

# INVERTED BUCKET – STEAM TRAPS TIBA

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#### GENERAL NOTE - STEAM TRAPS PRODUCTION

The inverted bucket type of steam trap is created for standard and special applications, designed to the customer's specifications, welded body.

Steam traps suitable for high pressures and capacities, usable for all applications. **how it works**:

**1**- The bucket is placed on the base, the shutter is opened; in the steam trap there is no fluid of any kind.

**2-** Start-up: when the condensate begins to circulate, the bucket is prevented from floating and the steam trap eliminates the excess condensate.

**3-** As the system heats up, the condensate reduces and steam starts to arrive, accumulating inside the vessel, trapped under the inverted bucket, which allows it to float on the condensate and keep the shutter closed.

**4-** As the steam condenses, the bucket sinks, returning to the base of the vessel where it opens the escape valve, permitting the internal pressure to discharge the accumulated condensate. All of Blu Zac products have been designed to satisfy the requests and specific requirements of the

customer, including high pressure applications.

#### MAIN FEATURES

Reduced dimension and weight simple and reliable. It discharges air. It withstands water hammer. Condensate discharge is intermittent. Some loss of live steam.

#### APPLICATION

- **G** Steam mains
- Tracing lines
- Turbines
- Marine applications
- Presses

#### DISCARGE CAPACITY



CONNECTIONS								
Buttweld	BW	ANSI B16.25						
Flanged	FLG	ANSI B16.5						
Socket Welding	SW	ANSI B16.11						
Screwed	NPT BSP	ANSI B1.20.1 ANSI BS21						
SIZES								
from 1/2" to 6"								

## LIMITING CONDITIONS

Steam Trap rating	600								
Max Working Differential Pressure	TIBA Dp10 bar			BA Dp20 bar	par TIBA Dp60 bar				
Min Working Differential Pressure				0,1	bar				
PMOB: max working back pressure				80	)%				
Body and Cover MaterialA105A182 F304A350 LF2A182 F316		F304 F316	A182 F304L A182 F316L	A182 F11 Cl.2 A182 F22 Cl.3 A182 F91	A182 A182	F321 F347	A182 F44 A182 F51 A182 F53		
PMA: Max allowable pressure	103bar at 280°C	99bar a	t 425℃	82bar at 260°C	103bar at 450°C	99bar a	t 425℃	103bar at 450°C	
TMA: max allowable temperature	400°C at 70bar	530°C a	t 74bar	425°C at 55bar	530°C at 75bar	530°C a	t 74bar	530°C at 75bar	
PMO: max working pressure	103bar at 280°C	99bar at 425°C		82bar at 260°C	103bar at 450°C	99bar a	t 425℃	103bar at 450°C	
TMO: max working temperature	400°C at 70bar	530°C a	t 74bar	425°C at 55bar	530°C at 75bar	530°C a	t 74bar	530°C at 75bar	

#### GENERAL NOTE – STEAM TRAPS STANDARD PRODUCTION





# INVERTED BUCKET – STEAM TRAPS TIBA

**Doc. n°:** 11A261241 Rev.00

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Size		1/2"	3/4"	1"	1.1/4"	1.1/2"	2"	2.1/2"	3"
A (mm)		258	258	258	258	258	258	258	258
F (mm)		47	47	47	47	47	47	47	47
S(r	nm)	382	382	382	400	400	400	420	420
	150RF	460	470	480	490	505	505		
SF (mm)	300RF	470	480	490	505	515	515		
(/////)	600RF	485	495	515	515	525	525		
14/4	150#	47	47	49	51	53	53		
Wt (Kg)	300#	47	47	49	52	56	56		
	600#	47	48	51	53	59	59		

Hold phase



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# **INVERTED BUCKET – STEAM TRAPS** TIBA

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POS	DESCRIPTION	MATERIALS	MATERIALS	MATERIALS	MATERIALS	SPARES
1	Body	ASTM A105	ASTM A350 LF2	ASTM A182 F304	ASTM A182 F316	
2	Cover	ASTM A105	ASTM A350 LF2	ASTM A182 F304	ASTM A182 F316	
3	Bucket	AISI 304 or 316	AISI 304 or 316	AISI 304 or 316	AISI 304 or 316	Х
4	Lever	AISI 304 or 316	AISI 304 or 316	AISI 304 or 316	AISI 304 or 316	X
5	Gasket	SPW: F-Graphite W-316	SPW: F-Graphite W-316	SPW: F-Graphite W-316	SPW: F-GraphiteW-316	x
6	Pivot	AISI 304 or 316	AISI 304 or 316	AISI 304 or 316	AISI 304 or 316	Х
7	Support lever	AISI 304 or 316	AISI 304 or 316	AISI 304 or 316	AISI 304 or 316	x
8	Seat	AISI 410	AISI 410	AISI 410	AISI 410	X
9	Nuts	ASTM A193 B7	ASTM A320 L7	ASTM A193 B8	ASTM A193 B8	
10	Studs	ASTM A194 Gr.2H	ASTM A194 Gr.4	ASTM A194 Gr.8	ASTM A194 Gr.8	
11	Screwed	Stainless Steel	Stainless Steel	Stainless Steel	Stainless Steel	X

Note 1: Other Materials and Dimensions on Request



#### HOW TO INSTALL:

Vertical installation with vertical connection. Due to gravity, the condensate tends to go down, so the trap should be installed vertically below the point of the system condensate drainage .In this way, the inlet connection, located below the trap, maintain the bucket immersed in water. Recommended:

- Install a filter upstream of the trap.

- Install a check valve upstream from the trap when

you have loads of very low condensate or superheated steam.

- Check that the trap is properly sized to the plant before starting the installation.

#### HOW TO MAINTENANCE:

1. Before starting, wear the required safety equipment and follow all plant safety procedures.

2. Stop the main line to make sure that no residues

of dangerous waste fluid could be emitted.

3. Unscrew cover studs(10) and nuts(9), then remove the blind flange(2) and gasket(5).

4. Pick up the bucket (3) from lever (4).

5. Unscrew the lever guides.

- 6. Unscrew the valve seat (8) from the cover.
- 7. Screw a new seat to the cover.
- 8. Replace the guides, the lever and assemble the bucket (3).
- 9. Reposition the cover (2), then screw the studs(10) and nuts(9).
- 10. Slowly start the plant and check if there are any line losses.
- 11. Apply a label to the trap with the maintenance date.

#### **ORDER CODE**

- *i.e.* TIBA 2" 150RF A105
- TIBAS 2" 150RF A105



# INVERTED BUCKET– STEAM TRAPS TIBAO

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The inverted bucket type of steam trap is created for standard and special applications, designed to the customer's specifications, welded body.

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how it works:

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2- Start-up: when the condensate begins to circulate, the bucket is prevented from floating and the

steam trap eliminates the excess condensate.

3- As the system heats up, the condensate reduces and steam starts to arrive, accumulating inside the vessel, trapped under the inverted bucket, which allows it to float on the condensate and keep the shutter closed.

**4-** As the steam condenses, the bucket sinks, returning to the base of the vessel where it opens the escape valve, permitting the internal pressure to discharge the accumulated condensate. All of Blu Zac products have been designed to satisfy the requests and specific requirements of the customer, including high pressure applications.

#### MAIN FEATURES

Reduced dimension and weight simple and reliable. It discharges air. It withstands water hammer. Condensate discharge is intermittent. Some loss of live steam.

#### APPLICATION

- **G** Steam mains
- Tracing lines
- Turbines
- Marine applications
- Presses

### DISCARGE CAPACITY



BLUZAC

CONNECTIONS										
Buttweld	BW	ANSI B16.25								
Flanged	FLG	ANSI B16.5								
Socket Welding	SW	ANSI B16.11								
Screwed	NPT BSP	ANSI B1.20.1 ANSI BS21								

### SIZES from 1/2" to 2"

		( ac	cording	to ISO 6552 )				
Steam Trap rating				60	00			
Max Working Differential Pressure	TIBA Dp10 b	ar	TI	BA Dp20 bar	TIBA Dp40 b	ar	TII	BA Dp60 bar
Min Working Differential Pressure				0,1	bar			
PMOB: max working back pressure				80	)%			
Body and Cover Material	A105 A350 LF2	A182 A182	F304 F316	A182 F304L A182 F316L	A182 F11 Cl.2 A182 F22 Cl.3 A182 F91	A182 A182	F321 F347	A182 F44 A182 F51 A182 F53
PMA: Max allowable pressure	103bar at 280°C	99bar a	t 425℃	82bar at 260°C	103bar at 480°C	99bar a	t 425℃	103bar at 480°C
TMA: max allowable temperature	400°C at 85bar	530°C a	t 73bar	425°C at 54bar	530°C at 78bar	530°C a	t 73bar	530°C at 75bar
PMO: max working pressure	103bar at 280°C	99bar a	t 425℃	82bar at 260°C	103bar at 480°C	99bar a	t 425℃	103bar at 480°C
TMO: max working temperature	400°C at 85bar	530°C a	t 73bar	425°C at 54bar	530°C at 78bar	530°C a	t 73bar	530°C at 75bar

#### GENERAL NOTE – STEAM TRAPS STANDARD PRODUCTION



**Doc. n°:** 11A261530 Rev.00

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# INVERTED BUCKET- STEAM TRAPS

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Size		1/2"	3/4"	1"	1.1/4"	1.1/2"	2"	
A (mm)		436	436	436	452	452	460	
S(mm)		310	310	310	330	330	340	
B (mm)	600RF	431	447	450	470	480	495	
SF	600RF	410	415	425	455	460	470	
(mm)	600RJ	410	415	425	455	460	475	
Wt (Kg)	600#	86	87	88	92	96	122	



	INVERTED BUCKET- STEAM TRA
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POS	DESCRIPTION	MATERIALS	MATERIALS	MATERIALS	MATERIALS	SPARES
1	Body	ASTM A105	ASTM A350 LF2	ASTM A182 F304	ASTM A182 F316	
2	Cover	ASTM A105	ASTM A350 LF2	ASTM A182 F304	ASTM A182 F316	
3	Bucket	AISI 304 or 316	AISI 304 or 316	AISI 304 or 316	AISI 304 or 316	Х
4	Lever	AISI 304 or 316	AISI 304 or 316	AISI 304 or 316	AISI 304 or 316	X
5	Gasket	SPW: F-Graphite W-316	SPW: F-Graphite W-316	SPW: F-Graphite W-316	SPW: F-GraphiteW-316	x
6	Pivot	AISI 304 or 316	AISI 304 or 316	AISI 304 or 316	AISI 304 or 316	X
7	Support lever	AISI 304 or 316	AISI 304 or 316	AISI 304 or 316	AISI 304 or 316	x
8	Seat	AISI 410	AISI 410	AISI 410	AISI 410	Х
9	Nuts	ASTM A193 B7	ASTM A320 L7	ASTM A193 B8	ASTM A193 B8	
10	Studs	ASTM A194 Gr.2H	ASTM A194 Gr.4	ASTM A194 Gr.8	ASTM A194 Gr.8	
11	Screwed	Stainless Steel	Stainless Steel	Stainless Steel	Stainless Steel	Х
12	Inner Pipe	ASTM A312 TP316	ASTM A312 TP316	ASTM A312 TP316	ASTM A312 TP316	
14	Plug	Stainless Steel	Stainless Steel	Stainless Steel	Stainless Steel	

Note 1: Other Materials and Dimensions on Request

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#### HOW TO INSTALL:

Vertical installation with horizontal connection. Due to gravity, the condensate tends to go down, so the trap should be installed vertically below the point of the system condensate drainage .In this way, the inlet connection, located below the trap, maintain the bucket immersed in water. Recommended:

DS

- Install a filter upstream of the trap.

- Install a check valve upstream from the trap when

you have loads of very low condensate or superheated steam.

- Check that the trap is properly sized to the plant before starting the installation.

#### HOW TO MAINTENANCE:

1. Before starting, wear the required safety equipment and follow

- all plant safety procedures.
- 2. Stop the main line to make sure that no residues
- of dangerous waste fluid could be emitted.
- 3. Unscrew cover studs(10) and nuts(9), then remove the blind flange(2) and gasket(5).

4. Unscrew cover studs(10) and nuts(9), remove the blind flange(2) and gasket(5).

5.Pick up the bucket (3) from lever (4).

6.Unscrew the lever guides.

7. Unscrew the valve seat (8) from the cover.

8.Screw a new seat to the cover.

9. Replace the guides, the lever and assemble the bucket (3).

- 10. Reposition the cover (3), then screw the studs(10) and nuts(9).
- 11. Slowly start the plant and check if there are any line losses.

ORDER CODE

- *i.e.* TIBAO10 2" 150RF A105
- TIBAO10S 2″ 150RF A105



# INVERTED BUCKET– STEAM TRAPS TIBDO

**Doc. n°:** 11G130917 Rev.00

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#### GENERAL NOTE - STEAM TRAPS PRODUCTION

The inverted bucket type of steam trap is created for standard and special applications, designed to the customer's specifications, welded body.

Steam traps suitable for high pressures and capacities, usable for all applications.

how it works:

1- The bucket is placed on the base, the shutter is opened; in the steam trap there is no fluid of any kind.

**2-** Start-up: when the condensate begins to circulate, the bucket is prevented from floating and the steam trap eliminates the excess condensate.

3- As the system heats up, the condensate reduces and steam starts to arrive, accumulating inside the

vessel, trapped under the inverted bucket, which allows it to float on the condensate and keep the shutter closed.

**4-** As the steam condenses, the bucket sinks, returning to the base of the vessel where it opens the escape valve, permitting the internal pressure to discharge the accumulated condensate. All of Blu Zac products have been designed to satisfy the requests and specific requirements of the customer, including high pressure applications.

#### MAIN FEATURES

Reduced dimension and weight simple and reliable. It discharges air. It withstands water hammer. Condensate discharge is intermittent. Some loss of live steam.

#### APPLICATION

□ Steam mains

Tracing lines

- Turbines
- Marine applications
- Presses

#### DISCARGE CAPACITY



CONNECTIONS									
Buttweld	BW	ANSI B16.25							
Flanged	FLG	ANSI B16.5							
Socket Welding	SW	ANSI B16.11							
Screwed	NPT BSP	ANSI B1.20.1 ANSI BS21							

# SIZES from 1/2" to 2"

( according to ISO 6552 )												
Steam Trap rating				3	00							
Max Working Differential Pressure	TIBDO Dp5 b	bar	TIE	3DO Dp10 bar	TIBDO Dp20 bar	TIBDO Dp30 bar	TIBDO Dp40 bar					
Min Working Differential Pressure	0,1 bar											
PMOB: max working back pressure	80%											
Body and Cover Material	A105 A350 LF2	A182 F304 A182 F316		A182 F304L A182 F316L	A182 F11 Cl.2 A182 F22 Cl.3 A182 F91	A182 F321 A182 F347	A182 F44 A182 F51 A182 F53					
PMA: Max allowable pressure	51bar at 315°C	50bar a	nt 425℃	42bar at 260°C	52bar at 480°C	50bar at 425°C	52bar at 480°C					
TMA: max allowable temperature	400°C at 45bar	530°C at 48bar		425°C at 40bar	530°C at 50bar	530°C at 48bar	530°C at 50bar					
PMO: max working pressure	51bar at 315°C	50bar at 425°C		42bar at 260°C	52bar at 480°C	50bar at 425°C	52bar at 480°C					
TMO: max working temperature	400°C at 45bar	530℃ a	nt 48bar	425°C at 40bar	530°C at 50bar	530°C at 48bar	530°C at 50bar					

#### GENERAL NOTE - STEAM TRAPS STANDARD PRODUCTION

ORIENTATION	Not possible		CONNECTION		
	Vertical connection	Horizontal connection		BW or NPT or BSP	Flanged

**Doc. n°:** 11G130917 Rev.00

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# INVERTED BUCKET- STEAM TRAPS

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Size		1/2"	3/4"	1"	1.1/4"	1.1/2"	2"
A (mm)		160	160	160			
B (mm)		106	106	106			
S (mm)		120	120	120			
SF	150RF						
(mm)	300RF			225			
Wt	150#						
(Kg)	300#			6,9			





# INVERTED BUCKET– STEAM TRAPS TIBDO

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POS	DESCRIPTION	MATERIALS	MATERIALS	MATERIALS	MATERIALS	SPARES
1	Body	ASTM A105 + ASTM A240 F316/316L	ASTM A350 LF2 + ASTM A240 F316/316L	ASTM A182 F304 + ASTM A240 F316/316L	ASTM A182 F316 + ASTM A240 F316/316L	
2	Cover	ASTM A105	ASTM A350 LF2	ASTM A182 F304	ASTM A182 F316	
3	Bucket	AISI-316L	AISI-316L	AISI-316L	AISI-316L	Х
4	Lever	AISI-316L	AISI-316L	AISI-316L	AISI-316L	Х
5	Gasket	SPW: F-Graphite W-316	SPW: F-Graphite W-316	SPW: F-Graphite W-316	SPW: F-GraphiteW-316	X
6	Pivot	AISI-316L	AISI-316L	AISI-316L	AISI-316L	Х
7	Support lever	AISI-316L	AISI-316L	AISI-316L	AISI-316L	X
8	Seat	AISI 410	AISI 410	AISI 410	AISI 410	Х
9	Nuts	ASTM A193 B7	ASTM A320 L7	ASTM A193 B8	ASTM A193 B8	
10	Studs	ASTM A194 Gr.2H	ASTM A194 Gr.4	ASTM A194 Gr.8	ASTM A194 Gr.8	
11	Nut Seat	Stainless Steel	Stainless Steel	Stainless Steel	Stainless Steel	Х
12	Inner Pipe	ASTM A312 TP316L	ASTM A312 TP316L	ASTM A312 TP316L	ASTM A312 TP316L	
13	Washer	Stainless Steel	Stainless Steel	Stainless Steel	Stainless Steel	X
14	Plug	Stainless Steel	Stainless Steel	Stainless Steel	Stainless Steel	X

Note 1: Other Materials and Dimensions on Request



#### HOW TO INSTALL:

Vertical installation with horizontal connection. Due to gravity, the condensate tends to go down, so the trap should be installed vertically below the point of the

system condensate drainage .In this way, the inlet connection, located below the trap, maintain the bucket immersed in water. Recommended:

- Install a filter upstream of the trap.

- Install a check valve upstream from the trap when

you have loads of very low condensate or superheated steam.

- Check that the trap is properly sized to the plant before starting the installation.

#### HOW TO MAINTENANCE:

1. Before starting, wear the required safety equipment and follow all plant safety procedures.

2. Stop the main line to make sure that no residues

of dangerous waste fluid could be emitted.

3. Unscrew cover studs(10) and nuts(9), then remove the blind flange(2) and gasket(5).

4. Unscrew cover studs(10) and nuts(9), remove the blind flange(2) and gasket(5).

5.Pick up the bucket (3) from lever (4).

6.Unscrew the lever guides.

7. Unscrew the valve seat (8) from the cover.

8.Screw a new seat to the cover.

9. Replace the guides, the lever and assemble the bucket (3).

- 10. Reposition the cover (3), then screw the studs(10) and nuts(9).
- 11. Slowly start the plant and check if there are any line losses.

#### ORDER CODE

*i.e.* TIBDO5 2" 150RF A105 TIBDO5S 2" 150RF A105



# INVERTED BUCKET– STEAM TRAPS TIBEO

#### GENERAL NOTE - STEAM TRAPS PRODUCTION

The inverted bucket type of steam trap is created for standard and special applications, designed to the customer's specifications, welded body.

Steam traps suitable for high pressures and capacities, usable for all applications.

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#### MAIN FEATURES

Reduced dimension and weight simple and reliable. It discharges air. It withstands water hammer. Condensate discharge is intermittent. Some loss of live steam.

#### APPLICATION

- □ Steam mains
- Tracing lines
- Turbines
- Marine applications
- Presses

#### DISCARGE CAPACITY



CONNECTIONS								
Buttweld	BW	ANSI B16.25						
Flanged	FLG	ANSI B16.5						
Socket Welding	SW	ANSI B16.11						
Screwed	NPT BSP	ANSI B1.20.1 ANSI BS21						

# SIZES

from 1/2" to 2"

LIMITING CONDITIONS ( according to ISO 6552 )								
Steam Trap rating		300						
Max Working Differential Pressure	TIBEO Dp5 b	bar	TIE	BEO Dp10 bar	TIBEO Dp20 bar	TIBEO Dp30 bar	TIBEO Dp40 bar	
Min Working Differential Pressure	0,1 bar							
PMOB: max working back pressure	80%							
Body and Cover Material	A105 A350 LF2	A182 A182	F304 F316	A182 F304L A182 F316L	A182 F11 Cl.2 A182 F22 Cl.3 A182 F91	A182 F321 A182 F347	A182 F44 A182 F51 A182 F53	
PMA: Max allowable pressure	51bar at 315°C	50bar a	t 425℃	42bar at 260°C	52bar at 480°C	50bar at 425°C	52bar at 480°C	
TMA: max allowable temperature	400°C at 45bar	530°C a	t 48bar	425°C at 40bar	530°C at 50bar	530°C at 48bar	530°C at 50bar	
PMO: max working pressure	51bar at 315°C	50bar a	t 425℃	42bar at 260°C	52bar at 480°C	50bar at 425°C	52bar at 480°C	
TMO: max working temperature	400°C at 45bar	530°C a	t 48bar	425°C at 40bar	530°C at 50bar	530°C at 48bar	530°C at 50bar	

#### GENERAL NOTE - STEAM TRAPS STANDARD PRODUCTION









# INVERTED BUCKET– STEAM TRAPS TIBEO

**Doc. n°:** 11G211025 Rev.00

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	Size	1/2"	3/4"	1"	1.1/4"	1.1/2"	2″
A (mm)		150	150	155	155	155	155
B (mm)		85	85	85	85	85	85
S	(mm)	100	100	100	100	100	100
SF	150RF						
(mm)	300RF		195				
Wt	150#						
(Kg)	300#						







DIMENSION TOLLERANCE					
	DIMENSION*				
SIZE	s	SF & A B			
1/2" to 2.1/2"	± 1	± 1			
3" to 4"	± 2	± 2			

\*S, SF, A, H and H1 are in millimeters (mm)



# INVERTED BUCKET– STEAM TRAPS TIBEO

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POS	DESCRIPTION	MATERIALS	MATERIALS	MATERIALS	MATERIALS	SPARES
1	Body	ASTM A240 Gr.316/316L	ASTM A240 Gr.316/316L	ASTM A240 Gr.316/316L	ASTM A240 Gr.316/316L	
2	Cover	ASTM A105	ASTM A350 LF2	ASTM A182 F304	ASTM A182 F316	
3	Bucket	AISI-316L	AISI-316L	AISI-316L	AISI-316L	
4	Lever	AISI-316L	AISI-316L	AISI-316L	AISI-316L	
6	Pivot	AISI-316L	AISI-316L	AISI-316L	AISI-316L	
7	Support lever	AISI-316L	AISI-316L	AISI-316L	AISI-316L	
8	Seat	AISI 410	AISI 410	AISI 410	AISI 410	
11	Nuts Seat	Stainless Steel	Stainless Steel	Stainless Steel	Stainless Steel	
12	Inner Pipe	ASTM A312 TP316L	ASTM A312 TP316L	ASTM A312 TP316L	ASTM A312 TP316L	
13	Washer	Stainless Steel	Stainless Steel	Stainless Steel	Stainless Steel	
14	Plug	Stainless Steel	Stainless Steel	Stainless Steel	Stainless Steel	

Note 1: Other Materials and Dimensions on Reauest

#### ASSEMBLING PRE-WELD



#### ASSEMBLING AFTER-WELD



#### HOW TO INSTALL:

Vertical installation with horizontal connection. Due to gravity, the condensate tends to go down, so the trap should be installed vertically below the point of the system condensate drainage .In this way, the inlet connection,

located below the trap, maintain the bucket immersed in water. Recommended:

- Install a filter upstream of the trap.

- Install a check valve upstream from the trap when
- you have loads of very low condensate or superheated steam.
- Check that the trap is properly sized to the plant before starting the installation.

#### HOW TO MAINTENANCE:

The inverted bucket TIBEO doesn't allowed any kind of maintenance because body and cover are welded.

ORDER CODE

*i.e.* TIBEO5 1/2" 150RF A105