



## INSTALLATION AND MAINTENANCE INSTRUCTIONS IB - INVERTED BUCKET STEAM TRAPS ( IB 12- IBB - IB30S )

**GENERAL**

1. These instructions must be carefully read before any work involving products supplied by VALSTEAM ADCA ENGINEERING S.A. is undertaken.
2. The installation procedure is a critical stage in a life of a steam trap and care should be taken to avoid damage to the trap or equipment.

**Warning !**

- At start up , the presence of small particles in the water (dirt,scale,weld splatters,etc) may cause an unperfect closure of the seat . If this occur, proceed to an accurate cleaning.
- Do not touch the equipment without appropriate protection during working operation because it may conduct heat if the used fluid is at high temperature.
- Before starting maintenance be sure that the equipment is not pressurized or hot .
- The equipments must be used within the working temperature and pressure limits laid down for them, otherwise they may fail ( refer to nameplate and/or IS- Information Sheet).
- Do not remove the nameplate attached to the equipment. Serial number and other useful information is stamped on it.

**INSTALLATION**

1. Before to install remove plastic covers placed on flanges or connection ends. The equipment has an arrow or Inlet/Outlet designations. Be sure that it will be installed on the appropriate direction.
2. Install the steam trap in the point of the system, where the condensate tends to collect. It must be installed with horizontal connections, with the bucket lever in horizontal plane so that it rises and falls vertically.

An ADCA strainer can be installed upstream of the IB30S trap.

**Limiting conditions IB12 & IBB 12 :**

PMA :Max.allowable pressure	16 bar
TMA: Max.allowable temperature	250 °C
PMO: Max.operating pressure	14 bar
TMO: Max.operating temperature	230 °C

**Max.differential pressure :**

IB12- 4 - 4 bar	IB12- 4 - 4 bar
IB12- 8 - 8 bar	IB12- 8 - 8 bar
IB12- 8 - 8 bar	IB12-12 -12 bar

**Limiting conditions IB30 & IB30SS :**

PMA :Max.allowable pressure	40 bar
TMA: Max.allowable temperature	425 °C
PMO: Max.operating pressure	27 bar
TMO: Max.operating temperature	380 °C

**Max.differential pressure :**

IB30- 4 - 4 bar
IB30- 8 - 8 bar
IB30-12 -12 bar
IB30-17 -17 bar
IB30-27 -27 bar

**MAINTENANCE**

1. We recommend that the inverted bucket steam traps are serviced as necessary. Steam traps should be checked periodically (at least yearly), to verify that they are operating correctly and to clean the internal parts and screen (if any).
2. When reassembling make sure that all gasket faces are clean and always use a new gasket. Tighten cover bolts uniformly in a diagonal sequence.
3. For further information refer to the relevant IS (Information Sheet) or consult our Sales Office.

**CE Marking :**

This product have been designed for use on steam and water wich are in Group 2 of the PED-European Pressure Equipment Directive 97/23/EC and it comply with those requirements.  
The product fall within category SEP and must not be CE marked.

**LOSS OF GUARANTEE : Total or partial disregard of above instructions involves loss of any right to guarantee.**

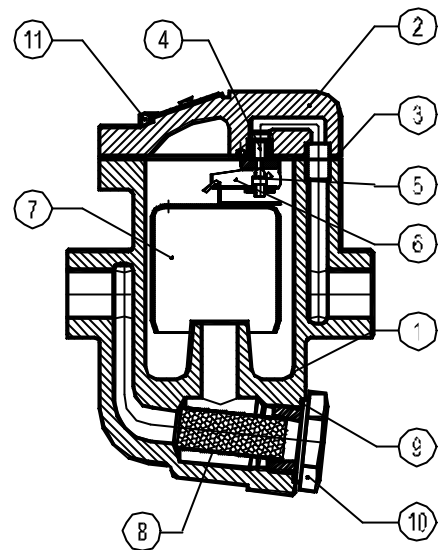
**PARTS LIST FOR IB 12 STEAM TRAPS**

Code	Designation	SizeTrap	Pos.Nr.	Qty.
A.93.2302.015	Main valve,seat,gasket D.P.4bar	DN1/2"-3/4"	3,4,5	1Set
A.93.2303.015	Main valve,seat,gasket D.P.8bar	DN1/2"-3/4"	3,4,5	1Set
A.93.2304.015	Main valve,seat,gasket D.P.12bar	DN1/2"-3/4"	3,4,5	1Set
A.93.2302.115	Bucket & gasket	DN1/2"-3/4"	3,7	1Set
A.93.2302.215	Strainer screen & gasket	DN1/2"-3/4"	8,9	1Set

**Recommended tightening torques IB 12**

Pos.Nr.	Size	Nm
4	1/2"-3/4"	50
10	1/2"-3/4"	50
11	1/2"-3/4"	25

Remarks: Tighten cover bolts uniformly.

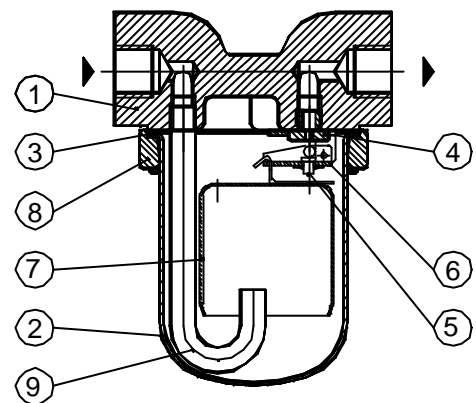

**PARTS LIST FOR IB 30S STEAM TRAPS**

Code	Designation	SizeTrap	Pos.Nr.	Qty.
A.93.4502.015	Main valve,seat,gasket D.P.4bar	DN1/2"-1"	3,4,5	1Set
A.93.4503.015	Main valve,seat,gasket D.P.8bar	DN1/2"-1"	3,4,5	1Set
A.93.4504.015	Main valve,seat,gasket D.P.12bar	DN1/2"-1"	3,4,5	1Set
A.93.4502.115	Bucket & gasket	DN1/2"-1"	3,7	1Set

**Recommended tightening torques IB 12**

Pos.Nr.	Size	Nm
4	1/2"-1"	90
10	1/2"-1"	60

Remarks: Tighten cover bolts uniformly.


**PARTS LIST FOR IBB 12 STEAM TRAPS**

Code	Designation	SizeTrap	Pos.Nr.	Qty.
A.93.3352.020	Main valve,seat,gasket D.P.4bar	DN3/4"-1"	3,4,5	1Set
A.93.3353.020	Main valve,seat,gasket D.P.8bar	DN3/4"-1"	3,4,5	1Set
A.93.3354.020	Main valve,seat,gasket D.P.12bar	DN3/4"-1"	3,4,5	1Set
A.93.3352.120	Bucket & gasket	DN3/4"-1"	3,7	1Set
A.93.3352.220	Strainer screen & gasket	DN3/4"-1"	8,9	1Set

**Recommended tightening torques IBB 12**

Pos.Nr.	Size	Nm
4	3/4"-1"	85
10	3/4"-1"	60
11	3/4"-1"	25

Remarks: Tighten cover bolts uniformly.

