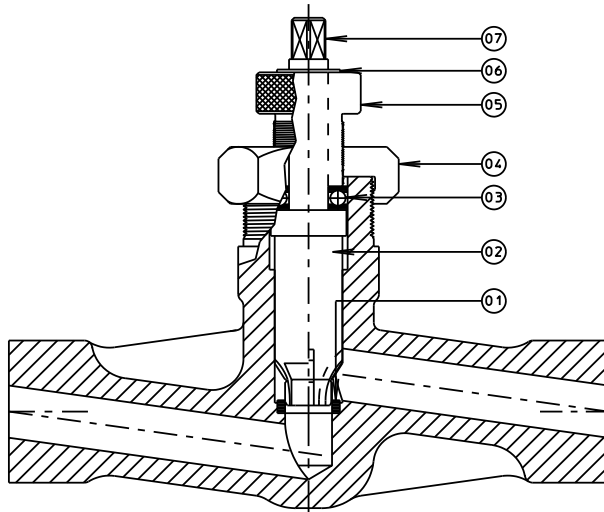


**RESEATING HP VALVES**  
GLOBE VALVES ≤4"



Specially designed reseating tools allow re-cutting of worn or damaged seats without removing the valve body from the line.

Cutters of various size 3/8" - 2" straight type and 3/8" - 4" y-type assure that HP Valves manufactured valves are **cut with the correct angle**

Due to the hardness, solid stellite seats require carbide cutters. These carbide cutters should be handled with great care to prevent from chipping.

Jamming these carbide cutters against the valve seat can cause cutting-chipping, or fracturing of the hard stellite seat.

RENEWING THE SEATING SURFACE

- Disassemble the valve as described in the disassembly instructions.
- Screw the feed screw (05) out of the adaptor (04) as far as possible.
- Insert the tool assembly into the valve body (03) screwing the adaptor (04) to the threaded part located at the valve body.
- Carefully rotate the feed screw (05) clockwise, while rotating the handle (07) clockwise until the cutter (02) lightly contacts the valve seat (01).
- Cut the valve seat (01) by slowly rotating the handle (07) clockwise while applying a steady force with the feed screw (05). Rotate the handle (07) as smoothly as possible (at least 3 revolutions).
- Unscrew the feed screw (05) by rotating it counter clockwise while rotating the handle (07) clockwise.
- Unscrew the adaptor (04), remove the tool assembly and clean it by removing valve seat chips.
- Inspect the seat (01) for a smooth, bright, continuous surface. Repeat the aforementioned steps if necessary, in order to obtain a satisfactory reconditioned seat.