






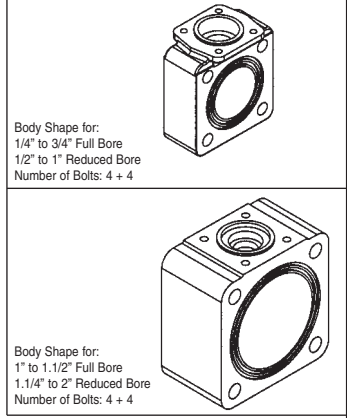
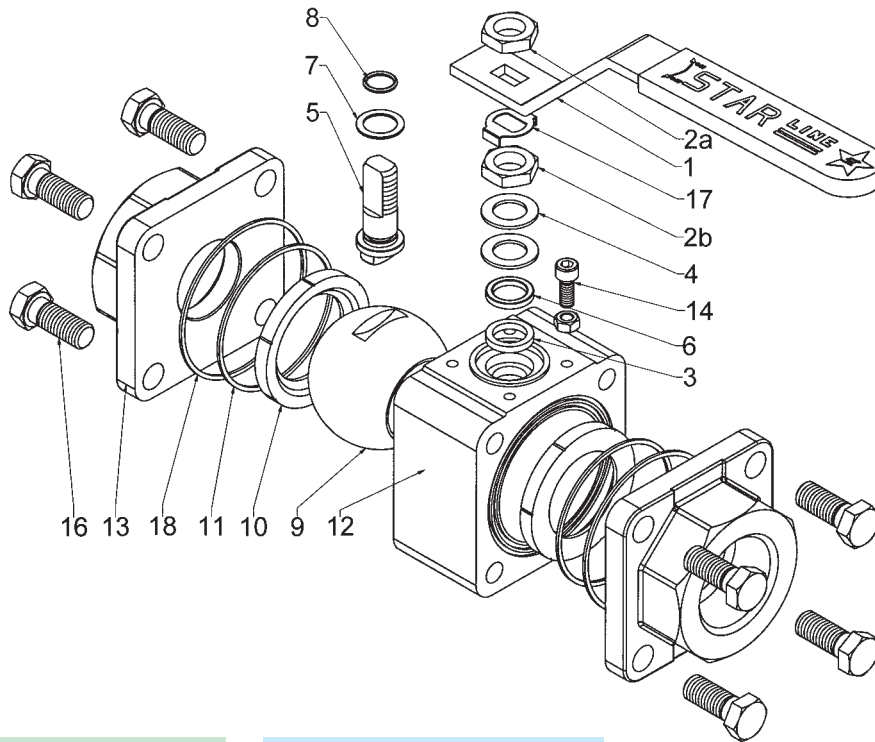


3 MASTER STAR & 1 SUPER STAR

FORGED STEEL BALL VALVES



<p>PED 97/23 EC</p>  <p>0038</p> <p>Certificate N°: RPS 0160304/01</p>	<p>ATEX 94/9 CE</p>  <p>Tech. File N° ST01 ATEX</p>		 <p>P10228 P10227</p>	 <p>MAC/10699/3/TO/99 MAC/10699/1/TO/99</p>	 <p>6D-0233</p>	 <p>TYPE APPROVED</p>
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• Suggested materials after 2 years service
 • Empfohlene ersatzteile für 2 Jahres betrieb
 • Pièces de rechange conseillées pour 2 ans de service
 • Recambios aconsejados para 2 años de servicio

•• Suggested materials after 5 years service
 •• Empfohlene ersatzteile für 5 Jahres betrieb
 •• Pièces de rechange conseillées pour 5 ans de service
 •• Recambios aconsejados para 5 años de servicio

ITEM	Q.TY	Part name - Bezeichnung	Designation - Componentes	A105/F316	LF2/F316	F316/F316
1	1	Handle - Handhebel	Levier - Maneta	C.S. Galvanized - Plastic cover	C.S. Galvanized - Plastic cover	C.S. Galvanized - Plastic cover
•• 2 ^A / _B	2	Nut - Mutter	Ecrou - Tuerca	C.S. Cadmium -Plated	C.S. Cadmium -Plated	S.S. 316
• 3	1	Packing ring - Stopfbuchsenpackung	Garniture - Junta eje	Graphite	Graphite	Graphite
•• 4	2	Spring washer - Tellerfedern	Rondelle ressort - Arandela	Special S.S.	Special S.S.	Special S.S.
•• 5	1	Antistatic stem - Antistatische spindel	Tige antistatique - Eje antiestatico	S.S. 316	S.S. 316	S.S. 316
6	1	Gland packing - Druck ring	Fouloir - Estopada	S.S. 316	S.S. 316	S.S. 316
• 7	1	Thrust washer - Spindeldichtung	Rondelle butée - Junta eje	Reinf. PTFE	Reinf. PTFE	Reinf. PTFE
• 8	1	«O» Ring stem - «O» Ring spindel	Joint torique - Torica eje	VITON	VITON	VITON
•• 9	1	Ball - Kugel	Sphère - Espera	S.S. 316	S.S. 316	S.S. 316
• 10	2	Seats - Sitzring	Sièges - Asientos	T-R-S-B-U	T-R-S-B-U	T-R-S-B-U
• 11	2	Body seal - Gehäuse-dichtung	Joint de corps - Junta cuerpo	T-S-V-G	T-S-V-G	T-S-V-G
12	1	Body - Gehäuse	Corps - Cuerpo	ASTM A105N	A350 LF2	A182 F316
13	2	End connections - Anschlußstutzen	Embout - Terminales	ASTM A105N	A350 LF2	A182 F316L
14	1	Stop-pin - Anschlag	Butée - Tope	S.S. 304	S.S. 304	S.S. 304
16	8	Bolts - Gehäuseschraube	Vis - Goujon	ASTM A193 - B7 Galvanized	ASTM A193 - B8	ASTM A193 B8
•• 17	1	Stop washer - Sicherungsscheiße	Rondelle-frein - Arandela de seguridad	S.S. 304	S.S. 304	S.S. 304
• 18	2	Body seal - Gehäuse-dichtung	Joint de corps - Junta de cuerpo	Graphite	Graphite	Graphite

DESCRIPTION

CONSTRUCTION : THREE PIECES BOLTED CONSTRUCTION - SOLID BALL - ANTI BLOW OUT PROOF STEM DESIGN - SOFT SEATS - ANTISTATIC DEVICE - ISO 5211 ON THE TOP FOR EASY AUTOMATION - FIRE TEST APPROVED.

SIZE : DN 8 ÷ 40 FULL BORE -- DN 15 ÷ 50 REDUCED BORE
 1/4" ÷ 1.1/2" FULL BORE -- 1/2" ÷ 2" REDUCED BORE

TEMPERATURE : -200°C UP TO + 260°C

DESIGN MARKING CE 0038 : ASME B16.34 - ASME B31.1 - BS5351 - API 6D - P.E.D. 97/23/EC - ATEX 94/9 CE : MSS SP25 : ACCORDING TO DIRECTIVE 97/23/CE - MODULE H CATEGORY III - NOTIFIED BODY LLOYD'S REGISTERED CERTIFICATE NR. RPS 01060304/01

Ex IM2/II 2GD TEST CERTIFICATE SERVICES : ACCORDING TO ATEX 94/9 CE - TECHNICAL FILE NR. ST01 ATEX : UNI EN 10204 TYPE 3.1B UNLESS OTHERWISE REQUIRED : FOR PETROLEUM, CHEMICALS, PETROLCHEMICALS AND ALLIED INDUSTRIES

HOW TO ORDER

PORT DESIGN	TYPE OF VALVE	BASE MATERIAL BODY/TRIM	INSERT SEAT MATERIAL	STEM PACKING	FIRST BODY SEAL
1 Full Bore 2 Reduced Bore	3 - Master Star	1 321/316 2 A105/MONEL 3 A105/316 4 F44/F44 5 LF2/316 6 316/316 7 316L/316L 8 MONEL/MONEL 9 F51/F51 0 All different materials	T Virgin PTFE R PTFE + 15% Fiberglass S PTFE + 25% Carborgraphite B PTFE + 60% Bronze U UHMWPE Polyethylene	G Graphite T Virgin PTFE R PTFE + 15% Fiberglass S PTFE + 25% Carborgraphite	T Virgin PTFE S PTFE + 25% Carborgraphite V O-Ring Viton G Graphite
NOTES: The above codifications are punched on the nameplate. Size, rating and connectoins are not in code and must be clearly shown on all orders.			EXAMPLE: 1/2" threaded NPT 800 LBS reduced bore body A105 trim 316 with PTFE seals. ON THE ORDER MUST BE DESCRIBED : 1/2" NPT 800 LBS 233-TGT.G		

THREADED ENDS

BSP Parallel:
BS21 - DIN 259 - ISO R/228 - UNI 338
BSP Taper:
BS21 - DIN 2999 - ISO R/7 - UNI 339
NPT:
ANSI B1 20.1

S.W.:
ASME / ANSI B16.11 - BS 5351
B.W. - P.E.:
ASME / ANSI B16.25 Sch. 5S-10S-40-80-XS
Note: other overall lengths are available on request.
Instruction for welding the valve on the line:
With the valve in open position tack-weld in four points on both ends. Lift-out the center piece and complete the welding. Insert the center piece and control for easy operation.

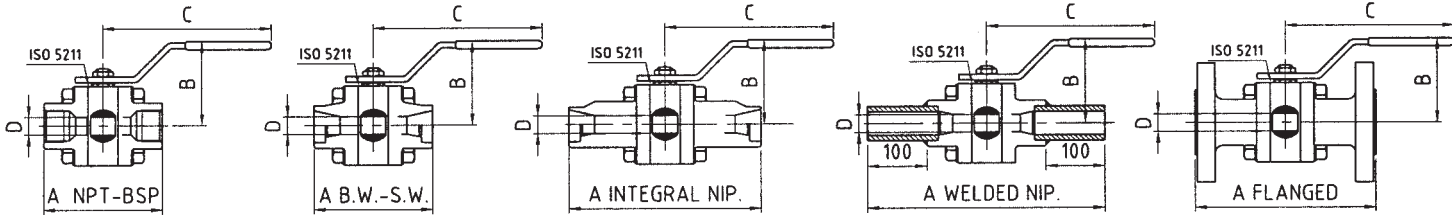
WELDED ENDS

INTEGRAL NIPPLES
S.W.:
ASME / ANSI B16.11 - BS 5351
B.W. - P.E.:
ASME / ANSI B16.25 Sch. 5S-10S-40-80-XS
Note: other overall lengths are available on request.

WELDED NIPPLES:
ASME / ANSI B3610 B.W. - P.E.
Sch. 10-40-80-XS
Instruction for welding the valve on the line:
With the valve in open position tack-weld in four points on both ends and then complete the welding without dismantling the valve.

FLANGED ENDS

FLANGES to ASME / ANSI B 16.5
FACE to FACE to ASME / ANSI B16.10
Note: when flanges are RF type of finish must be stated on the order.
FLANGES to DIN
DIN 2633 PN16 - DIN 2634 PN25
DIN 2635 PN40
FACE to FACE to EN 558-1 Basic Series 1 (DIN 3202 F1)

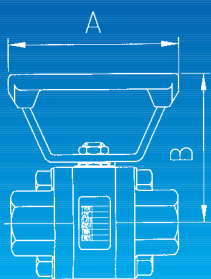


FULL BORE																			
VALVE SIZE	DIMENSIONS mm / Inch											ISO 5211	WEIGHT KG/LBS						
	NPT - BSP B.W. - S.W.	NIPPLES		FLANGED				B	C	D	NPT - BSP B.W. - S.W.		NIPPLES		FLANGED				
		INTEGRAL B.W. - S.W.	WELDED B.W. - P.E.	PN 16 - 25 - 40	RF	RJ	RF						RJ	INTEGRAL	WELDED	PN	150	300	
DN 8	75	236	275	-	-	-	-	-	-	67	152	11.1	F03	1.1	1.5	1.2	-	-	-
Inch 1/4"	2.9	9.3	10.8	-	-	-	-	-	-	2.6	6	0.44	F03	2.4	3.3	2.6	-	-	-
DN 10	75	236	275	-	-	-	-	-	-	67	152	11.1	F03	1	1.5	1.2	-	-	-
Inch 3/8"	2.9	9.3	10.8	-	-	-	-	-	-	2.6	6	0.44	F03	2.2	3.3	2.6	-	-	-
DN 15	80	239	280	130	140	-	140	151.5	70	152	14.2	F03	1.3	1.7	1.6	3.2	3	3.4	
Inch 1/2"	3.2	9.4	11	5.1	5.5	-	5.5	6	2.7	6	0.56	F03	2.8	3.7	3.5	7	6.6	7.5	
DN 20	100	250	300	150	152	-	152	165	80	193	20.5	F04	2.3	3	2.7	4.7	4.4	5.2	
Inch 3/4"	3.9	9.8	11.8	5.9	6	-	6	6.5	3.2	7.5	0.83	F04	5	6.6	5.9	10.4	9.7	11.5	
DN 25	110	261	310	160	165	178	165	178	92	193	25.4	F04	3.2	4.3	3.9	6	5.5	7	
Inch 1"	4.3	10.3	12.2	6.3	6.5	7	6.5	7	3.6	7.5	1	F04	7	9.4	8.6	13.2	12.1	15.4	
DN 32	120	272	320	180	178	191	178	191	108	225	31.7	F05	4.3	5.5	5.1	8.4	7.2	10	
Inch 1.1/4"	4.7	10.7	12.6	7.1	7	7.5	7	7.5	4.2	9	1.25	F05	9.5	12.1	11.2	18.5	15.8	22	
DN 40	140	279	340	200	191	203.5	191	203	113	225	38	F05	5.8	7.2	6.8	10.5	9.5	13	
Inch 1.1/2"	5.5	11	13.4	7.9	7.5	8	7.5	8	4.4	9	1.5	F05	12.8	15.8	15	23.1	21	28.6	

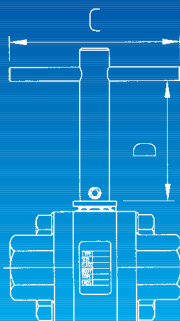
REDUCED BORE																		
VALVE SIZE	DIMENSIONS mm / Inch											ISO 5211	WEIGHT KG/LBS					
	NPT - BSP B.W. - S.W.	NIPPLES		FLANGED				B	C	D	NPT BSP B.S.P		NIPPLES		FLANGED			
		INTEGRAL B.W. - S.W.	WELDED B.W. - P.E.	PN 16 - 25 - 40	RF	RJ	RF						RJ	INTEGRAL	WELDED	PN	150	300
DN 15	75	236	275	130	108	-	140	151.5	67	152	11.1	F03	1	1.4	1.3	2.8	2.6	3
Inch 1/2"	2.9	9.3	10.8	5.1	4.2	-	5.5	6	2.6	6	0.44	F03	2.2	3.1	2.8	6.2	5.7	6.6
DN 20	80	239	280	150	117.5	-	152	165	70	152	14.2	F03	1.2	1.7	1.6	3.5	3.2	4
Inch 3/4"	3.2	9.4	11	5.9	4.6	-	6	6.5	2.7	6	0.56	F03	2.6	3.7	3.5	7.7	7	8.8
DN 25	100	250	300	160	127	140	165	178	80	193	20.5	F04	2.2	3	2.8	5	4.4	5.8
Inch 1"	3.9	9.8	11.8	6.3	5	5.5	6.5	7	3.2	7.5	0.83	F04	4.8	6.6	6.2	11	9.7	12.8
DN 32	110	261	310	180	140	152.5	178	191	92	193	25.4	F04	3.1	4.3	4	7	6	8.5
Inch 1.1/4"	4.3	10.3	12.2	7.1	5.5	6	7	7.5	3.6	7.5	1	F04	6.8	9.4	8.8	15.4	13.2	18.7
DN 40	120	272	320	200	165	178	191	203	108	225	31.7	F05	4.2	5.5	5.2	9	8	11.5
Inch 1.1/2"	4.7	10.7	12.6	7.9	6.5	7	7.5	8	4.2	9	1.25	F05	9.2	12.1	11.4	19.8	17.6	25.3
DN 50	140	279	340	230	178	191	216	232	113	225	38	F05	5.5	7.2	6.8	11.5	11	14
Inch 2"	5.5	11	13.4	9.1	7	7.5	8.5	9	4.4	9	1.5	F05	12.1	15.8	15	25.3	24.2	30.8

DIFFERENT CONFIGURATIONS FOR MASTER STAR & SUPER STAR

OVAL HANDLE



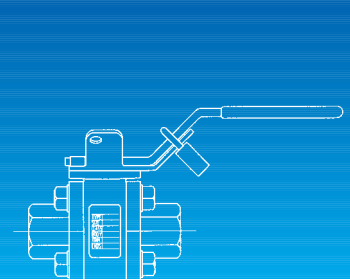
Valve Size	Dimension		Type of Handle
	Full B.	Red. B.	
1/4"	-	100	OH1
3/8"	1/2"	100	OH1
1/2"	3/4"	100	OH1
3/4"	1"	100	OH2
1"	1.1/4"	100	OH2



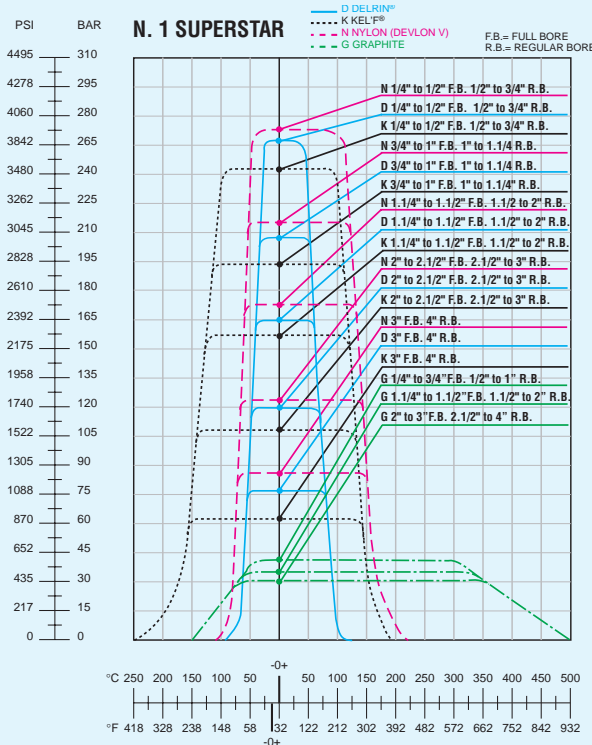
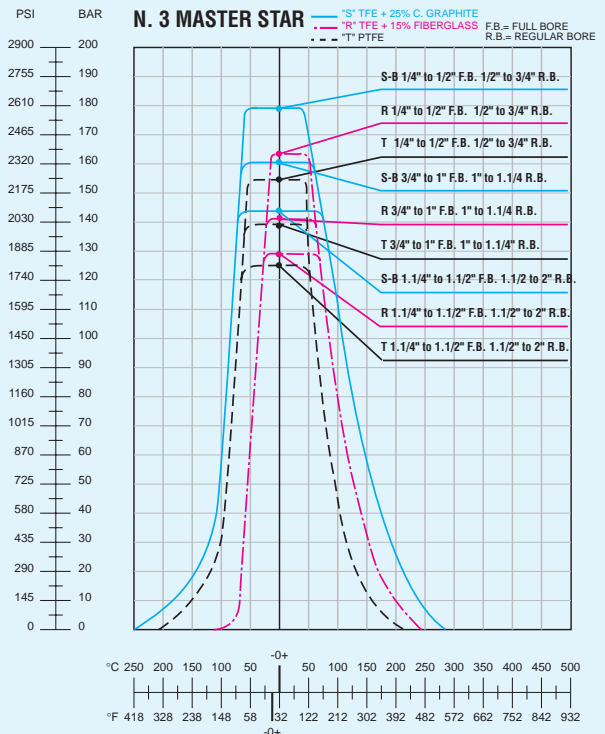
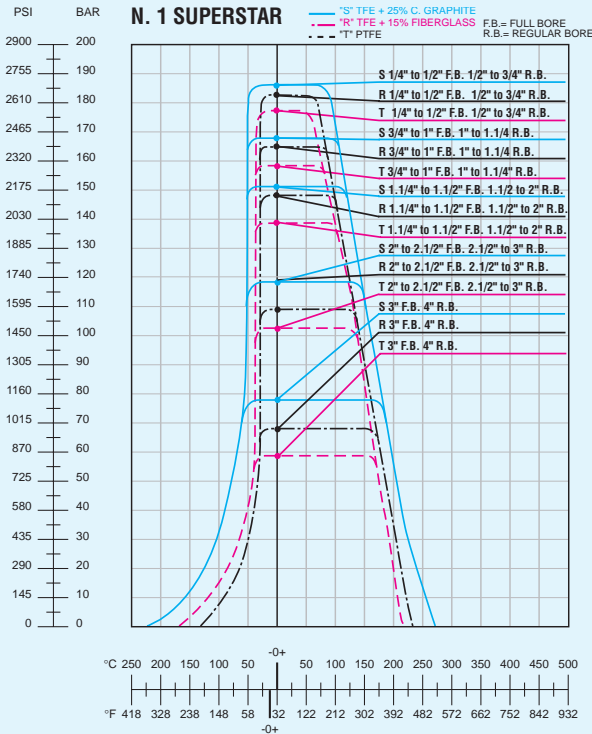
"T" HANDLE

Valve Size	Dimension			Type of Extention
	Full B.	Red. B.	D	
1/4"	-	140	115	OH1
3/8"	1/2"	140	115	
1/2"	3/4"	140	115	
3/4"	1"	150	125	OH2
1"	1.1/4"	150	125	
1.1/4"	1.1/2"	220	132	TH3
1.1/2"	2"	220	132	
2"	2.1/2"	220	132	
2.1/2"	3"	300	152	
3"	4"	450	168	

LOCKING DEVICE



PRESSURE/TEMPERATURE LIMITATIONS OF SEAT SEAL



The pressure-temperature rating of soft-seated ball valves bolted - construction is determined by:

- 1 Type of material group N° used for valve body
- 2 Type of material group N° used for body bolts
- 3 Type of sealing material used for seal and seats

Where:

A For material group N° we refer to ASME/ANSI B16.34 (stress-dimensions - thickness - etc.)

B For seats material we have prepared general pressure-temperature chart (at full differential pressure) based upon our experiences both in the field and in our laboratory.

SOME SPECIAL SERVICE BALL VALVES

- 1 OXYGEN GAS** - Valves tested using dry nitrogen gas. All valves are solvent cleaned and individually sealed in a polyethylene bag to prevent contamination: 316 TT.
- 2 DRY, LIQUID AND GASEOUS CHLORINE** - Valves tested using dry nitrogen gas. All valves are specially cleaned and individually sealed in a polyethylene bag. A supplementary venting hole on the ball.
- 3 CRYOGENIC SERVICE - HELIUM LEAK TEST** - Valves are dry tested. All valves are cleaned and individually sealed in a polyethylene bag. Extended stem and supplementary venting hole on the ball. For low class use T seats, medium class S seats, for class 900 and up K seats.
- 4 VACUUM** - Until 10⁻⁴ torr can use all type of starting valves. For high vacuum consult factory.
- 5 Phenol at low temperature** - Liquid asphalt - Steam jacket valves.
- 6 ALIMENTARY - FOOD SERVICE** - Valve cleaned, polished and cavity filled.
- 7 SLURRY SERVICE** - Cavity filled.
- 8 ABRASIVE MEEDIA** - Metal to metal seats.
- 9 HIGH TEMPERATURE** - Metal to metal seats.
- 10 NACE** (sour oil and gas) H₂S. All Starline FIRE SAFE valves types mmeet the requirements as a standard class 3. For class 2 and 1 must be selected proper bolts like B7M - L7M - B8M.
- 11 HYDROGEN PEROXIDE - NITROGEN LEAK TEST** - Valves are dry tested. All valves are cleaned. Supplementary venting hole.

FLOW DATA

The following flow rates were determined for ball valves in fully open position and a water temperature of 60°F (15°C). Kv value is the full capacity flow rate through the ball valve in cubic metres per hour (m³/h) with a pressure drop of 1 bar. Cv value is the full capacity flow rate through the ball valve in gallons/min. of water at 60°F with a pressure drop of 1 psi.

REGULAR BORE

VALVE SIZE	1/2"	3/4"	1"	1.1/4"	1.1/2"	2"	2.1/2"	3"	4"
Cv	8	13	32	48	82	120	275	460	700
KV	6,8	11	27,5	41	70	103	236	394	600

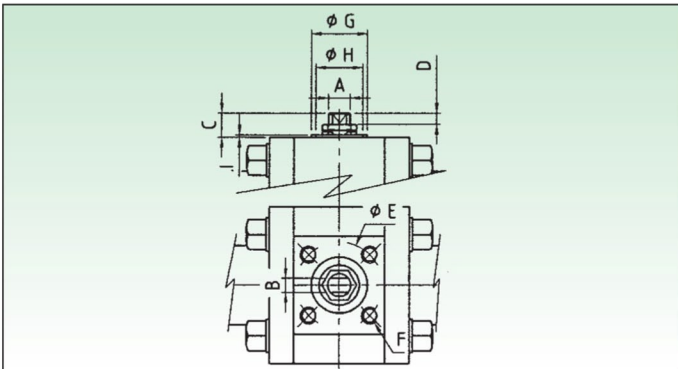
FULL BORE

VALVE SIZE	1/4"	3/8"	1/2"	3/4"	1"	1.1/4"	1.1/2"	2"	2.1/2"	3"
Cv	8	8	12	30	45	78	115	265	445	680
KV	6,8	6,8	10	26	38	67	99	227	381	583



HOW TO TRANSFORM A MANUAL OPERATED VALVE IN AUTOMATED VALVES

- 1) Take out the handle nut
- 2) Take out the handle
- 3) For size: 1/4" - 3/8" - 1/2" F.B. or 1/2" - 3/4" R.B. handle nut is not to be fitted For bigger sizes the handle nut has to be fitted



DIMENSIONS AND TORQUE TO SELECT ACTUATOR SUITABLE FOR STARLINE BALL VALVES

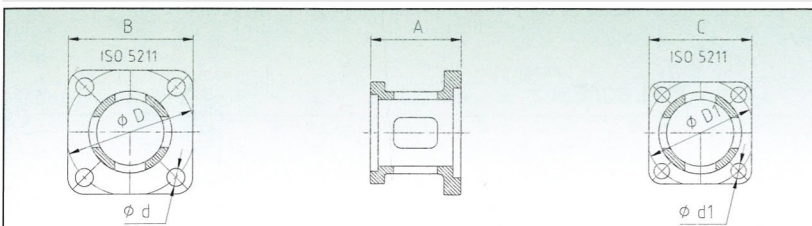
VALVE SIZE				TOP MOUNTING								BREAK AWAY TORQUE	
FULL BORE		RED. BORE		DIMENSION									
Inch	DN	Inch	DN	A	B	C	D	ØE	F	ØG	ØH	I	Nm
1/4"	8	-	-	M10x1	5.5	9	3.6	36	M5x8	25	21	1.5	12
3/8"	10	1/2"	15	M10x1	5.5	9	3.6	36	M5x8	25	21	1.5	12
1/2"	15	3/4"	20	M10x1	5.5	9.5	3.6	36	M5x8	25	21	1.5	16
3/4"	20	1"	25	M12x1.25	7.5	14	9	42	M5x8	30	25	1.5	22
1"	25	1.1/4"	32	M12x1.25	7.5	20	10	42	M5x8	30	25	1.5	30
1.1/4"	32	1.1/2"	40	M15x1.5	8.9	27	13	50	M6x10	35	30	1.5	38
1.1/2"	40	2"	50	M15x1.5	8.9	28	14	50	M6x10	35	30	1.5	46
2"	50	2.1/2"	65	M15x1.5	8.9	25	12.5	50	M6x10	35	30	1.5	90
2.1/2"	65	3"	80	M22x1.5	16	35	17	70	M8x12	55	48	1.5	110
3"	80	4"	100	M24x2	18	37.5	15	70	M8x12	55	48	1.5	125

- BREAK AWAY TORQUE AT MAX. WORKING PRESSURE WITH SEATS TYPE PTFE + 25% C. GRAPHITE
 "S" FOR SEATS IN VIRGIN PTFE "T" -5%.
 -CONVERSION FACTORS: 1Nm= 0,7376 Lb-in / 1 lb.ft.= 1.365 Nm / 1 Nm= 8,86 Lb-in

It must be understood that many factors can influence the torque of ball valves in field service. For this reason to SELECT PROPER ACTUATOR it must be used the "TORQUE ADJUSTMENT FACTORS" table no. A003/94.

NET BREAK AWAY TORQUE OF VALVES + PROCESS MEDIA + FREQUENCY OF OPERATION + PROCESS TEMPERATURE + VALVE SEATING MATERIAL + SUGGESTED SAFETY FACTOR = TORQUE TO SELECT ACTUATOR OR GEAR IN Nm

"STARLINE" BRACKETS ISO 5211 IN STAINLESS STEEL



TYPE OF BRACKET	DIMENSIONS (mm)							ISO 5211
	A	B	C	D	d	d1		
ST1	35	48.5	36.5	42-50	31	6-7	6	F03/F04-F05
ST2	35	48.5	40	50	42	7	6	F04/F05
ST3	39	48.5	48.5	50	50	7	7	F05/F05
ST35	45	65.5	48.5	70	50	9	7	F05/F07
ST4	45	65.5	65.5	70	70	9	9	F07/F07
ST5	56	92	92	102	102	11	11	F10/F10

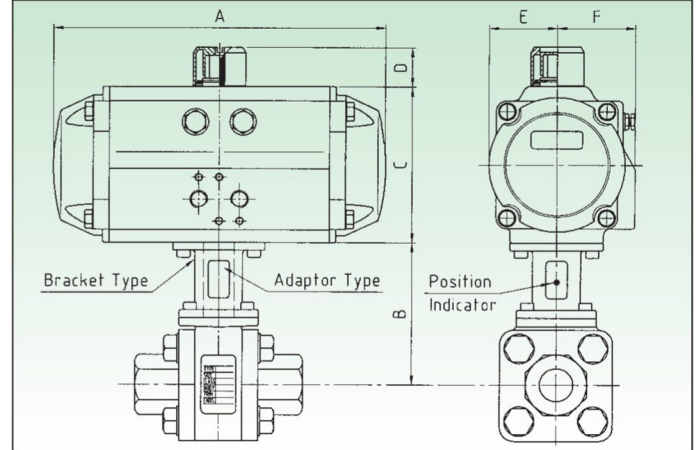


TABLE FOR AUTOMATION

VALVE SIZE & TOP ISO			DOUBLE ACTING ACTUATOR										
FULL BORE	RED. BOR	ISO	DIMENSIONS (mm)					ACTUATOR TYPE	Bracket Type	Adaptor Type			
Inch	DN	Inch	DN	5211	A	B	C	D	E	F			
1/4"	8	-	-	F03	140.5	65	69	20	29	41.5	AT 051 DA ISO F04-CH14	ST1	A1/E
3/8"	10	1/2"	15	F03	140.5	65	69	20	29	41.5	AT 051 DA ISO F04-CH14	ST1	A1/E
1/2"	15	3/4"	20	F03	158.5	67	85	20	36	47	AT 101 DA ISO F05-CH14	ST1	A1/A
3/4"	20	1"	25	F04	158.5	73	85	20	36	47	AT 101 DA ISO F05-CH14	ST2	A2/A
1"	25	1.1/4"	32	F04	210.5	73	102	20	42.5	52	AT 201 DA ISO F05/F07-CH14	ST2	A2/B
1.1/4"	32	1.1/2"	40	F05	210.5	82	102	20	42.5	52	AT 201 DA ISO F05/F07-CH14	ST3	A3/E
1.1/2"	40	2"	50	F05	210.5	86	102	20	42.5	52	AT 201 DA ISO F05/F07-CH14	ST3	A3/E
2"	50	2.1/2"	65	F05	247.5	97	115	20	49.5	56.8	AT 251 DA ISO F05/F07-CH17	ST3	A3/B
2.1/2"	65	3"	80	F07	268.5	115	127	20	56	67	AT 301 DA ISO F07/F10-CH22	ST4	A4/G
3"	80	4"	100	F07	268.5	132	127	20	56	67	AT 301 DA ISO F07/F10-CH22	ST4	A5/E

VALVE SIZE & TOP ISO			SPRING RETURN ACTUATOR (S10)										
FULL BORE	RED. BOR	ISO	DIMENSIONS (mm)					ACTUATOR TYPE	Bracket Type	Adaptor Type			
Inch	DN	Inch	DN	5211	A	B	C	D	E	F			
1/4"	8	-	-	F03	158.5	65	85	20	36	47	AT 101 S10 ISO F05-CH14	ST1	A1/A
3/8"	10	1/2"	15	F03	158.5	65	85	20	36	47	AT 101 S10 ISO F05-CH14	ST1	A1/A
1/2"	15	3/4"	20	F03	210.5	67	102	20	42.5	52	AT 201 S10 ISO F05/F07-CH14	ST1	A1/A
3/4"	20	1"	25	F04	210.5	73	102	20	42.5	52	AT 201 S10 ISO F05/F07-CH14	ST2	A2/A
1"	25	1.1/4"	32	F04	247.5	73	115	20	49.5	56.8	AT 251 S10 ISO F05/F07-CH17	ST2	A2/E
1.1/4"	32	1.1/2"	40	F05	268.5	82	127	20	56	67	AT 301 S10 ISO F07/F10-CH22	ST3	A3/A
1.1/2"	40	2"	50	F05	268.5	86	127	20	56	67	AT 301 S10 ISO F07/F10-CH22	ST3	A3/A
2"	50	2.1/2"	65	F05	268.5	97	127	20	56	67	AT 301 S10 ISO F07/F10-CH22	ST3	A3/B
2.1/2"	65	3"	80	F07	345	115	157	30	69.5	82	AT 401 S10 ISO F07/F10-CH22	ST4	A4/A
3"	80	4"	100	F07	345	132	157	30	68.5	82	AT 401 S10 ISO F07/F10-CH22	ST4	A5/A

General Remarks:

- 1) The above actuators have been selected considering an air supply of 80 psi or 5,6 bar.
- 2) On spring return actuators the N. of spring per side is 5.
- 3) For different air supply please see Air Torque Catalogue.
- 4) Bracket and adaptor are dimensioned to fit Air Torque actuators.
- 5) When air supply for actuator is lower than 5,6 bar bigger actuator must be selected and bracket plus adaptor become special