



Valve Concepts, Inc.  
ISO Registered Company

# Model 3200

## Pressure / Vacuum Relief Vent w/ Pipeaway Connection

### SECTION I

#### I. 3000 SERIES DESIGN AND FUNCTION

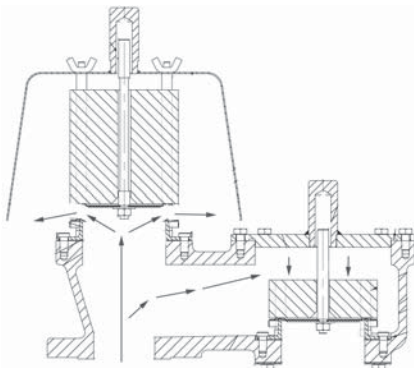
MODEL	P	V	DESCRIPTION
3100	P	V	Vent to Atmosphere
3200	P	V	Vent to Header
3300		V	Top Mounted
3400	P		Vent to Atmosphere
3500	P		Vent to Header
3600		V	Side Mounted
3700	P		Emergency/Manhole Cover

Models 3100 through 3600 Pressure and /or Vacuum Vents are used for the normal venting requirements. Normal venting is defined as venting required because of operational requirements (i.e. filling and emptying the tank) or atmospheric changes. Model 3700 Emergency Relief Vent is used to meet venting required when an abnormal condition, such as an external fire or such as ruptured internal heating coils, exist either outside or inside the tank.

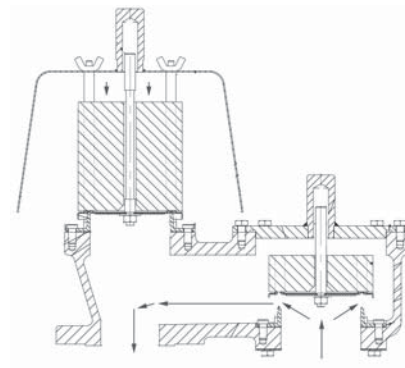
All of these devices are sized in accordance with API Standard 2000. Improperly specified relief vents may result in structural damage to the tank or system and can cause severe personal injury or death.

**Figure 1** illustrates the operation of the Pressure Relief Vent under overpressure conditions. As the tank pressure increases as a result of product being pumped into the tank and/or because of thermal expansion of the product and vapors, the pressure pallet remains closed until the set pressure of the vent is reached. When the tank pressure reaches the pressure setting of the vent, the pressure pallet lifts allowing the tank pressure to bleed off.

**Figure 2** illustrates the operation of the Vacuum Relief Vent under vacuum conditions. As the tank pressure decreases as a result of product being pumped out of the tank and/or because of thermal contraction of the product and vapors, the vacuum pallet remains closed until the set vacuum of the vent is reached. When the tank vacuum reaches the vacuum setting of the vent, the vacuum pallet lifts allowing air to be drawn into the tank.



**Figure 1 - Pressure Relief**



**Figure 2 - Vacuum Relief**

## SECTION II

### II. SAFETY WARNINGS

Tank or system protection is the primary function of the weight loaded Pressure and/or Vacuum Relief Vent. It must be selected to meet the total pressure and vacuum flow requirements within the Maximum Allowable Working Pressure and Vacuum of the system on which it is installed. Consult API Standard 2000 for tank protection sizing procedures. Improperly specified relief vents may result in structural damage to the tank or system and can cause severe personal injury or death.



#### CAUTION

**DO NOT attempt to remove the vent from the tank or process vessel without first bleeding all pressure from the system. ALTERNATIVE MEANS OF PRESSURE RELIEF MUST BE PROVIDED WHEN THE VENT IS OUT OF SERVICE.**



#### CAUTION

**DO NOT change pressure or vacuum setpoints by adding additional weights to the pallet assembly without consulting Cashco Inc. or your VCI representative.**



#### CAUTION

**DO NOT mix pressure/vacuum weight assemblies. Failure to ensure that both weight assemblies are installed in the correct location can change the pressure and vacuum relief settings. This can cause tank failure.**

## SECTION III

### III. INSPECTION AND STORAGE

The pressure/vacuum relief vent is carefully packaged to prevent damage or contamination during shipping. Inspect the equipment when it is received and report any damage to the carrier immediately. The vent should be stored with all the protective flange covers

in place. Make sure that any loading weights that might have been shipped separately, to protect the vent during shipping, are accounted for and stored with the vent. These weights, when required, will be installed during installation. See Section IV.

## SECTION IV

### IV. INSTALLATION



#### WARNING

**The vent must be installed in a vertical position as shown in Figure 1. The tank nozzle on which the vent is mounted should have the same nominal diameter as the venting device. It is recommended that the tank nozzle flange face be within 1 degree of horizontal for best performance of the venting device.**

The 3000 Series Vents are designed to mate with a 150 lb ASME flange. Torque guidelines are provided in Table 1. The Vents are **NOT** rated for full flange pressure and do not require high bolting torque.

Before installing any 3000 Series Vent, remove all packing materials from inside and outside the vent.

If loading weights were shipped separate from the vent, make sure to install weights on the appropriate pallet. Tighten cover dome cap screws to 15 ft.-lbs.

Inspect the gasket seating surface of the tank nozzle flange. It must be clean, free of scratches, corrosion, tool marks and flat.

FRP and Aluminum vents are furnished with flat faced flanges. It is recommended that they be installed on mating flat face flanges with a full faced gasket. If the flat face of the vent is sealing against a raised face steel flange, a spacer or filler ring must be used to fill the annular space of the raised face steel flange.

Make sure the gasket is suitable for the application.



### WARNING

**Minimum clearance between tank roof and vacuum inlet port must be at least equal to the vents' nominal flange bore. Tank nozzle bore must be greater than or equal to vent inlet flange bore. Inlet and outlet piping loads must be supported by appropriate structural supports, NOT by the vent body.**

Fiberglass flanges 2 inch to 12 inch require the use of a full-face 150 lb. gasket. For full face gaskets, we recommend the use of a 1/8-inch Gortex gasket.

Center the gasket within the bolt circle of the tank flange, align the bolt holes and carefully set the vent on the flange nozzle.

**NOTE:** At installation, the vent valve should be carefully lifted into position using the lifting brackets (2) on the body.

All stud threads must be lubricated to obtain proper torque results. A washer should be used under each stud nut.

Install the studs, washers and nuts and tighten nuts hand tight. Check proper alignment of flange faces. Misalignment of flange faces will cause bending stresses at the flange and flange joint and damage may result. Correct any misalignment prior to applying torque to nuts.

All nuts must be tightened in proper sequence and equal increments. Proceed through the tightening sequence until the recommended torque is attained.

Recheck the torque on each bolt in the same sequence, as bolts previously tightened may have relaxed through the torque sequence.

**TABLE 1**  
**All Torque Requirements Are Dependant On Gasket Material**  
**Bolt Torque and Stud Specifications - ASME #150 Flange Connections**

MOUNTING FLANGE	BOLT TORQUE - Ft. lbs.	NUMBER BOLTS TOTAL	STUD SPECIFICATIONS		
			THREAD UNC	STUD LENGTH *	QUANTITY *
2"	47	4	5/8" - 11	2.50"	2
3"		4	5/8" - 11	2.75"	2
4"		8	5/8" - 11	2.75"	4
6"	83	8	3/4" - 10	3.00"	4
8"		8	3/4" - 10	3.00"	4
10"	134	12	7/8" - 9	3.50"	6
12"		12	7/8" - 9	3.50"	6

**Bolt Torque and Stud Specifications for FRP Flanges Drilled to ASME #150 Flange Connections**

MOUNTING FLANGE	BOLT TORQUE - Ft. lbs.	NUMBER BOLTS TO-TAL	STUD SPECIFICATIONS		
	FLAT FACE		THREAD UNC	STUD LENGTH *	QUANTITY *
2"	20	4	5/8" - 11	2.50"	2
3"	20	4	5/8" - 11	2.75"	2
4"	20	8	5/8" - 11	2.75"	4
6"	30	8	3/4" - 10	3.00"	4
8"	30	8	3/4" - 10	3.00"	4
10"	30	12	7/8" - 9	3.50"	6
12"	30	12	7/8" - 9	3.50"	6

\* Blind tapped holes only (Models 3100, 3200, and 3300). Use standard ASME stud length for other holes.

## SECTION V

### V. MAINTENANCE

Tank or system protection is the primary function of the weight loaded Pressure and/or Vacuum Relief Vent. As a safety device, it is very important that maintenance/inspection be done on a regular interval. Maintenance should only be done by a qualified technician. Valve Concepts recommends that all service be performed at the factory or a factory authorized repair center. For information on repair centers in your area, please contact factory.

**Maintenance procedures hereinafter are based upon removal of the relief vent unit from the tank where installed.**

Owner should refer to Owner's procedures for removal, handling and cleaning of nonreusable parts, i.e. gaskets, suitable solvents, etc.

**NOTE:** Item Numbers that are specific to FRP body material are in parenthesis and underscored; i.e. (8). See Figure 11. Item Numbers that are generic to all body materials are **not** underscored; i.e. (1). See Figures 3 thru 9 where applicable.

**To Dis-assemble:** Remove cover cap screws (10) (10 & 33), covers (8) the TFE tape /rope seals (34).

Inspect covers for corrosion, damage, or foreign material. Clean with a suitable solvent, replace as necessary.

**NOTE:** During re-assembly, install new TFE tape / rope (34). **For FRP material - nuts (10) for covers (8) should be tightened to 50 in. - lbs. (5.6 Nm).**

Remove pressure and vacuum pallet assemblies, including any loading weights (21 & 28) that may be on the pallets (19,26). **NOTE:** As the pallets are removed from the vent, identify each assembly (including the stack of weights) by tagging as "pressure" side or "vacuum" side.

Clean and inspect pallet assemblies. Inspect the diaphragms (18,25) and replace if necessary.

**To Replace Diaphragms - Std. Construction:** See Figure 4. Secure pressure or vacuum stem assembly (23,30) in a soft-jawed vise with short, threaded end up. Remove washer and nut (14).

**For settings above 32oz/in<sup>2</sup>** See Figure 5. Remove machine screws (43) CCW

Lift up to remove diaphragm retainer (17,24) and diaphragm (18,25) and pallet (19,26) and stiffener plate (20,27). Clean parts with a suitable solvent,

replace as necessary. **NOTE:** Before re-assembly, apply TFE paste to threads of the stem and around center hole on the pallets (19,26).

Place stiffener plate (20,27) over threaded end of stem. Set diaphragm (18,25) and diaphragm retainer plate (17,24), over end of stem. Install washer and nut (14) tight on stem.

**For settings above 32oz/in<sup>2</sup>** See Figure 5 for assembly. Install machine screws (43).

Inspect and clean pressure / vacuum seat ring(s) (16). Check seat surface for any nicks, corrosion, pitting or foreign material. Seat surfaces must be clean and smooth for vent to perform properly. **NOTE:** FRP seat surfaces are integral inside the body.



#### CAUTION

**The pipeaway body (13) is no longer fastened securely to the lower body (1) and could fall and cause severe personal injury and material damage.**

**To Remove Seat Rings (except for FRP body material):** Make a match mark between the lower body and the upper body. Rotate cap screws (15) CCW and remove. Remove guides (22,29). (Use the slot on top of the guides and rotate CCW to remove.) Mark the location of each guide on the seat ring (16) flange for reference at re-assembly.

Lift up to remove seat rings (16) and TFE tape / rope seal(s) (34.1). (There is no rope seal on FRP material.) Inspect guides (22,29) and inside of the body cavity for any corrosion or product build up. Clean all parts as necessary.

**To Remove Pipeaway Tape Seal:** Separate pipeaway upper body (13) from lower body (1). Remove TFE tape seals (34.1 & 34.2) and clean sealing surfaces of both parts. Place new TFE tape seals (34.1 & 34.2) in grooves in body (1). See Figure 9.

Using match marks to align upper body with lower body, lower pipeaway body on lower body, resting on tape seals.

Place new seat ring TFE tape seals (34.1) in grooves in upper and lower bodies (1,13). See Figure 9.



## WARNING

When assembling a P/V vent, always put the pressure (long stem) and vacuum (short stem) pallet assemblies back in their original location and ensure that the stem is straight and fits into the guide in the cover.

If the pressure and vacuum pallet assemblies are mixed at assembly, the settings will be changed and the flow for the vacuum side will be restricted.

If the stem is cocked at an angle, pallet lift may be completely blocked. An over-pressure can occur if any of these three conditions happens. This can cause a tank failure, severe personal injury and material damage.

Using match marks align seat rings (16) with body and re-position seat rings back in body, resting on tape seals.

Re-install pallet guides (22,29) around the seat rings as previously marked. Install cap screws (15) - apply 15 ft.-lbs. (20.3 Nm) torque to tighten.

Place pressure and vacuum pallet stem assemblies on the correct seat rings (16).

Select the appropriately tagged set of weights (21,28) and carefully lower each set of loading weights on the pallet stem assembly, Exercise care so as not to damage the pallet diaphragm and seat surfaces.

**NOTE:** When installing the pressure and vacuum covers, ensure the pressure stem assembly(30) and vacuum stem assembly (23) are inserted in the cover guides.

Place a new piece of TFE tape / rope seal (34, 34.0) on the face of the body cover flanges. See Figure 9. Place covers (8) over stem of pallet assembly, align bolt holes with the body (1) and install cap screws (10). Using a star crossing pattern, tighten nuts to 15 ft. lbs. (20.3 Nm). **For FRP material - install (10,33) and tighten to 50 in. - lbs. (5.6 Nm).**

**To Remove Flame Screen:** Rotate cap screws (42) CCW and remove cap screws and ring (41). Inspect and clean screen (40), replace as necessary. Re-secure screen and ring to body with cap screws. See Figure 10.

## SECTION VI

### VI. TEST PROCEDURE

**To Calculate Weight of Pallet Assembly:**

Table 2 shows the pallet weight per unit of pressure or vacuum setting. The total pallet assembly weight is determined by multiplying the desired set point (in the appropriate units) by the incremental weight per unit listed in Table 2.

For Example:

4" Model 3204 CS - if the desired setting is 5 oz/in<sup>2</sup>

Table 2 shows that for a 4" vent, the pallet would weigh 2.05 lb per oz/in<sup>2</sup>

So the pallet assembly for a 5 oz/in<sup>2</sup> setting would weigh: 2.05 lbs/oz/in<sup>2</sup> x 5.0 oz/in<sup>2</sup> = 10.25 lbs

Valve Concepts allows a deviation from this theoretical weight of ± 3.0%.

**To Determine Diaphragm/Seat Leakage:**

After both pallets' weight has been determined and verified for the required setting, reassemble the vent and mount on a Tank Vent Test Stand and slowly raise the pressure at the flow rate of 1.0 SCFH.

**ACCEPTANCE CRITERIA:**

The pressure gauge shall maintain a pressure equal to or greater than 90% of set pressure for a one minute period while the specified flow rate is maintained. Note: Valve Concepts acceptance criteria exceed the requirements of API. API 2521 states that if the rate of leakage does not exceed ½ SCFH for 6 inch size and smaller, or 5 SCFH for 8 inch and larger, at 75% of set point, then a vent is considered satisfactory for all practical purposes.

If the vent fails to meet the 90% criteria, it must be disassembled and the seat, pallet, and or diaphragms repaired or replaced.

A test report should be completed for each vent. The report should indicate the total pallet weight and the pressure achieved at the Test Flow Rate for both pressure and vacuum. Other general information such as serial number, model number, material of construction, set pressure and vacuum, etc. should be included in the report.

The test report should be kept with the Valve Maintenance Records.

**TABLE 2  
Nominal Pallet Assembly Weight Per Unit of Pressure lbs (kg)**

SET Point Units	VALVE SIZE							
	2" VTA	2" PV	3"	4"	6"	8"	10"	12"
	Lb (kg)	Lb (kg)	Lb (kg)	Lb (kg)	Lb (kg)	Lb (kg)	Lb (kg)	Lb (kg)
1.0 oz/in <sup>2</sup>	0.25 (0.11)	0.55 (0.25)	0.93 (0.42)	2.05 (0.93)	3.50 (1.59)	5.45 (2.47)	7.71 (3.50)	9.17 (4.16)
1.0 in WC	0.15 (0.07)	0.32 (0.14)	0.54 (0.24)	1.18 (0.53)	2.03 (0.92)	3.15 (1.43)	4.46 (2.02)	5.30 (2.40)
1.0 mbar	0.13 (0.06)	0.13 (0.06)	0.22 (0.10)	0.48 (0.22)	0.81 (0.37)	1.26 (0.57)	1.79 (0.81)	2.13 (0.97)

**TABLE 3  
Maximum Pressure Setting in oz/in<sup>2</sup> Vs. Diaphragm mil**

Line Size	10 mil	20 mil	30 mil	40 mil
2" VTA	7.00	34.00	40.00	n/a
2" P/V	4.50	23.50	33.00	40.00
3" P/V	3.50	18.00	25.00	40.00
4" P/V	2.25	12.00	17.00	40.00
6" P/V	1.75	9.25	13.25	40.00
8" P/V	1.75	7.50	10.50	40.00
10" P/V	1.25	6.25	8.75	40.00
12" P/V	1.00	5.75	8.00	40.00



## SECTION VII

### VII. ORDERING INFORMATION

#### NEW REPLACEMENT UNIT vs PARTS "KIT" FOR FIELD REPAIR

To obtain a quotation or place an order, please retrieve the Serial Number and Product Code that was stamped on the metal name plate and attached to the unit. This information can also be found on the Bill of Material ("BOM"), a parts list that was provided when unit was originally shipped. (Serial Number typically 6 digits).

#### NEW REPLACEMENT UNIT:

Contact your local Cashco, Inc., Sales Representative with the Serial Number, Product code and the pressure/vacuum settings. With this information they can provide a quotation for a new unit including a complete description, price and availability.

#### PARTS "KIT" for FIELD REPAIR:

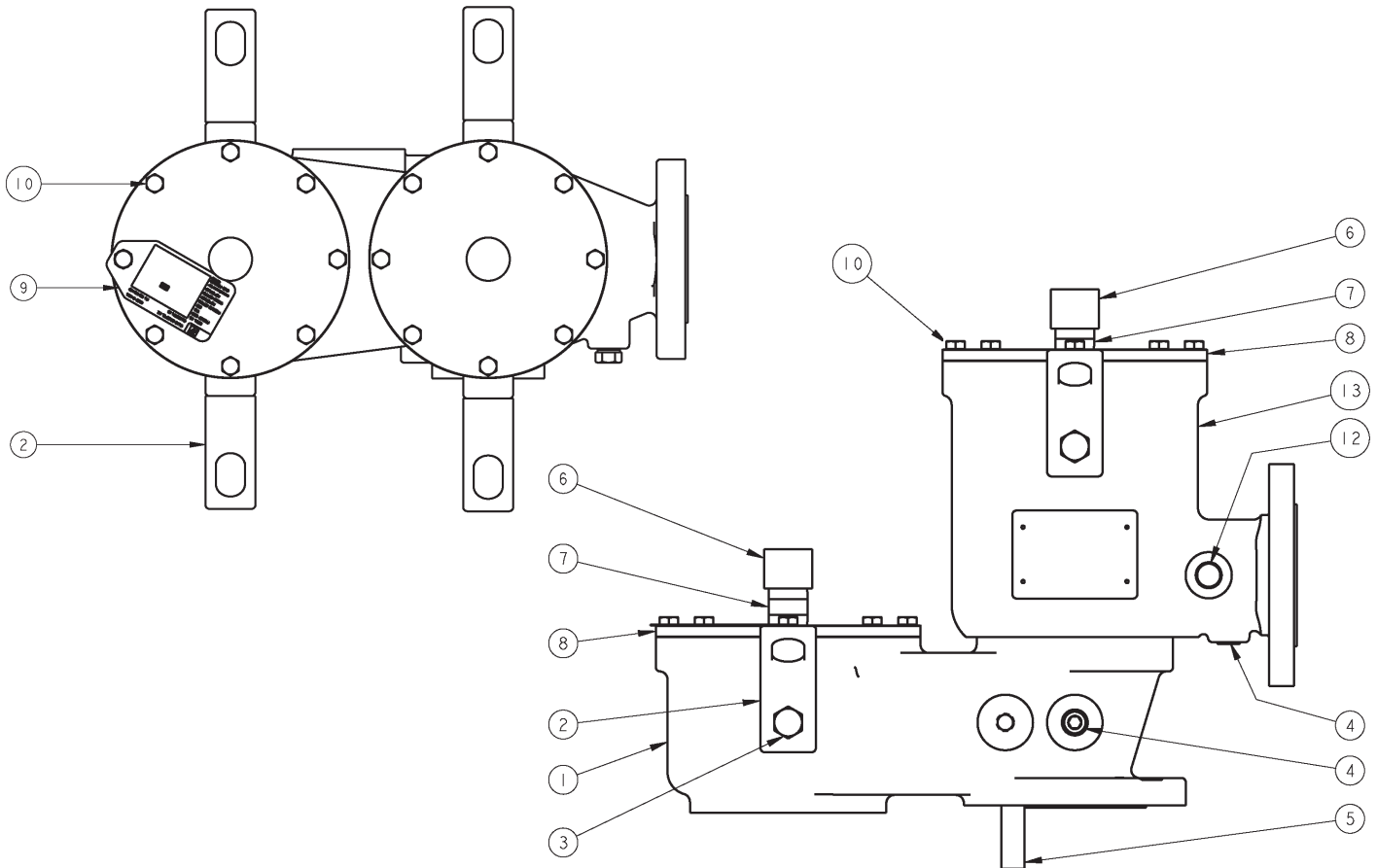
Contact your local Cashco, Inc., Sales Representative with the Serial Number and Product code. Identify the parts and the quantity required to repair the unit from the "BOM" sheet that was provided when unit was originally shipped.

**NOTE:** If the "BOM" is not available, refer to the cross-sectional drawings included in this manual for part identification and selection.

A Local Sales Representative will provide quotation for appropriate Kit Number, Price and Availability.

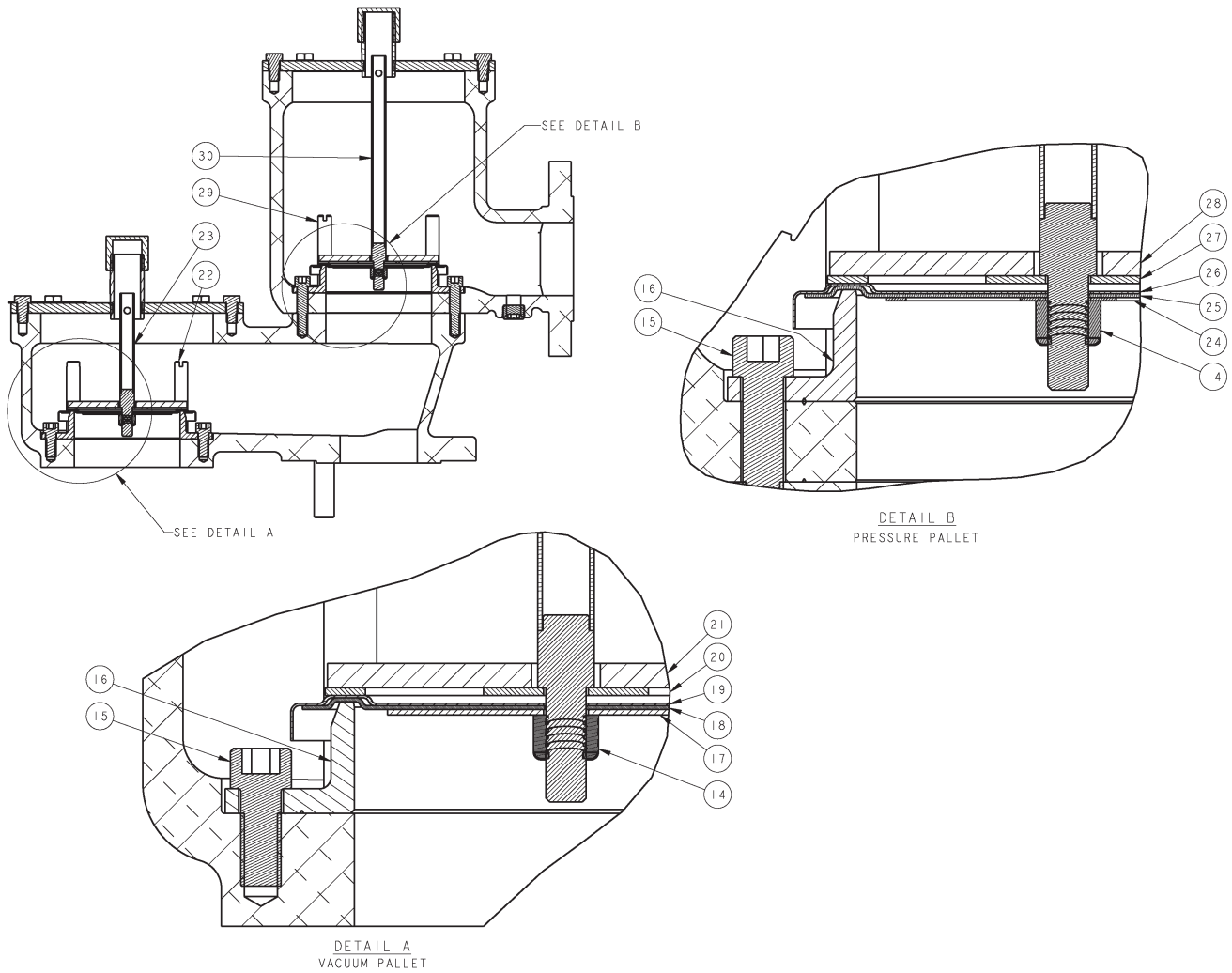
**⚠ CAUTION**

**Do not attempt to alter the original construction of any unit without assistance and approval from the factory. All proposed changes will require a new name plate with appropriate ratings and new product code to accommodate the recommended part(s) changes.**



**Figure 3 - View with Lifting brackets**

**Figure 4 - Standard Vent  
Aluminum, Carbon Steel, Stainless Steel**



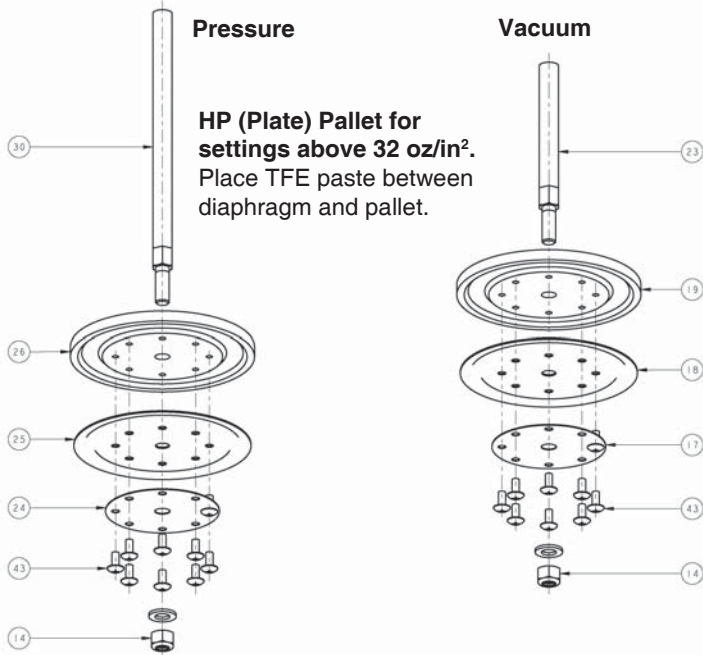
<u>ITEM NO.</u>	<u>DESCRIPTION</u>	<u>ITEM NO.</u>	<u>DESCRIPTION</u>	<u>ITEM NO.</u>	<u>DESCRIPTION</u>
1	Lower Body	13	Upper Body	24	Diaphragm Retainer - Press
2	Lift Brackets	14	Nuts *	25	Pallet Diaphragm - Press ‡
3	Cap Screws	15	Socket Cap Screw	26	Pallet - Press
4	Plug	16	Seat Rings	27	Stiffner Plate - Press
5	Studs	17	Diaphragm Retainer - Vac	28	Pallet Weights - Press
6	Cap	18	Pallet Diaphragm - Vac ‡	29	Stem Guide - Press
7	Nipple	19	Pallet - Vac	30	Stem Assy - Press
8	Cover	20	Stiffner Plate - Vac	34	Joint Tape (Not Shown - See Figure 9) ‡
9	Name Plate (Not Shown)	21	Pallet Weights - Vac		
10	Cap Screws	22	Pallet Guide - Vac		
12	Pipe Plug	23	Stem Assy - Vac		

\* Early Models included a lock washer, plain washer and a cotter pin.

‡ Recommended Spare Part



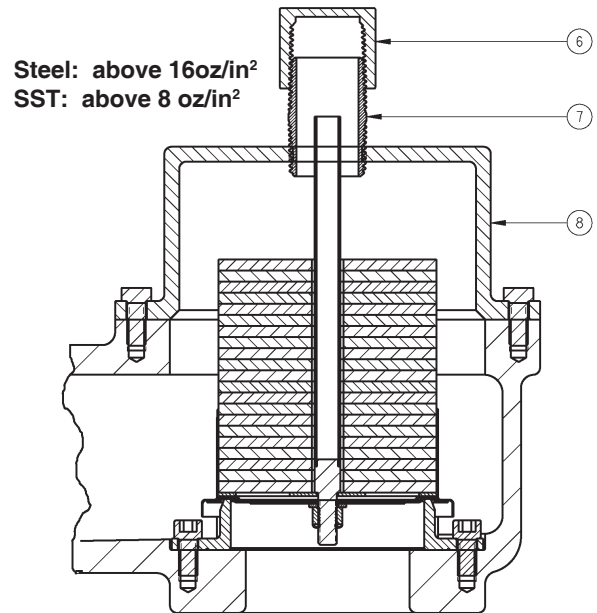
**Figure 5 - Pallet Assembly**



ITEM NO.	DESCRIPTION
14	Lock Nuts
17	Diaphragm Retainer - Vac
18	Pallet Diaphragm -Vac ‡
19	Pallet - Vac
22	Pallet Guide - Vac
23	Stem Assy - Vac

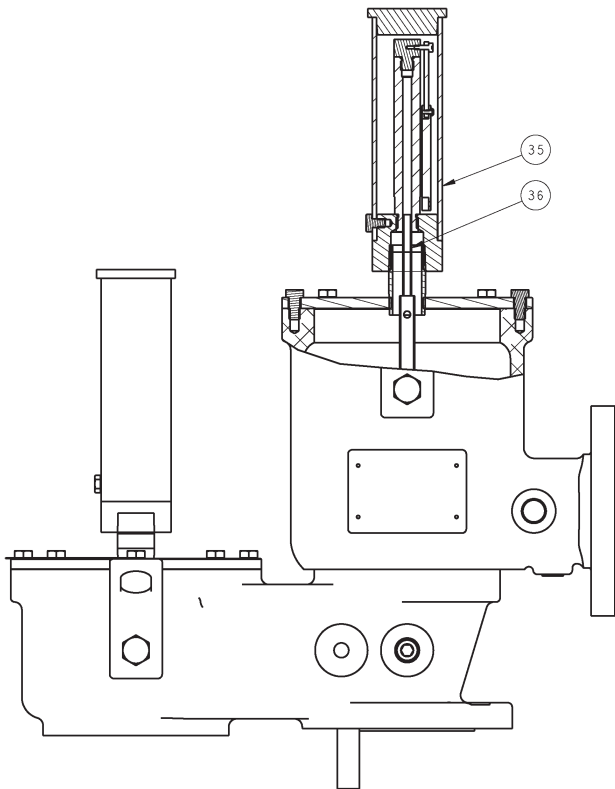
ITEM NO.	DESCRIPTION
24	Diaphragm Retainer- Pres
25	Pallet Diaphragm -Pres ‡
26	Pallet - Pres
29	Pallet Guide - Press
30	Stem Assy - Pres
35	Indicator Housing

**Figure 6 - Extended Cover Vacuum Settings**

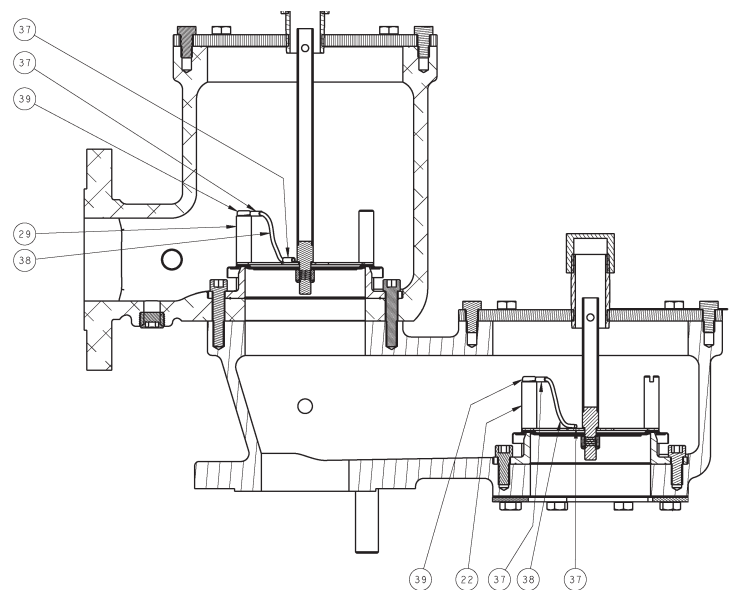


ITEM NO.	DESCRIPTION
36	Indicator
37	Cable Connector
38	Cable - ATEX
39	Cap Screw
43	Machine Screw

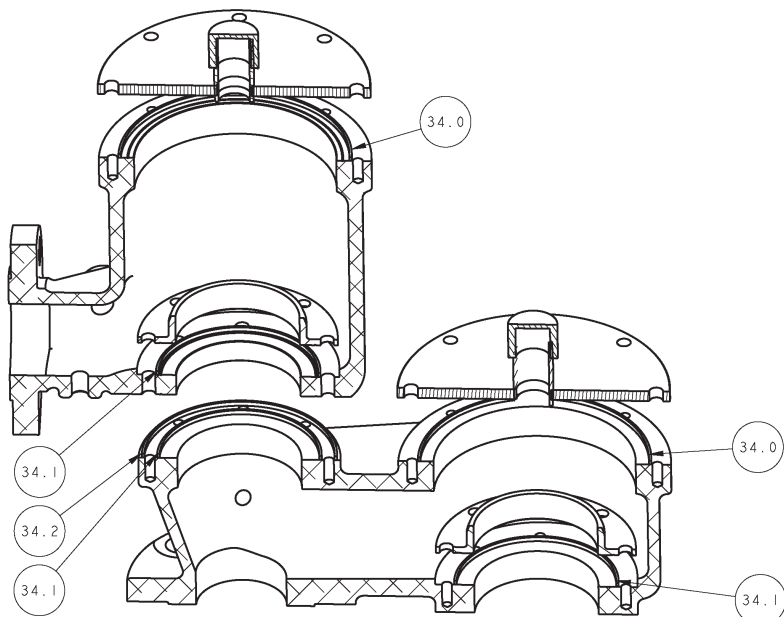
**Figure 7 - Indicators**



**Figure 8 - ATEX Cable Connections**



**Figure 9 - Joint Tape Application**

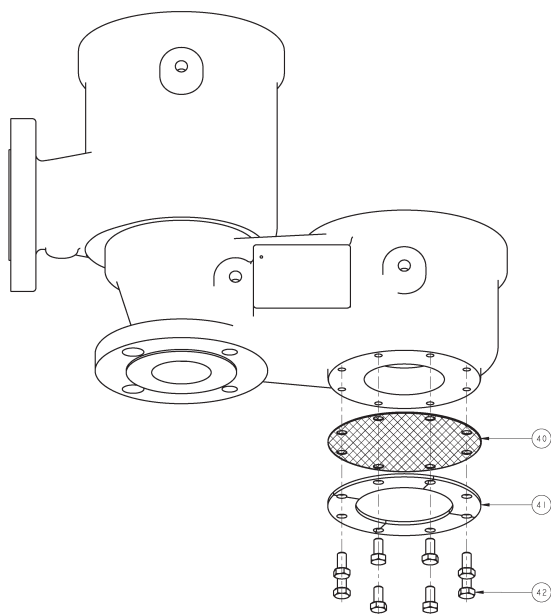


**TFE TAPE LENGTH**

Size	Item 34.0 *	Item 34.1 **	Item 34.2
2"	23"	17"	20"
3"	25"	20"	22"
4"	33"	28"	26"
6"	38"	34"	32"
8"	46"	41"	39"
10"	56"	47"	47"
12"	58"	51"	55"

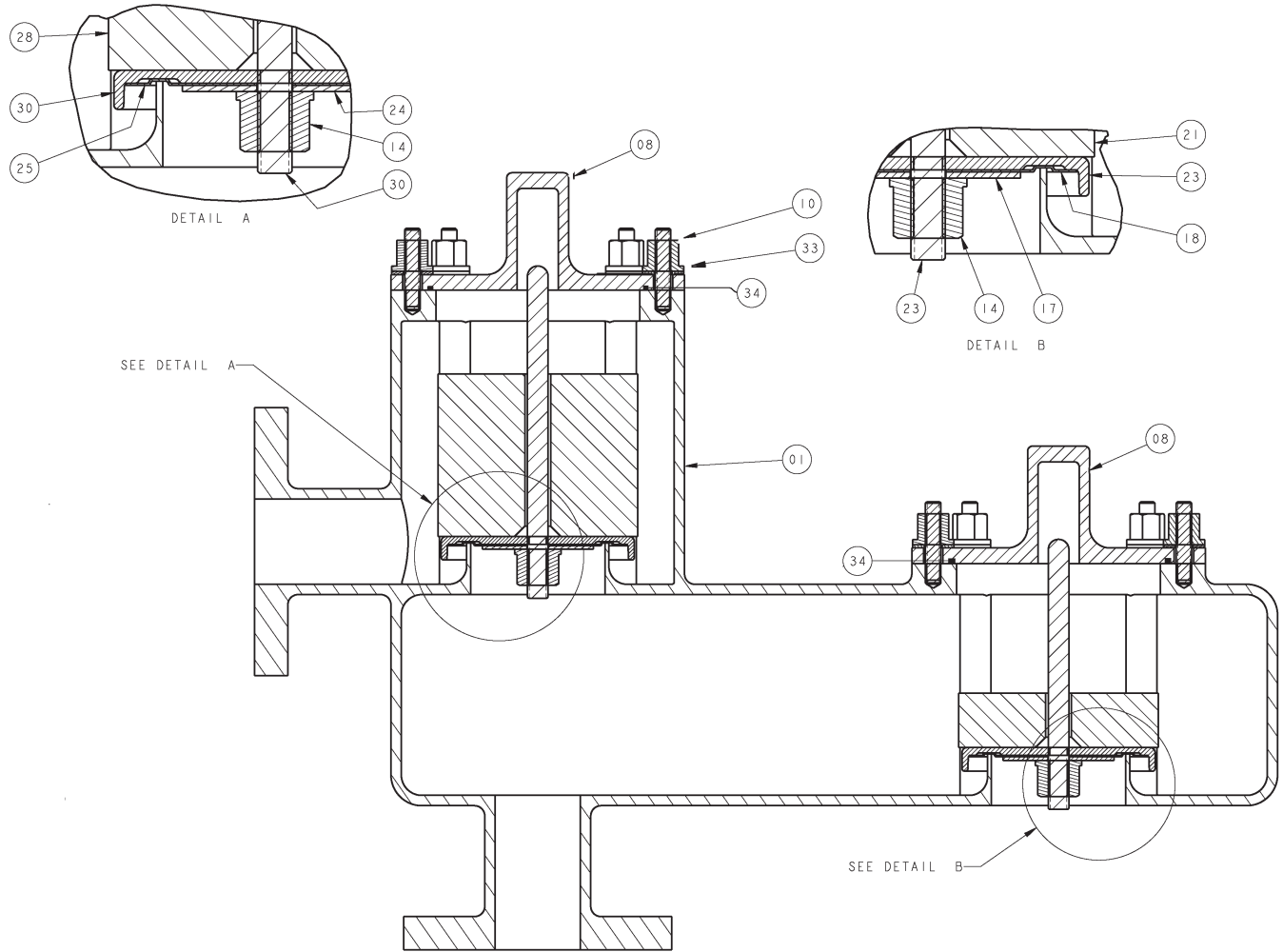
\* Quantity 2 per unit.  
 \*\* Quantity 3 per unit.

**Figure 10 - Flame Screen**



ITEM NO.	DESCRIPTION
40	Flame / Bug Screen
41	Flame Screen Ring
42	Cap Screws

**Figure 11 - FRP Vent**



**ITEM NO. DESCRIPTION**

1	Body
8	Cover
9	Name Plate (Not shown)
10	Fibrenut
14	Fibrenut
17	Diaphragm Retainer - Vac
18	Pallet Diaphragm - Vac ‡
21	Pallet Weights - Vac

**ITEM NO. DESCRIPTION**

23	Stem Assy - Vac
24	Diaphragm Retainer - Press
25	Pallet Diaphragm - Press ‡
28	Pallet Weights - Press
30	Stem Assy - Press
33	Washer (Flat)
34	TFE Rope ‡
‡	Recommended Spare Part

**TFE ROPE LENGTH**

Size	Item 34 *
2"	21"
3"	24"
4"	31"
6"	37"
8"	44"
10"	50"
12"	54"

\* Quantity 2 per unit.

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