

INN Type Sample Valve Technical Manual



Steel & O'Brien Manufacturing

7869 Route 98, Arcade, NY 14009

Tel: 585-492-5800 | www.steelobrien.com

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A. General Information

Steel & O'Brien INN type sample valves are specifically designed to be the optimum product sampling solution in the industry. With superior engineering and quality, INN sample valves offer exclusive performance benefits, not found in other alternatives. INN sample valves have been developed with pharmaceutical and sanitary standards in mind, which is reflected in design aspects such as drainability and product contact geometries.

Inline (INN) models are available in ½" – 4" sanitary clamp inlet sizes and offer a variety of hose barb outlet sizes.

B. Part Numbers and Ordering Information

INN Part Number Matrix:

INN SAMPLE VALVE PART NUMBER MATRIX					
TYPE	STEM MATERIAL	O-RING MATERIAL	INLET CONNECTION	OUTLET CONNECTION	ID SURFACE FINISH
INN - INLINE	K - PEEK	E - EPDM	50 - 1/2" TC	A - 1/4" HB	SF1 - 20Ra
			75 - 3/4" TC		
			10 - 1" TC	B - 3/8" HB	
			15 - 1-1/2" TC		
		V - FKM	20 - 2" TC	C - 1/2" HB	SF4 - 15Ra W/ EP
			25 - 2-1/2" TC		
			30 - 3" TC		SF5 - 20Ra W/ EP
			40 - 4" TC		

Part number example:

INKV15ASF1 – In-line sample valve, PEEK stem, FKM seal, 1-1/2" TC inlet, 1/4" hose barb outlet, 20Ra internal surface finish.

For ordering and sales, please contact: SALES@SOB.US

C. TECHNICAL INFORMATION

C.1. Material Specifications

Product contact surfaces:

Body: 316L Stainless Steel

Stem: TECAPEEK® MT Natural PEEK conforming to FDA/USP CLASS VI

O-Ring: EPDM or FKM conforming to FDA/USP CLASS VI

Non product contact surfaces:

Knob: Polytherimide/PEI or PPS black autoclavable thermoplastic

Indicator: Flex500® yellow vinyl

Hardware/Other Misc. Parts: Stainless Steel

C.2. Finish Specifications

Internal surface finishes per ASME BPE (see ordering options):

SF1: 20Ra maximum

SF5: 20Ra maximum with Electropolish

SF4: 15Ra maximum with Electropolish

External surface finish: 32Ra maximum

C.3. Service Conditions

Maximum operating temperature – 300°F

Maximum operating pressure – 250 PSIG

Maximum SWP – 50 PSIG @ 298°F

C.4. Documentation

Types of documentation available (upon request)

- Material test reports (MTR) for 316L product contact surfaces
- Certificate of compliance for FDA/USP Class VI PVDF stem
- Certificate of compliance for FDA/USP Class VI FKM O-Ring
- Certificate of compliance for FDA/USP Class VI EPDM O-Ring
- Internal surface finish certification
- Electropolish certification
- Passivation certification

D. Installation

CAUTION

Proper safety procedures and equipment should be taken into consideration during install, as determined by the installer.

For INN valve styles:

1. Orient valve outlet in a downward direction (see Figure D.1.)
2. Attach sample valve clamp inlet with sanitary clamp and gasket to corresponding clamp face. Use clamp manufacturer's recommended tightening torque when attaching the clamp.

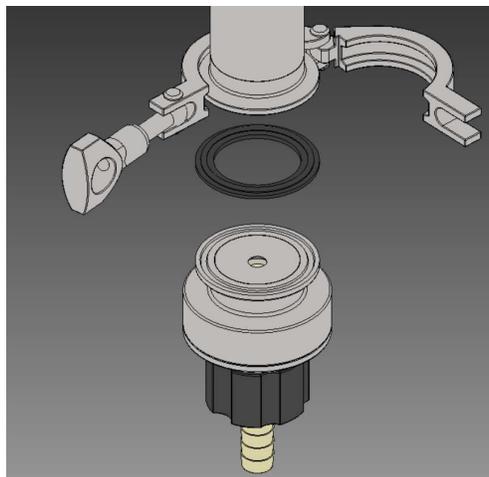


FIGURE D. 1. - SAMPLE VALVE INSTALLATION

Additional notes:

Specific installation parameters of sample valves are to be determined by the installer. Installation orientation of sample valves can vary; however, drain-ability should be taken into account during the installation.

E. Operation

CAUTION

Proper safety procedures and equipment should be taken into consideration during operation, as determined by the end user and/or operator.

Sample valves are not intended for continuous exposure to steam or high temperatures.

Excessive temperature exposure will lead to premature valve failure.

Sample Valves are to be operated by hand *only*. Overtightening or over torquing the valve will damage the valve.

Valve Opening for INN valve styles:

1. Rotate valve knob counterclockwise until desired valve position and outlet flow is achieved.
2. Yellow indicator should be visible upon valve opening (see Figure E.1.)

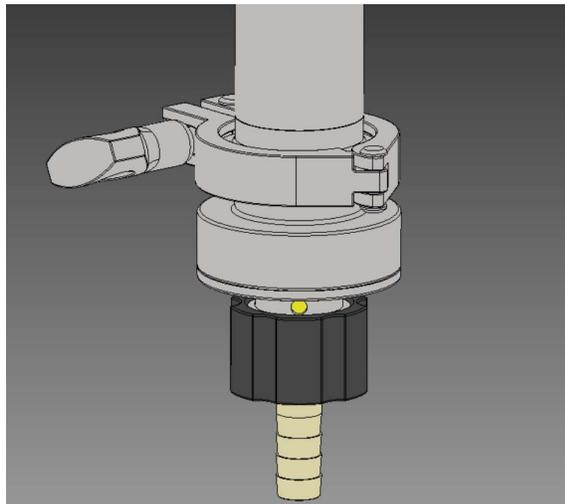


FIGURE E. 1. - SAMPLE VALVE IN OPEN POSITION

Valve Closing for INN valve styles:

1. Rotate valve knob clockwise until snug and no outlet flow is achieved. Operator should ensure that knob is not overtightened.
2. Yellow indicator should not be visible upon valve closing (see Figure E.2.)

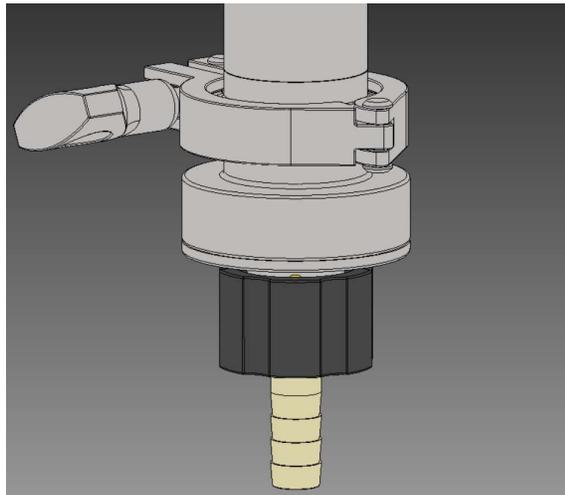


FIGURE E. 2. - SAMPLE VALVE IN CLOSED POSITION

Additional operation notes:

Visible leakage from the valve outlet may indicate potential stem failure.

Visible leakage from the valve indicator or knob area may indicate potential O-ring seal failure.

Any form of leakage suggests immediate action to repair or replace the valve or valve components

F. Maintenance

CAUTION

Proper safety procedures and equipment should be taken into consideration during maintenance as determined by the end user and/or operator.

F.1. Disassembly:

1. Viewing the valve from the outlet end, orient the knob so that the screw heads are visible through the knob fluting (see Figure F.1.)

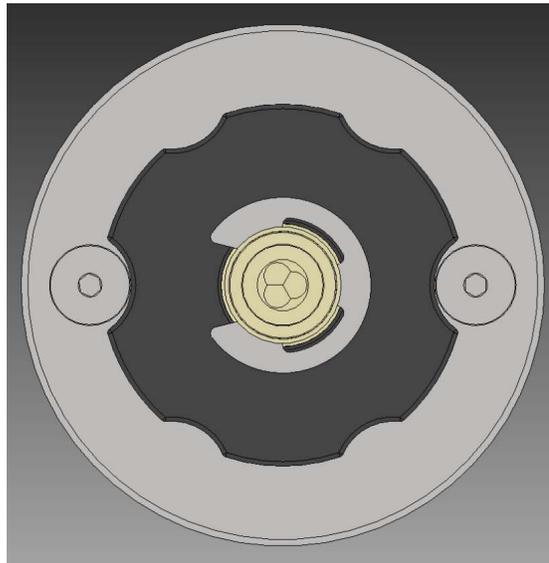


FIGURE F. 1. - KNOB ORIENTATION

2. Loosen screws and remove from valve body and remove (see Figure F.2.)

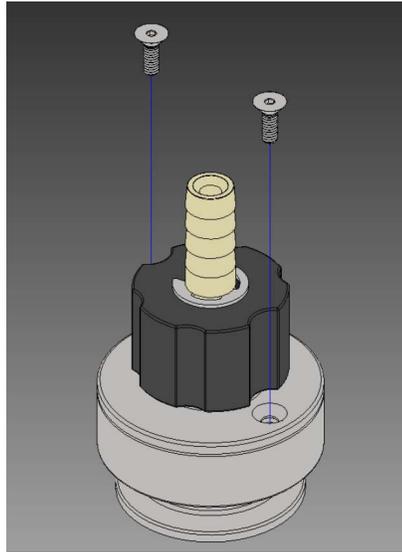


FIGURE F. 2. – SCREW REMOVAL

3. Remove upper half of the valve from the valve body (see Figure F.3.)

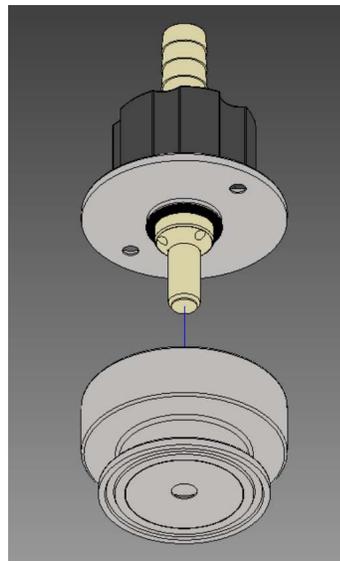


FIGURE F. 3. - TOP HALF REMOVAL

4. Remove the O-ring from the stem. Do not roll O-ring, as this may damage the O-ring. Gently work the O-ring off the stem (see Figure F. 4.)

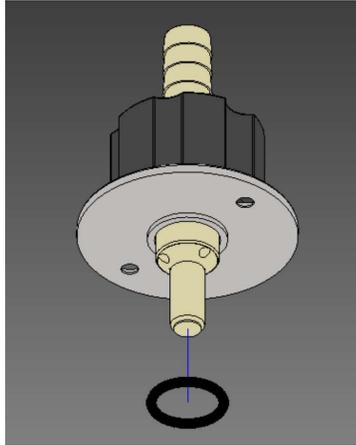


FIGURE F. 4. - O-RING REMOVAL

5. Remove external E-Clip (see Figure F.5.)

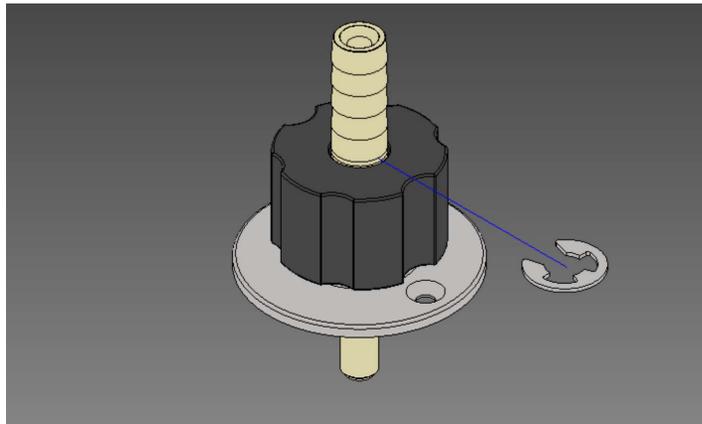


FIGURE F. 5. – EXTERNAL E-CLIP REMOVAL

6. Rotate the knob counterclockwise to remove from the rest of the assembly (see Figure F.6.)

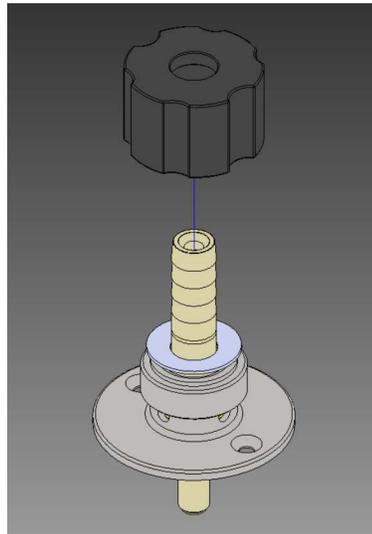


FIGURE F. 6. – KNOB REMOVAL

7. Remove the spring washer (see Figure F.7.)

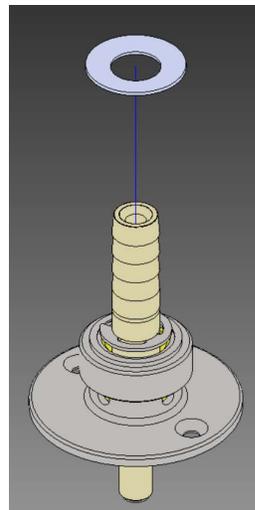


FIGURE F. 7. – SPRING WASHER REMOVAL

8. Remove the internal E-Clip (see Figure F.8.).

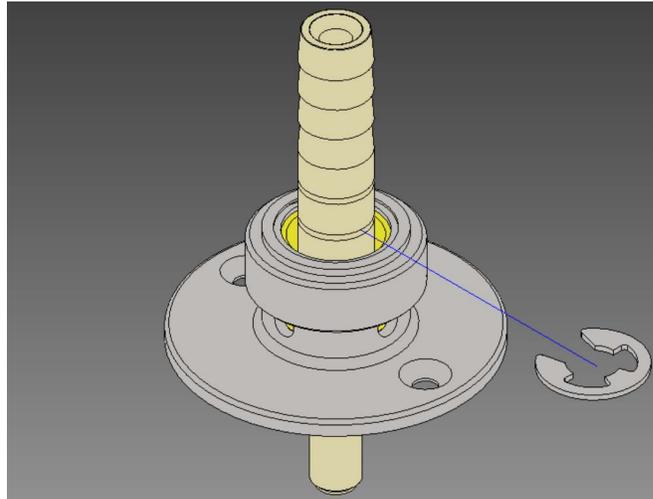


FIGURE F. 8. – INTERNAL E-CLIP REMOVAL

9. Remove the wetted stem (see Figure F.9.).

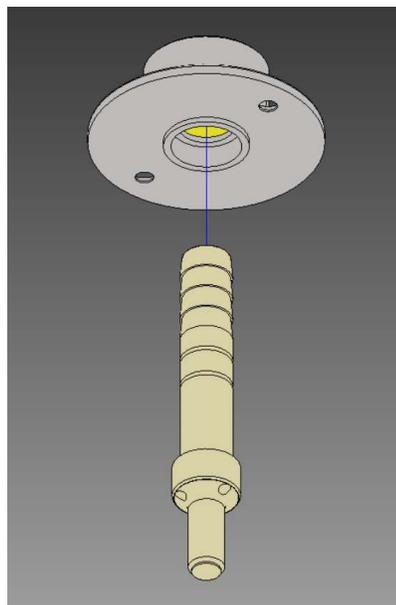


FIGURE F. 9. – STEM REMOVAL

10. OPTIONAL – Remove the internal retaining ring and indicator (see Figure F.10.). This is typically not recommended for usual maintenance, unless for indicator replacement or as required by the user/operator.

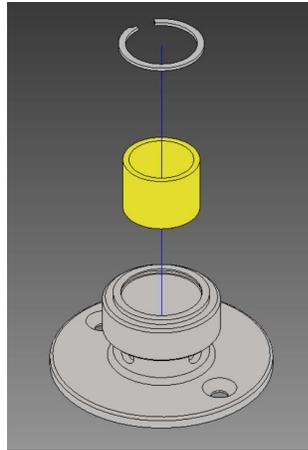


FIGURE F. 10. – INDICATOR REMOVAL

F.2. Assembly:

1. OPTIONAL – If required, install the indicator and internal retaining ring (see Figure F.11.). Typically, this is only required if indicator is missing or needs replacement.

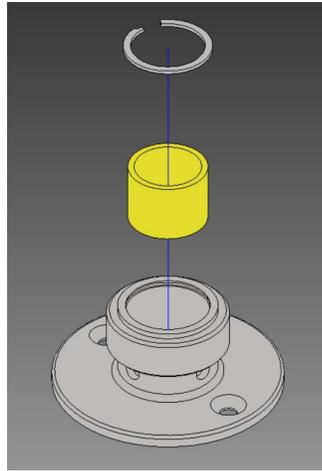


FIGURE F. 11. - INDICATOR INSTALLATION

2. Install the wetted stem (see Figure F.12.)

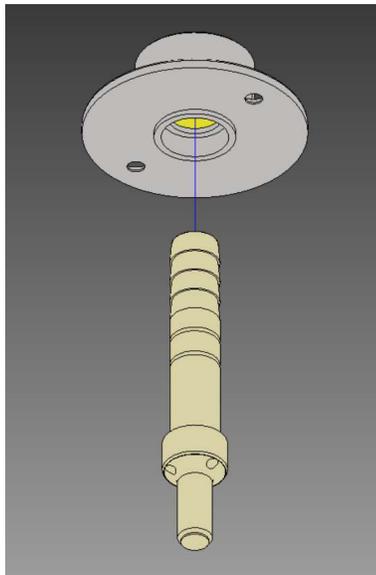


FIGURE F. 12. – STEM INSTALLATION

3. Install the Internal E-Clip (see Figure F.13.)

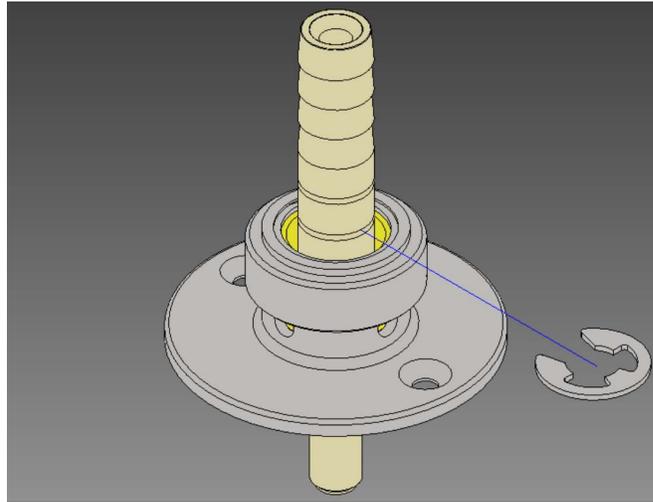


FIGURE F. 13. – INTERNAL E-CLIP INSTALLATION

4. Install the spring washer (see Figure F.14.). Note the orientation of the spring washer.

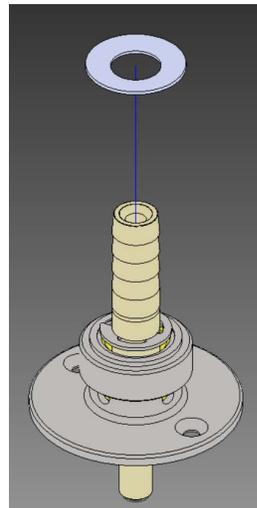


FIGURE F. 14. – SPRING WASHER INSTALLATION

5. Install the knob by screwing in a clockwise direction (see Figure F.15.)

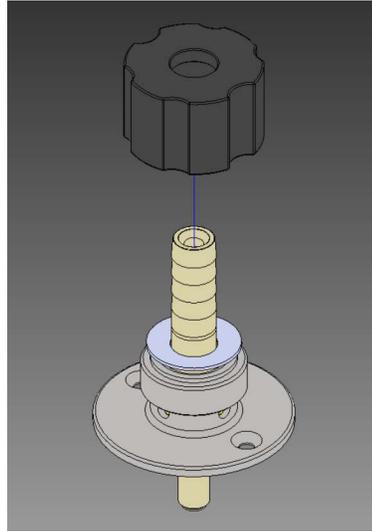


FIGURE F. 15. – KNOB INSTALLATION

6. Install the external E-Clip (see Figure F.16.)

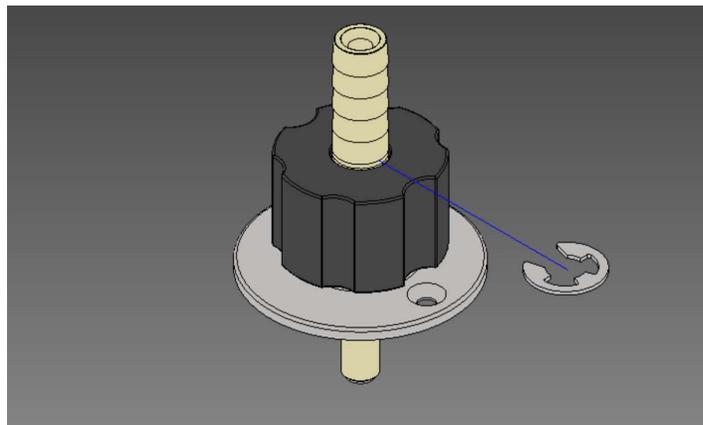


FIGURE F. 16. – EXTERNAL E-CLIP INSTALLATION

7. Install the O-ring onto the stem. Do not roll O-ring, as this may damage the O-ring. Gently work the O-ring onto the stem (see Figure F. 17.)

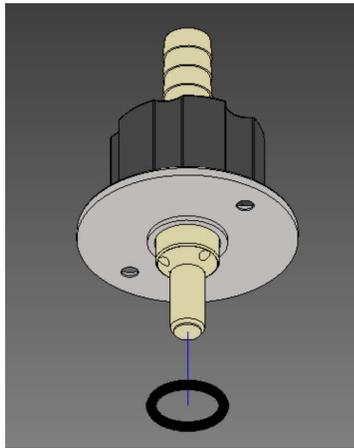


FIGURE F. 17. - O-RING INSTALLATION

11. Join together the upper half of the valve and the valve body (see Figure F.18.).

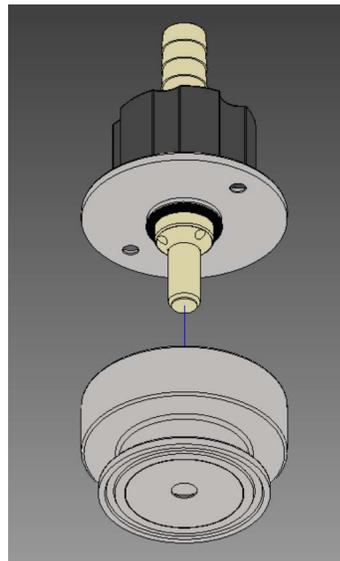


FIGURE F. 18. – TOP HALF INSTALLATION

8. Rotate the valve knob into a position so that the screw holes are visible through the knob fluting (see Figure F. 19.)

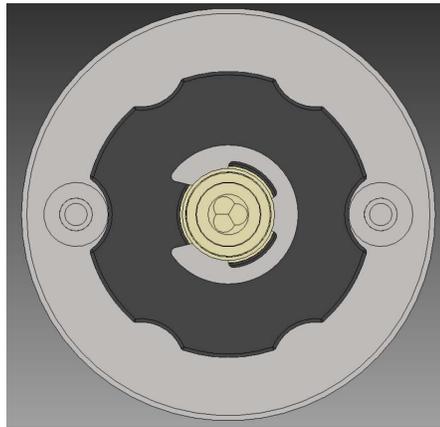


FIGURE F. 19. - KNOB ORIENTATION

9. Thread screws to complete valve assembly (see Figure F.20.). Ensure that screws are tightened evenly to ensure that the O-Ring will not be pinched and the valve stem will not misalign. It is recommended for screws to be tightened a few turns or fractions of a turn in an alternating pattern. Turn until screws are snug. Do not overtighten or over torque.

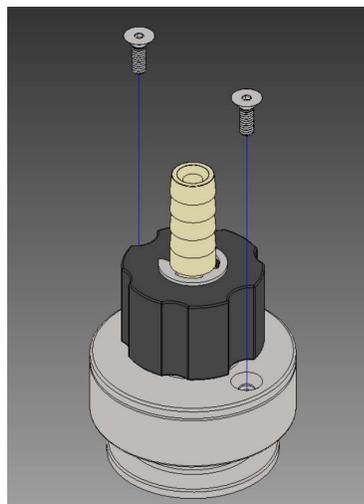
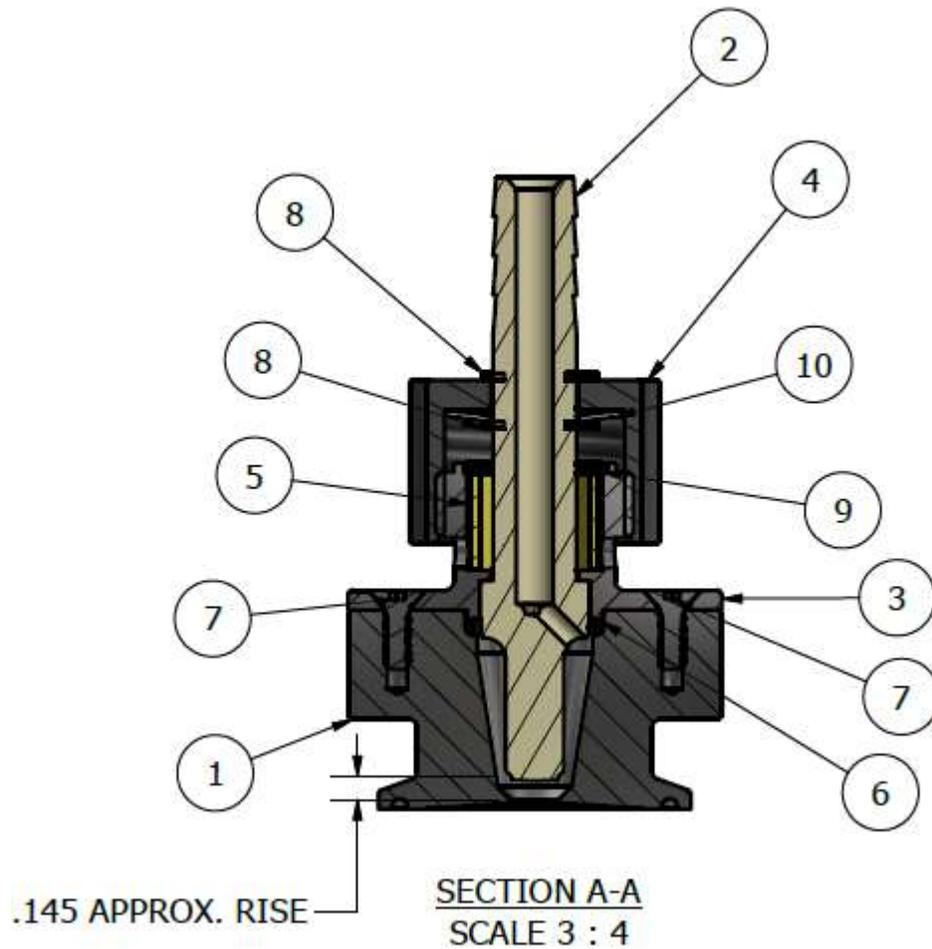


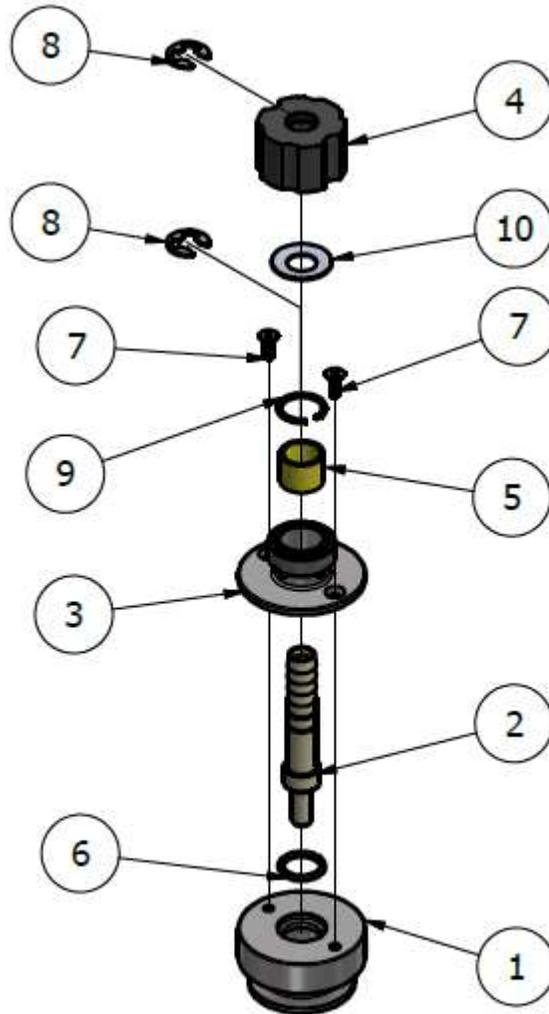
FIGURE F. 20. – SCREW INSTALL

G. Appendix

G.1. INN Valve Cross Section:



G.2. INN Exploded View:



EXPLODED VIEW
SCALE NTS
INN SAMPLE VALVES

G.3. INN Bill of Materials:

ITEM	PART NUMBER	PART	QTY
1	CONTACT SOB FOR REPLACEMENT	VALVE BODY	1
2	CONTACT SOB FOR REPLACEMENT	WETTED STEM	1
3	INNBOD-316L-O	BONNET	1
4	INNKNB-ULT-BLACK-O	KNOB	1
5	INNIND-VINYL-O	INDICATOR	1
6	ORING-115-FDA-2107-EPDM-O OR ORING-115-FDA-V70SW-FKM-O	O-RING (EPDM OR FKM OPTIONS)	1
7	CSSH14-NA-O	SCREW	2
8	INNCLP-304-O	E-CLIP	2
9	INNRING-304-O	INTERNAL RETAINING RING	1
10	BSW9-NA-O	SPRING WASHER	1

For ordering and sales of replacement parts, please contact: SALES@SOB.US

G.4. Revision History:

REVISION NUMBER	NOTES	DATE
1	ORIGINAL RELEASE	10/21/22
2	REV. PART NUMBERS	1/5/23
3	REV. SERVICE CONDITIONS	2/20/23
4	REV. DRAWING	3/22/23