away adapters or deflectors used on lift truck containers have been found choked with debris. Inspection of relief valves with deflectors can only be accomplished by removing the deflector.

Similarly, larger relief valves with vent stacks have been found choked with debris and water. Valves have failed because springs rusted through. The weep hole was plugged. It was obvious that the relief valves had not been inspected in many years. These conditions must be alleviated by periodic inspections and replacement of relief valves as needed.

Summary Recommendations

Predicting the safe useful life of a relief valve is obviously not an exact science. The conditions to which the valve is subjected will vary widely and will largely control its life. In matters of this kind, only basic guidelines can be suggested. The LP-Gas dealer must observe and determine the safe useful life of relief valves in his territory. The valve manufacturers can only make recommendations for the continuing safety of the industry:

1. Make sure proper protective caps are in place at all times. Do not release a container for service or fill a container unless it has a protective cap in place.
2. Replace relief valves periodically, at least every 10 years. Every relief valve has the month and year of manufacture stamped on the valve. This is most particularly true of small *separate* relief valves.
3. Carefully inspect valves each time before the container is filled. Replace valves showing any signs of contamination, corrosion, damage, plugging, leakage, or any other problem. Eye protection must be used when examining relief valves under pressure.

Chart A – Minimum Required Rate of Discharge for LP-Gas Pressure Relief Valves Used on ASME Containers

Minimum required rate of discharge in cubic feet per minute of air at 120% of the maximum permitted start-to-discharge pressure for pressure relief valves to be used on containers other than those constructed in accordance with Interstate Commerce Commission specification.

From NFPA Pamphlet #58, Appendix D (1986).

Surface Area Sq. Ft.	Flow Rate CFM Air	Surface Area Sq. Ft.	Flow Rate CFM Air	Surface Area Sq. Ft.	Flow Rate CFM Air	Surface Area Sq. Ft.	Flow Rate CFM Air	Surface Area Sq. Ft.	Flow Rate CFM Air	Surface Area Sq. Ft.	Flow Rate CFM Air	Surface Area Sq. Ft.	Flow Rate CFM Air
20 or less	626	85	2050	150	3260	230	4630	360	6690	850	13540	1500	21570
25	751	90	2150	155	3350	240	4800	370	6840	900	14190	1550	22160
30	872	95	2240	160	3440	250	4960	380	7000	950	14830	1600	22740
35	990	100	2340	165	3530	260	5130	390	7150	1000	15470	1650	23320
40	1100	105	2440	170	3620	270	5290	400	7300	1050	16100	1700	23900
45	1220	110	2530	175	3700	280	5450	450	8040	1100	16720	1750	24470
50	1330	115	2630	180	3790	290	5610	500	8760	1150	17350	1800	25050
55	1430	120	2720	185	3880	300	5760	550	9470	1200	17960	1850	25620
60	1540	125	2810	190	3960	310	5920	600	10170	1250	18570	1900	26180
65	1640	130	2900	195	4050	320	6080	650	10860	1300	19180	1950	26750
70	1750	135	2990	200	4130	330	6230	700	11550	1350	19780	2000	27310
75	1850	140	3080	210	4300	340	6390	750	12220	1400	20380		
80	1950	145	3170	220	4470	350	6540	800	12880	1450	20980		

Surface area = Total outside surface area of container in square feet.

When the surface area is not stamped on the name plate or when the marking is not legible, the area can be calculated by using one of the following formulas:

1. Cylindrical container with hemispherical heads. Area (in sq. ft.) = overall length (ft.) x outside diameter (ft.) x 3.1416.
2. Cylindrical container with semi-ellipsoidal heads. Area (in sq. ft.) = [overall length (ft.) + .3 outside diameter (ft.)] x outside diameter (ft.) x 3.1416.
3. Spherical container. Area (in sq. ft.) = outside diameter (ft.) squared x 3.1416.

Flow Rate CFM Air = Required flow capacity in cubic feet per minute of air at standard conditions, 60°F. and atmospheric pressure (14.7 psia).

The rate of discharge may be interpolated for intermediate values of surface

area. For containers with total outside surface area greater than 2000 square feet, the required flow rate can be calculated using the formula, Flow Rate in CFM Air = 53.632 A^{0.82}. Where A = total outside surface area of the container in square feet.

Valves not marked "Air" have flow rate marking in cubic feet per minute of liquefied petroleum gas. These can be converted to ratings in cubic feet per minute of air by multiplying the liquefied petroleum gas ratings by the factors listed below. Air flow ratings can be converted to ratings in cubic feet per minute of liquefied petroleum gas by dividing the air ratings by the factors listed below.

Air Conversion Factors

Container Type	100	125	150	175	200
Air Conversion Factor	1.162	1.142	1.113	1.078	1.010

Chart B – Minimum Required Rate of Discharge for Anhydrous Ammonia Pressure Relief Valves Used on ASME Containers

Minimum required rate of discharge in cubic feet per minute of air at 120% of the maximum permitted start-to-discharge pressure for pressure relief valves to be used on containers other than those constructed in accordance with United States Department of Transportation cylinder specifications.

From ANSI K61.1-1981, Appendix A (1981).

Surface Area Sq. Ft.	Flow Rate CFM Air	Surface Area Sq. Ft.	Flow Rate CFM Air	Surface Area Sq. Ft.	Flow Rate CFM Air	Surface Area Sq. Ft.	Flow Rate CFM Air	Surface Area Sq. Ft.	Flow Rate CFM Air	Surface Area Sq. Ft.	Flow Rate CFM Air	Surface Area Sq. Ft.	Flow Rate CFM Air
20	258	95	925	170	1500	290	2320	600	4200	1350	8160	2100	11720
25	310	100	965	175	1530	300	2380	650	4480	1400	8410	2150	11950
30	360	105	1010	180	1570	310	2450	700	4760	1450	8650	2200	12180
35	408	110	1050	185	1600	320	2510	750	5040	1500	8900	2250	12400
40	455	115	1090	190	1640	330	2570	800	5300	1550	9140	2300	12630
45	501	120	1120	195	1670	340	2640	850	5590	1600	9380	2350	12850
50	547	125	1160	200	1710	350	2700	900	5850	1650	9620	2400	13080
55	591	130	1200	210	1780	360	2760	950	6120	1700	9860	2450	13300
60	635	135	1240	220	1850	370	2830	1000	6380	1750	10090	2500	13520
65	678	140	1280	230	1920	380	2890	1050	6640	1800	10330		
70	720	145	1310	240	1980	390	2950	1100	6900	1850	10560		
75	762	150	1350	250	2050	400	3010	1150	7160	1900	10800		
80	804	155	1390	260	2120	450	3320	1200	7410	1950	11030		
85	845	160	1420	270	2180	500	3620	1250	7660	2000	11260		
90	885	165	1460	280	2250	550	3910	1300	7910	2050	11490		

Surface area = Total outside surface area of container in square feet.

When the surface area is not stamped on the name plate or when the marking is not legible, the area can be calculated by using one of the following formulas:

1. Cylindrical container with hemispherical heads. Area (in sq. ft.) = overall length (ft.) x outside diameter (ft.) x 3.146.
2. Cylindrical container with other than hemispherical heads. Area (in sq. ft.) = [overall length (ft.) + .3 outside diameter (ft.)] x outside diameter (ft.) x 3.1416.
3. Spherical container. Area (in sq. ft.) = outside diameter (ft.) squared x 3.1416.

Flow Rate CFM Air = Required flow capacity in cubic feet per minute of air at standard conditions, 60°F. and atmospheric pressure (14.7 psia).

The rate of discharge may be interpolated for intermediate values of surface area. For containers with total outside surface area greater than 2,500 square feet, the required flow rate can be calculated using the formula, Flow Rate in CFM Air = 22.11 A^{0.82} where A = outside surface area of the container in square feet.

Conversion Factor

$$\begin{aligned} \text{ft}^2 \times 0.092903 &= \text{m}^2 \\ \text{CFM} \times 0.028317 &= \text{m}^3/\text{min} \\ \text{ft} \times 0.3048 &= \text{m} \end{aligned}$$



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“Pop-Action” Pressure Relief Valves

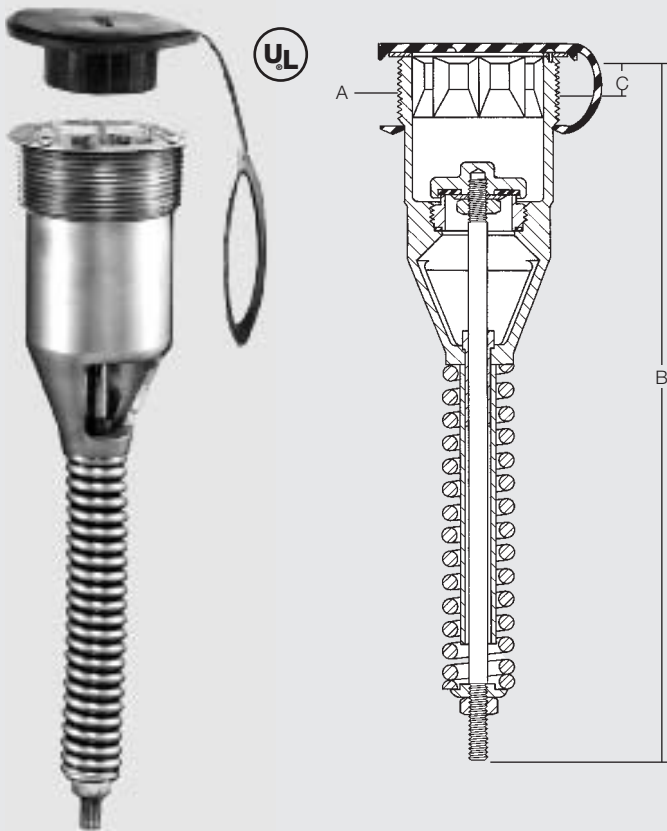
General Information

The “Pop-Action” design permits the RegO® Pressure Relief Valve to open slightly to relieve moderately excessive pressure in the container. When pressure increases beyond a predetermined point, the valve is designed to “pop” open to its full discharge capacity, reducing excess pressure quickly. This is a distinct advantage over ordinary valves which open gradually over their entire range, allowing excessive pressure to develop before the relief valve is fully open. All RegO® internal, semi-internal, and external relief valves incorporate this “Pop-Action” design.

Relief valves in this catalog are only intended for use in LP-Gas or anhydrous ammonia service. Do not use any relief valve contained in this catalog with any other service commodity. If you have an application other than conventional LP-Gas or anhydrous ammonia service, contact Engineered Controls International, Inc. before proceeding.

Fully Internal “Pop-Action” Pressure Relief Valves for Transports and Delivery Trucks

A8434 and A8436 Series



Application

Designed specifically for use as a primary relief valve in ASME transports and delivery trucks with 2" and 3" NPT couplings.

Features

- Low profile design assures maximum protection against shearing or distortion.
- All functioning parts are located below the level of the container connection to reduce the possibility of damage or tampering.
- Longer spring size designed to minimize stress cracking in service.
- Use of two different materials for stem and guide minimizes the possibility of stem seizure which may occur when similar materials are used.
- Internal octagonal wrenching broach assures easy installation and removal.
- ASME approved for use with LP-Gas and anhydrous ammonia.

Materials

Body	Stainless Steel
Spring	Stainless Steel
Stem	Stainless Steel
Stem Bushing	17-4PH Stainless Steel
Seat Disc	Resilient Synthetic Rubber

Ordering Information

Part Number	Start To Discharge Setting PSIG	A Container Connection	B Overall Height (Approx.)	C Height Above Coupling (Approx.)	Flow Capacity SCFM/Air		Suitable for Tanks with Surface Area Up To:*	Protective Cap (Included)
					UL (At 120% of Set Pressure)	ASME (At 120% of Set Pressure)		
A8434N	265	2" M. NPT	9 1/16"	1/2"	3700	3659	175 Sq. Ft.	A8434-11B
A8434G	250					3456		
A8436N	265	3" M. NPT	17 7/8"	3/4"	10210	9839	602 Sq. Ft.	A8436-11B
A8436G	250					9598		

* Per NFPA Pamphlet #58, Appendix D. Area shown is for UL or ASME flow rating—whichever is larger.

Fully Internal "Pop-Action" Pressure Relief Valves for Motor Fuel Containers

8543 and 8544 Series

Application

8543 Series relief valves are designed for use as a primary relief valve in larger ASME motor fuel containers such as on buses, trucks and construction equipment.

8544 Series relief valves are designed for use as a primary relief valve in smaller ASME and DOT motor fuel containers such as on tractors, lift trucks, cars and taxicabs.

Features

- Assure minimum product loss due to "pop-action" design.
- Recessed design minimizes possibility of damage and tampering.
- All are threaded to accept RegO® Pipeaway Adapters that permit the addition of a discharge hose or piping.
- ASME rated for use with LP-Gas (except 8544K which meets DOT requirements).
- Specify RegO® Relief Valves on all your original equipment motor fuel container purchases for reliable performance.

Materials

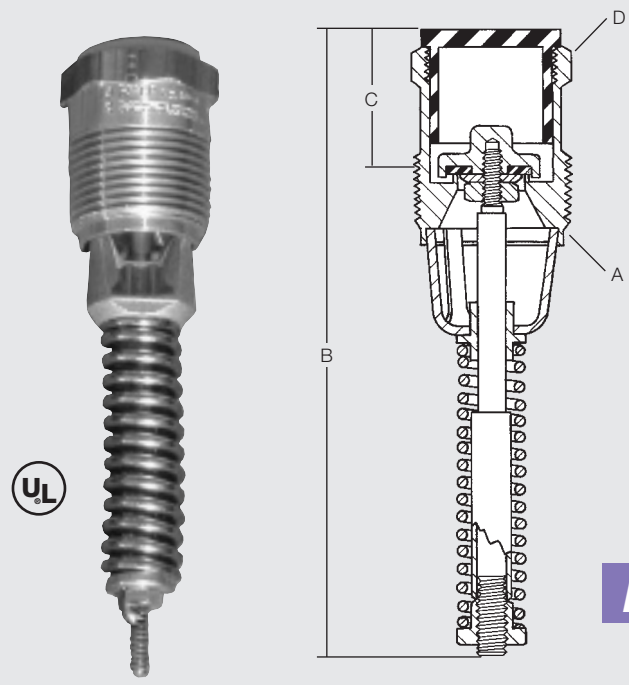
Body Brass
 Spring (8543)Stainless Steel
 Spring (8544) Coated Steel
 Seat Disc Resilient Rubber



7543-10



7544-11A



Ordering Information

Part Number	Container Type	Start To Discharge Setting PSIG	A Container Connection M. NPT	B Overall Height (Approx.)	C Height Above Coupling (Approx.)	D Hex Wrenching Section	Flow Capacity SCFM/Air****		Protective Cap (Included)	Accessories
							UL (At 120% of Set Pressure)	ASME (At 120% of Set Pressure)		Pipeaway Adapter
8544G	ASME	250	1"	5 ⁷ / ₁₆ "	7 ⁷ / ₈ "	1 ⁵ / ₁₆ "	1020	936	7544-41	7544-11A*
8543G			1 ¹ / ₄ "			1 ¹¹ / ₁₆ "	1465	1400	7543-40C	7543-10**
8544T		312	1"			1 ⁵ / ₁₆ "	1938	1158	7544-41	7544-11A*
8543T			1 ¹ / ₄ "			1 ¹¹ / ₁₆ "	1990	1731	7543-40C	7543-10**
8544K	DOT	375	1"			1 ⁵ / ₁₆ "	1547***	—	7544-41	7544-11A*

* 1" M. NPT outlet connection.
 ** 1¹/₄" M. NPT outlet connection.
 *** Rating determined per RegO® specifications at 480 PSIG.
 **** Flow rates shown are for bare relief valves. Adapters and pipeaway will reduce flow as discussed in forewording information.

Fully Internal "Pop-Action" Pressure Relief Valve for DOT Fork Lift Cylinders

8545AK

Application

Designed specifically for use as a primary relief valve on forklift cylinders, the 8545AK reduces the possibility of improper functioning of the relief mechanism due to foreign material build up. All guides, springs, stem and adjusting components are located inside the cylinder - removed from the direct exposure of foreign materials and debris from the atmosphere.

NFPA Pamphlet #58 requires that:

"All containers used in industrial truck (including forklift truck cylinders) service shall have the container pressure relief valve replaced by a new or unused valve within 12 years of the date of manufacture of the container and each 10 years thereafter."

Features

- Positive stop in the upper body protects against improper insertion of a pipeway adapter that might interfere with proper operation of the relief valve.
- Internal stem guide eliminates the need for a close fit between the body and poppet, which lessens the chance of clogging due to foreign material.
- Single piece cold-headed stem provides more accurate positioning of working parts for more consistent operation and precise adjustment.
- Two different deflector adapters and a protective cap are available as accessories to provide complete protection.
- "Pop-action" design keeps product loss at a minimum.
- Request RegO® Relief Valves on all your original equipment forklift cylinders for reliable performance.

Materials

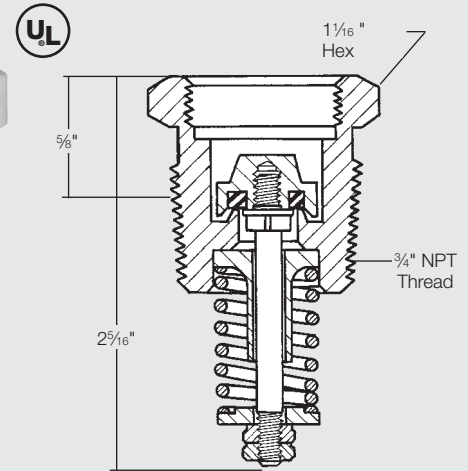
Body	Brass
Stem	Stainless Steel
Spring	Stainless Steel
Poppet	Brass
Guide	Brass
Seat Disc	Resilient Rubber



7545-12 90° Adapter



7545-14 45° Adapter



Ordering Information

Part Number	Container Type	Start To Discharge Setting PSIG	Container Connection M. NPT	Flow Capacity SCFM/Air** (ECII® Rated at 480 PSIG)	Accessories (Order Separately)		
					Protective Cap	Deflectors***	
						45° Elbow	90° Elbow
8545AK	DOT	375	3/4"	350*	7545-40	7545-14	7545-12

* Classified by U.L. in accordance with Compressed Gas Association Pamphlet S-1.1 Pressure Device Standards for Cylinders. Meets requirements for use on DOT containers with 216 pounds or less weight of water or 90 pounds or less of LP-Gas.

** Flow rates are shown for bare relief valves. Adapters and pipeways will reduce flow as discussed in forewording information.

*** Order protective cap #8545-41 or 7545-40.

Semi-Internal "Pop-Action" Pressure Relief Valves for ASME Containers

Application

Designed for use as a primary relief valve on ASME containers such as 250, 500 and 1,000 gallon tanks. Underwriters' Laboratories lists containers systems on which these types of valves are mounted outside the hood without additional protection, if mounted near the hood and fitted with a protective cap.

Features

- Huddling chamber design allows quick opening and resists chattering for long dependable service life.
- Constructed of non-corrosive materials.
- "Pop-action" design keeps product loss at a minimum.
- ASME rated for use with LP-Gas.
- Request RegO® Relief Valves on all your original equipment ASME containers for reliable performance.

7583, 8684 and 8685 Series

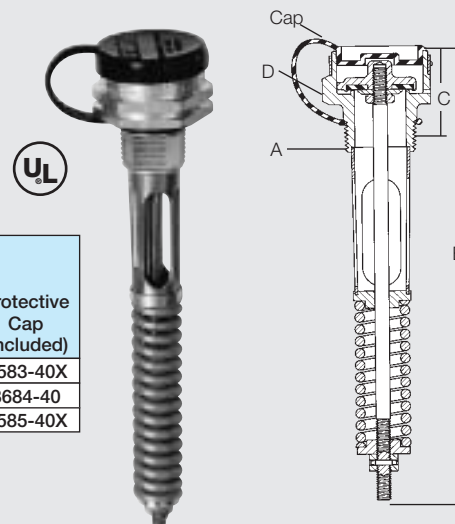
Materials

Body Brass
 Spring Steel
 Stem Stainless Steel
 Seat Disc Resilient Rubber

Ordering Information

Part Number	Start To Discharge Setting PSIG	A Container Connection M. NPT	B Overall Height (Approx.)	C Height Above Coupling (Approx.)	D Wrench Hex Section	Flow Capacity SCFM/Air		Suitable for Tanks w/Surface Area Up To:*	Protective Cap (Included)
						UL (At 120% of Set Pressure)	ASME (At 120% of Set Pressure)		
7583G	250	¾"	8¾"	1¾"	1¾"	1980	1806	80 Sq. Ft.	7583-40X
8684G		1"	9¾"	1¾"	1¾"	2620	2565	113 Sq. Ft.	8684-40
8685G		1¼"	11¼"	1¼"	2¾"	4385	4035	212 Sq. Ft.	7585-40X

* Per NFPA Pamphlet #58, Appendix D. Area shown is for UL or ASME flow rating—whichever is larger.



Semi-Internal "Pop-Action" Pressure Relief Valves for Large Storage Containers

Application

Designed especially for use as a primary relief valve on large stationary storage containers, these low profile relief valves are generally mounted in half couplings. However, they are designed so that the inlet ports clear the bottom of a full 2" coupling. This assures that the relief valve should always be capable of maximum flow under emergency conditions.

Features

- Large huddling chamber design allows quick opening and resists chattering for long dependable service life.
- High capacity, low turbulence design has a maximum guiding area providing for dependable shut-off after opening.
- Built-in spring stop limits the rise of the seat in full open position and prevents the spring from going "solid".
- External 3" NPT threaded body allows easy attachment of vent stacks. Optional pipeaway adapter has break-off groove to prevent damage to the relief valve should piping be stressed by damaging winds.
- "Pop-Action" design keeps product loss at a minimum.
- No guiding projections around the seat disc retainer to bind and hinder opening of valve if body is damaged.

7534 Series

- Weep hole deflector is furnished, installed, to guard against flame impingement on adjacent containers.
- ASME rated for use with LP-Gas.

Materials

Upper Body Brass Forging
 Lower Body Brass Casting
 Stem Stainless Steel
 Spring Coated Steel
 Seat Disc Resilient Rubber

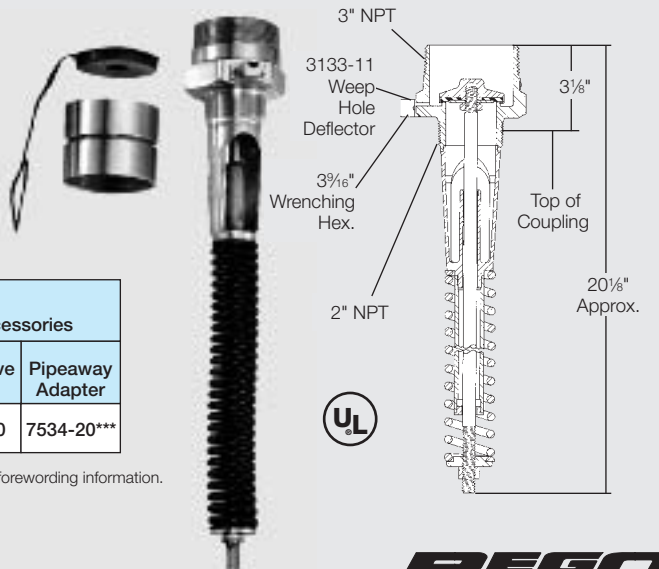
Ordering Information

Part Number	Start To Discharge Setting PSIG	Container Connection M. NPT	Flow Capacity SCFM/Air*		Suitable for Tanks w/Surface Area Up To:**	Accessories	
			UL (At 120% of Set Pressure)	ASME (At 120% of Set Pressure)		Protective Cap	Pipeaway Adapter
7534B	125	2"	6,025	—	319 Sq. Ft.	7534-40	7534-20***
7534G	250		11,675	10,422	708 Sq. Ft.		

* Flow rates shown are for bare relief valves. Adapters and pipeaways will reduce flow as discussed in the forewording information.

** Per NFPA Pamphlet #58, Appendix D. Area shown is for UL or ASME—whichever is larger.

*** 3" F. NPT outlet connection.



External "Pop-Action" Pressure Relief Valves for ASME Containers and Bulk Plant Installations

AA3126, AA3130, 3131, 3132, 3133, 3135, AA3135, and A3149 Series

Application

Designed for use as a primary relief valve on ASME above ground and underground containers, bulk plant installations and skid tanks. The 3131 Series may also be used as a primary or secondary relief valve on DOT cylinders, or as a hydrostatic relief valve.

All working components of these relief valves are outside the container connection, so the valves must be protected from physical damage.

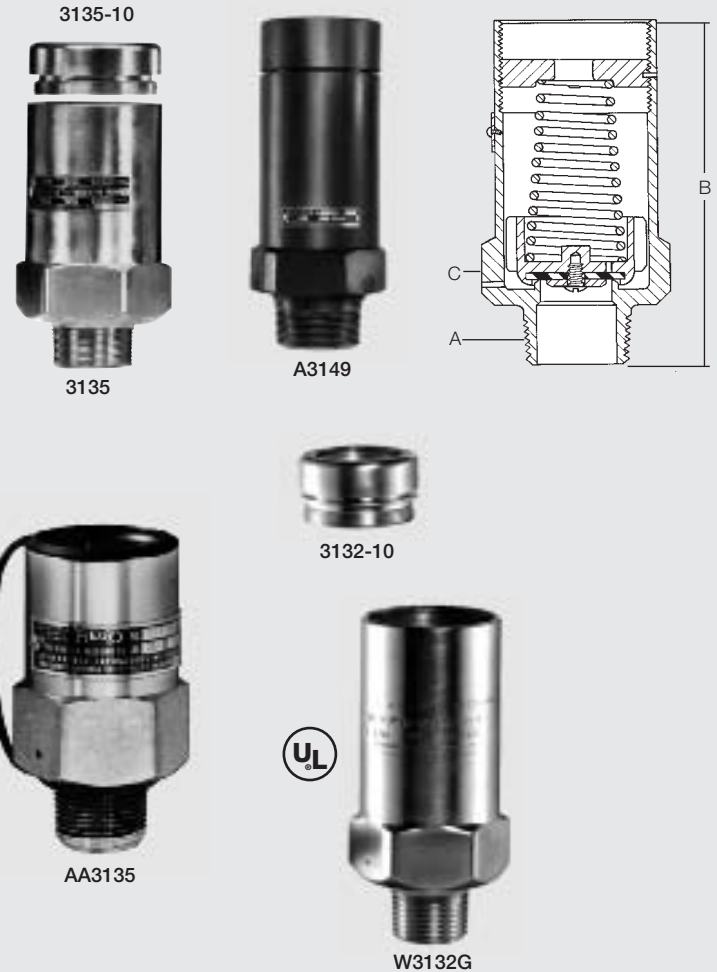
Features

- "Pop-action" design keeps product loss at a minimum.
- Relief valve designed to automatically reseal firmly after discharge.
- Resilient seat disc provides "bubble-tight" seal.
- 3149 relief valves incorporate integral pipeway adapter with break off groove that protects the valve from piping stress damage.
- Optional pipeway adapters have grooves that will break off to protect the relief valve from damage should excess stress be applied to the piping.
- 3149 relief valves include weep hole deflectors, installed to guard against flame impingement on adjacent containers.
- Most are ASME rated for use with LP-Gas and anhydrous ammonia.

Materials

Description	3131, 3132 3133, 3135	AA3126 AA3130	AA3135	A3149
Body	Brass	Aluminum Rod*		Upper Cold Rolled Steel Lower Ductile Iron
Liner	None			Stainless Steel
Spring Guide	Brass	Aluminum		Stainless Steel
Spring	Corrosion Resistant Steel	Stainless Steel	Stainless Steel or Coated Steel	
Seat Disc	Resilient Synthetic Rubber			

* A special coating is applied to the inlet threads to minimize possibility of electrolytic action between the valve and steel coupling.



Ordering Information

Part Number	Start To Discharge Setting PSIG	A Container Connection M. NPT	B Overall Height (Approx.)	C Wrench Hex Section	Flow Capacity SCFM/Air (a)			Suitable for Tanks with Surface Area Up To: (e)	Accessories			
					UL (At 120% of Set Pressure)	ASME (At 120% of Set Pressure)	Protective Cap		Pipeway Adapter		Weep Hole Deflector	
									Part Number	Outlet Size		
AA3126L030	30	1/2"	2 3/8"	7/8"	(b)	—	—	7545-40	AA3126-10	1/2" M. NPT	—	
A3149L050	50	2 1/2"	10 1/2"	4 1/8"	2600(c)	—	113 Sq. Ft.	3149-40	(h)		Included ()	
A3149L200	200				8770 (c)	—	500 Sq. Ft.					
AA3126L250	250				1/2"	2 3/8"	7/8"		277 (c)	—		23 Sq. Ft. (f)
3131G	250	3/4"	3 7/16"	1 3/4"	2060	1939	85 Sq. Ft.	3131-40 (g)	—		3133-11B	
AA3130UA250		1"	6 1/32"	2 3/8"	2045	1838	249 Sq. Ft. (f)	AA3130-40P	AA3131-10	1" F. NPT		
W3132G					3340	—	154 Sq. Ft.	3132-54 (g)	3132-10	1 1/4" F. NPT		
3132G					4130	—	200 Sq. Ft.		—			
T3132G					3790	—	180 Sq. Ft.		3132-10	1 1/4" F. NPT		
MV3132G		1 1/4"	5 21/32"	2 11/16"	3995	—	190 Sq. Ft.	3135-54 (g)	—			
3135G					5770	—	300 Sq. Ft.		3135-10	2" F. NPT		
AA3135UA250					6430	5080 (d)	1010 Sq. Ft. (f)		AA3135-40PR			AA3135-10
3133G		1 1/2"	5 15/16"	3 1/8"	6080	—	320 Sq. Ft.	3133-40 (g)	3133-10	—		
A3149G		2 1/2"	10 1/2"	4 1/8"	10390	9153	613 Sq. Ft.	3149-40	(h)			Included (j)
AA3130UA265	265	3/4"	3 7/16"	1 3/4"	2125	1912	261 Sq. Ft. (f)	AA3130-40P	AA3131-10	1" F. NPT	—	
AA3135UA265		1 1/4"	6 11/16"	2 11/16"	6615	5370 (d)	1045 Sq. Ft. (f)	AA3135-40PR	AA3135-10	2" F. NPT	3133-11B	
AA3126L312	312	1/2"	2 3/8"	7/8"	330 (c)	—	27 Sq. Ft. (f)	7545-40	AA3126-10	1/2" M. NPT	—	

(a) Flow rates shown are for bare relief valves. Adapters and pipeways will reduce flow as discussed in forewording information.

(b) Not UL or ASME rated. .059 square inch effective area.

(c) Not UL or ASME rated. ECII* rated at 120% of set pressure.

(d) Rated at 110% of set pressure.

(e) Per NFPA Pamphlet #58, Appendix D. Area shown is for UL or ASME flow rating—whichever is larger.

(f) Per ANSI K61.1-1972, Appendix A.

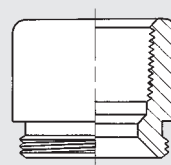
(g) Cap supplied with chain.

(h) Outlet 3/8"-8N (F) thread, will accept 3" M. NPT pipe thread.

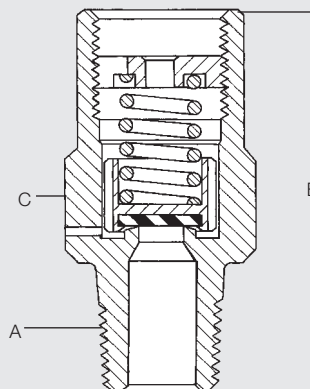
(j) Weep hole deflector is Part No. A3134-11B.

External "Pop-Action" Supplementary Pressure Relief Valves for Small ASME Containers and DOT Cylinders

3127 and 3129 Series



3129-10
Pipe Away Adapter



Application

Designed for use as a supplementary relief valve on small ASME above ground and underground containers. They may also be used as a primary or secondary relief device on DOT cylinders, or as hydrostatic relief valves.

All working components of these relief valves are outside the container connection, so the valves must be protected from physical damage.

Materials

Body Brass
 Spring Stainless Steel
 Seat Disc Resilient Rubber

Features

- "Pop-action" design keeps product loss at a minimum.
- Relief valve designed to automatically reseal firmly after discharge.
- Resilient seat disc provides a "bubble-tight" seal.

Ordering Information

Part Number	Container Type	Start To Discharge Setting PSIG	A Container Connection M. NPT	B Overall Height (Approx.)	C Wrench Hex Section	Flow Capacity SCFM/Air*		Suitable for Tanks with Surface Area Up to: ***	Accessories		
						UL (At 120% of Set Pressure)	ECII® Rated at 480 PSIG**		Protective Cap	Pipeaway Adapter	
										Part Number	Outlet Size
3127G	ASME	250	1/4"	1 31/32"	7/8"	295	—	—	7545-40	—	
3129G			1/2"	2 19/32"	1 1/8"	465	—			3129-10	1/2" F. NPT
3127K	DOT	375	1/4"	1 31/32"	7/8"	—	450	100 lbs./Propane		—	
3129K			1/2"	2 19/32"	1 1/8"		780	200 lbs./Propane		3129-10	1/2" F. NPT

* Flow rates shown are for bare relief valves. Adapters and pipeaways will reduce flow as discussed in forewording information.

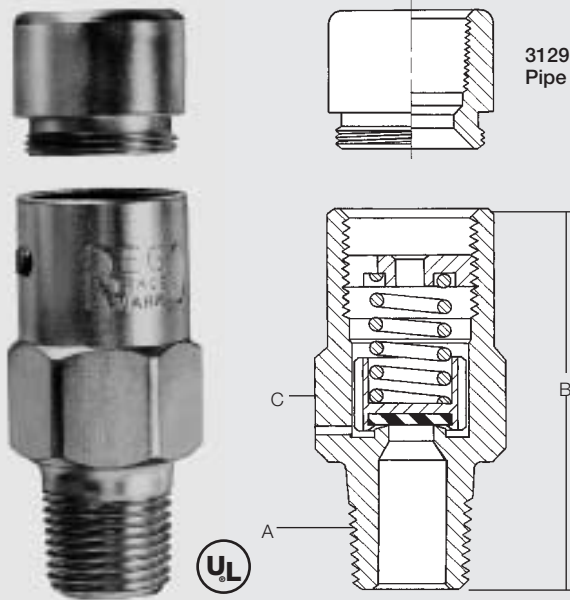
** Not UL or ASME rated. ECII® rated at 480 PSIG.

*** Meets DOT requirements.

D

External Hydrostatic Relief Valves

3125, 3127, 3129, SS8001, SS8002, SS8021 and SS8022 Series



3129-10
Pipe Away Adapter

Application

Designed especially for the protection of piping and shut-off valves where there is a possibility of trapping liquid LP-Gas or anhydrous ammonia. They may be installed in pipelines and hoses located between shut-off valves or in the side boss of RegO® shut-off valves.

Features

- Relief valve designed to automatically reseal firmly after discharge.
- Resilient seat disc provides a "bubble-tight" seal.
- Available in both brass and stainless steel.
- Available in configurations that permit direct attachment of vent piping when required.

Materials

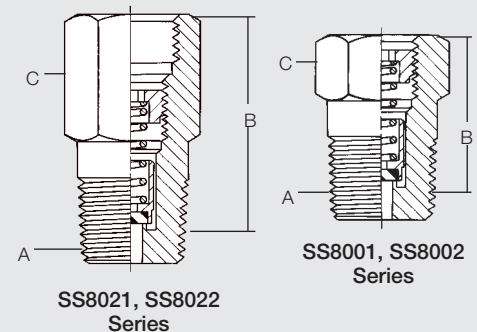
Body (3125, 3127, 3129) Brass
 Body (SS8001, SS8002, SS8021, SS8022)..... Stainless Steel
 Spring Stainless Steel
 Seat Disc Resilient Rubber

3125, 3127, 3129 Series

Ordering Information

Part Number	Start To Discharge Setting PSIG	Valve Body Material	A Container Connection M. NPT	B Height (Approx.)	C Wrench Hex Section	Accessories		
						Protective Cap	Pipeaway Adapter or Threads	
SS8001G	250	Stainless Steel	1/4"	7/8"	1 1/16"	8001-54*	-	
SS8002G			1/2"		7/8"	8022-54*		
SS8021G			1/4"	1 3/8"	1 1/16"	8001-54	1/4" NPSM Thrds	
SS8022G			1/2"		7/8"	8002-54*	3/8" NPT Thrds	
3127G			1/4"	1 31/32"	7/8"	9103-54*	-	
3129G			1/2"	2 19/32"	1 1/8"	3129-40P*	3129-10**	
3127H		275	Brass	1/4"	1 31/32"	7/8"	9103-54*	-
3129H				1/2"	2 19/32"	1 1/8"	3129-40P*	3129-10**
3127P				1/4"	1 31/32"	7/8"	9103-54*	-
3129P		300		1/2"	2 19/32"	1 1/8"	3129-40P*	3129-10**
3127J				1/4"	1 31/32"	7/8"	9103-54*	-
3129J				1/2"	2 19/32"	1 1/8"	3129-40P*	3129-10**
SS8001J	350	Stainless Steel	1/4"	7/8"	1 1/16"	8001-54*	-	
SS8002J			1/2"		7/8"	8002-54*		
SS8021J			1/4"	1 3/8"	1 1/16"	8001-54	1/4" NPSM Thrds	
SS8022J		1/2"	7/8"		8002-54*	3/8" NPT Thrds		
3127K		375	Brass	1/4"	1 31/32"	7/8"	9103-54*	-
3129K				1/2"	2 19/32"	1 1/8"	3129-40P*	3129-10**
3125L	1/4"			1 9/16"	5/8"	3125-40P*	-	
3127L	400	Stainless Steel		1/4"	1 3/8"	7/8"	9103-54*	-
3129L				1/2"		2 19/32"	1 1/8"	
SS8001L				1/4"	7/8"	1 1/16"	8001-54*	-
SS8002L	1/2"		7/8"	8002-54*				
SS8021L	1/4"		1 3/8"	1 1/16"	8001-54	1/4" NPSM Thrds		
SS8022L	1/2"			7/8"	8002-54*	3/8" NPT Thrds		
3127U	450	Brass	1/4"	1 31/32"	7/8"	9103-54*	-	
3129U			1/2"	2 19/32"	1 1/8"	3129-40P*	3129-10**	
SS8001U			1/4"	7/8"	1 1/16"	8001-54*	-	
SS8002U		1/2"	7/8"		8002-54*			
SS8021U		1/4"	1 3/8"	1 1/16"	8001-54	1/4" NPSM Thrds		
SS8022U		1/2"		7/8"	8002-54*	3/8" NPT Thrds		

* Included
 ** 1/2" F. NPT outlet connection.



DuoPort® Pressure Relief Valve Manifolds for Small Storage Containers

8542 Series

Application

Designed especially for use as a primary relief device on smaller stationary storage containers, with 2" NPT threaded couplings. These manifolds allow servicing or replacement of either of the two relief valves without evacuating the container or loss of service. The operating lever selectively closes off the entrance port to the relief valve being removed while the remaining valve provides protection for the container and its contents. The rating of each manifold is based on actual flow through the manifold and a single pressure relief valve, taking friction loss into account. It is not merely the rating of the relief valve alone.

Features

- Allows for relief valve removal and replacement on a periodic basis without shutting down and evacuating the container.
- Unique seat ring assemblies provide a smooth tubular section to preclude turbulence and assure more efficient flow capacity.
- Operating lever is only locked in the mid-position or in a position to seal either relief valve. Placement of the clapper disc in an intermediate position could restrict flow through one of the relief valves, causing it to chatter and destroy the resilient seat disc.
- A rubber plug with chain is provided to protect manifold outlet threads where the relief valve has been removed.
- "Pop-action" design insures maximum protection with only minimal product loss at moderately excessive pressures.
- Resilient relief valve seat disc provides "bubble-tight" seal.
- Relief valves are ASME rated for use with LP-Gas and anhydrous ammonia.

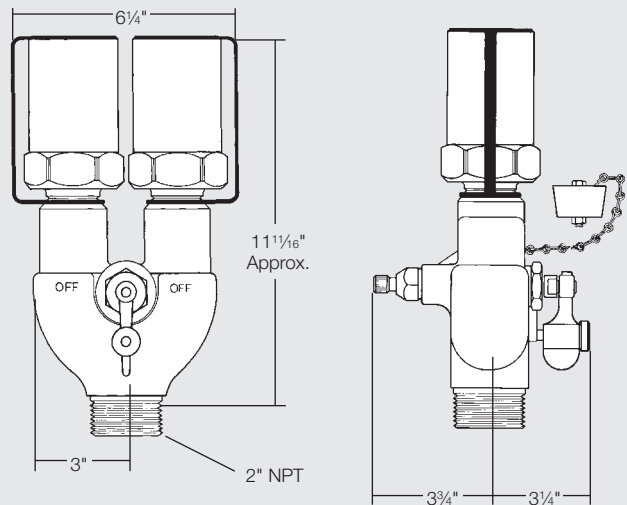
Manifold Materials

Body Ductile Iron
Clapper Disc Stainless Steel
Bleeder Valve Stainless Steel
Seat Disc Teflon
Packing Polyethylene

Relief Valve Materials

Body Forged Aluminum*
Spring Guide Aluminum
Spring Coated Steel
Seat Disc Resilient Synthetic Rubber

*A special coating is applied to the inlet threads to minimize the possibility of electrolytic action.



Ordering Information

Part Number	Start To Discharge Setting PSIG	Application		Container Connection M. NPT	Relief Valve Included			Flow Capacity SCFM/Air** UL (At 120% of Set Pressure)	
		LP-Gas	NH ₃		Quantity	Part Number	Inlet Connection M. NPT		Accessory Pipeaway Adapters
8542G	250	Yes	No	2"	2	3135MG	1 1/4"	3135-10*	5250 (1)
AA8542UA250		No	Yes			AA3135MUA250		AA3135-10*	5865 (1)
AA8542UA265	265					AA3135MUA265	5975 (1)		

* 2" F. NPT outlet connection.

** Flow rating based on number of relief valves indicated in parenthesis (). Flow rates shown are for bare relief valves. Adapters and pipeaways will reduce flow rates as discussed in forewording information.

Multiport™ Pressure Relief Valve Manifold Assemblies for Large Storage Containers

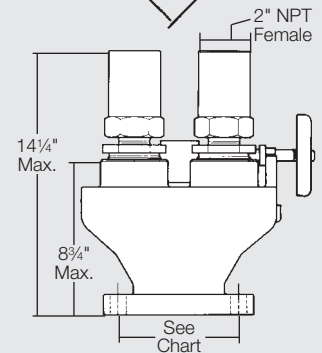
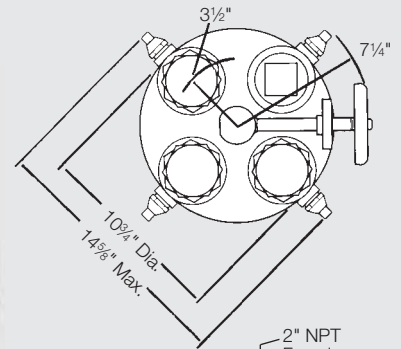
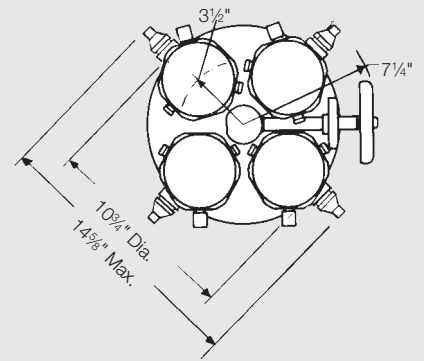
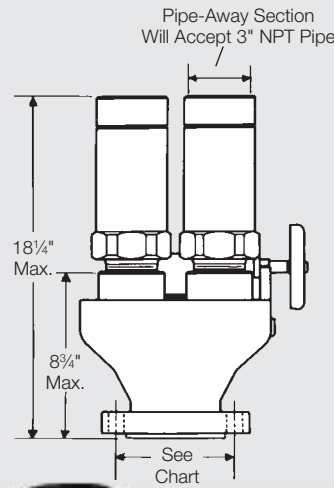
A8560, A8570 and AA8570 Series



A8560
A8570



AA8570



Application

Designed especially for use as a primary relief device on large stationary pressurized storage containers with flanged openings. These manifolds incorporate an additional relief valve, not included in the flow rating, allowing for servicing or replacement of any one of the relief valves without evacuating the container. The handwheel on the manifold selectively closes off the entrance port to the relief valve being removed while the remaining relief valves provide protection for the container and its contents. All manifold flow ratings are based on flow through the relief valves after one has been removed for service or replacement.

Features

- Allows for relief valve removal and replacement on a periodic basis without shutting down and evacuating the container.
- “Pop-action” design of relief valves insures maximum protection with only minimal product loss at moderately excessive pressures.
- A rubber plug with chain is provided to protect manifold outlet threads where the relief valve has been removed.
- May be mounted directly to a welding neck flange or manhole cover plate. Requires no inlet piping.
- Relief valves designed to automatically reseal firmly after discharge.
- Resilient relief valve seat disc provides “bubble-tight” seal.
- Relief valves are ASME rated for use with LP-Gas and anhydrous ammonia.

Manifold Materials

Body Ductile Iron
Resilient Parts Teflon
Clapper Disc Stainless Steel
Bleeder Valve Stainless Steel

Relief Valve Materials

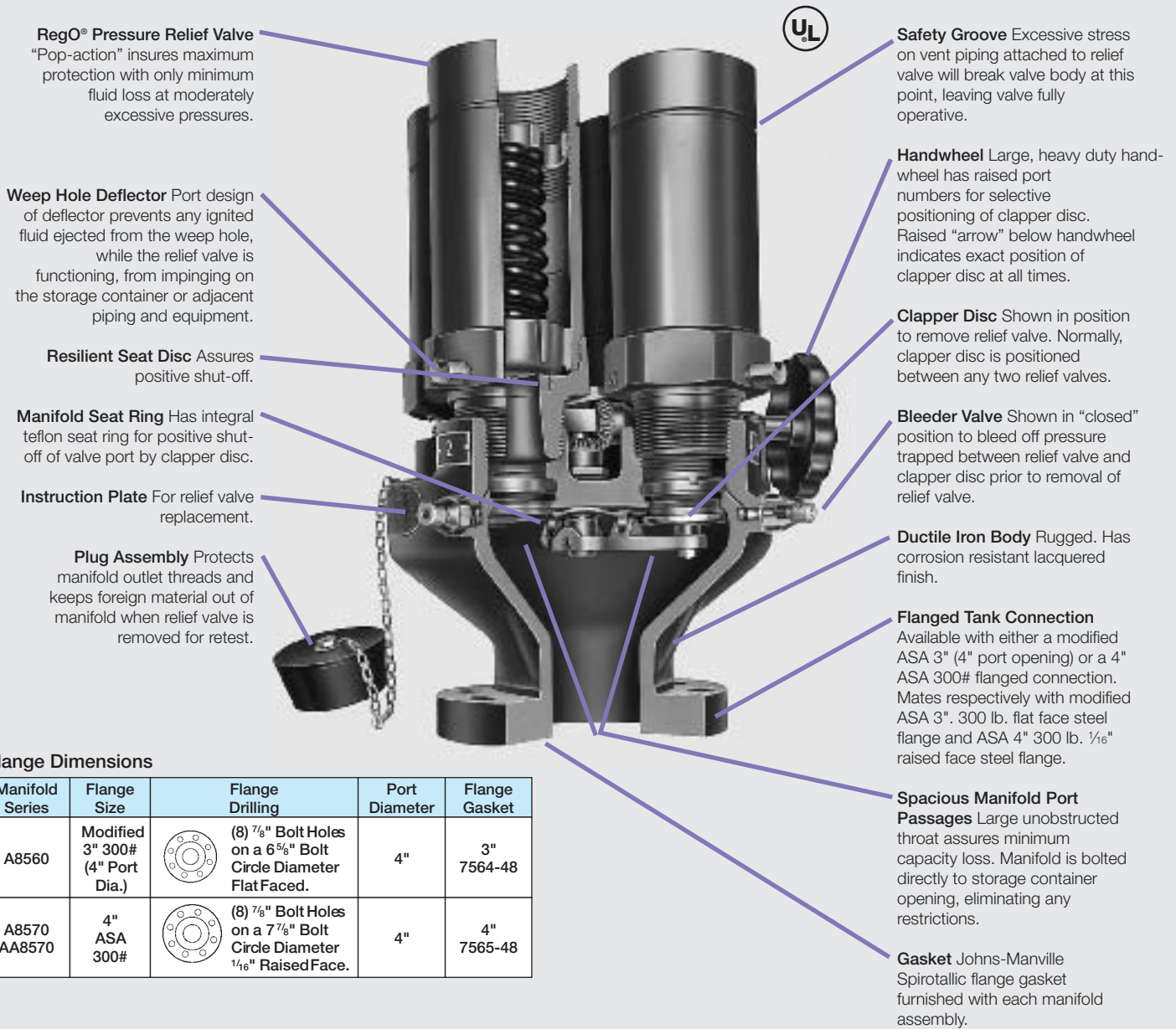
Description	A8563, A8564, A8573, A8574	AA8573
Body	Upper Cold Rolled Steel Lower Ductile Iron	Forged Aluminum*
Liner	Stainless Steel	None
Spring Guide	Stainless Steel	Aluminum
Spring	Coated Steel	
Seat Disc	Resilient Synthetic Rubber	

*A special coating is applied to the inlet threads to minimize possibility of electrolytic action.



Bolt Stud and Nut Assemblies

Part Number	Consists of	For Use With:	For Connection To:	Number Required
7560-55	1-Bolt Stud and Nut	All RegO Multiports	Modified 3"-300# and 4"-ASA 300# Welding Neck Flange	8
7560-56			Manhole Cover Plate	

Typical RegO Multiport™ Pressure Relief Valve Manifold



Flange Dimensions

Manifold Series	Flange Size	Flange Drilling	Port Diameter	Flange Gasket
A8560	Modified 3" 300# (4" Port Dia.)	 (8) 7/8" Bolt Holes on a 6 5/8" Bolt Circle Diameter Flat Faced.	4"	3" 7564-48
A8570 AA8570	4" ASA 300#	 (8) 7/8" Bolt Holes on a 7 7/8" Bolt Circle Diameter 1/4" Raised Face.	4"	4" 7565-48

Ordering Information

Part Number	Start To Discharge Setting PSIG	Application		Container Flange Connection	Relief Valve			Flow Capacity SCFM/Air** At 120% of Set Pressure			
					Quantity	Part Number	Inlet Connection M. NPT	Accessories		UL Rating	ASME Rating
								Pipeaway Adapters			
A8563G	250	Yes		3"-300#*	3	A3149MG	2 1/2"	****	18,500 (2)	Not Applicable	
A8564G					4				27,750 (3)		
AA8573G		No	Yes	4"-300#	3	AA3135MUA250	1 1/4"	AA3135-10***	11,400 (2)		
A8573G					Yes	4	A3149MG	2 1/2"	****		
A8574G	4	27,750 (3)									
A8563AG	250	Yes	Yes	3"-300#*	3	A3149G	2 1/2"	****	18,300 (2)	Not Applicable	
A8564AG					4				27,400 (3)		
A8573AG				3	4				4"-300#		18,300 (2)
A8574AG											4

* For use with modified 300# ANSI flange with 4" port.

*** 2" F. NPT outlet connection.

** Flow rating based on number of relief valves indicated in parenthesis (). Flow rates shown are for bare relief valves. Adapters and pipeaways will reduce flow rates as discussed in forewording information.

**** Outlet 3/2-8N (F) thread, will accept 3" M. NPT pipe thread.