

Factory Leakage Standards

Gas Internal Leakage Standard

SEAT MATERIAL

TEST PRESSURE, PSIG

1 - 25 26 - 100 101 - 500 501 - 1500 1501 - 3000 OVER 3000

Pilot Operated & Semi-Direct Lift Valves

Rubber Pilot & Disc	B.T.	B.T.	B.T.	B.T.	B.T.	B.T.
---------------------	------	------	------	------	------	------

For 500 and 15400 valve series both N.O and N.C.

Teflon pilot & Teflon Disc	500 sccm	100 sccm	B.T.	B.T.	B.T.	B.T.
----------------------------	----------	----------	------	------	------	------

For 4000, 5000, 6000, 7000, 8000, 12000, 15800, and 30000 valve series both N.O. and N.C.

Teflon Pilot & Teflon Disc	100 sccm	10 sccm	B.T.	B.T.	B.T.	B.T.
----------------------------	----------	---------	------	------	------	------

Metal Pilot & Teflon/KEL-F/Rubber Disc	1500 sccm	1500 sccm	1000 sccm	500 sccm	500 sccm	500 sccm
--	-----------	-----------	-----------	----------	----------	----------

Metal Pilot & Metal Disc	2000 sccm	2000 sccm	3000 sccm	3000 sccm	3000 sccm	3000 sccm
--------------------------	-----------	-----------	-----------	-----------	-----------	-----------

KEL-F Pilot & KEL-F Disc	500 sccm	250 sccm	100 sccm	10 sccm	B.T.	B.T.
--------------------------	----------	----------	----------	---------	------	------

Direct Lift Valves

Rubber Seat	B.T.	B.T.	B.T.	B.T.	B.T.	B.T.
-------------	------	------	------	------	------	------

Plastic Seat	50 sccm	5 sccm	B.T.	B.T.	B.T.	B.T.
--------------	---------	--------	------	------	------	------

Metal Seat	1000 sccm	1000 sccm	1500 sccm	1500 sccm	1500 sccm	1500 sccm
------------	-----------	-----------	-----------	-----------	-----------	-----------

DEFINITIONS: Rubber: Elastomer (Buna, Viton, EPR, etc.)

B.T.: Bubble tight (less than 10 cc/hr leakage)

SCCM: Standard cubic centimeters per minute

Note: Leakage values with Teflon and Kel-F seats are after applicable after the valve has been cycled in production acceptance testing. Typically on clean fluid applications with Teflon or Kel-F seats leakage decreases with number of cycles.

Liquid Internal Leakage Standard

SEAT MATERIAL

TEST PRESSURE, PSIG

1 - 25 26 - 100 101 - 500 501 - 1500 1501 - 3000 OVER 3000

Pilot Operated & Semi-Direct Lift Valves

Rubber Pilot & Disc	0	0	0	0	0	0
Teflon Pilot & Teflon Disc	5 cc/m	*	0	0	0	0
Metal Pilot & Teflon/KEL-F/Rubber Disc	5 cc/m	5 cc/m	5 cc/m	5 cc/m	5 cc/m	5 cc/m
Metal Pilot & Metal Disc	10 cc/m	10 cc/m	10 cc/m	10 c/m	10 cc/m	10 cc/m
KEL-F Pilot & KEL-F Disc	5 cc/m	5 cc/m	0	0	0	0

Direct Lift Valves

Rubber Seat	0	0	0	0	0	0
Plastic Seat	2 1/2 cc/m	**	0	0	0	0
Metal Seat	5 cc/m	5 cc/m	5 cc/m	5 cc/m	5 cc/m	5 cc/m

* 5 cc/m to 75 psig
0 75 to 100 psig

** 2 1/2 cc/m to 75 psig
0 75 to 100 psig

DEFINITIONS: Rubber: Elastomer (Buna, Viton, EPR, etc.)
0: No leakage visible to the naked eye
cc/m: Cubic centimeters per minute

Note: Leakage values with Teflon and Kel-F seats are after applicable after the valve has been cycled in production acceptance testing. Typically on clean fluid applications with Teflon or Kel-F seats leakage decreases with number of cycles.