



SG Series Stainless Solar Grade Ball Valve

ENGINEERING SPECIFICATION

DOCUMENT NUMBER:	ES-2
DOCUMENT TITLE:	Clean Stainless Steel Ball Valve Specification
REVISION LEVEL:	0
REVISION DATE:	5/01/08

Approved by: Coke Evans Date: 05/01/08
President

Approved by: Scott Hughes Date: 05/01/08
Quality System Management Representative

1.0 PURPOSE AND SCOPE

This specification establishes the engineering specifications applicable to Solar Grade stainless steel ball valve manufacturing processes.

This specification applies to Evans SG Series ball valve manufacturing unless dictated by specific customer requirements.

2.0 GAS SPECIFICATIONS

Argon (Liquid)	
Grade:	Ultra Pure
Oxygen:	1 ppm, maximum
Moisture:	1 ppm, maximum
Total hydrocarbons:	0.5 ppm, maximum
Purity:	99.999%, minimum

Helium (Liquid)	
Grade:	Ultra Grade
Composition:	Helium
Oxygen:	5 ppm, maximum
Moisture:	3.5 ppm, maximum
Purity:	99.997%, minimum

Nitrogen (Liquid)	
Grade:	Ultra Pure
Oxygen:	1 ppm, maximum
Moisture:	1 ppm, maximum
Total hydrocarbons:	0.5 ppm, maximum
Purity:	99.999%, minimum

3.0 MATERIALS OF CONSTRUCTION

Ball Valve Body	
Ball:	304 SS
Body, End Cap	ASTM A351 GR CF8, 304 SS
Seats, Stem Packing, Thrust Washer	PTFE
Stem:	304 SS
Bolts, Handles, Nuts, Washers	304 SS
Handle Cover	Plastic

Tubing: Domestic 304L seamless or welded seam (depending on size) construction, cold drawn bright annealed, sulfur content controlled to 0.005 to 0.017%	
OD – 1 in. and larger	ASTM A269, ASTM A270
OD – ½ in. and ¾ in.	ASTM A269, ASTM A213
OD – less than ½ in.	ASTM A269, ASTM A632
ID Finish No. 180 Grit	40 Ra, max; 8" > 50 Ra, max
Final ID Cleaning	Ultrasonic cleaned in a Cleanroom
Certification	Physical/chemical characteristics Cleaning compliance

4.0 WELDING SPECIFICATIONS

Weld atmosphere	Inert gas (argon)
Porosity:	None allowed
Inspection:	100% with no discoloration

5.0 CLEANING SPECIFICATIONS

Pre-Heated Deionized Water	
Usage:	100% of all ball valve components
Resistivity:	18 Megohms-cm minimum

Hobart Pre-Washer in Cleanroom	
Usage:	100% of all ball valve components
Time (wash):	4-6 minutes
Time (rinse)	1 minute
Rinse agent:	18 MGH DI water

Crest Ultrasonic Cleaning System in Cleanroom	
Usage:	100% of all ball valve components
Cleaning agent:	Valtron Sp2555 Surfactant
Tanks:	1 wash, 1 pre-rinse, 1 rinse
Time (wash):	5 minute, minimum
Time (rinse)	5 minute, minimum
Tank temperature:	150 degrees F minimum
Rinse flow rate:	1.2 GPM
Filtering:	0.5 micron (sequential)

Blow Down with Nitrogen in Cleanroom	
Usage:	Ball valve components
In-line N2 Filtration:	0.5 micron

6.0 AIR OVEN DRYING SPECIFICATIONS

Environment:	Clean Room
Usage:	100% of all ball valve components
Temperature:	100 degrees C
Resolution:	+/- 1 degree C
Time:	30 minutes, minimum

7.0 ASSEMBLY SPECIFICATIONS

Environment:	Clean Room
Torque Verification:	100% of all ball valves

8.0 TESTING SPECIFICATIONS

Leybold UL 400 Helium Leak Detector Test	
Environment:	Clean Room
Usage:	100% of all ball valve components
External agent:	Helium
Helium detection device:	Mass spectrometer
Device resolution:	0.1 (x10-x scc/sec)
Specification:	1x10- 7scc/sec, minimum

Pressure Decay Leak Test	
Usage:	Upon customer requirement
Applied pressure:	100 psig-120 psig ball open 100 psig-120 psig across seat
Pressure agent:	Nitrogen
Application time:	30 seconds
Measuring device:	Magnehelic differential pressure
Device resolution:	0.1 inch
Specification:	Less than 0.5 inch per application time

9.0 FINAL INSPECTION REQUIREMENTS

Visual inspection	100% of all ball valves
Dimensional check	100% of all ball valves
Final N2 Blowdown	100% of all ball valves
Capping and bagging	100% of all ball valves
Tubing Certification	100% of all ball valves
Certification of Conformance	Provided upon request

Reviewed and Approved by:

(See Record of Procedure Review on File in Master Binder)

Revision History		
Rev	Description of Changes	Author & date
0	Original issue.	C. Evans 5/01/08