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### Electronic Signatures

Signed by	Meaning of Signature	Server Date (dd-MMM-yyyy HH:mm z)
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# Closure Instructions for Container Valves and Fittings

Per SOP # 20338773

EMD **Electronics** - Haverhill, US



## Instructions

- This document provides open and closure instructions for the valves and fittings on containers in which EMD **Electronics** supplies its products.
- Proper closure of fittings and valves is required for safe handling and transport.
- This document may be used to provide training to personnel responsible for the proper closure of valves and fittings used on containers provided by EMD **Electronics**.
- Additional detail on fittings and valves are also available from the original manufacturer of the valve or fitting.
- References are provided at the end of the document.

## SECTION 1: VALVES

### Swagelok® DS Manual Series Valve



#### Open Position:

Turn handle counterclockwise direction



#### Closed Position:

Torque handle to 36 inch-pounds in clockwise direction

### Swagelok® DP Pneumatic Series Valve



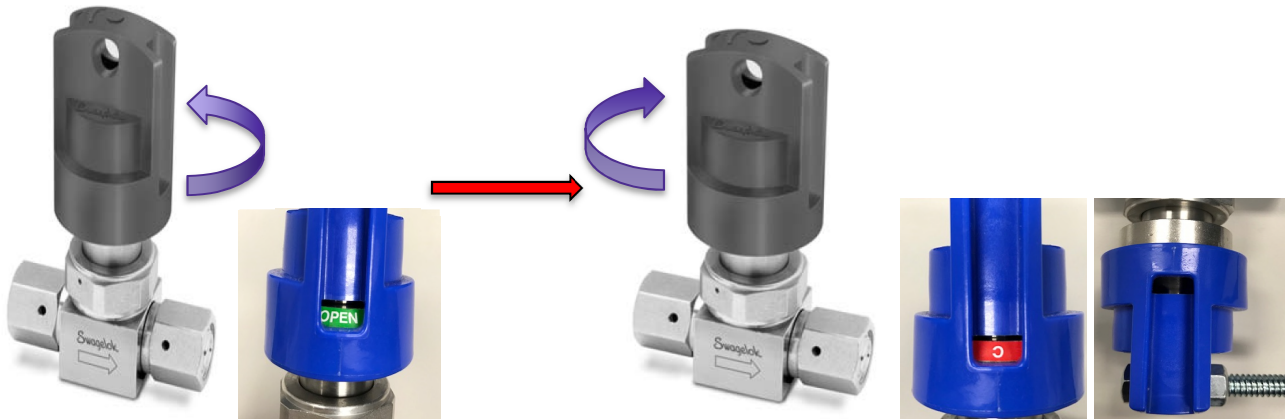
#### Open Position:

Apply between 60-120 psig of gas



#### Closed Position:

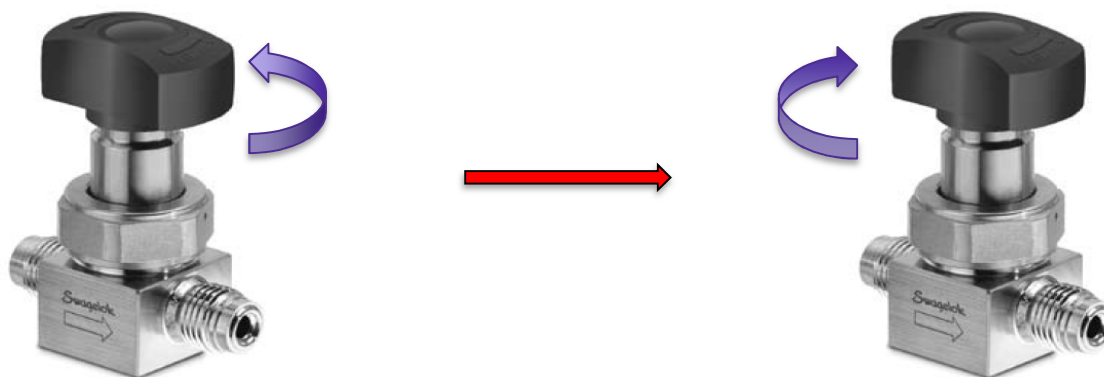
Normally close valve

**SECTION 1: VALVES****Swagelok® DP Manual Integral Series Valve****Open Position:**

Turn handle counterclockwise direction until "Open" window is in view

**Closed Position:**

Turn valve handle 1/4 turn in clockwise direction until "C"/ "Closed" position is in view. Pull valve handle out and lockable in closed position through hole on top of valve handle.

**Swagelok® DP Manual Directional Series Valve****Open Position:**

Turn handle counterclockwise direction

**Closed Position:**

Turn valve handle 1/4 turn in clockwise direction

**SECTION 1: VALVES****Swagelok® HP Pneumatic Series Valve**

**Open Position:**  
Apply between 60-120 psig of gas



**Closed Position:**  
Normally close valve

**AP-Tech® 3550- Pneumatic Series Valve**

**Open Position:**  
Apply between 60-120 psig of gas



**Closed Position:**  
Normally close valve

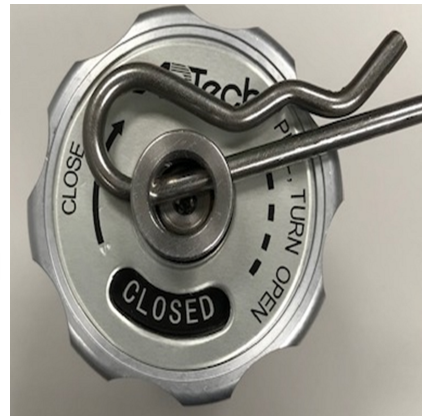
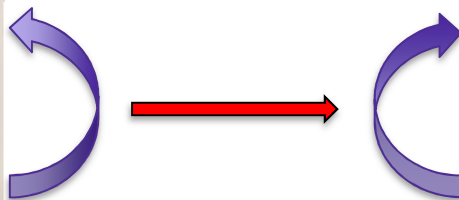
## SECTION 1: VALVES

### AP-Tech® 3657 - Manual Series Valve



#### Open Position:

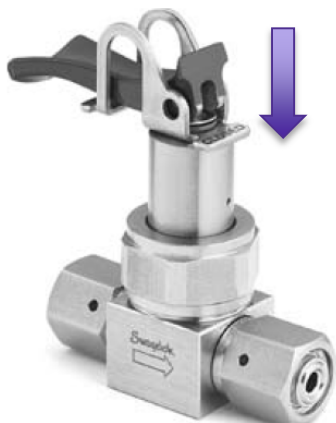
Turn handle counterclockwise direction until "Open" window is in view



#### Closed Position:

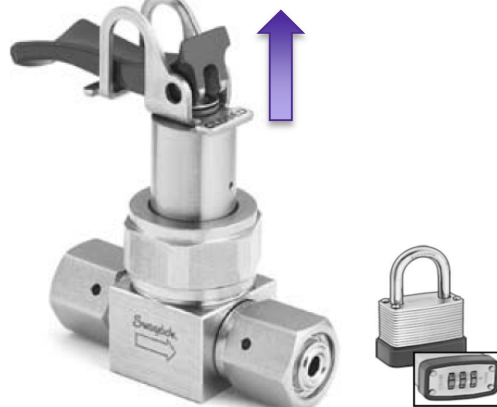
Pull twist knob clockwise direction until "Closed" window is in view. Use pin to lock in closed position

### Swagelok® DP Toggle Series Valve



#### Open Position:

Lift up on handle to open

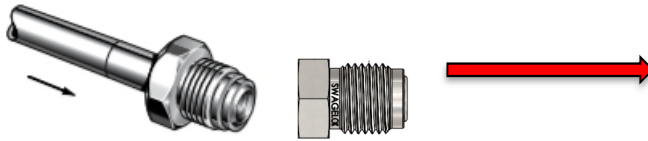


#### Closed Position:

Push down on handle to close. Use a resettable combination padlock on valve when in closed position for safety.

## SECTION 2: FITTINGS

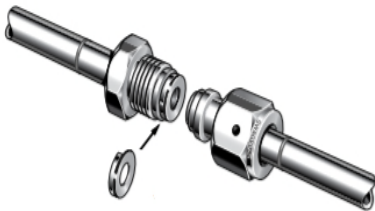
### Swagelok® VCR (Vacuum Coupling Retainer) Fitting/Container Installation Instruction



**Step 1.** Male VCR connection or plug



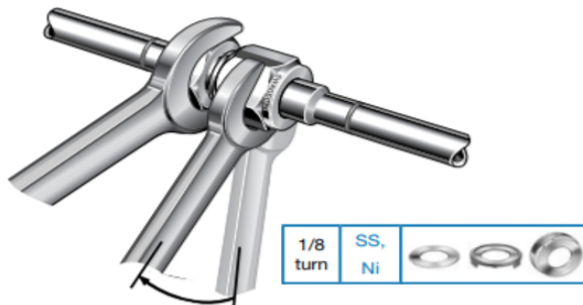
**Step 2.** Female VCR connection or cap.



**Step 3.** Mate two connections together with NEW gasket.



**Step 4.** Finger tight both connections



**Step 5.** 1/8 of a turn on stainless steel and nickel gasket

## SECTION 2: FITTINGS

### Flange top Containers\*

Install or remove bolts in a star pattern *with new gasket from container manufacturer*.  
Do not exceed 94 inch-pounds of torque per bolt.



**\*Customer must not open or close flange top container at flange without additional instruction from EMD Electronics.**

## REFERENCES

SWAGELOK® Website: <https://www.swagelok.com/en/catalog/Valves/Diaphragm-Sealed?N=10000273&nrpp=24&language=en&>

SWAGELOK® Downloads: <https://www.swagelok.com/downloads/WebCatalogs/en/MS-CRD-VCR.PDF>

APTECH Website: <http://aptech-online.com/>

Website: <https://www.emdgroup.com/en/expertise/semiconductors/services/container-return.html>



**For each Effective version, Document owner will raise IT ticket to request upload of new version to this website.**

## APPROVAL

Review, approvals and signatures for this document will be generated electronically using the EDMS. Print a « CONTROLLED » copy if a hardcopy with signature verification is required

## REVISION HISTORY

The latest effective version content is written in black, standard letters (Verdana, 9 pt.). *Changes to the previous effective version content are written in blue, italic letters.* A complete document history is available in the EDMS. A summary of revision changes is tabulated below.

Rev #	Description of change
3.0	<i>Updated from EMD Performance Materials to EMD Electronics</i>
2.0	<b>SECTION 1: Valves</b> <ul style="list-style-type: none"> <li>Added new valve type DP Toggle Series</li> </ul> <b>SECTION 2: FITTINGS</b> <ul style="list-style-type: none"> <li>Removed specific container style and photo of flange top container. This requirement is inclusive of all flange top design types.</li> <li>Added "with new gasket from container manufacturer" to current procedure.</li> </ul> <b>REFERENCE SECTION</b> <ul style="list-style-type: none"> <li>Added EMD website</li> <li>Added requirement to update EMD Website with this procedure after each revision.</li> </ul>
1.0	<ul style="list-style-type: none"> <li>Initial form document</li> </ul>