

# MOUNTING AND OPERATING INSTRUCTIONS



## EB 8115 EN

Translation of original instructions



### Type 3321CT Valve · DIN and ANSI versions

For combining with actuators, e.g. Type 3379 Pneumatic Actuator

## Note on these mounting and operating instructions

These mounting and operating instructions assist you in mounting and operating the device safely. The instructions are binding for handling SAMSON devices. The images shown in these instructions are for illustration purposes only. The actual product may vary.

- For the safe and proper use of these instructions, read them carefully and keep them for later reference.
- If you have any questions about these instructions, contact SAMSON's After-sales Service ([aftersaleservice@samsongroup.com](mailto:aftersaleservice@samsongroup.com)).



Documents relating to the device, such as the mounting and operating instructions, are available on our website at [www.samsongroup.com](http://www.samsongroup.com) > **Downloads > Documentation.**

## Definition of signal words

### **DANGER**

*Hazardous situations which, if not avoided, will result in death or serious injury*

### **WARNING**

*Hazardous situations which, if not avoided, could result in death or serious injury*

### **NOTICE**

*Property damage message or malfunction*

### **Note**

*Additional information*

### **Tip**

*Recommended action*

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# 1 Safety instructions and measures

## Intended use

The SAMSON Type 3321CT Globe Valve in combination with an actuator (e.g. Type 3379 Pneumatic Actuator) is designed to regulate the flow rate, pressure or temperature of liquids, gases or vapors.

The valve with its actuator is designed to operate under exactly defined conditions (e.g. operating pressure, process medium, temperature). Therefore, operators must ensure that the control valve is only used in operating conditions that meet the specifications used for sizing the valve at the ordering stage. In case operators intend to use the control valve in applications or conditions other than those specified, contact SAMSON.

SAMSON does not assume any liability for damage resulting from the failure to use the device for its intended purpose or for damage caused by external forces or any other external factors.

→ Refer to the technical data and nameplate for limits and fields of application as well as possible uses.

## Reasonably foreseeable misuse

The control valve is not suitable for the following applications:

- Use outside the limits defined during sizing and by the technical data
- Use outside the limits defined by the valve accessories connected to the valve

Furthermore, the following activities do not comply with the intended use:

- Use of non-original spare parts
- Performing service and repair work not described

## Qualifications of operating personnel

The control valve must be mounted, started up, serviced and repaired by fully trained and qualified personnel only; the accepted industry codes and practices must be observed.

According to these mounting and operating instructions, trained personnel refers to individuals who are able to judge the work they are assigned to and recognize possible hazards due to their specialized training, their knowledge and experience as well as their knowledge of the applicable standards.

Explosion-protected versions of this device must be operated only by personnel who has undergone special training or instructions or who is authorized to work on explosion-protected devices in hazardous areas.

## Safety instructions and measures

### Personal protective equipment

We recommend checking the hazards posed by the process medium being used (e.g.

▶ GESTIS (CLP) hazardous substances database). Depending on the process medium and/or the activity, the protective equipment required includes:

- Protective clothing, gloves, eye protection and respiratory protection in applications with hot, cold and/or corrosive media
  - Wear hearing protection when working near the valve
  - Hard hat
  - Safety harness, e.g. when working at height
  - Safety footwear, if applicable ESD (electrostatic discharge) footwear
- ➔ Check with the plant operator for details on further protective equipment.

### Revisions and other modifications

Revisions, conversions or other modifications of the product are not authorized by SAMSON. They are performed at the user's own risk and may lead to safety hazards, for example. Furthermore, the product may no longer meet the requirements for its intended use.

### Safety features

The fail-safe position of the control valve upon air supply or control signal failure depends on the actuator used (see associated actuator documentation). When the valve is combined with a SAMSON Type 3379 Pneumatic Actuator, the valve moves to a certain fail-safe position (see the 'Design and principle of operation' section) upon supply air or control signal failure. The fail-safe action of the actuator is the same as its direction of action and is specified on the nameplate of SAMSON actuators.

### Warning against residual hazards

To avoid personal injury or property damage, plant operators and operating personnel must prevent hazards that could be caused in the control valve by the process medium, the operating pressure, the signal pressure or by moving parts by taking appropriate precautions. Plant operators and operating personnel must observe all hazard statements, warnings and caution notes in these mounting and operating instructions.

Hazards resulting from the special working conditions at the installation site of the valve must be identified in a risk assessment and prevented through the corresponding safety instructions drawn up by the operator.

### Responsibilities of the operator

Operators are responsible for proper use and compliance with the safety regulations. Operators are obliged to provide these mounting and operating instructions as well as the referenced documents to the operating personnel and to instruct them in proper operation. Furthermore, operators must ensure that operating personnel or third parties are not exposed to any danger.

Operators are additionally responsible for ensuring that the limits for the product defined in the technical data are observed. This also applies to the start-up and shutdown procedures. Start-up and shutdown procedures fall within the scope of the operator's duties and, as such, are not part of these mounting and operating instructions. SAMSON is unable to make any statements about these procedures since the operative details (e.g. differential pressures and temperatures) vary in each individual case and are only known to the operator.

### Responsibilities of operating personnel

Operating personnel must read and understand these mounting and operating instructions as well as the referenced documents and observe the specified hazard statements, warnings and caution notes. Furthermore, operating personnel must be familiar with the applicable health, safety and accident prevention regulations and comply with them.

### Referenced standards, directives and regulations

The control valves comply with the requirements of the European Pressure Equipment Directive 2014/68/EU, Machinery Directive 2006/42/EC, Directive 2016 No. 1105 Pressure Equipment (Safety) Regulations 2016 and Directive 2008 No. 1597 Supply of Machinery (Safety) Regulations 2008. Valves with a CE marking and/or UKCA marking have a declaration of conformity, which includes information about the applied conformity assessment procedure. The 'Certificates' section contains this declaration of conformity.

According to the ignition hazard assessment performed in accordance with Clause 5.2 of ISO 80079-36, the non-electrical control valves do not have their own potential ignition source even in the rare incident of an operating fault. As a result, they do not fall within the scope of Directive 2014/34/EU.

➔ For connection to the equipotential bonding system, observe the requirements specified in Clause 6.4 of EN 60079-14 (VDE 0165-1).

### Referenced documentation

The following documents apply in addition to these mounting and operating instructions:

- Mounting and operating instructions for the mounted actuator, e.g. ► EB 8315 for SAMSON's Type 3379 Pneumatic Actuator

## Safety instructions and measures

- Mounting and operating instructions for mounted valve accessories (positioner, solenoid valve etc.)
- When a substance is used in the device, which is listed as being a substance of very high concern on the candidate list of the REACH regulation:

Information on safe use of the part affected

▶ [www.samsongroup.com](http://www.samsongroup.com) > About SAMSON > Material Compliance > REACH

If a device contains a substance listed as a substance of very high concern on the candidate list of the REACH regulation, this is indicated on the SAMSON delivery note.



## 1.1 Notes on possible severe personal injury

### DANGER

#### **Risk of bursting in pressure equipment.**

Valves and pipelines are pressure equipment. Impermissible pressure or improper opening can lead to valve components bursting.

- Observe the maximum permissible pressure for valve and plant.
- Before starting any work on the control valve, depressurize all plant sections affected as well as the valve.
- Drain the process medium from all the plant sections concerned as well as the valve.

## 1.2 Notes on possible personal injury

### WARNING

#### **Risk of burn injuries due to hot or cold components and pipelines.**

Depending on the process medium, valve components and pipelines may get very hot or cold and cause burn injuries.

- Allow components and pipelines to cool down or warm up to the ambient temperature.
- Wear protective clothing and safety gloves.

#### **Risk of hearing loss or deafness due to loud noise.**

The noise emissions depend on the valve version, plant facilities and process medium.

- Wear hearing protection when working near the valve.

#### **Risk of personal injury due to exhaust air being vented.**

While the valve is operating, air is vented from the actuator, e.g. during closed-loop operation or when the valve opens or closes.

- Install the control valve in such a way that vent openings are not located at eye level and the actuator does not vent at eye level in the work position.
- Use suitable mufflers and vent plugs.
- Wear eye protection when working in close proximity to the control valve.

### **WARNING**

#### **Risk of personal injury due to preloaded springs.**

Valves in combination with pneumatic actuators with preloaded springs are under tension.

- Before starting any work on the actuator, relieve the compression from the preloaded springs (see associated actuator documentation).

#### **Risk of personal injury due to residual process medium in the valve.**

While working on the valve, residual medium can flow out of the valve and, depending on its properties, cause personal injury, e.g. (chemical) burns.

- If possible, drain the process medium from all the plant sections affected and the valve.
- Wear protective clothing, safety gloves, respiratory protection and eye protection.

#### **Exposure to hazardous substances poses a serious risk to health.**

Certain lubricants and cleaning agents are classified as hazardous substances. These substances have a special label and a material safety data sheet (MSDS) issued by the manufacturer.

- Make sure that an MSDS is available for any hazardous substance used. If necessary, contact the manufacturer to obtain an MSDS.
- Inform yourself about the hazardous substances and their correct handling.

#### **Risk of personal injury due to incorrect operation, use or installation as a result of information on the valve being illegible.**

Over time, markings, labels and nameplates on the valve may become covered with dirt or become illegible in some other way. As a result, hazards may go unnoticed and the necessary instructions not followed. There is a risk of personal injury.

- Keep all relevant markings and inscriptions on the device in a constantly legible state.
- Immediately renew damaged, missing or incorrect nameplates or labels.

## 1.3 Notes on possible property damage

### ! NOTICE

#### **Risk of valve damage due to contamination (e.g. solid particles) in the pipeline.**

The plant operator is responsible for cleaning the pipelines in the plant.

→ Flush the pipelines before start-up.

#### **Risk of valve damage due to unsuitable medium properties.**

The valve is designed for a process medium with defined properties.

→ Only use the process medium specified for sizing the equipment.

#### **Risk of leakage and valve damage due to excessively high or low tightening torques.**

Observe the specified torques when tightening control valve components. Excessive tightening torques lead to parts wearing out more quickly. Parts that are too loose may cause leakage.

→ Observe the specified tightening torques (see 'Tightening torques' in Annex).

#### **Risk of valve damage due to the use of unsuitable tools.**

Certain tools are required to work on the valve.

→ Only use tools approved by SAMSON (see the 'Tools' section in Annex).

#### **Risk of valve damage due to the use of unsuitable lubricants.**

The lubricants to be used depend on the valve material. Unsuitable lubricants may corrode and damage surfaces.

→ Only use lubricants approved by SAMSON (see the 'Lubricants' section in Annex).

#### **Risk of the process medium being contaminated through the use of unsuitable lubricants and/or contaminated tools and components.**

→ Keep the valve and the tools used free from solvents and grease.

→ Make sure that only suitable lubricants are used.



## 2 Markings on the device

The nameplate shown was up to date at the time of publication of this document. The nameplate on the device may differ from the one shown.

### 2.1 Valve nameplate

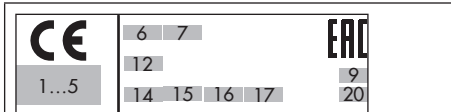


Fig. 2-1: Inscriptions on the valve nameplate

Item	Inscription meaning
1...5	PED (Pressure Equipment Directive), Article 4, paragraph 3 ID of the notified body, fluid group and category
6	Type designation
7	Device index (2-digit number)
9	Year of manufacture
12	Production number
14	Flow coefficient: $K_{VS}$
15	Characteristic: % (equal percentage)
16	Seat-plug seal: ME: metal PK: soft seal with PEEK
17	Seat code (trim material): 00 (1.4404)
20	Country of origin

The nameplate is affixed to the flange of the valve (see Fig. 2-2).

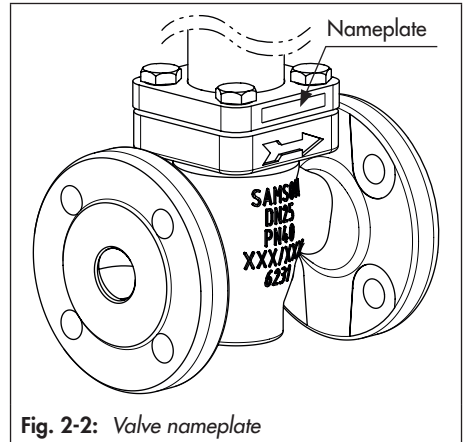


Fig. 2-2: Valve nameplate

### 2.2 Actuator nameplate

See associated actuator documentation.



### 3 Design and principle of operation

The single-seated Type 3321CT Globe Valve is preferably combined with a SAMSON Type 3379 Pneumatic Actuator.

The seat (2) and plug with plug stem (3) are installed in the body (1). The plug stem has a thread to screw it onto the actuator stem and is sealed by the spring-loaded packing (8).

The process medium flows through the valve in the direction indicated by the arrow in the flow-to-open direction. The plug position determines the cross-sectional area between the seat and plug.

The position of the plug is changed by the control signal acting on the actuator.

#### 3.1 Fail-safe action

Depending on how the compression springs are arranged in the actuator, the control valve with the SAMSON Type 3379 Pneumatic Actuator has one of two fail-safe positions that become effective when the supply air fails:

- **Actuator stem extends (FA)**

When the signal pressure is reduced or the air supply fails, the springs move the actuator stem downward and close the valve. The valve opens when the signal pressure is increased enough to overcome the force exerted by the springs.

- **Actuator stem retracts (FE)**

When the signal pressure is reduced or the air supply fails, the springs move the actuator stem upwards and open the valve. The valve closes when the signal pressure is increased enough to overcome the force exerted by the springs.

#### 3.2 Additional fittings

##### Strainers

We recommend installing a SAMSON strainer upstream of the valve. It prevents solid particles in the process medium from damaging the valve.

##### Bypass and shut-off valves

We recommend installing a shut-off valve both upstream of the strainer and downstream of the valve and installing a bypass line. The bypass ensures that the plant does not need to be shut down for service and repair work on the valve.

# Design and principle of operation

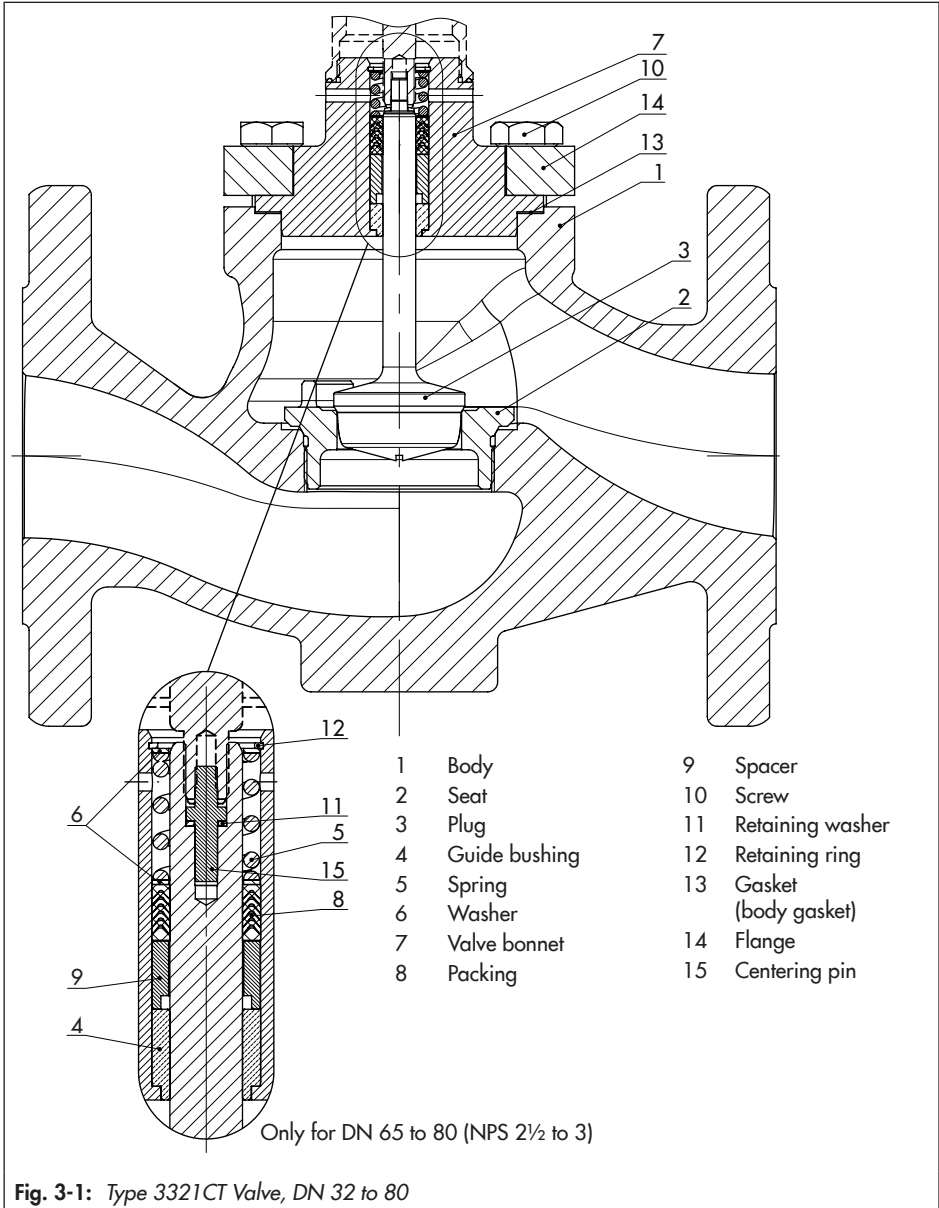
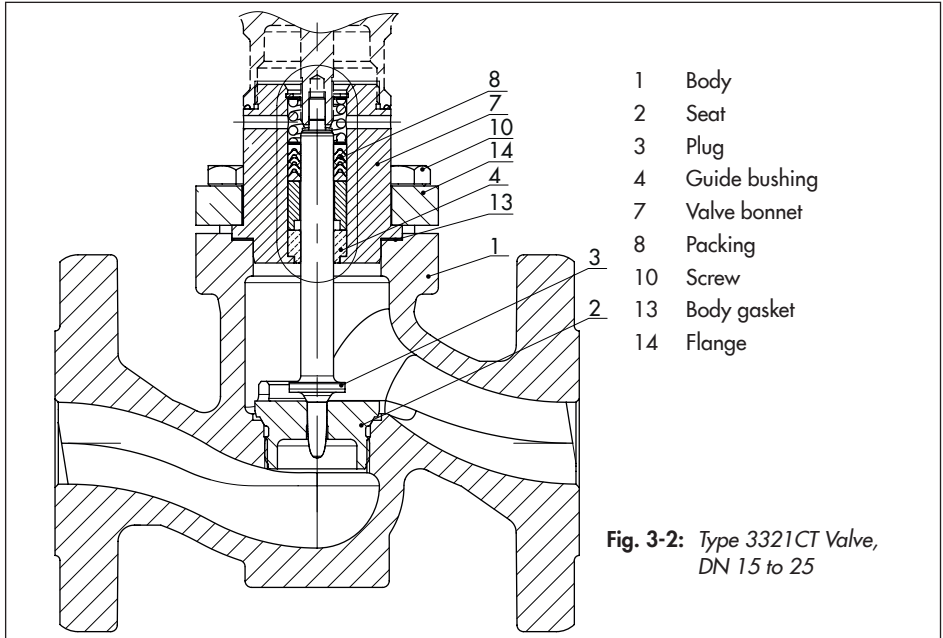


Fig. 3-1: Type 3321CT Valve, DN 32 to 80





**Fig. 3-2:** Type 3321CT Valve, DN 15 to 25

### 3.3 Technical data

The nameplates on the valve and actuator provide information on the control valve version. See the 'Markings on the device' section.

**i Note**

More information is available in Data Sheet  
 ► T 8115.

### Noise emissions

SAMSON is unable to make general statements about noise emissions. The noise emissions depend on the valve version, plant facilities and process medium.

## Design and principle of operation

**Table 3-1:** *Technical data for Type 3321CT*

<b>Valve size</b>	<b>DN 15 to 80 · NPS ½ to 3</b>
Pressure rating	PN 16 and 40 · Class 150 and 300
Type of connection	Flanges with raised face form B1 according to EN 1092-1/RF
Seat-plug seal	Metal or soft seal
Characteristic	Equal percentage
Rangeability	50 :1
<b>Permissible medium temperature</b>	
Standard version	-10 to 220 °C · 14 to 428 °F
<b>Leakage class according to IEC 60534-4 or ANSI/FCI 70-2</b>	
Metal seal	IV
Soft seal	VI
<b>Conformity</b>	<b>CE · UK · EAC</b>
	FDA compliance Compliance with EC Directive 1935/2004

**Table 3-2:** *Materials*

<b>Type 3321CT Valve</b>	
Valve body	Stainless steel 1.4408 · A351 CF8M
Valve bonnet	Stainless steel 1.4404 or 1.4408 · A182 F316L or A351 CF8M
Seat	Stainless steel 1.4404 · A182 F316L
Plug with plug stem	Stainless steel 1.4404 · A182 F316L
Plug seal	Seal for soft-seated plug: PEEK (certified according to FDA/Regulation (EC) 1935/2004)
Guide bushing	Nickel alloy
Packing	V-ring packing: PTFE with carbon, spring: 1.4310
Body gasket	Graphite seal on metal core

Type 3379 Pneumatic Actuator	
Housing and cover	Stainless steel 1.4409 · A351 CF3M
Actuator stem	Stainless steel 1.4404 · A182 F316L
Piston	Glass-fiber-reinforced polyamide
	Stainless steel 1.4409 · A351 CF3M <sup>1)</sup>
Dome (visual indicator)	Polycarbonate
Bearing	Polymer
Spring	Spring steel
Gasket	NBR

<sup>1)</sup> For Ø150 piston

Type 3724 Positioner	
Housing and cover	Stainless steel 1.4409 · A351 CF3M
Transparent cover	Polycarbonate

**Table 3-3:** *Dimensions and weights*

**Table 3-3.1:** *Type 3321CT Valve*

DN	15	20	25	32	40	50	65	80	
NPS	½	¾	1	–	1½	2	2½	3	
PN 16/40 mm	130	150	160	180	200	230	290	310	
L Class 150 in <sup>1)</sup>	7.25	7.25	7.25	–	8.75	10	10.88	11.75	
Class 300 in <sup>1)</sup>	7.5	7.62	7.75	–	9.25	10.5	11.5	12.5	
H1	mm	102			114		147		
	in <sup>1)</sup>	4.02			–	4.49		5.78	
H2	mm	44			72		98		
	in <sup>1)</sup>	1.73			–	2.83		3.86	
Weight	kg	5	6	7	11	12	16	28	32
	lbs <sup>1)</sup>	15	18	20	–	35	44	71	82

<sup>1)</sup> ANSI specifications

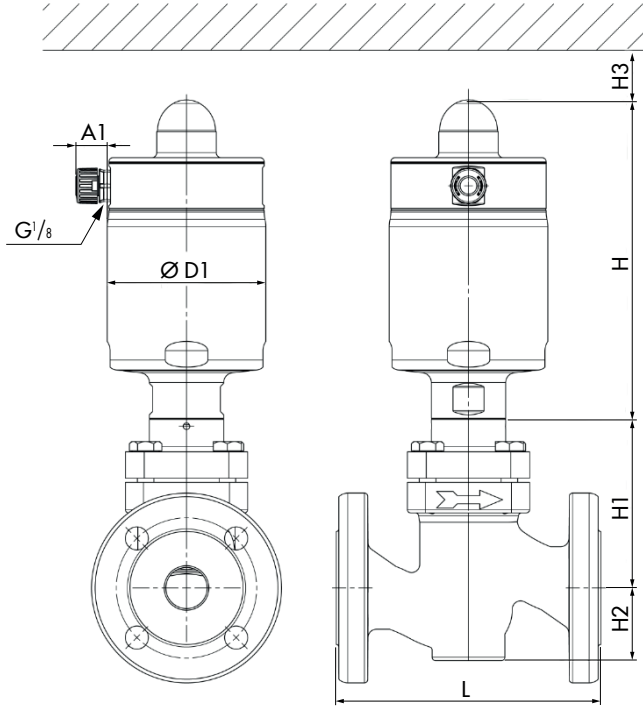
## Design and principle of operation

**Table 3-3.2:** *Type 3379 Pneumatic Actuator*

Piston diameter		mm	63	90	150
Actuator area		cm <sup>2</sup>	31	63	176
With Type 3724 Positioner	H	mm	285		310
	H3 <sup>1)</sup>	mm	150		
	A1	mm	30		
	ØD2	mm	108		
	ØD1	mm	69	96	160
	Weight	kg (approx.)	3.7	4.9	10.7
Without posi- tioner	H	mm	195		215
	H3 <sup>1)</sup>	mm	150		
	A1	mm	20		
	ØD1	mm	69	96	160
	Weight	kg (approx.)	1.8	3.1	8.9

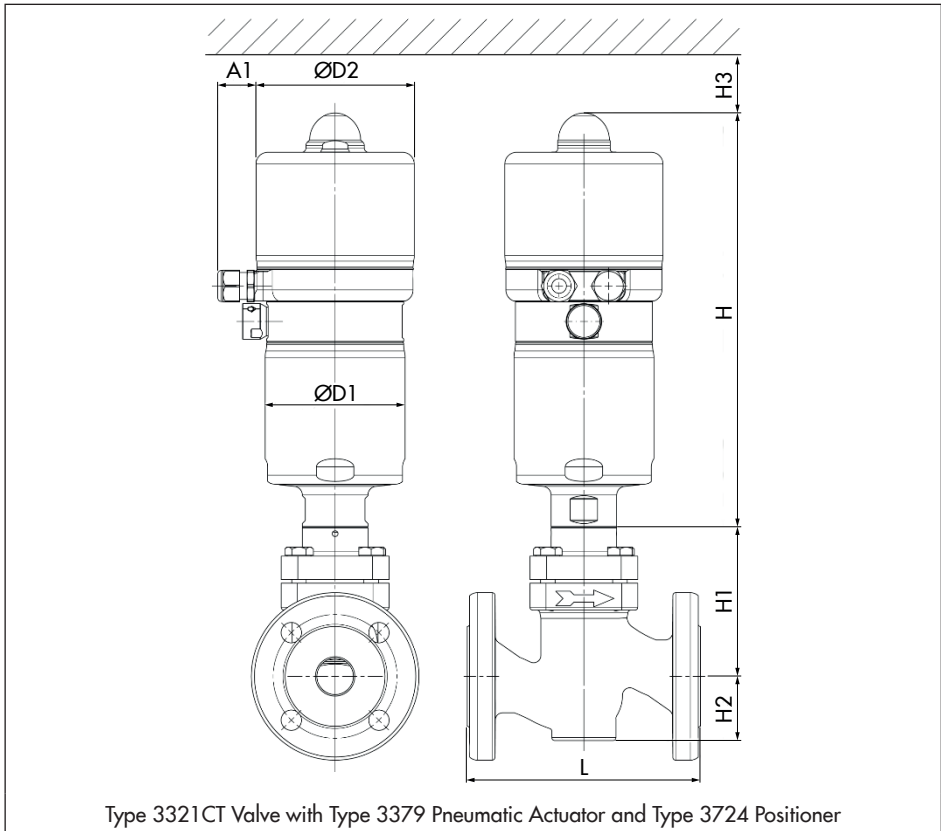
<sup>1)</sup> Minimum clearance required to remove the actuator

Dimensional drawings



Type 3321CT Valve with Type 3379 Pneumatic Actuator

## Design and principle of operation



### **i** Note

The associated documentation applies to the actuator and valve accessories. For example:

- ▶ EB 8315 for Type 3379 Pneumatic Actuator
- ▶ T 8395 for Type 3724 Electropneumatic Positioner

## 4 Shipment and on-site transport

The work described in this section is only to be performed by personnel appropriately qualified to carry out such tasks.

### 4.1 Accepting the delivered goods

After receiving the shipment, proceed as follows:

1. Check the scope of delivery. Check that the specifications on the valve nameplate match the specifications in the delivery note. See the 'Markings on the device' section for nameplate details.
2. Check the shipment for transportation damage. Report any damage to SAMSON and the forwarding agent (refer to delivery note).
3. Determine the weight and dimensions of the units to be lifted and transported in order to select the appropriate lifting equipment and lifting accessories, if required. Refer to the transport documents and the 'Technical data' section.

### 4.2 Removing the packaging from the valve

Observe the following sequence:

- Do not open or remove the packaging until immediately before lifting to install the valve into the pipeline.

- Leave the control valve in its transport container or on the pallet to transport it on site.
- Do not remove the protective caps from the inlet and outlet until immediately before installing the valve into the pipeline. They prevent foreign particles from entering the valve.
- Dispose and recycle the packaging in accordance with the local regulations.

### 4.3 Transporting and lifting the valve

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#### **⚠ DANGER**

***Danger due to suspended loads falling.***

- *Stay clear of suspended or moving loads.*
  - *Close off and secure the transport paths.*
- 

#### **⚠ WARNING**

***Risk of lifting equipment tipping over and risk of damage to lifting accessories due to exceeding the rated lifting capacity.***

- *Only use approved lifting equipment and accessories whose minimum lifting capacity is higher than the weight of the valve (including actuator and packaging, if applicable).*
-

### WARNING

**Risk of personal injury due to the control valve tipping over.**

- Observe the valve's center of gravity.
- Secure the valve against tipping over or turning.

### WARNING

**Risk of injury due to incorrect lifting without the use of lifting equipment.**

Lifting the control valve without the use of lifting equipment may lead to injuries (back injury in particular) depending on the weight of the control valve.

- Observe the occupational health and safety regulations valid in the country of use.

### NOTICE

**Risk of valve damage due to incorrectly attached slings.**

- When lifting the control valve, make sure that the slings attached to the valve body bear the entire load.
- Do not attach load-bearing slings to the actuator or any other parts.
- Observe lifting instructions (see section 4.3.2).

### Tip

Our after-sales service can provide more detailed transport and lifting instructions on request.

## 4.3.1 Transporting the valve

The control valve can be transported using lifting equipment (e.g. crane or forklift).

- Leave the control valve in its transport container or on the pallet to transport it.
- Observe the transport instructions.

### Transport instructions

- Protect the control valve against external influences (e.g. impact).
- Do not damage the corrosion protection (paint, surface coatings). Repair any damage immediately.
- Protect the piping and any mounted valve accessories against damage.
- Protect the control valve against moisture and dirt.
- The permissible transportation temperature of standard control valves is  $-20$  to  $+65$  °C.

### Note

Contact our after-sales service for the transportation temperatures of other valve versions.

## 4.3.2 Lifting the valve

To install a large valve into the pipeline, use lifting equipment (e.g. crane or forklift) to lift it.

### Lifting instructions

- Use a hook with safety latch (see Fig. 4-1) to secure the slings from slip-



- ping off the hook during lifting and transporting.
- Secure slings against slipping.
- Make sure the slings can be removed from the valve once it has been installed into the pipeline.
- Prevent the control valve from tilting or tipping over.
- Do not leave loads suspended when interrupting work for longer periods of time.
- Make sure that the axis of the pipeline is always horizontal during lifting and the axis of the plug stem is always vertical.

#### Lifting the control valve

1. Attach one sling to each flange of the body and to the rigging equipment (e.g. hook) of the crane or forklift (see Fig. 4-3).
2. Carefully guide two slings around the actuator. Secure the slings against slipping by using a connector.
3. Carefully lift the control valve. Check whether the lifting equipment and accessories can bear the weight.
4. Move the control valve at an even pace to the site of installation.
5. Install the valve into the pipeline (see the 'Installation' section).
6. After installation in the pipeline, check whether the flanges are bolted tight and the valve in the pipeline holds.
7. Remove slings.

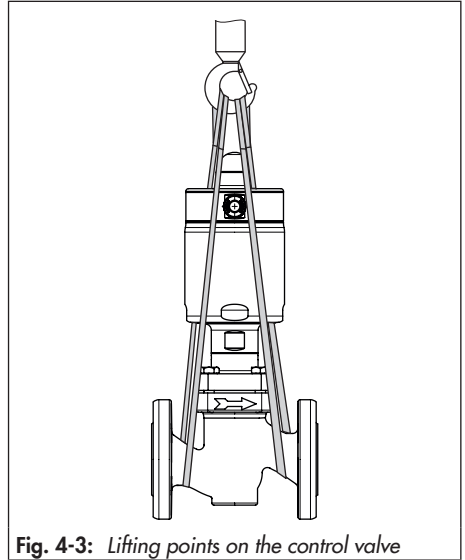


Fig. 4-3: Lifting points on the control valve

## 4.4 Storing the valve

### NOTICE

**Risk of valve damage due to improper storage.**

- Observe the storage instructions.
- Avoid long storage times.
- Contact SAMSON in case of different storage conditions or longer storage times.

### Note

We recommend regularly checking the control valve and the prevailing storage conditions during long storage periods.

## Shipment and on-site transport

### Storage instructions

- Protect the control valve against external influences (e.g. impact).
- Secure the valve in the stored position against slipping or tipping over.
- Do not damage the corrosion protection (paint, surface coatings). Repair any damage immediately.
- Protect the control valve against moisture and dirt. Store it at a relative humidity of less than 75 %. In damp spaces, prevent condensation. If necessary, use a drying agent or heating.
- Make sure that the ambient air is free of acids or other corrosive media.
- The permissible storage temperature of standard control valves is  $-20$  to  $+65$  °C. Contact our after-sales service for the storage temperatures of other valve versions.
- Do not place any objects on the control valve.



#### **Tip**

*SAMSON's After-sales Service can provide more detailed storage instructions on request.*

---

## 5 Installation

The work described in this section is only to be performed by personnel appropriately qualified to carry out such tasks.

### 5.1 Installation conditions

#### Work position

The work position for the control valve is the front view looking onto the operating controls (including valve accessories).

Plant operators must ensure that, after installation of the device, the operating personnel

can perform all necessary work safely and easily access the device from the work position.

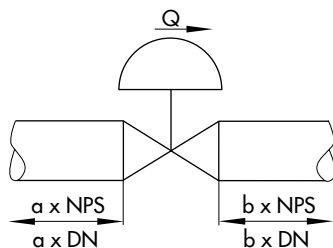
#### Pipeline routing

The inlet and outlet lengths (see Table 5-1) vary depending on several variables and process conditions and are intended as recommendations. Contact SAMSON if the lengths are significantly shorter than the recommended lengths.

To ensure that the valve functions properly, proceed as follows:

**Table 5-1:** Inlet and outlet lengths

State of process medium	Valve conditions	Inlet length a	Outlet length b
Gas	$Ma \leq 0.3$	2	4
	$0.3 \leq Ma \leq 0.7$	2	10
Vapor	$Ma \leq 0.3$ <sup>1)</sup>	2	4
	$0.3 \leq Ma \leq 0.7$ <sup>1)</sup>	2	10
	Wet steam (percentage of condensate > 5 %)	2	20
Liquid	Free of cavitation/ $w < 10$ m/s	2	4
	Cavitation producing noise/ $w \leq 3$ m/s	2	4
	Cavitation producing noise/ $3 < w < 5$ m/s	2	10



Q Flow rate  
a Inlet length  
b Outlet length

<sup>1)</sup> No wet steam

## Installation

- Observe the recommended inlet and outlet lengths (see Table 5-1). Contact SAMSON if the valve conditions or states of the medium process deviate.
- Install the valve free of stress and with the least amount of vibrations as possible. Read information under “Mounting position” and “Support or suspension” in this section.
- Install the valve allowing sufficient space to remove the actuator and valve or to perform service and repair work on them.

### Mounting position

Generally, we recommend installing the valve with the actuator upright and on top of the valve.

- Contact SAMSON if the mounting position is not as specified above.

### Support or suspension

---

#### **i** Note

*The plant engineering company is responsible for selecting and implementing a suitable support or suspension of the installed control valve and the pipeline.*

---

Depending on the valve version and mounting position, the valve, actuator and pipeline must be supported or suspended.

Valves, which are not installed in the pipeline in the upright position with the actuator on top, must be supported or suspended.

### Valve accessories

- During connection of valve accessories, make sure that they are easily accessible and can be operated safely from the work position.

### Vent plugs

Vent plugs are screwed into the exhaust air ports of pneumatic and electropneumatic devices. They ensure that any exhaust air that forms can be vented to the atmosphere (to avoid excess pressure in the device). Furthermore, the vent plugs allow air intake to prevent a vacuum from forming in the device.

- Locate the vent plug on the opposite side to the work position of operating personnel.

## 5.2 Preparation for installation

Before installation, make sure the following conditions are met:

- The valve is clean.
- The valve and all valve accessories (including piping) are not damaged.
- The valve data on the nameplate (type designation, valve size, material, pressure rating and temperature range) match the plant conditions (size and pressure rating of the pipeline, medium temperature etc.). See the 'Markings on the device' section for nameplate details.
- The requested or required additional pipe fittings (see 'Additional fittings' in the 'Design and principle of operation' section) have been installed or prepared as necessary before installing the valve.

Proceed as follows:

- Lay out the necessary material and tools to have them ready during installation work.
- Flush the pipelines.

---

**i Note**

*The plant operator is responsible for cleaning the pipelines in the plant.*

---

- For steam applications, dry the pipelines. Moisture will damage the inside of the valve.
- Check any mounted pressure gauges to make sure they function properly.
- When the valve and actuator are already assembled, check the tightening torques of the bolted joints (see the 'Tightening torques' section in Annex). Components may loosen during transport.

### 5.3 Mounting the device

The activities listed below are necessary to install the valve and before it can be started up.

---

**! NOTICE**

***Risk of valve damage due to excessively high or low tightening torques.***

*Observe the specified torques when tightening control valve components. Excessive tightening torques lead to parts wearing out more quickly. Parts that are too loose may cause leakage.*

- *Observe the specified tightening torques (see 'Tightening torques' in Annex).*
- 

**! NOTICE**

***Risk of valve damage due to the use of unsuitable tools.***

- *Only use tools approved by SAMSON (see the 'Tools' section in Annex).*
- 

**! NOTICE**

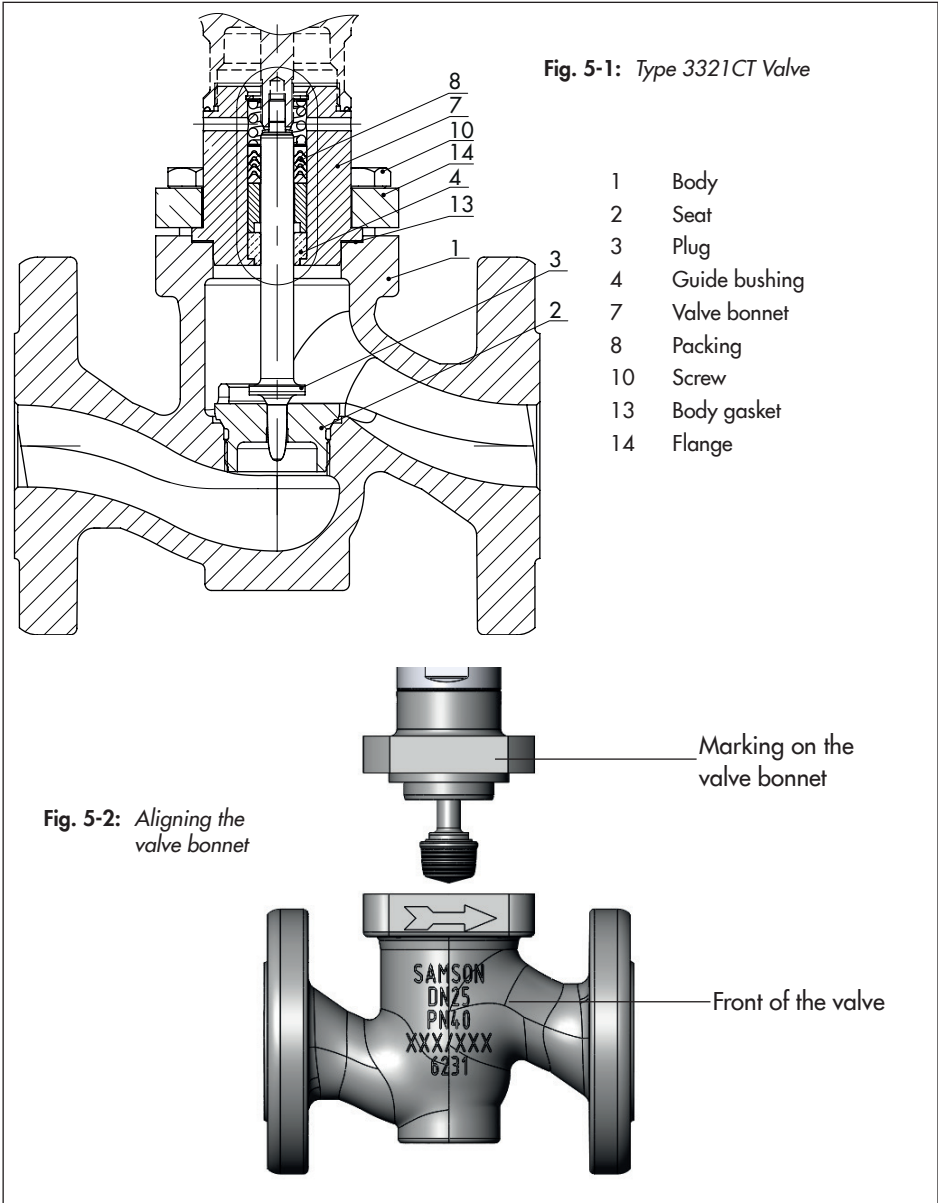
***Risk of valve damage due to the use of unsuitable lubricants.***

- *Only use lubricants approved by SAMSON (see the 'Lubricants' section in Annex).*
- 

**! NOTICE**

***Risk of the process medium being contaminated through the use of unsuitable lubricants and/or contaminated tools and components.***

- *Keep the valve and the tools used free from solvents and grease.*
  - *Make sure that only suitable lubricants are used.*
-



### 5.3.1 Mounting the actuator onto the valve

Depending on the version, SAMSON control valves are either delivered with the actuator already mounted on the valve or the valve and actuator are delivered separately. When delivered separately, the valve and actuator must be assembled together on site.

1. Make sure that the valve is completely open (the plug stem is completely retracted).

**Version with "actuator stem extends"**

**fail-safe action:** apply a signal pressure that corresponds to the upper bench range value to the connection on the bottom diaphragm chamber.

**Version with "actuator stem retracts"**

**fail-safe action:** make sure that no signal pressure is applied to the actuator.

2. Undo the screws (10) on the valve bonnet (7).
3. Lift the flange (14), valve bonnet (7) together with the plug and plug stem (3) off the body (1).
4. Apply a suitable thread-locking fluid to the female thread of the actuator stem.
5. Screw the plug stem (3) into the actuator stem. Observe tightening torques.
6. Apply a suitable lubricant to the thread of the valve bonnet (7).
7. Screw the valve bonnet (7) into the actuator base until it reaches the metal stop. Observe tightening torques.

8. Carefully place the actuator, valve bonnet (7), flange (14) and plug with plug stem (3) onto the body (1).

Make sure that the marking on the valve bonnet are aligned with the front of the valve (see Fig. 5-2).

Make sure that the gasket (13) is properly seated in the body.

9. Apply a suitable lubricant to the screws (10).
10. Firmly press the plug (3) into the seat (2), while fastening down the valve bonnet (7) with the screws (10). Gradually tighten the screws in a crisscross pattern. Observe tightening torques.
11. For further instructions concerning Type 3379 Actuator (pneumatic connections, alignment of the actuator etc.)  
▶ EB 8315.

### 5.3.2 Installing the valve into the pipeline

**NOTICE**

**Premature wear and leakage due to insufficient support or suspension.**

➔ *Support or suspend the valve sufficiently at suitable points.*

1. Close the shut-off valves in the pipeline at the inlet and outlet of the plant section while the valve is being installed.
2. Prepare the relevant section of the pipeline for installing the valve.

## Installation

3. Remove the protective caps from the valve ports before installing the valve.
4. Lift the valve using suitable lifting equipment to the site of installation (see information under 'Lifting the valve' in the 'Shipment and on-site transport' section). Observe the flow direction through the valve. The arrow on the valve indicates the direction of flow.
5. Make sure that the correct flange gaskets are used.
6. Bolt the pipe to the valve free of stress.
7. Attach a support or suspension on the valve, if necessary.

## 5.4 Testing the installed valve

### **⚠ DANGER**

#### **Risk of bursting due to incorrect opening of pressurized equipment or components.**

Valves and pipelines are pressure equipment that may burst when handled incorrectly. Flying projectile fragments or the release of process medium under pressure can cause serious injury or even death.

Before working on the control valve:

- ➔ Depressurize all plant sections affected and the valve (including the actuator). Release any stored energy.
- ➔ Drain the process medium from all the plant sections concerned as well as the valve.

### **⚠ WARNING**

#### **Risk of hearing loss or deafness due to loud noise.**

Noise emission (e.g. cavitation or flashing) may occur during operation caused by the process medium and the operating conditions. Additionally, a loud noise may briefly occur through the sudden venting of the pneumatic actuator or pneumatic valve accessories not fitted with noise-reducing fittings. Both can damage hearing.

- ➔ Wear hearing protection when working near the valve.

### **⚠ WARNING**

#### **Risk of personal injury due to exhaust air being vented.**

While the valve is operating, air is vented from the actuator, for example, during closed-loop operation or when the valve opens or closes.

- ➔ Wear eye protection when working in close proximity to the control valve.

### **⚠ WARNING**

#### **Risk of personal injury due to preloaded springs.**

Actuators with preloaded springs are under tension.

- ➔ Before starting any work on the actuator, relieve the compression from the preloaded springs (see associated actuator documentation).



To test the valve functioning before start-up or putting back the valve into operation, perform the following tests:

### 5.4.1 Leak test

The plant operator is responsible for performing the leak test and selecting the test method. The leak test must comply with the requirements of the national and international standards that apply at the site of installation.



#### Tip

*Our after-sales service can support you to plan and perform a leak test for your plant.*

---

1. Close the valve.
2. Slowly apply the test medium to the inlet space upstream of the valve. Avoid sudden surges in pressure since the resulting high velocities may damage the valve.
3. Open the valve.
4. Apply the required test pressure.
5. Check the valve for leakage to the atmosphere.
6. Depressurize the pipeline section and valve.
7. Rework any parts that leak and repeat the leak test.

### 5.4.2 Travel motion

The movement of the actuator stem must be linear and smooth.

- Apply the maximum and minimum control signals to check the end positions of the valve while observing the movement of the actuator stem.

### 5.4.3 Fail-safe position

- Shut off the signal pressure line.
- Check whether the valve moves to the fail-safe position (see the 'Design and principle of operation' section).

### 5.4.4 Pressure test

The plant operator is responsible for performing the pressure test.



#### Tip

*Our after-sales service can support you to plan and perform a pressure test for your plant.*

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During the pressure test, make sure the following conditions are met:

- Retract the plug stem to open the valve.
- Observe the maximum permissible pressure for both the valve and plant.



## 6 Start-up

The work described in this section is only to be performed by personnel appropriately qualified to carry out such tasks.

### **⚠ WARNING**

#### **Risk of burn injuries due to hot or cold components and pipeline.**

Valve components and the pipeline may become very hot or cold. Risk of burn injuries.

- Allow components and pipelines to cool down or warm up to the ambient temperature.
- Wear protective clothing and safety gloves.

### **⚠ WARNING**

#### **Risk of hearing loss or deafness due to loud noise.**

Noise emission (e.g. cavitation or flashing) may occur during operation caused by the process medium and the operating conditions. Additionally, a loud noise may briefly occur through the sudden venting of the pneumatic actuator or pneumatic valve accessories not fitted with noise-reducing fittings. Both can damage hearing.

- Wear hearing protection when working near the valve.

### **⚠ WARNING**

#### **Risk of personal injury due to exhaust air being vented.**

While the valve is operating, air is vented from the actuator, for example, during closed-loop operation or when the valve opens or closes.

- Wear eye protection when working in close proximity to the control valve.

Before start-up or putting the valve back into service, make sure the following conditions are met:

- The valve is properly installed into the pipeline (see the 'Installation' section).
- The leak and function tests have been completed successfully (see 'Testing the installed valve' in the 'Installation' section).
- The prevailing conditions in the plant section concerned meet the valve sizing requirements (see information under 'Intended use' in the 'Safety instructions and measures' section).

## Start-up

### Start-up/putting the valve back into operation

1. Allow the valve to cool down or warm up to reach ambient temperature before start-up when the ambient temperature and process medium temperature differ greatly or the medium properties require such a measure.
2. Slowly open the shut-off valves in the pipeline. Slowly opening these valves prevents a sudden surge in pressure and high flow velocities which can damage the valve.
3. Check the valve to ensure it functions properly.

## 7 Operation

Immediately after completing start-up or putting the valve back into operation, the valve is ready for use.

---

### **⚠ WARNING**

#### ***Risk of burn injuries due to hot or cold components and pipeline.***

Valve components and the pipeline may become very hot or cold. Risk of burn injuries.

- Allow components and pipelines to cool down or warm up to the ambient temperature.
  - Wear protective clothing and safety gloves.
- 

---

### **⚠ WARNING**

#### ***Risk of hearing loss or deafness due to loud noise.***

Noise emission (e.g. cavitation or flashing) may occur during operation caused by the process medium and the operating conditions. Additionally, a loud noise may briefly occur through the sudden venting of the pneumatic actuator or pneumatic valve accessories not fitted with noise-reducing fittings. Both can damage hearing.

- Wear hearing protection when working near the valve.
- 

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### **⚠ WARNING**

#### ***Risk of personal injury due to exhaust air being vented.***

While the valve is operating, air is vented from the actuator, for example, during closed-loop operation or when the valve opens or closes.

- Wear eye protection when working in close proximity to the control valve.
-



## 8 Malfunctions

Read hazard statements, warnings and caution notes in the 'Safety instructions and measures' section.

### 8.1 Troubleshooting

Malfunction	Possible reasons	Recommended action
Actuator and plug stem does not move on demand.	Actuator is blocked.	Check attachment. Remove the blockage. <b>WARNING!</b> A blocked actuator or plug stem (e.g. due to seizing up after remaining in the same position for a long time) can suddenly start to move uncontrollably. Injury to hands or fingers is possible if they are inserted into the actuator or valve. Before trying to unblock the actuator or plug stem, disconnect and lock the pneumatic air supply as well as the control signal. Before unblocking the actuator, release any stored energy in the actuator (e.g. spring compression). See associated actuator documentation.
	Signal pressure too low	Check the signal pressure. Check the signal pressure line for leakage.
Actuator and plug stem does not stroke through the entire range.	Signal pressure too low	Check the signal pressure. Check the signal pressure line for leakage.
Increased flow through closed valve (seat leakage)	Dirt or other foreign particles deposited between the seat and plug.	Shut off the section of the pipeline and flush the valve.
	Valve trim is worn out.	Replace seat and plug (see the 'Servicing' section) or contact our after-sales service.
The valve leaks to the atmosphere (fugitive emissions).	Defective packing	Replace packing (see the 'Servicing' section) or contact our after-sales service.
	Flanged joint loose or gasket worn out	Check the flanged joint. Replace gasket at the flanged joint (see the 'Servicing' section) or contact our after-sales service.

**i Note**

*Contact our after-sales service for malfunctions not listed in the table.*

---

## 8.2 Emergency action

Plant operators are responsible for emergency action to be taken in the plant.

In the event of a valve malfunction:

1. Close the shut-off valves upstream and downstream of the control valve to stop the process medium from flowing through the valve.
2. Perform troubleshooting (see section 8.1).
3. Rectify those malfunctions that can be remedied based on the instructions provided here. Contact our after-sales service in all other cases.

### **Putting the valve back into operation after a malfunction**

See the 'Start-up' section.



## 9 Servicing

The work described in this section is to be performed only by personnel appropriately qualified to carry out such tasks.

The following documents are also required for servicing the valve:

- Mounting and operating instructions for the mounted actuator, e.g. ► EB 8315 for Type 3379 Pneumatic Actuator

### **⚠ DANGER**

**Risk of bursting due to incorrect opening of pressurized equipment or components.**

Valves and pipelines are pressure equipment that may burst when handled incorrectly.

Flying projectile fragments or the release of process medium under pressure can cause serious injury or even death.

Before working on the control valve:

- Depressurize all plant sections affected and the valve (including the actuator). Release any stored energy.
- Drain the process medium from all the plant sections concerned as well as the valve.

### **⚠ WARNING**

**Risk of burn injuries due to hot or cold components and pipeline.**

Valve components and the pipeline may become very hot or cold. Risk of burn injuries.

- Allow components and pipelines to cool down or warm up to the ambient temperature.

- Wear protective clothing and safety gloves.

### **⚠ WARNING**

**Risk of hearing loss or deafness due to loud noise.**

Noise emission (e.g. cavitation or flashing) may occur during operation caused by the process medium and the operating conditions. Additionally, a loud noise may briefly occur through the sudden venting of the pneumatic actuator or pneumatic valve accessories not fitted with noise-reducing fittings. Both can damage hearing.

- Wear hearing protection when working near the valve.

### **⚠ WARNING**

**Risk of personal injury due to exhaust air being vented.**

While the valve is operating, air is vented from the actuator, e.g. during closed-loop operation or when the valve opens or closes.

- Wear eye protection when working in close proximity to the control valve.

### **⚠ WARNING**

**Risk of personal injury due to preloaded springs.**

Actuators with preloaded springs are under tension.

- Before starting any work on the actuator, relieve the compression from the preloaded springs (see associated actuator documentation).

---

### **⚠ WARNING**

**Risk of personal injury due to residual process medium in the valve.**

While working on the valve, residual medium can flow out of the valve and, depending on its properties, cause personal injury, e.g. (chemical) burns.

→ Wear protective clothing, safety gloves, respiratory protection and eye protection.

---

### **ⓘ NOTICE**

**Risk of valve damage due to excessively high or low tightening torques.**

Observe the specified torques when tightening control valve components. Excessive tightening torques lead to parts wearing out more quickly. Parts that are too loose may cause leakage.

→ Observe the specified tightening torques (see 'Tightening torques' in Annex).

---

### **ⓘ NOTICE**

**Risk of valve damage due to the use of unsuitable tools.**

→ Only use tools approved by SAMSON (see the 'Tools' section in Annex).

---

### **ⓘ NOTICE**

**Risk of valve damage due to the use of unsuitable lubricants.**

→ Only use lubricants approved by SAMSON (see the 'Lubricants' section in Annex).

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### **ⓘ NOTICE**

**Risk of the process medium being contaminated through the use of unsuitable lubricants and/or contaminated tools and components.**

→ Keep the valve and the tools used free from solvents and grease.

→ Make sure that only suitable lubricants are used.

---

### **i Note**

The control valve was checked by SAMSON before delivery.

– Certain test results certified by SAMSON lose their validity when the valve is opened. Such testing includes seat leakage and leak tests.

– The product warranty becomes void if service or repair work not described in these instructions is performed without prior agreement by SAMSON's After-sales Service.

– Only use original spare parts by SAMSON, which comply with the original specifications.

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## 9.1 Periodic testing

Depending on the operating conditions, check the valve at certain intervals to prevent possible failure before it can occur. Plant operators are responsible for drawing up an inspection and test plan.

**Tip**

*Our after-sales service can support you in drawing up an inspection and test plan for your plant.*

## 9.2 Preparing the valve for service work

1. Lay out the necessary material and tools to have them ready for the service work.
2. Put the control valve out of operation (see the 'Decommissioning' section).
3. Remove the valve from the pipeline (see the 'Removal' section).
4. Make sure that the valve is completely open (the plug stem is completely retracted).

### Version with "actuator stem extends"

**fail-safe action:** apply a signal pressure that corresponds to the upper bench range value to the connection on the bottom diaphragm chamber.

### Version with "actuator stem retracts"

**fail-safe action:** make sure that no signal pressure is applied to the actuator.

The following service work can be performed after preparation is completed:

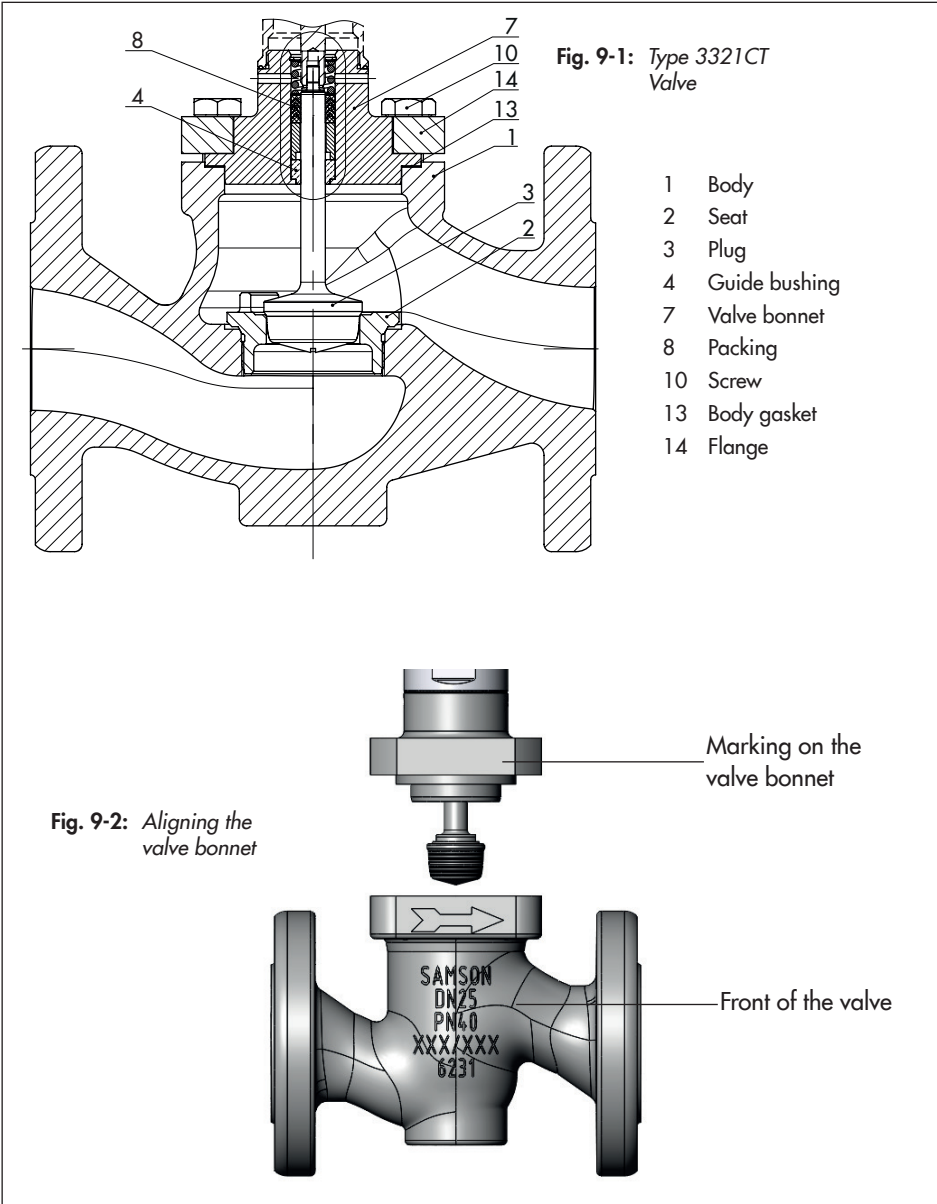
- Replace the gaskets as described in section 9.4.1.
- Replace the packing (see section 9.4.2)
- Replace the seat and plug (see section 9.4.3)

## 9.3 Installing the valve after service work

1. Reinstall the valve into the pipeline (see the 'Installation' section).
2. Put the control valve back into operation (see the 'Start-up' section). Observe the requirements and conditions for start-up or putting the valve back into operation.

## 9.4 Service work

- ➔ Before performing any service work, preparations must be made to the control valve (see section 9.2).
- ➔ After all service work is completed, check the control valve before putting it back into operation (see 'Testing the installed valve' in the 'Installation' section).



### 9.4.1 Replacing the gasket

1. Undo the screws (10) on the valve bonnet (7).
2. Lift the actuator, flange (14), valve bonnet (7) and plug with plug stem (3) off the body (1).
3. Remove the gasket (13). Carefully clean the sealing faces in the valve body (1) and on the valve bonnet (7).
4. Insert a new gasket (13) into the body.
5. Carefully place the actuator, valve bonnet (7), flange (14) and plug with plug stem (3) onto the body (1).

Make sure that the marking on the valve bonnet are aligned with the front of the valve (see Fig. 9-2).

6. Apply a suitable lubricant to the screws (10).
7. Firmly press the plug (3) into the seat (2), while fastening down the valve bonnet (7) with the screws (10). Gradually tighten the screws in a crisscross pattern. Observe tightening torques.

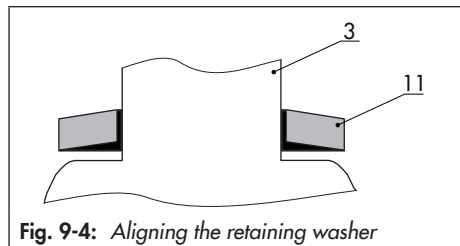
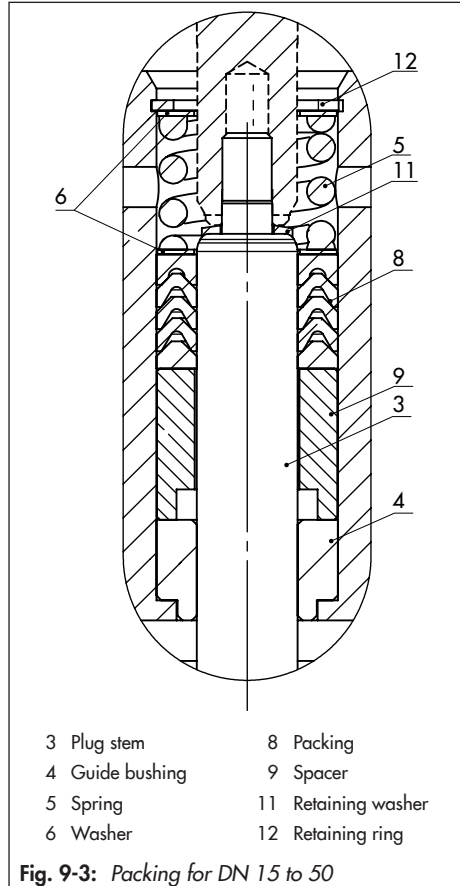
### 9.4.2 Replacing the packing

1. Undo the screws (10) on the valve bonnet (7).
2. Lift the actuator, flange (14), valve bonnet (7) and plug with plug stem (3) off the body (1).
3. Replace the gasket (see section 9.4.1)
4. Unscrew the valve bonnet (7) from the actuator base.

5. Unscrew the plug stem (3) from the actuator stem.
6. Pull the plug with plug stem (3) out of the valve bonnet (7).
7. Pull the entire packing out of the packing chamber using a suitable tool.
8. Renew damaged parts. Clean the packing chamber thoroughly.
9. Apply a suitable lubricant to all the packing parts and to the plug stem (3).
10. Make sure that the guide bushing (4) and spacer (9) are seated correctly in the valve bonnet (7).
11. Insert the packing parts into the packing chamber. Make sure to observe the proper order (see Fig. 9-3 or Fig. 9-5).
12. Place the retaining ring (12) on the packing parts.
13. Use a suitable tool to press the packing together until the retaining ring (12) is seated in the groove of the valve bonnet (7).
14. Place the retaining washer (11) from above onto the plug stem (3). Observe the proper alignment (see Fig. 9-4).
15. Carefully slide the plug stem (3) into the valve bonnet (7).
16. Apply a suitable thread-locking fluid to the female thread of the actuator stem.
17. Screw the plug stem (3) into the actuator stem. Observe tightening torques.
18. Apply a suitable lubricant to the thread of the valve bonnet (7).

## Servicing

19. Screw the valve bonnet (7) into the actuator base until it reaches the metal stop. Observe tightening torques.
20. Carefully place the actuator, valve bonnet (7), flange (14) and plug with plug stem (3) onto the body (1).  
Make sure that the marking on the valve bonnet are aligned with the front of the valve (see Fig. 9-2).  
Make sure that the gasket (13) is properly seated in the body.
21. Apply a suitable lubricant to the screws (10).
22. Firmly press the plug (3) into the seat (2), while fastening down the valve bonnet (7) with the screws (10). Gradually tighten the screws in a crisscross pattern. Observe tightening torques.
23. For further instructions concerning Type 3379 Actuator (pneumatic connections, alignment of the actuator etc.)  
▶ EB 8315.



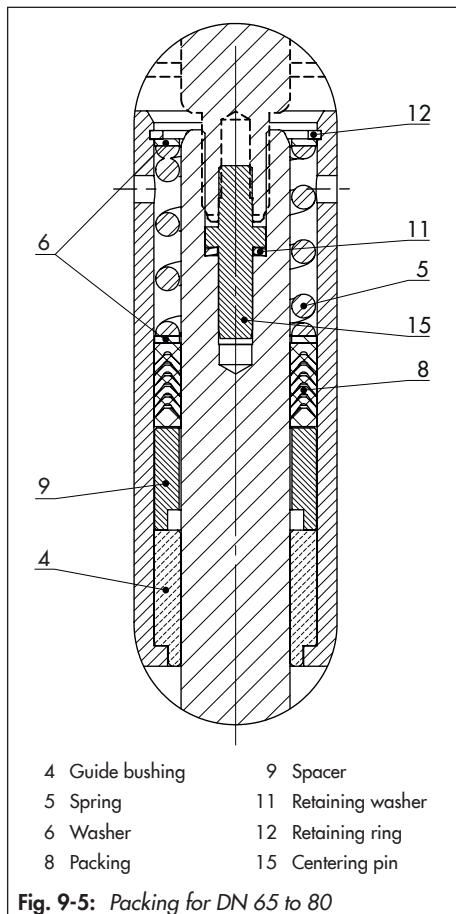


Fig. 9-5: Packing for DN 65 to 80

### 9.4.3 Replacing the seat and plug

**NOTICE**

**Risk of damage to the facing of the seat and plug due to incorrect service or repair.**

→ Always replace both the seat and plug.

**Tip**

When replacing the seat and plug, we also recommend replacing the gasket and packing. See sections 9.4.1 and 9.4.2.

1. Undo the screws (10) on the valve bonnet (7).
2. Lift the actuator, flange (14), valve bonnet (7) and plug with plug stem (3) off the body (1).
3. Replace the gasket (see section 9.4.1)
4. Unscrew the seat (4) using a suitable tool (see the 'Tools' section in the Annex).
5. Apply a suitable lubricant to the thread and the sealing cone of the new seat.
6. Screw in the seat (4). Observe tightening torques.
7. Unscrew the valve bonnet (7) from the actuator base.
8. Unscrew the plug stem (3) from the actuator stem.
9. Pull the plug with plug stem (3) out of the valve bonnet (7).
10. Pull the entire packing out of the packing chamber using a suitable tool.
11. Apply a suitable lubricant to all the packing parts and to the new plug stem (3). We recommend replacing the packing as well. See section 9.4.2.
12. Make sure that the guide bushing (4) and spacer (9) are seated correctly in the valve bonnet (7).

## Servicing

13. Insert the packing parts into the packing chamber. Make sure to observe the proper order (see Fig. 9-3 or Fig. 9-5).
14. Place the retaining ring (12) on the packing parts.
15. Use a suitable tool to press the packing together until the retaining ring (12) is seated in the groove of the valve bonnet (7).
16. Place the retaining washer (11) from above onto the new plug stem (3). Observe the proper alignment (see Fig. 9-4).
17. Carefully slide the new plug stem with plug (3) into the valve bonnet (7).
18. Apply a suitable thread-locking fluid to the female thread of the actuator stem.
19. Screw the plug stem (3) into the actuator stem. Observe tightening torques.
20. Apply a suitable lubricant to the thread of the valve bonnet (7).
21. Screw the valve bonnet (7) into the actuator base until it reaches the metal stop. Observe tightening torques.
22. Carefully place the actuator, valve bonnet (7), flange (14) and plug with plug stem (3) onto the body (1).

Make sure that the marking on the valve bonnet are aligned with the front of the valve (see Fig. 9-2).

Make sure that the gasket (13) is properly seated in the body.
23. Apply a suitable lubricant to the screws (10).
24. Firmly press the plug (3) into the seat (2), while fastening down the valve bonnet (7) with the screws (10). Gradually tighten the screws in a crisscross pattern. Observe tightening torques.
25. For further instructions concerning Type 3379 Actuator (pneumatic connections, alignment of the actuator etc.)  
▶ EB 8315.



## 9.5 Ordering spare parts and operating supplies

Contact your nearest SAMSON subsidiary or SAMSON's After-sales Service for information on spare parts, lubricants and tools.

### **Spare parts**

See the 'Spare parts' section in the Annex for details on spare parts.

### **Lubricants**

See the 'Lubricants' section in the Annex for details on suitable lubricants.

### **Tools**

See the 'Tools' section in the Annex for details on suitable tools.



## 10 Decommissioning

The work described in this section is only to be performed by personnel appropriately qualified to carry out such tasks.

### **⚠ DANGER**

#### **Risk of bursting due to incorrect opening of pressurized equipment or components.**

Valves and pipelines are pressure equipment that may burst when handled incorrectly.

Flying projectile fragments or the release of process medium under pressure can cause serious injury or even death.

Before working on the control valve:

- Depressurize all plant sections affected and the valve (including the actuator). Release any stored energy.
- Drain the process medium from all the plant sections concerned as well as the valve.

### **⚠ WARNING**

#### **Risk of burn injuries due to hot or cold components and pipeline.**

Valve components and the pipeline may become very hot or cold. Risk of burn injuries.

- Allow components and pipelines to cool down or warm up to the ambient temperature.
- Wear protective clothing and safety gloves.

### **⚠ WARNING**

#### **Risk of hearing loss or deafness due to loud noise.**

Noise emission (e.g. cavitation or flashing) may occur during operation caused by the process medium and the operating conditions. Additionally, a loud noise may briefly occur through the sudden venting of the pneumatic actuator or pneumatic valve accessories not fitted with noise-reducing fittings. Both can damage hearing.

- Wear hearing protection when working near the valve.

### **⚠ WARNING**

#### **Risk of personal injury due to exhaust air being vented.**

While the valve is operating, air is vented from the actuator, for example, during closed-loop operation or when the valve opens or closes.

- Wear eye protection when working in close proximity to the control valve.

### **⚠ WARNING**

#### **Risk of personal injury due to residual process medium in the valve.**

While working on the valve, residual medium can flow out of the valve and, depending on its properties, cause personal injury, e.g. (chemical) burns.

- Wear protective clothing, safety gloves, respiratory protection and eye protection.

## Decommissioning

To decommission the control valve for service work or to remove it from the pipeline, proceed as follows:

1. Close the shut-off valves upstream and downstream of the control valve to stop the process medium from flowing through the valve.
2. Completely drain the pipelines and valve.
3. Disconnect and lock the pneumatic air supply to depressurize the actuator.
4. Release any stored energy.
5. If necessary, allow the pipeline and valve components to cool down or warm up to the ambient temperature.

## 11 Removal

The work described in this section is only to be performed by personnel appropriately qualified to carry out such tasks.

### **⚠ WARNING**

**Risk of burn injuries due to hot or cold components and pipeline.**

Valve components and the pipeline may become very hot or cold. Risk of burn injuries.

- Allow components and pipelines to cool down or warm up to the ambient temperature.
- Wear protective clothing and safety gloves.

### **⚠ WARNING**

**Risk of personal injury due to residual process medium in the valve.**

While working on the valve, residual medium can flow out of the valve and, depending on its properties, cause personal injury, e.g. (chemical) burns.

- Wear protective clothing, safety gloves, respiratory protection and eye protection.

### **⚠ WARNING**

**Risk of personal injury due to preloaded springs.**

Actuators with preloaded springs are under tension.

- Before starting any work on the actuator, relieve the compression from the preloaded springs.

Before removing the valve, make sure the following conditions are met:

- The control valve is put out of operation (see the 'Decommissioning' section).

### 11.1 Removing the valve from the pipeline

1. Support the valve to hold it in place when separated from the pipeline (see the 'Shipment and on-site transport' section).
2. Unbolt the flanged joint.
3. Remove the valve from the pipeline (see the 'Shipment and on-site transport' section).



## 12 Repairs

If the valve does not function properly according to how it was originally sized or does not function at all, it is defective and must be repaired or exchanged.

### ! NOTICE

**Risk of valve damage due to incorrect service or repair work.**

- ➔ Do not perform any repair work on your own.
- ➔ Contact SAMSON's After-sales Service for service and repair work.

### 12.1 Returning devices to SAMSON

Defective devices can be returned to SAMSON for repair.

Proceed as follows to return devices:

1. Exceptions apply concerning some special device models
  - ▶ [www.samsongroup.com](http://www.samsongroup.com) > Service & Support > After-sales Service.
2. Send an e-mail
  - ▶ [retouren@samsongroup.com](mailto:retouren@samsongroup.com) to register the return shipment including the following information:
    - Type
    - Article number
    - Configuration ID
    - Original order

- Completed Declaration on Contamination, which can be downloaded from our website at
  - ▶ [www.samsongroup.com](http://www.samsongroup.com) > Service & Support > After-sales Service.

**After checking your registration, we will send you a return merchandise authorization (RMA).**

3. Attach the RMA (together with the Declaration on Decontamination) to the outside of your shipment so that the documents are clearly visible.
4. Send the shipment to the address given on the RMA.

### i Note

*Further information on returned devices and how they are handled can be found at*

- ▶ [www.samsongroup.com](http://www.samsongroup.com) > Service & Support > After-sales Service.





## 13 Disposal



SAMSON is a producer registered at the following European institution  
 ► <https://www.ewrn.org/national-registers/national-registers>.  
 WEEE reg. no.: DE 621 94439/  
 FR 02566

- ➔ Observe local, national and international refuse regulations.
- ➔ Do not dispose of components, lubricants and hazardous substances together with your household waste.

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### **i** Note

*We can provide you with a recycling passport according to PAS 1049<sup>1)</sup> on request. Simply e-mail us at [offersaleservice@samsongroup.com](mailto:offersaleservice@samsongroup.com) giving details of your company address.*

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### Tip

*On request, we can appoint a service provider to dismantle and recycle the product as part of a distributor take-back scheme.*

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<sup>1)</sup> PAS 1049 is relevant to electrical and electronic equipment (e.g. electric actuators). This PAS specification does not apply to non-electrical equipment.



## 14 Certificates

These declarations are included on the next pages:

- Declaration of conformity in compliance with Pressure Equipment Directive 2014/68/EU:
  - Country of origin: France, see page 14-2 to 14-5
  - Country of origin: Germany, see page 14-6 to 14-8
- Declaration of conformity in compliance with Machinery Directive 2006/42/EC for Type 3321CT Globe Valve and the SAMSON Type 3379 Pneumatic Actuator on page 14-9
- Declaration of incorporation in compliance with Machinery Directive 2006/42/EC for Type 3321CT Valve on page 14-10
- Declaration of conformity in compliance with the 2016 Regulations No. 1105 Pressure Equipment (Safety) Regulations 2016, see pages 14-11 to 14-14
- Declaration of conformity in compliance with the 2008 Regulations No. 1597 Supply of Machinery (Safety) Regulations 2008:
  - Final machinery, see page 14-15
  - Partly completed machinery, see page 14-16
- Declaration of conformity in compliance with the EU Regulation (EC) No. 1935/2004 and the US Regulation FDA 21 CFR Section 177.1550 ("Industrial valves in special execution with seals

and packings for food contact") on page 14-17

- Declaration of conformity in compliance with the EU Regulation (EC) No. 1935/2004 and the US Regulation FDA 21 CFR Section 177.1550 ("Industrial valves in special execution used in food or pharmaceutical environment") on page 14-18
- Declaration of conformity in compliance with the requirements in TSG D7002-2006 for Chinese pressure equipment on page 14-19

The certificates shown were up to date at the time of publishing. The latest certificates can be found on our website:

- ► [www.samsongroup.com](http://www.samsongroup.com) > Products > Valves > 3321CT

Other optional certificates are available on request.



## DECLARATION UE DE CONFORMITE EU DECLARATION OF CONFORMITY

1/2

### Module A / Modul A

**DC014  
2022-05**

Par la présente, SAMSON REGULATION SAS déclare sous sa seule responsabilité pour les produits suivants :  
For the following products, SAMSON REGULATION SAS hereby declares under its sole responsibility:

Appareils / Devices	Type	Exécution / Version	Matériel du corps / body Material	PN Class	DN NPS	Fluides / fluids
Vanne de décharge / Back pressure reducing valve	2371-0	DIN	Acier / steel	$P_{max} T = 20^{\circ}C$ 10 bar	DN 32 – 50	Tous fluides / all fluids
		ANSI		$P_{max} T = 70^{\circ}F$ 150 psi	NPS 1 1/4 – 2	
Détendeur alimentaire / Pressure reducing valve	2371-1	DIN	Acier / steel	$P_{max} T = 20^{\circ}C$ 10 bar	DN 32 – 50	Tous fluides / all fluids
		ANSI		$P_{max} T = 70^{\circ}F$ 150 psi	NPS 1 1/4 – 2	
Vanne de régulation passage droit / Globe valve	2423	à membrane with diaphragm	Fonte grise / cast iron	PN25	DN 65 – 125	G2 (L2 1)
		à soufflet with bellow	Fonte sphéroïdale / spheroidal graphite iron	PN25	DN 50 – 125	
Vanne de régulation passage droit / Globe valve	3241	DIN	Fonte grise / cast iron	PN16	DN 65 – 100	G2, L1, L2 1)
		DIN	Fonte grise & fonte sphéroïdale / cast iron & spheroidal graphite iron	PN25	DN 50 – 100	
		DIN	Fonte sphéroïdale / spheroidal graphite	PN40	DN 40 – 100	
		ANSI	Fonte grise / cast iron	PN10	DN 125 – 150	
		DIN	Fonte sphéroïdale / spheroidal graphite	PN16	DN 65 – 125	
		ANSI	Fonte grise / cast iron	PN 25	DN 50 – 80	
Vanne de régulation 3 voies / 3-way Valve	3244	DIN	Acier / steel	CI 125 CI 250	NPS 2 1/2 – 4 NPS 1 1/2 – 2	Tous fluides / all fluids
		DIN	Fonte grise / cast iron	PN10	DN 32 – 100	
		ANSI	Acier / steel	PN16 PN25	DN 32 – 50 DN 32 – 40	
		DIN	Fonte grise / cast iron	CI 150	NPS 1 1/4 – 2	
Vanne de régulation passage droit / Globe valve	3251	DIN	Acier / steel	PN10	DN 125 – 150	G2, L1, L2 1)
		ANSI	Fonte grise / cast iron	PN16	DN 65 – 125	
Vanne équerre / Angle valve	3256	DIN	Acier / steel	PN10	DN 32 – 100	Tous fluides / all fluids
		ANSI	Acier / steel	PN16 PN25	DN 32 – 50 DN 32 – 40	
Vanne à segment sphérique / Segment ball valve	3310	DIN	Acier / steel	PN16	DN 32 – 50	Tous fluides / all fluids
		ANSI	Acier / steel	PN25	DN 80 – 100	
Vanne de régulation passage droit / Globe valve	3321	DIN	Fonte grise / cast iron	CI 150	NPS 1 1/2 – 2	G2, L1, L2 1)
		ANSI	Fonte grise / cast iron	PN16	DN 65 – 100	
		DIN	Fonte sphéroïdale / spheroidal graphite iron	PN25	DN 50 – 80	
Vanne de régulation 3 voies / 3-way Valve	3323	DIN	Acier / steel	CI 150	NPS 1 1/2 – 2	Tous fluides / all fluids
		ANSI	Fonte grise / cast iron : GJL-250	PN16	DN 65 – 100	
Vanne papillon / Butterfly valve	3331	DIN	Fonte sphéroïdale / spheroidal graphite iron	PN25	DN 50 – 80	G2, L1, L2 1)
		ANSI	Acier / steel	PN10	DN 100	
Vanne à membrane Diaphragm valve	3345	DIN	Acier / steel	$P_{max} T = 20^{\circ}C$ 10 bar $P_{max} T = 20^{\circ}C$ 16 bar	DN 32 – 100 DN 32 – 50	Tous fluides / all fluids
		ANSI	Acier / steel	$P_{max} T = 70^{\circ}F$ 150 psi or 230 psi	NPS 1 1/4 – 2	
		DIN	Fonte grise & fonte sphéroïdale / cast iron & spheroidal graphite iron	$P_{max} T = 20^{\circ}C$ 10 bar $P_{max} T = 20^{\circ}C$ 16 bar $P_{max} T = 20^{\circ}C$ 40 bar	DN 125 – 150 DN 65 – 125 DN 40 – 50	
		ANSI	Fonte grise & fonte sphéroïdale / cast iron & spheroidal graphite iron	$P_{max} T = 70^{\circ}F$ 150 psi $P_{max} T = 70^{\circ}F$ 230 psi $P_{max} T = 70^{\circ}F$ 580 psi	NPS 2 1/2 – 4 NPS 2 1/2 – 5 NPS 1 1/2 – 2	



## DECLARATION UE DE CONFORMITE EU DECLARATION OF CONFORMITY

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Module A / Modul A

DC014  
2022-05

Appareils / Devices	Type	Exécution / Version	Matériau du corps / body Mate- rial	PN Class	DN NPS	Fluides / fluids
Vanne alimentaire / Sanitary valve	3347	DIN	Acier / steel	$P_{max} T = 20^{\circ}C$ 10 bar	DN 125 – 150	G2, L1, L2 <sup>1)</sup>
		ANSI		$P_{max} T = 70^{\circ}F$ 150 psi	NPS 5 – 6	
Vanne aseptique / Aseptic valve	3349	DIN	Acier / steel	$P_{max} T = 20^{\circ}C$ 10 bar	DN 32 – 100	Tous fluides / all fluids
		ANSI		$P_{max} T = 20^{\circ}C$ 16 bar	DN 32 – 50	
Vanne Tout ou Rien / On-Off Valve	3351	DIN	Acier / steel	$P_{max} T = 20^{\circ}C$ 25 bar	DN 32 – 40	Tous fluides / all fluids
				ANSI	$P_{max} T = 20^{\circ}C$ 150 psi	
		DIN	Fonte grise & fonte sphéroïdale / cast iron & spheroidal graphite iron	$P_{max} T = 70^{\circ}F$ 230 psi	DN 32 – 50	G2, L1, L2 <sup>1)</sup>
				$P_{max} T = 70^{\circ}F$ 360 psi	NPS 1 1/4 – 1 1/2	
		ANSI	Fonte sphéroïdale / spheroidal graphite iron	PN16	DN 32 – 40	G2, L1, L2 <sup>1)</sup>
				CI 150	NPS 1 1/4 – 2	
DIN	Fonte grise / cast iron	PN25	DN 50 – 80	G2, L1, L2 <sup>1)</sup>		
		CI 125	NPS 2 1/2 – 4			
Bride de mesure / Measure flange	5090	DIN	Acier / steel	PN6	DN 200 – 500	G2, L2 <sup>1)</sup>
				PN10	DN 125 – 350	
				PN16	DN 65 – 200	
				PN25	DN 50 – 125	
				PN40	DN 40 – 100	

<sup>1)</sup> Gas selon l'article 4 § 1.c) i) / Gases Acc. to article 4 paragraphs 1.c) i)  
Liquide selon l'article 4 § 1.c) ii) / Liquids Acc. to article 4 paragraphs 1.c) ii)

la conformité avec le règlement suivant : / the conformity with the following requirement :

La Directive du Parlement Européen et du Conseil d'harmonisation des lois des Etats Membres concernant la mise à disposition sur le marché d'équipements sous pression / Directive of the European Parliament and of the Council on the Harmonization of the laws of the Member States relating of the making available on the market of pressure equipment	2014/68/UE 2014/68/EU	Du / of 15.05.2014
Procédure d'évaluation de la conformité appliquée pour les fluides selon l'Article 4 § 1 Applied conformity assessment procedure for fluids according to Article 4 § 1	Module A / Modul A	

Normes techniques appliquées / Technical standards applied :  
DIN EN 12516-2, DIN EN 12516-3, ASME B16.34, DIN-EN 60534-4, DIN-EN 1092-1

Fabricant / manufacturer : Samson Régulation SAS, 1, rue Jean Corona, FR-69120 VAULX-EN-VELIN

Vaulx-en-Velin, le 23/05/22

Bruno Soulas  
Directeur Stratégie et Développement / Head of Strategy and  
Development

Joséphine Signoles-Fontaine  
Responsable du service QSE / Head of QSE Department



## DECLARATION UE DE CONFORMITE EU DECLARATION OF CONFORMITY

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### Module H / Modul H, N°/ Nr CE-0062-PED-H-SAM 001-23-FRA

**DC012  
2023-06**

Par la présente, SAMSON REGULATION SAS déclare sous sa seule responsabilité pour les produits suivants :  
For the following products, SAMSON REGULATION SAS hereby declares under its sole responsibility:

Appareils / Devices	Type	Exécution / Version	Matériel du corps / body Material	PN Class	DN NPS	Fluides / fluids	
Vanne de régulation passage droit / globe valve	3241	DIN	Fonte grise & fonte sphéroïdale / cast iron & spheroidal graphite iron	PN 16	DN 150	G2, L1, L2 <sup>1)</sup>	
		ANSI		Cl 125	NPS 6		
		DIN	Fonte sphéroïdale / spheroidal graphite iron	PN 25	DN 100 – 150		
		DIN	Acier / steel	PN10	DN 125 – 150		Tous fluides / all fluids
				PN16	DN 65 – 150		
ANSI	Acier / steel	PN25	DN 50 – 150				
		PN40	DN 32 – 150				
		Cl 150	NPS 2 ½ – 6				
		Cl 300	NPS 1 ½ – 6				
Vanne de régulation 3 voies / 3-way Valve	3244	DIN	Fonte grise / cast iron	PN 16	DN 150	G2, L1, L2 <sup>1)</sup>	
		DIN	Acier / steel	PN10	DN 125 – 150	Tous fluides / all fluids	
				PN16	DN 65 – 150		
ANSI	Acier / steel	PN25	DN 50 – 150				
		PN40	DN 32 – 150				
		Cl 150	NPS 2 ½ – 6				
		Cl 300	NPS 1 ½ – 6				
Vanne de régulation passage droit / globe valve	3251	DIN	Acier / steel	PN16	DN 65 – 150	Tous fluides / all fluids	
		ANSI		PN25	DN 50 – 150		
Vanne haute pression / High pressure valve	3252	DIN	Acier / steel	PN40 – 400	DN 32 – 150		Tous fluides / all fluids
		ANSI		Cl 150	NPS 2 ½ – 6		
		Cl 300 - 2500	NPS 1 ½ – 6				
Vanne équerre / Angle valve	3256	DIN	Acier / steel	PN40 – 400	DN 32 – 80	Tous fluides / all fluids	
		ANSI		Cl 300 - 2500	NPS 1 ½ – 3		
Vanne à segment sphérique / Segment ball valve	3310	DIN	Acier / steel	PN16	DN 65 – 150		Tous fluides / all fluids
		ANSI		PN40 – 400	DN 32 – 150		
		Cl 150	NPS 2 ½ – 6				
		Cl 300	NPS 1 ½ – 6				
		Cl 300 - 2500	NPS 1 ½ – 6				
Vanne de régulation passage droit / globe valve	3321	DIN	Fonte sphéroïdale / spheroidal graphite iron	PN 25	DN 100	G2, L1, L2 <sup>1)</sup>	
		DIN	Acier / steel	PN16	DN 65 – 100	Tous fluides / all fluids	
				PN40	DN 32 – 100		
ANSI	Acier / steel	Cl 150	NPS 2 ½ – 4				
		Cl 300	NPS 1 ½ – 4				
Vanne de régulation 3 voies / 3-way Valve	3323	DIN	Fonte sphéroïdale / spheroidal graphite iron	PN 25	DN 100		G2, L1, L2 <sup>1)</sup>
		DIN	Acier / steel	PN16	DN 65 – 100	Tous fluides / all fluids	
				PN40	DN 32 – 100		
ANSI	Acier / steel	Cl 150	NPS 2 ½ – 4				
		Cl 300	NPS 1 ½ – 2				
Vanne papillon / Butterfly valve	3331	DIN	Acier / steel	PN10	DN 150 – 400		Tous fluides / all fluids
		ANSI		PN16 – 50	DN 100 – 400		
		Cl 150 – 300	NPS 4 – 16				
Vanne à membrane / Diaphragm valve	3345	ANSI	Fonte grise & fonte sphéroïdale / cast iron & spheroidal graphite iron	P <sub>max</sub> T=70°F 150 psi	NPS 5 – 6	G2, L1, L2 <sup>1)</sup>	
				P <sub>max</sub> T=70°F 230 psi	NPS 6		
		Acier / steel	P <sub>max</sub> T=70°F 150 - 230 psi	NPS 2 ½ – 6			



## DECLARATION UE DE CONFORMITE EU DECLARATION OF CONFORMITY

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Module H / Modul H, N°/ Nr CE-0062-PED-H-SAM 001-23-FRA

DC012  
2023-06

Appareils / Devices	Type	Exécution / Version	Matériel du corps / body Material	PN Class	DN NPS	Fluides / fluids
Vanne alimentaire / Sanitary valve	3347	DIN	Acier / steel	P <sub>max</sub> T = 20°C 16 bar DN 65 – 150 DN 32 – 150	DN 150 DN 65 – 150 DN 32 – 150	G2, L1, L2 <sup>1)</sup>
		ANSI		P <sub>max</sub> T = 20°C 230 psi P <sub>max</sub> T = 70°F 580 psi P <sub>max</sub> T = 70°F 910 psi	NPS 6 NPS 2 1/2 – 6 NPS 1 1/2 – 6	
Vanne Tout ou Rien / On-Off Valve	3351	DIN	Fonte sphéroïdale / spheroidal graphite iron	PN 25	DN 100	G2, L1, L2 <sup>1)</sup>
		DIN	Acier / steel	PN16 PN25 PN40	DN 65 – 100 DN 50 – 100 DN 32 – 100	Tous fluides / all fluids
		ANSI		Cl 150 Cl 300	NPS 2 1/2 – 4 NPS 1 1/2 – 4	
		DIN	Acier / steel	PN10 PN16 PN25 PN40	DN 400 – 500 DN 250 – 500 DN 150 – 500 DN 125 – 500	G2, L2 <sup>1)</sup>

<sup>1)</sup> Gas selon l'article 4 § 1.c) i) / Gases Acc. to article 4 paragraph 1.c) i)  
Liquide selon l'article 4 § 1.c) ii) / Liquids Acc. to article 4 paragraph 1.c) ii)

la conformité avec le réglage suivant : / the conformity with the following requirement:

La Directive du Parlement Européen et du Conseil d'harmonisation des lois des Etats Membres concernant la mise à disposition sur le marché d'équipements sous pression / Directive of the European Parliament and of the Council on the Harmonization of the laws of the Member States relating of the making available on the market of pressure equipment	2014/68/UE 2014/68/EU	Du / of 15.05.2014
Procédure d'évaluation de la conformité appliquée pour les fluides selon l'Article 4 § 1 Applied conformity assessment procedure for fluids according to Article 4 § 1	Module H / Modul H	Certificat n° CE- 0062-PED-H-SAM 001-23-FRA

Normes techniques appliquées / Technical standards applied :  
DIN EN 12516-2, DIN EN 12516-3, ASME B16.34, DIN-EN 60534-4, DIN-EN 1092-1

Le système de contrôle Qualité du fabricant est effectué par l'organisme de certification suivant :  
The manufacturer's quality management system is monitored by the following notified body:

Bureau Veritas Services SAS N°/Nr 0062, 8 Cours du Triangle, 92800 PUTEAUX - LA DEFENSE  
Fabricant / manufacturer : Samson Régulation SAS, 1, rue Jean Corona, FR-69120 VAULX-EN-VELIN

Vaulx-en-Velin, le 19/06/23

Bruno Soulas  
Directeur Général – Directeur Stratégie et Développement /  
Director general - Head of Strategy and Development

Joséphine Signoles-Fontaine  
Responsable du service QSE / Head of QSE department



SAMSON

## EU-KONFORMITÄTSERKLÄRUNG EU DECLARATION OF CONFORMITY

### Modul A/Module A

SAMSON erklärt in alleiniger Verantwortung für folgende Produkte:/For the following products, SAMSON hereby declares under its sole responsibility:

Geräte/Devices	Bauart/Series	Typ/Type	Ausführung/Version
Durchgangsventil/Globe valve	240	3241	DIN, Gehäuse GG, DN 65-125, Gehäuse GGG, DN 50-80, Fluide G2, L1, L2 <sup>1)</sup> / DIN, body of cast iron, DN 65-125, body of spherical-graphite iron, DN 50-80, fluids G2, L1, L2 <sup>1)</sup>
Durchgangsventil/Globe valve	240	3241	DIN, Gehäuse Stahl u.a., DN 40-100, Fluide G2, L2 <sup>2)</sup> / DIN, body of steel, etc., DN 40-100, fluids G2, L2 <sup>2)</sup>
Durchgangsventil/Globe valve	240	3241	ANSI, Gehäuse GG, Class 250, NPS 1 1/2 bis NPS 2, Class 125, NPS 2 1/2 bis NPS 4, Fluide G2, L1, L2 <sup>1)</sup> / ANSI, body of cast iron, Class 250, NPS 1 1/2 to NPS 2, Class 125, NPS 2 1/2 to NPS 4, fluids G2, L1, L2 <sup>1)</sup>
Dreibegeventil/Three-way valve	240	3244	DIN, Gehäuse GG, DN 65-125, Gehäuse GGG, DN 50-80, Fluide G2, L1, L2 <sup>1)</sup> / DIN, body of cast iron, DN 65-125, body of spherical-graphite iron, DN 50-80, fluids G2, L1, L2 <sup>1)</sup>
Dreibegeventil/Three-way valve	240	3244	DIN, Gehäuse Stahl u.a., DN 40-100, Fluide G2, L2 <sup>2)</sup> / DIN, body of steel, etc., DN 40-100, fluids G2, L2 <sup>2)</sup>
Schrägsitzventil/Angle seat valve	---	3353	DIN, Rotzussgehäuse, alle Fluide DIN, red brass body, all fluids
Schrägsitzventil/Angle seat valve	---	3353	DIN, Gehäuse Stahl, Fluide G2, L1, L2 <sup>1)</sup> / DIN, body of steel, fluids G2, L1, L2 <sup>1)</sup>
Durchgangsventile/Globe valve	V2001	3321	DIN, Gehäuse GG, DN 65-100, Fluide G2, L1, L2 <sup>1)</sup> / DIN, body of cast iron, DN 65-100, fluids G2, L1, L2 <sup>1)</sup>
Durchgangsventile/Globe valve	V2001	3321	ANSI, Gehäuse GG, NPS 2 1/2 bis NPS 4, Fluide G2, L1, L2 <sup>1)</sup> / ANSI, body of cast iron, NPS 2 1/2 to NPS 4, fluids G2, L1, L2 <sup>1)</sup>
Dreibegeventil/Three-way valve	V2001	3323	DIN, Gehäuse GG, DN 65-100, Fluide G2, L1, L2 <sup>1)</sup> / DIN, body of cast iron, DN 65-100, fluids G2, L1, L2 <sup>1)</sup>
Dreibegeventil/Three-way valve	V2001	3323	ANSI, Gehäuse GG, NPS 2 1/2 bis NPS 4, Fluide G2, L1, L2 <sup>1)</sup> / ANSI, body of cast iron, NPS 2 1/2 to NPS 4, fluids G2, L1, L2 <sup>1)</sup>
Dreibegeventil/Three-way valve	250	3253	DIN, Gehäuse GG, DN 200 PN 10, Fluide G2, L1, L2 <sup>1)</sup> / DIN, body of cast iron, DN 200 PN 10, fluids G2, L1, L2 <sup>1)</sup>

<sup>1)</sup> Gase nach Art. 4 Abs.1 Pkt. c.) zweiter Gedankenstrich//Gases according to Article 4(1)(c.i), second indent  
Flüssigkeiten nach Art. 4 Abs.1 Pkt. c.iii//Liquids according to Article 4(1)(c.ii)

<sup>2)</sup> Gase nach Art. 4 Abs.1 Pkt. c.i) zweiter Gedankenstrich//Gases according to Article 4(1)(c.i), second indent  
Flüssigkeiten nach Art. 4 Abs.1 Pkt. c.ii) zweiter Gedankenstrich//Liquids according to Article 4(1)(c.ii), second indent

die Konformität mit nachfolgender Anforderung:/that the products mentioned above comply with the requirements of the following standards:

<b>Richtlinie des Europäischen Parlaments und des Rates zur Harmonisierung der Rechtsvorschriften der Mitgliedstaaten über die Bereitstellung von Druckgeräten auf dem Markt/Directive of the European Parliament and of the Council on the harmonization of the laws of the Member States relating to the making available on the market of pressure equipment</b>	2014/68/EU	vom 15. Mai 2014/ of 15 May 2014
<b>Angewandtes Konformitätsbewertungsverfahren für Fluide nach Art. 4 Abs. 1/ Applied conformity assessment procedure for fluids according to Article 4(1)</b>	Modul A/Module A	

Angewandte technische Spezifikation/Technical standards applied: DIN EN 12516-2, DIN EN 12516-3, ASME B16.34

Hersteller/Manufacturer: **SAMSON AG, Weismüllerstraße 3, 60314 Frankfurt am Main, Germany**

Frankfurt am Main, 23. Februar 2017/23 February 2017

*i. v. Klaus Horschken*

Klaus Horschken  
Zentralabteilungsleiter/Head of Central Department  
Entwicklung Ventile und Antriebe/R&D, Valves and Actuators

*Dr. Michael Heß*

Dr. Michael Heß  
Zentralabteilungsleiter/Head of Central Department  
Product Management & Technical Sales

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Revision 02



EU DECLARATION OF CONFORMITY  
TRANSLATION



**Module D / N° CE-0062-PED-D-SAM 001-22-DEU**

For the following products, SAMSON hereby declares under its sole responsibility:

Devices	Series	Type	Version
Control valve for hot water and steam with fail-safe action in heating systems	Actuator 3374-21/-26 (Force 2000 N)		with Type 3241, 2811, 2814, 2823, 3321 EU-Type examination (production type), Module B, Certificate no.: 01 202 931/B-15-0030-01, type-tested according to standard DIN EN 14597:2015
Control valve for water and water-steam with fail-safe action in heating systems	Actuator 5725-310/-313/-320/-323 5725-810/-820 5825-10/-13/-20/-23 (Force 500 N) (Product number 2770)		with Type 3214 (2814), 2423 (2823), 3213 (2710), 3222 (2710), 2488 (2730), 2489 (2730) EU-Type examination (production type), Module B, Certificate no.: 01 202 641/B-19-0017-01 type-tested according to standard DIN EN 14597:2015, appendix DX

that the products mentioned above comply with the requirements of the following standards:

Directive of the European Parliament and of the Council on the harmonization of the laws of the Member States relating to the making available on the market of pressure equipment	2014/68/EU	of 15 May 2014
Applied conformity assessment procedure for fluids according to Article 4(1)	Module D	Certificate-No.: N°CE-0062-PED-D-SAM 001-22-DEU by Bureau Veritas 0062

The manufacturer's quality management system is monitored by the following notified body:  
Bureau Veritas Services SAS, 8 Cours du Triangle, 92800 PUTEAUX – LA DEFENSE

Applied harmonised standards and technical specifications: EN 12516-2, EN 12516-3, EN 12266-1, ASME B16.34

Manufacturer: SAMSON AKTIENGESELLSCHAFT, Weismüllerstraße 3, 60314 Frankfurt am Main, Germany

Frankfurt am Main, 15<sup>th</sup> November 2022

Dr. Andreas Widl  
Chief Executive Officer (CEO)

Dr. Thomas Steckenreiter  
Chief Technology Officer (CTO)

Revision 09

Classification: Public · SAMSON AKTIENGESELLSCHAFT · Weismüllerstraße 3 · 60314 Frankfurt am Main, Germany

Page 1 of 1

# EU DECLARATION OF CONFORMITY TRANSLATION



## Module H / N° CE-0062-PED-H-SAM 001-22-DEU

For the following products, SAMSON hereby declares under its sole responsibility:

Devices	Series	Type	Version
Globe valve	240	3241	EN, body of gray cast iron from DN 150, body of spheroidal-graphite iron, from DN 100, fluids G2, L1, L2 <sup>1)</sup> EN/ANSI, body of steel, etc., all fluids
Three-way valve	240	3244	EN, body of gray cast iron from DN 150, body of spheroidal-graphite iron, from DN 100, fluids G2, L1, L2 <sup>1)</sup> EN/ANSI, body of steel, etc., all fluids
Cryogenic valve	240	3248	EN/ANSI, all fluids
Globe valve	250	3251	EN/ANSI, all fluids
Globe valve	250	3251-E	EN/ANSI, all fluids
Three-way valve	250	3253	EN/ANSI, body of steel, etc., all fluids
Globe valve	250	3254	EN/ANSI, all fluids
Angle valve	250	3256	EN/ANSI, all fluids
Split-body valve	250	3258	EN, all fluids
Angle valve (IG standards)	250	3259	EN, all fluids
Steam-converting valve	280	3281	EN/ANSI, all fluids
		3284	EN/ANSI, all fluids
		3286	EN/ANSI, all fluids
		3288	EN, all fluids
Globe valve	V2001	3321	EN, body of steel, etc., all fluids ANSI, all fluids
Three-way valve	V2001	3323	EN, body of steel, etc., all fluids ANSI, all fluids
Angle seat valve	---	3353	EN, body of steel, etc., all fluids
Silencer	3381	3381-1	EN/ANSI, single attenuation plate with welding ends, all fluids
		3381-3	EN/ANSI, all fluids
		3381-4	EN/ANSI, single attenuation plate multi-stage with welding ends, all fluids
Globe valve	240	3241	ANSI, body of gray cast iron, Class 125, from NPS 5, fluids G2, L1, L2 <sup>1)</sup>
Cryogenic valve	240	3246	EN/ANSI, all fluids
Three-way valve	250	3253	EN, body of gray cast iron from DN200 PN16, fluids G2, L1, L2 <sup>1)</sup>
Globe valve	290	3291	ANSI, all fluids
Angle valve	290	3296	ANSI, all fluids
Cryogenic valve	---	3588	ANSI, up to NPS 6, Class 600, all fluids
Globe valve	590	3591	ANSI, all fluids
Angle valve	590	3596	ANSI, all fluids
Cryogenic valve	590	3598	ANSI, NPS 3 to NPS 8, Class 900, all fluids
Control valve	590	3595	ANSI, all fluids

<sup>1)</sup> Gases according to Article 4(1)(c.i), second indent  
Liquids according to Article 4(1)(c.ii)

that the products mentioned above comply with the requirements of the following standards:

Directive of the European Parliament and of the Council on the harmonization of the laws of the Member States relating to the making available on the market of pressure equipment	2014/68/EU	of 15 May 2014
Applied conformity assessment procedure for fluids according to Article 4(1)	Module H	Certificate-No.: N°CE-0062-PED-H-SAM 001-22-DEU by Bureau Veritas 0062

The manufacturer's quality management system is monitored by the following notified body:  
Bureau Veritas Services SAS, 8 Cours du Triangle, 92800 PUTEAUX – LA DEFENSE  
Applied harmonised standards and technical specifications: EN 12516-2, EN 12516-3, EN 12266-1, ASME B16.34

Manufacturer: SAMSON AKTIENGESELLSCHAFT, Weismüllerstrasse 3, 60314 Frankfurt am Main, Germany

Frankfurt am Main, 15<sup>th</sup> November 2022

  
Dr. Andreas Widl  
Chief Executive Officer (CEO)

  
Dr. Thomas Steckenreiter  
Chief Technology Officer (CTO)

Revision 10

Classification: Public · SAMSON AKTIENGESELLSCHAFT · Weismüllerstrasse 3 · 60314 Frankfurt am Main, Germany Page 1 of 1



## EU DECLARATION OF CONFORMITY

DC030  
2020-07

### Declaration of Conformity of Final Machinery

in accordance with Annex II, section 1. A. of the Directive 2006/42/EC

For the following products:

#### **Type 3321CT Globe Valve in combination with Type 3379 Pneumatic Actuator**

We hereby declare that the machinery mentioned above complies with all applicable requirements stipulated in Machinery Directive 2006/42/EC.

For product descriptions of the valve and actuator, refer to:

- Type 3321CT Valve: Mounting and Operating Instructions EB 8115
- Type 3379 Actuator: Mounting and Operating Instructions EB 8315

Valve accessories (e.g. positioners, limit switches, solenoid valves, lock-up valves, supply pressure regulators, volume boosters and quick exhaust valves) are classified as machinery components in this declaration of conformity and do not fall within the scope of the Machinery Directive as specified in § 35 and § 46 of the Guide to Application of the Machinery Directive 2006/42/EC issued by the European Commission. In the SAMSON Manual H 02 titled "Appropriate Machinery Components for SAMSON Pneumatic Control Valves with a Declaration of Conformity of Final Machinery", SAMSON defines the specifications and properties of appropriate machinery components that can be mounted onto the above specified final machinery.

Referenced technical standards and/or specifications:

- VCI, VDMA, VGB: "Leitfaden Maschinenrichtlinie (2006/42/EG) — Bedeutung für Armaturen, Mai 2018" [German only]
- VCI, VDMA, VGB: "Zusatzdokument zum „Leitfaden Maschinenrichtlinie (2006/42/EG) — Bedeutung für Armaturen vom Mai 2018" [German only], based on DIN EN ISO 12100:201 1-03

Comment:

Information on residual risks of the machinery can be found in the mounting and operating instructions of the valve and actuator as well as in the referenced documents listed in the mounting and operating instructions.

Persons authorized to compile the technical file:

SAMSON REGULATION SAS – 1 rue Jean Corona – FR-69120 VAULX-EN-VELIN  
Vaulx-en-Velin, 30 July 2020

Michael Lachenal-Chevallet  
R&D Manager

Joséphine Signoles-Fontaine  
QSE Manager



## DECLARATION OF INCORPORATION

DC041  
2022-12

### Declaration of Incorporation in compliance with Machinery Directive 2006/42/EC

For the following products:  
**Type 3321CT Globe Valve**

We certify that the Type 3321CT Globe Valves are partly completed machinery as defined in the Machinery Directive 2006/42/EC and that the safety requirements stipulated in Annex I, 1.1.2, 1.1.3, 1.1.5, 1.3.2, 1.3.4 and 1.3.7 are observed. The relevant technical documentation described in Annex VII, part B has been compiled.

Products we supply must not be put into service until the final machinery into which it is to be incorporated has been declared in conformity with the provisions of the Machinery Directive 2006/42/EC.

Operators are obliged to install the products observing the accepted industry codes and practices (good engineering practice) as well as the mounting and operating instructions. Operators must take appropriate precautions to prevent hazards that could be caused by the process medium and operating pressure in the valve as well as by the signal pressure and moving parts.

The permissible limits of application and mounting instructions for the products are specified in the associated data sheets as well as the mounting and operating instructions; the documents are available in electronic form on the Internet at [www.samsongroup.com](http://www.samsongroup.com).

For product descriptions of the valve, refer to Mounting and Operating Instructions EB 8115.

Referenced technical standards and/or specifications:

- VCI, VDMA, VGB: "Leitfaden Maschinenrichtlinie (2006/42/EG) — Bedeutung für Armaturen, Mai 2018" [German only]
- VCI, VDMA, VGB: "Zusatzdokument zum „Leitfaden Maschinenrichtlinie (2006/42/EG) — Bedeutung für Armaturen vom Mai 2018" [German only], based on DIN EN ISO 12100:201 1-03

Comments:

- See mounting and operating instructions for residual hazards.
- Also observe the referenced documents listed in the mounting and operation instructions.

Persons authorized to compile the technical file:  
SAMSON REGULATION SAS – 1 rue Jean Corona – FR-69120 VAULX-EN-VELIN  
Vaulx-en-Velin, 23<sup>rd</sup> December 2022

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Bruno Soulas  
General Director  
Head of Strategy and Development

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Joséphine Signoles-Fontaine  
Head of QSE department



UK DECLARATION OF CONFORMITY

DC062  
2022-12

The Pressure Equipment (Safety) Regulations 2016 Module A

For the following products, SAMSON REGULATION SAS hereby declares under its sole responsibility:

Devices	Type	Version	Body Material	PN Class	DN NPS	Fluids		
Back pressure reducing valve	2371-0	DIN	Steel	P <sub>max</sub> T = 20°C 10 bar	DN 32 – 50	All fluids		
		ANSI		P <sub>max</sub> T= 70°F 150 psi	NPS 1 ¼ – 2			
Pressure reducing valve	2371-1	DIN		P <sub>max</sub> T = 20°C 10 bar	DN 32 – 50			
		ANSI		P <sub>max</sub> T= 70°F 150 psi	NPS 1 ¼ – 2			
Globe valve	2423	à membrane with diaphragm	Cast iron	PN25	DN 65 - 125	G2 /L2 1)		
		à soufflet with bellow	Spheroidal graphite iron	PN25	DN 50 - 125			
Globe valve	3241	DIN	Cast iron	PN16	DN 65 – 100	G2, L1, L2 1)		
		DIN	Cast iron & spheroidal graphite iron	PN25	DN 50 - 100			
		DIN		PN40	DN 40 - 100			
		ANSI	Spheroidal graphite	PN10	DN 125 – 150			
					Cast iron	PN 25	DN 50 - 80	All fluids
						CI 125	NPS 2 ½ - 4	
						CI 250	NPS 1 ½ - 2	
						CI 150	NPS 1 ¼ - 2	
3-way Valve	3244	DIN	Cast iron	PN10	DN 125 – 150	G2, L1, L2 1)		
		DIN	Steel	PN16	DN 65 – 125			
		ANSI		CI 150	NPS 1 ¼ - 2			
Globe valve	3251	DIN	Steel	PN16	DN 32 – 50	All fluids		
		ANSI	PN25	DN 32 – 40				
Angle valve	3256	DIN	Steel	PN16	DN 32 – 50	All fluids		
		ANSI	CI 150	NPS 1 ¼ - 2				
Segment ball valve	3310	DIN	Steel	PN10	DN 40 – 50	All fluids		
		ANSI	PN16	DN 80 – 100				
Globe valve	3321	DIN	Cast iron	PN25	DN 40	G2, L1, L2 1)		
		ANSI		CI 150	NPS 1 ½ – 2			
		DIN	Spheroidal graphite iron	PN16	DN 65 – 100			
		ANSI	Steel	CI 125	NPS 2 ½ - 4			
3-way Valve	3323	DIN	Cast iron : GJL-250	PN16	DN 65 – 100	G2, L1, L2 1)		
		DIN	Spheroidal graphite iron	PN25	DN 50 – 80			
Butterfly valve	3331	DIN	Steel	PN10	DN 100	All fluids		
Diaphragm valve	3345	DIN	Steel	P <sub>max</sub> T = 20°C 10 bar	DN 32 – 100	All fluids		
		ANSI		P <sub>max</sub> T = 20°C 16 bar	DN 32 – 50			
		DIN	Cast iron & spheroidal graphite iron	P <sub>max</sub> T = 20°C 10 bar	DN 125 – 150			
				P <sub>max</sub> T = 20°C 16 bar	DN 65 – 125			
ANSI		P <sub>max</sub> T = 20°C 40 bar	DN 40 – 50					
		P <sub>max</sub> T= 70°F 150 psi	NPS 2 ½ - 4					
				P <sub>max</sub> T= 70°F 230 psi	NPS 2 ½ – 5			
				P <sub>max</sub> T= 70°F 580 psi	NPS 1 ½ – 2			

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Société par actions simplifiée au capital de 10 000 000 € • Siège social : Vaulx-en-Velin  
N° SIRET: RCS Lyon B 788 165 603 00127 • N° de TVA: FR 86 788 165 603 • Code APE 2814Z

BNP Paribas N° compte 0002200215245 • Banque 3000401857  
IBAN FR7630004018570002200215245 • BIC (code SWIFT) BNPFRPP33  
Crédit Lyonnais N° compte 000060035841 • Banque 3000201936  
IBAN FR983000201936000000035841 • BIC (code SWIFT) CRLYFRPP



**UK DECLARATION OF CONFORMITY**

**DC062  
2022-12**

Devices	Type	Version	Body Material	PN Class	DN NPS	Fluids
Sanitary valve	3347	DIN	Steel	P <sub>max</sub> T = 20°C 10 bar	DN 125 – 150	G2, L1, L2 <sup>1)</sup>
		ANSI		P <sub>max</sub> T = 70°F 150 psi	NPS 5 – 6	
Aseptic valve	3349	DIN	Steel	P <sub>max</sub> T = 20°C 10 bar	DN 32 – 100	All fluids
				P <sub>max</sub> T = 20°C 16 bar	DN 32 – 50	
		P <sub>max</sub> T = 20°C 25 bar		DN 32 – 40		
		P <sub>max</sub> T = 70°F 150 psi		NPS 1 ¼ – 4		
ANSI	P <sub>max</sub> T = 70°F 230 psi	NPS 1 ¼ – 2				
	P <sub>max</sub> T = 70°F 360 psi	NPS 1 ¼ – 1 ½				
On-Off Valve	3351	DIN	Steel	PN16	DN 32 – 50	All fluids
		ANSI	Cast iron & spheroidal graphite iron	PN25	DN 32 – 40	
		DIN	Spheroidal graphite iron	CI 150	NPS 1 ¼ – 2	
		ANSI	Cast iron	PN16	DN 65 – 100	
		PN25	DN 50 – 80			
Measure flange	5090	DIN	Steel	CI 125	NPS 2 ½ – 4	G2, L2 <sup>1)</sup>
				PN6	DN 200 – 500	
				PN10	DN 125 – 350	
				PN16	DN 65 – 200	
				PN25	DN 50 – 125	
PN40	DN 40 – 100					

<sup>1)</sup> Gases Acc. to article 4 paragraphs 1.c) i)  
Liquids Acc. to article 4 paragraphs 1.c) ii)

the conformity with the following Union harmonization legislation:

<b>Legislation : STATUTORY INSTRUMENTS – 2016 No. 1105 – CONSUMER PROTECTION HEALTH AND SAFETY – The Pressure Equipment (Safety) Regulations 2016</b>	<b>PE(S)R 2016</b>	<b>2022</b>
<b>Applied conformity assessment procedure for fluids according to Article 4 § 1</b>	<b>2014/68/UE Modul A</b>	

Applied designated standards and technical specifications: EN 12516-2, EN 12516-3, ASME B16.34, EN 60534-4, EN 1092-1

**Manufacturer : Samson Régulation SAS, 1, rue Jean Corona, FR-69120 VAULX-EN-VELIN**

Vaulx-en-Velin, 23<sup>rd</sup> December 2022

Bruno Soulas  
General Director  
Head of Strategy and Development

Joséphine Signoles-Fontaine  
Head of QSE department

WEEEN° FR023645

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Crédit Lyonnais N° compte 0000060035B41 • Banque 3000201936  
IBAN FR893000201936000000035B41 • BIC (code SWIFT) CRLYFRPP



UK DECLARATION OF CONFORMITY

DC064  
2022-12

**The Pressure Equipment (Safety) Regulations 2016 Module H / N° CE-0062-PED-H-SAM 001-20-FRA-rev-A**

For the following products, SAMSON REGULATION SAS hereby declares under its sole responsibility:

Devices	Type	Version	Body Material	PN Class	DN NPS	Fluids
Globe valve	3241	DIN	Cast iron & spheroidal graphite iron	PN 16	DN 150	G2, L1, L2 <sup>1)</sup>
		ANSI		CI 125	NPS 6	
		DIN	Spheroidal graphite iron	PN 25	DN 100 – 150	
		DIN	Steel	PN10 PN16 PN25 PN40	DN 125 – 150 DN 65 – 150 DN 50 – 150 DN 32 – 150	All fluids
ANSI	CI 150 CI 300	NPS 2 ½ - 6 NPS 1 ¼ – 6				
3-way Valve	3244	DIN	Cast iron	PN 16	DN 150	G2, L1, L2 <sup>1)</sup>
		DIN	Steel	PN10 PN16 PN25 PN40	DN 125 – 150 DN 65 – 150 DN 50 – 150 DN 32 – 150	All fluids
		ANSI		CI 150 CI 300	NPS 2 ½ – 6 NPS 1 ¼ – 6	
Globe valve	3251	DIN	Steel	PN16 PN25 PN40 – 400	DN 65 – 150 DN 50 – 150 DN 32 – 150	All fluids
		ANSI		CI 150 CI 300 - 2500	NPS 2 ½ – 6 NPS 1 ¼ – 6	
High pressure valve	3252	DIN	Steel	PN40 – 400	DN 32 – 80	All fluids
		ANSI		CI 300 - 2500	NPS 1 ¼ – 3	
Angle valve	3256	DIN	Steel	PN16 PN40 – 400	DN 65 – 150 DN 32 – 150	All fluids
		ANSI		CI 150 CI 300 - 2500	NPS 2 ½ – 6 NPS 1 ¼ – 6	
Segment ball valve	3310	DIN	Steel	PN10 PN16 PN25 PN40	DN 150 DN 80 – 150 DN 50 – 150 DN 40 – 150	All fluids
		ANSI		CI 150 CI 300	NPS 3 – 6 NPS 1 ½ – 6	
Globe valve	3321	DIN	Spheroidal graphite iron	PN 25	DN 100	G2, L1, L2 <sup>1)</sup>
		DIN	Steel	PN16 PN40	DN 65 – 100 DN 32 – 100	All fluids
		ANSI		CI 150 CI 300	NPS 2 ½ – 4 NPS 1 ¼ – 4	
3-way Valve	3323	DIN	Spheroidal graphite iron	PN 25	DN 100	G2, L1, L2 <sup>1)</sup>
		DIN	Steel	PN16 PN40	DN 65 – 100 DN 32 – 100	All fluids
		ANSI		CI 150 CI 300	NPS 2 ½ – 4 NPS 1 ¼ – 2	
Butterfly valve	3331	DIN	Steel	PN10 PN16 – 50	DN 150 – 400 DN 100 – 400	All fluids
		ANSI		CI 150 – 300	NPS 4 – 16	
Diaphragm valve	3345	ANSI	Cast iron & spheroidal graphite iron	P <sub>max</sub> T= 70°F 150 psi	NPS 5 – 6	G2, L1, L2 <sup>1)</sup>
				P <sub>max</sub> T= 70°F 230 psi	NPS 6	
			Steel	P <sub>max</sub> T= 70°F 150 - 230 psi	NPS 2 ½ – 6	All fluids

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BNP Paribas N° compte 0002200215245 • Banque 3000401857  
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Crédit Lyonnais N° compte 0000600035841 • Banque 3000201936  
IBAN FR983000201936000000035841 • BIC (code SWIFT) CRLYFRPP



UK DECLARATION OF CONFORMITY

DC064  
2022-12

Devices	Type	Version	Body Material	PN Class	DN NPS	Fluids
Sanitary valve	3347	DIN	Steel	P <sub>max</sub> T = 20°C 16 bar P <sub>max</sub> T = 20°C 40 bar P <sub>max</sub> T = 20°C 63 bar	DN 150 DN 65 – 150 DN 32 – 150	G2, L1, L2 <sup>1)</sup>
		ANSI		P <sub>max</sub> T = 70°F 230 psi P <sub>max</sub> T = 70°F 580 psi P <sub>max</sub> T = 70°F 910 psi	NPS 6 NPS 2 ½ – 6 NPS 1 ½ – 6	
Aseptic valve	3349	DIN	Steel	P <sub>max</sub> T = 20°C 16 bar P <sub>max</sub> T = 20°C 25 bar	DN 65 – 100 DN 50 – 100	All fluids
		ANSI		P <sub>max</sub> T = 70°F 230 psi P <sub>max</sub> T = 70°F 360 psi	NPS 2 ½ – 4 NPS 2 – 4	
On-Off Valve	3351	DIN	Spheroidal graphite iron	PN 25	DN 100	G2, L1, L2 <sup>1)</sup>
		DIN	Steel	PN16 PN25 PN40	DN 65 – 100 DN 50 – 100 DN 32 – 100	All fluids
		ANSI		CI 150 CI 300	NPS 2 ½ – 4 NPS 1 ½ – 4	
Measure flange	5090	DIN	Steel	PN10	DN 400 – 500	G2, L2 <sup>1)</sup>
				PN16	DN 250 – 500	
				PN25	DN 150 – 500	
				PN40	DN 125 – 500	

<sup>1)</sup> Gases Acc. to article 4 paragraphs 1.c) i)  
Liquids Acc. to article 4 paragraphs 1.c) ii)

the conformity with the following Union harmonization legislation:

Legislation : STATUTORY INSTRUMENTS – 2016 No. 1105 – CONSUMER PROTECTION HEALTH AND SAFETY – The Pressure Equipment (Safety) Regulations 2016	PE(S)R 2016	2022
Applied conformity assessment procedure for fluids according to Article 4 § 1	2014/68/UE Modul H	Certificate n° CE-0062-PED- H-SAM 001-20- FRA-rev-A

Applied designated standards and technical specifications: EN 12516-2, EN 12516-3, ASME B16.34, EN 60534-4, EN 1092-1

The manufacturer's quality management system is monitored by the following notified body:  
**Bureau Veritas Services SAS N°/Nr 0062, 8 Cours du Triangle, 92800 PUTEAUX - LA DEFENSE**

**Manufacturer : Samson Régulation SAS, 1, rue Jean Corona, FR-69120 VAULX-EN-VELIN**

Vaulx-en-Velin, 23<sup>rd</sup> December 2022

Bruno Soulas  
General Director  
Head of Strategy and Development

Joséphine Signoles-Fontaine  
Head of QSE department

WEEEN° FR002645

SAMSON REGULATION SAS • 1 rue Jean Corona • 69120 Vaulx-en-Velin  
Tel.: +33 (0)4 72 04 75 00 • E-mail: france@samsongroup.com • Internet: www.samson.fr

Société par actions simplifiée au capital de 10 000 000 € • Siège social : Vaulx-en-Velin  
N° SIRET: RCS Lyon B 788 165 603 00127 • N° de TVA: FR 86 788 165 603 • Code APE 2814Z

BNP Paribas N° compte 0002200215245 • Banque 3000401857  
IBAN FR7630004018570002200215245 • BIC (code SWIFT) BNPFRPP33

Crédit Lyonnais N° compte 0000060035B41 • Banque 3000201936  
IBAN FR893000201936000000035B41 • BIC (code SWIFT) CRLYFRPP





# UK DECLARATION OF CONFORMITY

DC049  
2022-12

## Declaration of Conformity of Final Machinery

in accordance with Annex II, section 1. A. of the Machinery (Safety) Regulations 2008

For the following products:

### Type 3321CT Globe Valve in combination with Type 3379 Pneumatic Actuator

We hereby declare that the machinery mentioned above complies with all applicable requirements stipulated in Machinery (Safety) Regulations 2008.

For product descriptions of the valve and actuator, refer to:

- Type 3321CT Valve: Mounting and Operating Instructions EB 8115
- Type 3379 Actuator: Mounting and Operating Instructions EB 8315

Valve accessories (e.g. positioners, limit switches, solenoid valves, lock-up valves, supply pressure regulators, volume boosters and quick exhaust valves) are classified as machinery components in this declaration of conformity and do not fall within the scope of the Machinery Directive as specified in § 35 and § 46 of the Guide to Application of the Machinery (Safety) Regulations 2008. In the SAMSON Manual H 02 titled "Appropriate Machinery Components for SAMSON Pneumatic Control Valves with a Declaration of Conformity of Final Machinery", SAMSON defines the specifications and properties of appropriate machinery components that can be mounted onto the above specified final machinery.

Referenced technical standards and/or specifications:

- VCI, VDMA, VGB: "Leitfaden Maschinenrichtlinie (2006/42/EG) — Bedeutung für Armaturen, Mai 2018" [German only]
- VCI, VDMA, VGB: "Zusatzdokument zum „Leitfaden Maschinenrichtlinie (2006/42/EG) — Bedeutung für Armaturen vom Mai 2018" [German only], based on DIN EN ISO 12100:201 1-03

Comment:

Information on residual risks of the machinery can be found in the mounting and operating instructions of the valve and actuator as well as in the referenced documents listed in the mounting and operating instructions.

Persons authorized to compile the technical file:

SAMSON REGULATION SAS – 1 rue Jean Corona – FR-69120 VAULX-EN-VELIN  
Vaulx-en-Velin, 23<sup>rd</sup> December 2022

Bruno Soulas  
General Director  
Head of Strategy and Development

Joséphine Signoles-Fontaine  
Head of QSE department

WEEE N° FR029845

SAMSON REGULATION SAS • 1 rue Jean Corona • 69120 Vaulx-en-Velin  
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Société par actions simplifiée au capital de 10 000 000 € • Siège social : Vaulx-en-Velin  
N° SIRET: RCS Lyon B 788 165 603 00127 • N° de TVA: FR 86 788 165 603 • Code APE 2814Z

BNP Paribas N° compte 0002200215245 • Banque 3000401857  
IBAN FR7630004018570002200215245 • BIC (code SWIFT) BNPAPRPPVBE  
Crédit Lyonnais N° compte 0000060035841 • Banque 3000201936  
IBAN FR9830002019360000060035841 • BIC (code SWIFT) CRLYFRPP



## UK DECLARATION OF INCORPORATION

DC057  
2022-12

### Declaration of Incorporation of Partly Completed Machinery

In accordance with Schedule 2 Part 2 Annex II, section 1.B of the Directive 2008 No. 1597 Supply of Machinery (Safety) Regulations 2008

For the following products:

#### Type 3321CT Globe Valve

We certify that the Type 3321CT Globe Valves are partly completed machinery as defined in the Directive 2008 No. 1597 Supply of Machinery (Safety) Regulations 2008 and that the safety requirements stipulated in Annex I, 1.1.2, 1.1.3, 1.1.5, 1.3.2, 1.3.4 and 1.3.7 are observed. The relevant technical documentation described in Annex VII, (Part 7 of Schedule 2) part B has been compiled.

Products we supply must not be put into service until the final machinery into which it is to be incorporated has been declared in conformity with the provisions of the Directive 2008 No. 1597 Supply of Machinery (Safety) Regulations 2008.

Operators are obliged to install the products observing the accepted industry codes and practices (good engineering practice) as well as the mounting and operating instructions. Operators must take appropriate precautions to prevent hazards that could be caused by the process medium and operating pressure in the valve as well as by the signal pressure and moving parts.

The permissible limits of application and mounting instructions for the products are specified in the associated data sheets as well as the mounting and operating instructions; the documents are available in electronic form on the Internet at [www.samsongroup.com](http://www.samsongroup.com).

For product descriptions of the valve, refer to Mounting and Operating Instructions EB 8115.

Referenced technical standards and/or specifications:

- VCI, VDMA, VGB: "Leitfaden Maschinenrichtlinie (2006/42/EG) — Bedeutung für Armaturen, Mai 2018" [German only]
- VCI, VDMA, VGB: "Zusatzdokument zum „Leitfaden Maschinenrichtlinie (2006/42/EG) — Bedeutung für Armaturen vom Mai 2018" [German only], based on DIN EN ISO 12100:201 1-03

Comments:

- See mounting and operating instructions for residual hazards.
- Also observe the referenced documents listed in the mounting and operation instructions.

Persons authorized to compile the technical file:

SAMSON REGULATION SAS – 1 rue Jean Corona – FR-69120 VAULX-EN-VELIN  
Vaulx-en-Velin, 23<sup>rd</sup> December 2022

Bruno Soulas  
General Director  
Head of Strategy and Development

Joséphine Signoles-Fontaine  
Head of QSE department



**DECLARATION OF CONFORMITY**

For the following product

**DC021**

**2022-05**

**Industrial valves in special execution with seals and packings for food contact types 3241, 3321 CT, 3310, 3351 and 3252**

Seals and packings comply with:

- European Regulation (EC) No. 1935/2004
- American rules FDA 21 CFR §177.1550 (PTFE) & §177.2415 (PEEK) & §177.2600 (Rubber).

Grease used for the assembly of parts in contact with the fluid is in conformity with the requirements of NSF-H1.

On 02/05/22

SAMSON REGULATION S.A.S.

A handwritten signature in blue ink, appearing to read "Soulas", written over a horizontal line.

Bruno Soulas  
Director of Strategy and Innovation

A handwritten signature in blue ink, appearing to read "J. Signoles-Fontaine", written over a horizontal line.

Joséphine Signoles-Fontaine  
QSE Manager



**DECLARATION OF CONFORMITY**

For the following product

**DC022**

**2022-05**

**Industrial valves in special execution used in food or pharmaceutical environment types 3241, 3321 CT, 3310, 3351 and 3252.**

For these valves, the materials (seals, glands and bodies), the preparation of the parts and the conditions of assembly are in accordance with:

- European Regulation (EC) No. 1935/2004
- American rules FDA 21 CFR §177.1550 (PTFE) & §177.2415 (PEEK) & §177.2600 (Rubber).

Grease used for the assembly of parts in contact with the fluid is in conformity with the requirements of NSF-H1.

Metals used for the metal components of the valve(s) listed above and in contact with the fluid belong to the list of AISI 300 series materials recognized by the FDA.

On 02/05/22

SAMSON REGULATION S.A.S.

A handwritten signature in blue ink, appearing to read "Soulas", written over a horizontal line.

Bruno Soulas  
Director of Strategy and Innovation

A handwritten signature in blue ink, appearing to read "J. Signoles-Fontaine", written over a horizontal line.

Joséphine Signoles-Fontaine  
QSE Manager



## DECLARATION OF CONFORMITY

For the following products

DC016

2019-08

### Type 3241, 3244, 3249, 3251, 3252, 3256, 3347, 3321, 3349 Control Valve

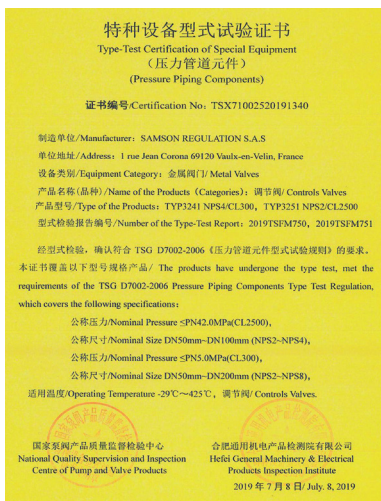
Certificate nb°: **TSX71002520191340**

Test report nb°: **2019TSFM750-TYP3241  
and 2019TSFM751-TYP3251**

Valves 3241 and 3251 have passed the evaluation tests according to the requirements of TSG D7002-2006 Chinese Pressure Equipment.

As a result, all of the above check valves meet the requirements of TSG D7002-2006 for Chinese pressure equipment according to the following characteristics:

- DN 50 to 200 PN ≤ 5 MPa (50 bar) or NPS 2 to NPS 8 Class ≤ 300,
- DN 50 to 100 PN ≤ 42 MPa (420 bar) or NPS 2 to NPS 4 Class ≤ 2500,
- Operating temperature: -29°C ≤ T ≤ 425°C.



SAMSON REGULATION S.A.

Bruno Soulas  
Head of Administration

SAMSON REGULATION S.A.

Joséphine Signoles-Fontaine  
QSE Manager



## 15 Annex

### 15.1 Tightening torques

**Note concerning the following specifications:**

- All tightening torques specified in Nm
- Tightening torque tolerance:  $\pm 10\%$
- The tightening torques are based on a friction coefficient of 0.06 with a lubricated seat thread and facing.
- After long operating times or long periods or use at temperatures above 250 °C, the breakaway torque may be twice as high as the tightening torque.

#### 15.1.1 Tightening torques to install the seat

Valve size			Seats (2) made of 1.4404	
DN	NPS	Thread	Without torque multiplier	With torque multiplier <sup>1)</sup>
15 to 25	½ to 1	M32x1.5	160	– <sup>2)</sup>
32 to 50	1½ to 2	M58x1.5	480	38
65 to 80	2½ to 3	M90x1.5	900	72

<sup>1)</sup> Torque multiplier with gear ratio 1:12.5

<sup>2)</sup> Only use a torque wrench to tighten the seat; do not use an additional torque multiplier.

#### 15.1.2 Tightening torques for connection of body and bonnet

Valve size		Tightening torque for body nut (10)
DN	NPS	
15 to 25	½ to 1	30
32 to 50	1½ to 2	50
65 to 80	2½ to 3	100

### 15.1.3 Tightening torques for connection of plug stem and actuator stems

Valve size		Tightening torque for plug stem (3)
DN	NPS	
15 to 50	½ to 2	4
65 to 80	2½ to 3	20

### 15.1.4 Tightening torques for connection of bonnet and Type 3379 Actuator

Valve size		Tightening torque for valve bonnet (7)
DN	NPS	
15 to 80	½ to 3	50



## 15.2 Lubricants

### **⚠ WARNING**

**Damage to health after contact with hazardous substances.**

Certain lubricants are classified as hazardous substances. These substances have a special label and a material safety data sheet (MSDS) issued by the manufacturer.

- Make sure that an MSDS is available for any hazardous substance used. If necessary, contact the manufacturer to obtain an MSDS.
- Inform operating personnel about the hazardous substances and their correct handling.

### 15.2.1 Recommended lubricant



Application	Quantity [g]	Temperature range in °C	Color	Material no.
Seat thread, valve bonnet, packing, body screws	650	-200 to +220	White	8150-0073

### 15.2.2 Lubricant sorted by parts

Component	Seat	Valve bonnet	Body screw	Packing
Number within drawing	2	7	10	8
Lubricant	8150-0073			



## 15.3 Tools


### 15.3.1 Seat wrenches

Valve size		Tool	Material no.	Image
DN	NPS			
15 to 25	½ to 1	Seat wrench	0440-0065	
32 to 50	1½ to 2	Seat wrench	9110-2464	
65 to 80	2½ to 3	Seat wrench	9110-2467	


### Special tools

The following tools are additionally required to install and remove the seat:


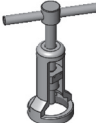
Valve size		Tool	Material no.	Image
DN	NPS			
32 to 80	1½ to 3	Torque multiplier SX30, gear ratio 1:12.5, max. 3000 Nm	9932-3808	
32 to 50	1½ to 2	Torque wrench	9932-3812	

Valve size		Tool	Material no.	Image
DN	NPS			
65 to 80	2½ to 3	Torque wrench	9932-3814	

### 15.3.2 Plug stem tool

Valve size		Tool	Material no.	Image
DN	NPS			
15 to 80	½ to 3	Socket wrench For seats >Ø24 mm	1281-0096	

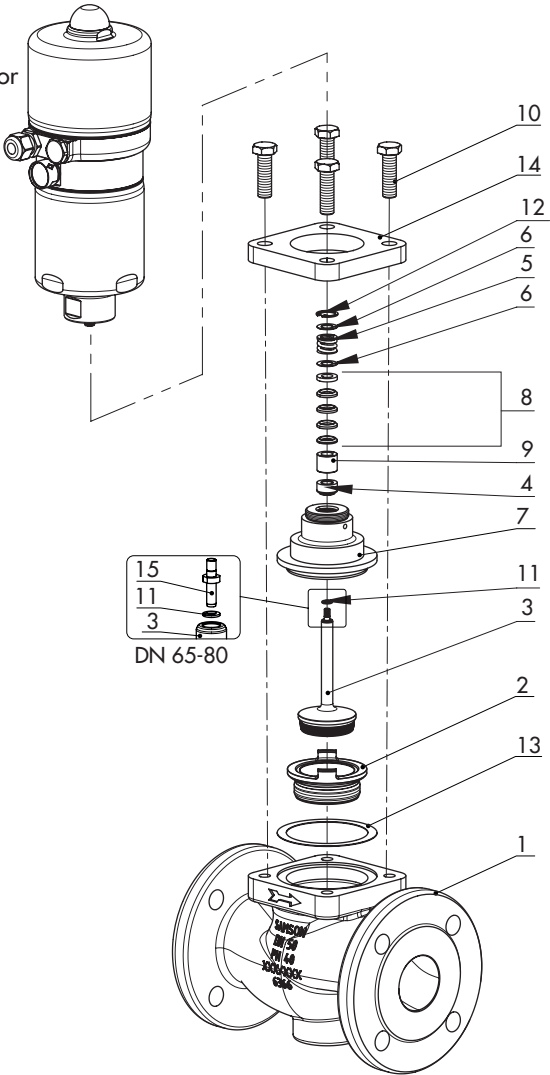
### 15.3.3 Packing extractor

Valve size		Tool	Material no.	Image
DN	NPS			
15 to 40	½ to 1½	Packing extractor	1280-3037	
50 to 80	2 to 3	Packing extractor	1280-3035	
15 to 50	½ to 2	Assembly tool for packing	1281-0094	
65 to 80	2½ to 3	Assembly tool for packing	1281-0145	

## 15.4 Spare parts

- 1 Body
- 2 Seat
- 3 Plug
- 4 Guide bushing
- 5 Spring
- 6 Washer
- 7 Valve bonnet
- 8 Packing
- 9 Spacer
- 10 Screw
- 11 Retaining washer
- 12 Retaining ring
- 13 Body gasket
- 14 Flange
- 15 Centering pin

Type 3379 Actuator



Type 3321CT Valve

## 15.5 After-sales service

Contact our after-sales service for support concerning service or repair work or when malfunctions or defects arise.

### E-mail address

You can reach our after-sales service at [aftersalesservice@samsongroup.com](mailto:aftersalesservice@samsongroup.com).

### Addresses of SAMSON AG and its subsidiaries

The addresses of SAMSON AG, its subsidiaries, representatives and service facilities worldwide can be found on our website ([www.samsongroup.com](http://www.samsongroup.com)) or in all SAMSON product catalogs.

### Required specifications

Please submit the following details:

- Order number and position number in the order
- Type, model number, valve size and valve version
- Pressure and temperature of the process medium
- Flow rate in m<sup>3</sup>/h
- Direction of flow
- Bench range of the actuator (e.g. 0.2 to 1 bar)
- Is a strainer installed?
- Installation drawing

## 15.6 Information on the UK sales region

The following information corresponds to the 2016 Regulations No. 1105 Pressure Equipment (Safety) Regulations 2016, STATUTORY INSTRUMENTS, 2016 No. 1105 (UKCA marking). It does not apply to Northern Ireland.

### Importer

SAMSON Controls Ltd  
Perrywood Business Park  
Honeycrock Lane  
Redhill, Surrey RH1 5JQ

Phone: +44 1737 766391

E-mail: [sales-uk@samsongroup.com](mailto:sales-uk@samsongroup.com)

Website: [uk.samsongroup.com](http://uk.samsongroup.com)









**EB 8115 EN**



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