

- System Specification - for ABS Imperial (Inch)-sized Piping Systems

1. Scope

This specification covers requirements for the Georg Fischer **ABS** Piping System intended for a wide range of applications including water, wastewater and effluent treatment as well as a wide range of chemical applications. The components of the **ABS** Imperial (Inch)-sized piping systems are in accordance with the following standards.

2. Basic System Data

2.1 Material Specification for Acrylonitrile Butadiene Styrene (ABS)

ABS pipes, fittings and valves from Georg Fischer Piping Systems shall be manufactured from acrylonitrile butadiene styrene (**ABS**), of which pipes and fittings are designed for 25 years of operation with water as medium (20°C). **ABS** has also an optimal chemical resistance against salt solutions, dilute acids and bases. For detailed information, please refer to the list of chemical resistance provided by Georg Fischer Piping Systems. The raw material used shall be material designed for use with pressure bearing piping systems with long term hydrostatic properties in accordance with DIN EN ISO 15493, as supplied by Georg Fischer Piping Systems.

2.2 Characteristics of ABS Material

Characteristic	Value	Test Standards
Density	1.04 g/cm ³	ISO 1183-1
Tensile E-modules	>2000 N/mm ²	EN ISO 527-1
Charpy notched impact strength at 23 °C	>35 kJ/m ²	EN ISO 179/1eA
Charpy notched impact strength at -40 °C	10 kJ/m ²	EN ISO 179/1eA
Vicat heat distortion temp. B/50N	≥90 °C	ISO 306
Thermal expansion coefficient	0.1 mm/mK	DIN 53752
Temperature range in °C	-50°C to 60°C	
Colour	light grey; similar 7001 RAL	

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2.3 ABS Product Range

Products	d	3/8"	1/2"	3/4"	1"	1 1/4"	1 1/2"	2"	2 1/2"	3"	4"
	bar										
Pipe	15 - class E										
	12 - class D/T										
	9 - class C										
Fittings	15 - class E										
	10										
Ball Valve*	10										
Butterfly Valve*	10										
Check Valve*	10										
Diaphragm Valve*	10										
Flanges*	16										
	10										
Gaskets & Pipe Clips	15										
Sensors & Controllers	--										

* For detailed information please consult the GF Piping Systems online catalogue

For more detailed physical properties and product pressure – temperature curves, please consult the Georg Fischer Piping Systems Planning Fundamentals on the Georg Fischer Piping Systems website.

2.4 Approvals / Acceptance / Conformance

This material specification for **ABS** is met by Georg Fischer Piping Systems. Therefore Georg Fischer Piping Systems is approved according to BS standards. For more information please consult our approvals database on the Georg Fischer Piping Systems website.

Approvals		GOST-R	WRAS
Raw Material	Rohmaterial		
Pipe	Rohre		
Fittings	Fittings		
Valves**	Ventile*		
Flange	Flansch		
gaskets	Dichtungen		

* For details on which valve (ball, butterfly, diaphragm etc. ...) please contact GF database

3. Pipes

Pipes are made of **ABS** and processed according to the quality specifications and dimensions according to BS 5391-1.

Processed pipes are straight and show a very low out-of-roundness. The wall structure is homogeneous and even.

OD-tolerances surpass the requirements of BS 5391-1 and are compatible with the fitting programme of GF Piping Systems for easy pre-assembly and minimized gaps.

Any installation should follow the Georg Fischer Piping Systems installation guidelines for industrial piping and the guidelines issued by the German association of plastic pipe producers (KRV).

4. Fittings

All **ABS** fittings shall be Imperial (inch)-sizes manufactured by Georg Fischer Piping Systems and shall be of a type suitable for solvent cementing, with dimensions and tolerances in accordance with ISO 727-2 and BS 5392. They need to be tested according to -ISO 3126, ISO 1167 and EN 802. All threaded connections shall have pipe threads in accordance with the requirements of ISO 7-1.

4.1 Packaging and Labelling

The packaging must ensure that the fittings are not damaged during transportation.

Packaging and Labelling must meet the following requirements:

- Identification of the content, in type, quantity and product details
- Information about standards and approvals covered by the product
- Content of the label has to accomplish legal requirements
- Labels must be EAN coded for automatic identification
- Comply to Georg Fischer Piping Systems standards as well as to international standards such as ISPM 15

5. Accessories

5.1 Flanges

Backing flanges, Imperial (inch)-sized 1/2" – 8", shall be designed according to EN ISO 15493, in a thermo plastic-oriented design, consisting of 100% glass fibre reinforced polypropylene, PP-GF30, graphite black and UV stabilized. These flanges are manufactured in a seamless technology injection moulding process by Georg Fischer Piping Systems. The backing flange shall be optimised with a V-groove in the inner diameter to ensure an evenly distributed force on the thermo plastic flange adapter.

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The backing flanges shall be marked with dimension, PN-value, standards, brand and lot number. Connecting dimensions metric according to ISO 7005, EN 1092; Bolt circle diameter PN 10; Inch: ANSI B 16.5, BS 1560; class 150.

Alternatively backing flanges, Imperial (inch)-sized 1/2" – 8", shall be designed according to EN ISO 15493, consisting of unplasticised polyvinyl chloride (PVC-U), in a thermo plastic-oriented design. The backing flanges shall be marked with dimension, PN-value, standards, brand and lot number. Connecting dimensions metric according to ISO 7005, EN 1092; Bolt circle diameter PN 10; Inch: ANSI B 16.5, BS 1560; class 150.

5.2 Gaskets

Gaskets, Imperial (inch)-sized 3/8" – 8", shall consist of elastomeric material according to EN681, designed with or without metal reinforcement for use with solvent cementable flange adaptors according to EN ISO 15493. Gaskets with reinforcement shall be designed to be centred by the outer diameter and shall provide fixation aids to fit on the flange bolts.

5.3 Pipe Support System

Pipe Support System shall be KLIP-IT, Imperial (inch)-sized 3/8" – 8", supplied by Georg Fischer Piping Systems.

6. Valves

All **ABS** valves shall be Imperial (Inch)-sizes manufactured by Georg Fischer Piping Systems or equal in accordance with EN ISO 16135 (ball valves), 16136 (butterfly valves), 16137 (check valves), 16138 (diaphragm valves), tested according to the same standard.

6.1 Ball Valves

All **ABS** ball valves, Imperial (inch)-sized 1/2" – 4", shall be Georg Fischer Piping Systems Type **546 Pro or 543** with true double union design manufactured by Georg Fischer Piping Systems in accordance with EN ISO 16135. Incorporated into its design shall be a safety stem with a predetermined breaking point above the upper O-ring, preventing any media leaking in the event of damage. The valve nut threads shall be buttress type to allow fast and safe radial mounting and dismounting of the valve during installation or maintenance work. Seats shall be PTFE with backing rings creating self-adjusting seals and constant operating torque. Backing rings and seals shall be EPDM or FPM. **The handle is lockable as standard and shall include in its design an integrated tool for removal of the union bush. Union bushes shall have left-hand threads to prevent possible unscrewing when threaded end connectors are removed from pipe. A data-matrix code, equipped with production data, is**

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lasered on every single valve after passing a leakage test. Leakage requirements are in accordance with ISO 9393-2 and EN 12266 (leak rate A).

Following accessories shall be available:

- Electrical position feedback for ball valves (DN10 - 50) shall be inductive (PNP, NPN or NAMUR) with visual LED feedback in order to allow long life- and operating time. The sensor shall detect the valve position (and not the actuator position) – hence it shall detect the position feedback below the predefined breaking point of the valve to guarantee the correct valve position under all conditions. Its body shall be made of plastic (PBTGF20) together with IP 67 rating to ensure functioning under all conditions.
- Manual spring return unit (DN10 – 25) to ensure self-closing of the valve after manually opening it.
- Labelling (UV-, weather- and chemical resistant) of manual or automated ball valves incorporated in the design of the valve.
- Mounting plate in PPGF with integrated inserts for later screw mounting on any support

6.1.1 Electric Ball Valves

Electric actuators shall be Types EA15 (Imperial (inch)-sized 3/8" – 2"), EA25 (Imperial (inch)-sized 3/8" – 2"), EA45 (Imperial (inch)-sized 2-1/2" and EA 120 3" – 4".

They shall be manufactured by Georg Fischer Piping Systems in accordance with EN 61010-1, EC directives 2004/108/EC (EMC) and 2006/95/EC (LVD). Additionally they need to be CE marked. Actuator housing shall be made of PPGF (polypropylene glass fibre reinforced), flame retardant with external stainless steel screws. All electric actuators shall have an integrated emergency manual override and integrated optical position indication.

All electric actuator types shall have the following accessories available:

Accessories

EA15 / EA25 / EA45 / EA120 / EA250:

- Failsafe return unit
Battery incorporated into the housing for moving to a safe position in case of power outage (open or closed).

EA25 / EA45 / EA120 / EA250:

- positioner

For continuous valve control with 4-20mA or 0-10V and 4-20mA feedback

- Monitoring board
 - Cycle time extension
 - Cycle time monitoring

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- Cycle counter
- Motor current monitoring
- Fieldbus connection
 - Profibus DP auxiliary card
 - AS interface module

The system Specifications for electric actuators are as follows:

* at rated torque

Specification		
Combinations	EA15	2-Way Ball valve type 546 up to DN50 3-Way Ball valve type 543 up to DN50
	EA25	2-Way Ball valve type 546 up to DN50 3-Way Ball valve type 543 up to DN50
	EA45	2-Way Ball valve type 546 up to DN65 Butterfly valve types 567/578, Type 038/039
	EA120	2-Way Ball valve type 546 up to DN100 Butterfly valve types 567/578, type 038/039
	EA250	Butterfly valve types 567/578, type 038/039
	Rated voltage	AC
AC/DC		24 V, 50/60 Hz
Rated voltage tolerance	- 10 % ... + 15 %	
Protection class	IP67per EN 60529	
Contamination level	2 according to EN 61010-1	
Overload protection	Current/time-dependent (resetting)	
Overvoltage category	II	
Ambient temperature	-10 °C to +45 °C	
Allowable humidity	Max. 90% relative humidity, non-condensing	
Housing material	PP-GF for very good chemical resistance	

	EA15	EA25	EA45	EA120	EA250
Power input max.	45 VA	45 VA	65 VA	60 VA	70 VA
Rated torque MDN. (peak)	10 (20)	10 (25)	20 (45)	60 (120)	100 (250)
Duty cycle at 25 °C / 15 min	40%	100%	50 %	50 %	35 %
Cycle time s/90 at Mdn.	5s	5 s	6s	15 s	20 s
Connection	F05	F05	F05	F07	F07
Tested cycles (at 20 °C and Mdn.)	150 000	250 000	100 000	100 000	75 000
Weight	1.85 kg	2.193 kg	2.193 kg	3.356 kg	4.995 kg
Actuating angle	Max. 355°, set to 90 °				

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Furthermore, GF Piping Systems offers the smart Electric Actuator Types dEA 25, dEA45 or dEA120. These smart electric actuators have following features compared to above mentioned options:

- Connectivity via NFC and WiFi Direct ensuring control, identification and visibility without opening the case
- Most relevant asset data visualized in the app
- Connection and control via app possible
- LED stripe for visual open/close 360° feedback

6.1.2 Pneumatic Ball Valves

6.1.2.1 Pneumatic Ball Valves 1/2" to 2"

Pneumatic actuators shall be Georg Fischer Piping Systems Types PPA 08, PPA15, PPA 40 or PPA80. Pneumatic actuators shall be available as fail safe close, fail safe open and double acting and have an integrated optical position indication. Actuator housing shall be made of Polypropylene fibre glass reinforced (PPGF) and flame retardant. Actuators shall contain a preloaded spring assembly to ensure safe actuator operation and maintenance. Actuators shall contain integrated Namur interface for the easy mounting of positioners, limit switches and accessories. The valve shall be equipped with a Multi-functional-module for reliable electric feedback, mounted directly between the valve body and the actuator as manufactured by Georg Fischer Piping Systems. In case of a blocked ball, the predefined breaking point shall be within the interface (Multi-functional module) of the valve and the actuator. Thus, the manual ball valve does still work and shut down of the line is prevented.

Allocation ball valve to pneumatic actuator:

Control pressure range	Pneumatic Actuator	DN	DN10 /15	DN20	DN25	DN32	DN40	DN50	DN65	DN 80	DN100
5.6 bar	PPA08 FC / FO	DN 10 - 20									
	PPA15 FC / FO	DN 25 - 32									
	PPA40 FC / FO	DN 40 - 50									
	PPA80 FC / FO	DN 65 - 100									
4.2 - 5.6 bar	PPA04 DA (NO NAMUR)	DN 10/15									

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PPA08 DA	DN 10 - 25									
PPA15 DA	DN 32 - 40									
PPA40 DA	DN 50 - 80									
PPA80 DA	DN 100									

6.1.2.2 Pneumatic Ball Valves 2 1/2” to 4”

- For valve size 2-1/2” pneumatic actuators shall be Type **PPA 80** or PA 30 (fail safe to close or open function), **Type PPA 40** or PA35 (double acting function).
- For valve size 3” pneumatic actuators shall be Type **PPA 80** or PA 35 (fail safe to close or open function), Type **PPA 40** or PA40 (double acting function).
- For valve size 4” pneumatic actuators shall be Type **PPA 80** or PA 45 (fail safe to close or open function), Type **PPA 80** or PA45 (double acting function)

Pneumatic actuators shall have an integrated optical position indicator. Actuator housing shall be made of hardened anodized aluminium. Actuators shall contain integrated Namur interface for the easy mounting of positioners, limit switches and accessories.

All pneumatically actuated ball valves shall have the following accessories available:

- Pilot valve remote or direct mounted in voltages 24VDC/AC, 110VAC, 230VAC
- Positioner: Electro-pneumatic positioners series RPC, RPC D, RPC PID for reliable control of pneumatic rotating valves
 - 24V DC supply voltage with 4-20 mA control and analogue feedback
 - Multi-pole plug for easy electrical connection
 - Different function levels standard, extended with display and PID
- Simple commissioning via TUNE function
- Electrical position feedback for ball valves (DN10 - 50) shall be inductive (PNP, NPN or NAMUR) with visual LED feedback in order to allow long life- and operating time. The sensor shall detect the valve position (and not the actuator position) – hence it shall detect the position feedback below the predefined breaking point of the valve to guarantee the correct valve position under all conditions. Its body shall be made of plastic (PBTGF20) together with IP 67 rating to ensure functioning under all conditions. Stroke limiter only for PA11 and PA21
- Manual override for all sizes up to d4”
- AS Interface control module with incorporated position feedback and a solenoid pilot valve

- System Specification -**6.2 Diaphragm Valves****6.2.1 Manual Diaphragm Valves****6.2.1.1 Manual Diaphragm Valves 1/2" to 2"**

All **ABS** diaphragm valves, Imperial (inch-) sized 1/2" – 2", shall be either:

- Type 514 (true double union design, 1/2" – 2")
- Type 517 (flange design, 1/2" – 2")

All diaphragm valves shall be manufactured by Georg Fischer Piping Systems in accordance with EN ISO 16138. The upper body shall be PPGF (polypropylene glass fibre reinforced) connected to the lower body with a central union avoiding exposed screws. A two-coloured position indicator integrated into the hand wheel must be present to determine diaphragm position. The hand wheel shall have an integrated locking mechanism. Diaphragms are to be EPDM, FPM, NBR, PTFE with EPDM or FKM backing diaphragm.

Following options shall be available:

- PN10 pressure rating
- Electrical feedback unit with either Ag-Ni or AU contacts
- Pressure proof housing

The diaphragm valve shall have following KV values:

d [mm]	DN [mm]	CV 100 [gal/min @ ΔP=1 PSI]
20	15	9
25	20	19
32	25	39
40	32	52
50	40	87
63	50	119

6.2.1.2 Manual Diaphragm Valves 2-1/2" to 4"

All **ABS** diaphragm valves, Imperial (inch-) sized 2-1/2" – 4", shall be Type 317 (flanged design). All diaphragm valves shall be manufactured by Georg Fischer Piping Systems in accordance with EN ISO 16138. The upper body shall be PPGF (polypropylene glass fibre reinforced) connected to the lower body with exposed stainless-steel bolts. A position indicator integrated into the hand wheel must be present to determine diaphragm position. Diaphragms are to be EPDM, FPM, NBR, or PTFE with EPDM or FKM backing diaphragm.

- System Specification -**6.2.2 Pneumatic Diaphragm Valves****6.2.2.1 Pneumatic Diaphragm Valves 1/2" to 2"**

All **ABS** diaphragm valves, Imperial (inch-) sized 1/2" – 2", shall be either:

- Type 514 (true double union design, 1/2" – 2")
- Type 517 (flange design, 1/2" – 2")

All diaphragm valves shall be manufactured by Georg Fischer Piping Systems in accordance with EN ISO 16138. The upper body shall be connected to the lower body with a central union nut avoiding exposed screws.

Diaphragms are to be EPDM, FPM, NBR, PTFE with EPDM or FKM backing diaphragm. The diaphragm valve shall have following KV values:

d [mm]	DN [mm]	CV 100 [gal/min @ ΔP=1 PSI]
20	15	8
25	20	16
32	25	29
40	32	45
50	40	76
63	50	194

* DIASTAR Six

Pneumatic actuators shall be Georg Fischer Piping Systems Type DIASTAR and shall be available as

- DIASTAR Six for PN up to 6bar (one side)
- DIASTAR Ten for PN up to 10bar (one side)

The mode of operation shall be fail safe close (FC), fail safe open (FO) and double acting (DA). The valves shall have an integrated optical position indicator. Actuator housing shall be made of PPGF (polypropylene glass fibre reinforced). Actuators with FC mode shall contain a preloaded galvanised steel spring assembly to ensure safe actuator operation and maintenance.

The actuator DIASTAR Ten, shall have following accessories available:

- Solenoid pilot valve remote or direct mounted in voltages 24VDC/AC, 110VAC, 230VAC
- Positioner: Electro-pneumatic positioners series SPC, SPC*, SPC D, SPC PID, SPC Lite for reliable control of pneumatic stroke valves
 - 24V DC supply voltage with 4-20 mA control and analogue feedback
 - Multi-pole plug for easy electrical connection
 - Different function levels standard, extended with display and PID
 - Simple commissioning via TUNE function
- Feedback with following limit switches Ag-Ni, Au, NPN, PNP, NAMUR

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- Stroke limiter & emergency manual override
- ASI controller

6.2.2.2 Pneumatic Diaphragm Valves 2-1/2" to 4"

All **ABS** diaphragm valves, Imperial (inch)-sized 2-1/2" – 4", shall be flanged design. All diaphragm valves shall be manufactured by Georg Fischer Piping Systems in accordance with EN ISO 16138. The upper body shall be connected to the lower body with exposed stainless-steel bolts. Diaphragms are to be EPDM, FKM, NBR, or PTFE with EPDM or FKM backing diaphragm.

Pneumatic diaphragm actuators shall be Georg Fischer Piping Systems Type DIASTAR Type 025. The mode of operation shall be fail safe close (FC), fail safe open (FO) and double acting (DA). The valves shall have an integrated optical position indicator. Actuator housing shall be made of PPGF (polypropylene glass fibre reinforced). Actuators with FC mode shall contain a preloaded galvanised steel spring assembly to ensure safe actuator operation and maintenance. The actuator DIASTAR 025 shall have following accessories available:

- Solenoid pilot valve remote or direct mounted in voltages 24VDC/AC, 110VAC, 230VAC
- Positioner: Electro-pneumatic positioners series SPC, SPC*, SPC D, SPC PID, SPC Lite for reliable control of pneumatic stroke valves
 - 24V DC supply voltage with 4-20 mA control and analogue feedback
 - Multi-pole plug for easy electrical connection
 - Different function levels standard, extended with display and PID
 - Simple commissioning via TUNE function
- Feedback with following limit switches AgNi, Au, NPN, PNP, NAMUR
- Stroke limiter & emergency manual override
- ASI Controller

6.3 Butterfly Valves

All **ABS** butterfly valves, with metric sizes 2-12", shall be GF Piping Systems 567/565 (wafer type) or 578 (lug type). The Types 567, 578 and 563 have a double eccentric disc design. All valves are manufactured by GF Piping Systems in accordance with EN ISO 16136. Butterfly valves $\geq 8"$ are available in PP-H or metal. Seals shall be available in both EPDM, FKM and PTFE/FKM. The lever handle shall be lockable in increments of 5 degrees.

There shall always be six teeth engaged between the ratchet and the index plate to ensure accurate and safe positioning of the lever. There shall be the option of fine adjustment by use of a specific hand lever, allowing the disc to be exposed at any angle between 0° und 90°. As an option, the hand lever shall be lockable. The option

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of an integrated electric position indicator shall be available. Optional the valves can be actuated by gear box with hand wheel. The electric position indicator shall be integrated into the mounting flange. Butterfly valves shall have low actuation torque to enable easy operation. All butterfly valves Type 567 / 578 manufactured by GF Piping Systems are designed for a nominal pressure rate of 10bar (2-8") and 8 bar (10-12"). All butterfly valves Type 563 are designed for a nominal pressure rate of 4 bar. The butterfly valve type 565 is designed for a nominal pressure rate of 16 bar (2-6"), 10 bar (8-10") and 6 bar (12").

Following accessories are available for the Type 565:

- Electrical position feedback for butterfly valves (DN10 - 50) shall be inductive (PNP, NPN) with visual LED feedback in order to allow long life- and operating time. The sensor shall detect the valve position (and not the actuator position) – hence it shall detect the position feedback of the shaft to guarantee the correct valve position under all conditions. Its body shall be made of plastic (PBTGF20) together with IP 67 rating to ensure functioning under all conditions

6.3.1. Electric Butterfly Valves

Electric actuators shall be Georg Fischer Piping Systems Types EA 45, EA 120 or EA250 dependent on valve size. They shall be manufactured by Georg Fischer Piping Systems in accordance with EN 61010-1, as per the above specifications. Actuator housing shall be made of PPGF (polypropylene glass fibre reinforced), flame retardant and feature external stainless steel screws. All electric actuators shall have an integrated emergency manual override and integrated optical position indication. All electric actuator types shall have the following accessories available:

- Failsafe return unit
Battery incorporated into the housing for moving to a safe position in case of power outage (open or closed).
- Simple commissioning via TUNE function

For continuous valve control with 4-20mA or 0-10V and 4-20mA feedback

- Monitoring board
 - Cycle time extension
 - Cycle time monitoring
 - Cycle counter
 - Motor current monitoring
- Fieldbus connection
 - Profibus DP auxiliary card
 - AS interface module

Furthermore GF Piping Systems offers the smart Electric Actuator Types dEA45, dEA120 or dEA250. This smart Actuators have following features compared to the above mentioned options:

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- Connectivity via NFC and Wi-Fi Direct ensuring control, identification and visibility without opening the cas
- Most relevant asset data visualized in the app
- Connection and control via app possible
- LED stripe for visual open/close 360° feedback

6.3.2. Pneumatic Butterfly Valves

Pneumatic actuators shall be Georg Fischer Piping Systems Types PA 35 (Imperial (inch)-sized 2" – 2-1/2"), PA40 (Imperial (inch)-sized 3" inch only), PA45 (Imperial (inch)-sized 4" – 5"), PA55 (Imperial (inch)-sized DN 6" – 8"), PA65 (Imperial (inch)-sized 10" FC) PA70 (Imperial (inch)-sized 12" FC). They shall be supplied by Georg Fischer Piping Systems. Pneumatic actuators shall be available as fail safe close, fail safe open and double acting and have an integrated optical position indication. Actuator housing shall be made of hardened anodized aluminium. Actuators shall contain integrated Namur interfaces for the easy mounting of positioners, limit switches and accessories. All pneumatically actuated butterfly valves shall have the following accessories available:

- Solenoid pilot valve remote or direct mounted in voltages 24VDC/AC, 110VAC, 230VAC
- Positioner: Electro-pneumatic positioners series RPC, RPC D, RPC PID for reliable control of pneumatic rotating valves
 - 24V DC supply voltage with 4-20 mA control and analogue feedback
 - Multi-pole plug for easy electrical connection
- Different function levels standard, extended with display and PID
- Simple commissioning via TUNE function
- Electrical position feedback for ball valves (DN10 - 50) shall be inductive (PNP, NPN) with visual LED feedback in order to allow long life- and operating time. The sensor shall detect the valve position (and not the actuator position) – hence it shall detect the position feedback of the shaft to guarantee the correct valve position under all conditions. Its body shall be made of plastic (PBTGF20) together with IP 67 rating to ensure functioning under all conditionsStroke limiter & emergency manual override
- ASI-controller

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6.4 Check Valves

6.4.1 Cone Check Valves

All **ABS** Cone Check Valves, according to EN ISO 16137, Imperial (inch)-sized 3/8" – 4", shall be Type 561 / 562 true double union design. Seals shall be EPDM or FKM, FFKM can be an option. Union bushes shall have a left hand thread to prevent possible unscrewing when threaded end connectors are removed from pipe. This valve shall be suitable for mounting in a vertical and horizontal position. Type 562 shall be equipped with a spring made of stainless steel (V2A) to allow position independent installation. The valves are designed for a nominal pressure of 10bar. Type 561 shall be leakproof from a water column of 2m (0.2bar). Type 562 shall be leakproof from a water column of 1m (0.1bar)

6.4.2 Angle Seat Check Valves

All **ABS** Angle Seat Check Valves, Type 303 shall be manufactured by Georg Fischer Piping Systems according to EN ISO 16137 and overall length according to EN 558-1, available in Imperial (inch)-sized 3/8"- 2" with EPDM or FPM seals and with solvent cement spigots. The Angle Seat Check Valves shall be leakproof from a water column of 2m for EPDM and 3m for FPM seals as supplied by Georg Fischer Piping Systems.

The Angle Seat Check valves manufactured by Georg Fischer Piping Systems are designed for a nominal pressure rate of 10bar.

6.9 Ventilating- and Bleed Valves

All **ABS** Ventilating- and Bleed valves shall be GF Piping System type 591. Dimensions 3/8" – 4" are with pressure rating PN10. They shall be equipped with a PP-H floater with density of 0.91 g/cm³.

6.10 Ventilating Valves

All **ABS** Ventilating Valves shall be GF Piping System type 595. Dimensions 1/2" – 4" are with pressure rating PN10. They shall be equipped with a coated stainless steel spring with minimal opening pressure (10-80 mbar).

7. Solvent Cement & Cleaner

For adhesive jointings, **ABS** cement with gap-filling adhesives must be used for solvent cementing. Georg Fischer Piping Systems recommends the Henkel cement system TANGIT ABS for all **ABS** solvent cement joints. All specifications are based on using TANGIT ABS, including strength and chemical resistance. For all other cements please refer to the manufacturers' instructions.

ABS TANGIT contains app. 20% **ABS**, dissolved in a blend of solvents. The solvents soften and macerate the edges of the surfaces they are applied to. Once the solvents

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have evaporated, they leave a homogenous joint with the same mechanical, thermic and chemical properties as of the **ABS** pipe system.

The jointing surfaces of pipe and fitting must be clean and free of grease. They must be cleaned with TANGIT cleaner.

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8. Measurement & Control / Instrumentation

The following parameters can be measured (Sensors), indicated and/ or transmitted (transmitters) to PLC, PC and other Data Acquisition Systems. All products comply with the CE standard.

Parameter	Technology	Compatible liquids (*)
Flow	Paddlewheel	clean liquids
	Rotameter	clean liquids
	Magmeter	contaminated liquids
Level	Hydrostatic/Ultrasonic/Radar	all liquids
pH-ORP	Glas electrodes	all liquids
Conductivity	Contact	all liquids
Pressure	Piezoresistive	all liquids
Temperature	Pt1000	all liquids

(*) please check first the sensors limitations in material, pressure and temperature (data sheet) and chemical resistance list

8.1 Sensors

The sensors listed hereafter will transfer the measured value to a GF Piping Systems Transmitter, to indicate the measured value and allowing simple calibration and maintenance of the devices. Alternatively the measured values of the sensors can be sent directly to a PLC, PC or other local made electronics using either an analogue signal (4-20mA, open collector or sinusoidal voltage) or a digital signal called S3L (GF Piping Systems Signet serial signal).

8.1.1 Installation Fittings

Depending on the sensor type, special installation fittings shall be used for connection to the pipeline. Sensor thread connection for flow- and pH-sensors shall be 1 1/4" NPSM. For all further sensors standard adaptor sockets or nipples with 1/2", 3/4" ISO, or 3/4" NPT thread shall be used.

8.1.2 Flow sensors

8.1.2.1 Paddlewheel sensors

515 and 525 sensors:

All sensors of this family are "sinusoidal" sensors. This sensor from GF Piping Systems SIGNET requires no external power source to produce a signal. Internal to the body of the sensor is a wire coil which when excited by the rotor assembly produces a small sinusoidal signal. The rotor assembly consists of four paddles; inserted into each of the paddles of the rotor are magnets. As liquid flows past the rotor assembly it rotates

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each of the four paddles produces a sine wave signal as it passes the centre of the body (two paddles of the rotor produces a full AC sine wave).

The sensors as manufactured by GF Piping Systems SIGNET produce a signal output which is proportional to the flow rate. A K-factor (number of pulses generated by the sensor per 1 liter or 1 gallon of fluid the sensor) is used to define the size of the pipe that the sensor is inserted into.

3-2536 and 3-2537 sensors:

All sensors of this family of sensors are “Hall Effect” sensors. Internal to the GF Piping Systems SIGNET sensors body is an open collector relay. The sensor is supplied with a voltage from the 3-8550 transmitters or an external power supply ranging from 5 to 24 volts. This voltage is switched through the open collector relay as the paddlewheel (rotor) of the sensor rotates. The sensor’s rotor assembly has four paddles. Inserted in two of the paddles is a magnet. As the paddles pass the centre of the sensors body, the magnetic field switches the open collector relay on and off which generates a square wave pulse as manufactured by GF Piping Systems SIGNET. Two pulses indicates a complete rotation (on/off cycle) of the open collector relay. The pulse output is directly proportional to the fluid velocity. A K-factor (number of pulses generated by the sensor per 1 liter or 1 gallon of fluid passing the sensor) is used to define the size of the pipe that the sensor is inserted into.

8.1.2.2 Rotameters

As supplied by GF Piping Systems are radially installed dismountable meters for flow rate measuring in industrial piping applications. If needed, minimum or maximum flow can also be monitored via limit switches. In addition, analogue flow measurement with a 4 to 20mA signal is possible.

The working principle of the rotameter is based in gravity and equilibrium of forces. If a medium flow upwards at a sufficient flow rate through the vertically mounted taper tube, the float is raised to the point, at which a state of equilibrium sets in between the lifting force of the medium and the weight of the float. Since the mean rate of flow is proportional to the quantity flowing through per unit of time, this state of equilibrium corresponds to the measurement of the instantaneous flow rate.

Following types and sizes are available:

- Type SK, 3/8” to 1”
- Type 335, 1” to 2½”
- Type 350, 1” to 2½”

8.1.2.3 Magmeter

The Magmeter sensor from GF Piping Systems SIGNET consists of two metallic pins that produce a small magnetic field across the inside of the pipe. The The Magmeter measures the velocity of a conductive liquid (20 μ S or greater) as it moves across the magnetic field produced by the Magmeter. A voltage occurs on the sensor tips, which

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is directly proportional to the flow rate of the fluid. The magnetic signal is conditioned and translated in to a pulse signal. A K-factor (number of pulses generated by the sensor per 1 liter or 1 gallon of fluid passing the sensor) is used to define the size of the pipe that the sensor is inserted into. The Magmeter of GF Piping Systems SIGNET is offered as a blind frequency, 4-20 mA or digital S3L output, or with integral display and control relays.

8.1.2.4 Ultrasonic Flowmeter

The U3000/4000 and PF220/330 from GF Piping system are transit time ultrasonic flow meter designed to work with clamp-on transducers, to provide accurate measurement of liquid flowing within a closed pipe, without the need for any mechanical parts to be inserted through the pipe wall or to protrude into the flow system. It takes just a few minutes to install and there is no need to shut down flow or drain the system! From process control in industrial applications, to water management from raw to deionized water, the Ultraflow 3000/4000 for fixed installation and the PF220/330 for portable flow monitoring cover a wide spectrum of flow monitoring and process control in many industries.

Using ultrasonic transit time techniques enables to be used with pipes having an outside diameter range from d13 to d2000 as standard and up to d5000 as an option. The instruments will also operate over a wide range of fluid temperatures. All of the Ultrasonic Flowmeters have the same basic features.

However, the standard U4000 and PF330 can also perform data logging and allows site details and flow data to be reordered with a memory, that is able to log more than 150 000 separate readings. The standard U4000 and PF330 is also capable of downloading the stored data via the USB or RS232 interface to the Portagraph software supplied with the unit.

8.2 Level Sensor and Level Switches

8.2.1 Hydrostatic Level Sensors

Hydrostatic pressure is the pressure exerted on a column of fluid by the weight of the fluid above it. Internal to the GF Piping Systems SIGNET PVDF sensor body is a ceramic diaphragm sensor and capillary tube/cable assembly. The ceramic diaphragm sensor exposed to the fluid senses the hydrostatic pressure of the fluid and compares the pressure to the atmospheric pressure monitored the capillary tube/cable assembly. The hydrostatic level sensor from GF Piping Systems SIGNET only senses the hydrostatic pressure of the fluid. The Level Sensor is offered as a blind output 4-20 mA or digital S3L output connected to the GF Piping Systems SIGNET Transmitter unit.

8.2.2 Ultrasonic Level

8.2.2.1 Ultrasonic Level Sensors (Series 2260 / 2270)

Ultrasonic level sensors are non-contact devices, using the travel time of sound and its reflection, for measuring the distance to a liquid or solid surface. Based on this information, GF Piping Systems sensors are capable of calculating a liquid level or volume. Their outstanding narrow 5° beam, allow reliable measurement even at the presence of disturbing objects or when space is limited. The GF Piping Systems portfolio contains sensing ranges 4 m, 6 m and 15 m.

Sensors with integrated display or blind sensors are available and provide 4-20 mA, HART protocol or relay outputs. GF Piping Systems ultrasonic level sensors are compatible with GF Piping Systems transmitters, indicators, controllers and valve actuators.

8.3 Radar

8.3.1 Radar 2290

The 25 GHz (K-band) 2290 Pulse Radars are the most progressive non-contact level transmitters for industrial processes. With an excellent accuracy, compact antennas and a user-friendly set-up the 2290 is an effective, simple, low cost choice for demanding level applications. GF's new K-band radar featuring ± 3 mm (± 0.1 inch) accuracy and short dead band excels with its robust full plastic housing. Its antenna range incorporates a stainless steel horn and enclosed plastic tube choices. The enclosed antenna versions can be replaced without removing the antenna enclosure from the process. Local programming of type 2290 is aided by a plug-in display module. The signal processing algorithm of the 2290 is based on years of experience with non-contact level measurement making it an excellent choice for applications simple and challenging alike. Process enclosures are available in PTFE, PP & PE

8.3.2 Radar 2291

With its ability to read accurately when other non-contacting or invasive methods fail, the guided level transmitter type 2291 using GWR (guided wave radar) is the solution to your level needs.

The radar signal is sent down the probe assembly eliminating the interferences caused by low dielectric liquids, heavy fuming, slightly conductive foams, internal tank obstructions, etc. By focusing its energy along the probe, the type 2291 can be installed in tanks with limited space. The type 2291 is also less sensitive to turbulence that would normally upset the readings in ultrasonic and unguided radar technologies. The probes are also available as coated options in FEP & PFA

8.4 Point Level Switches (Series 2280)

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The GF Piping Systems portfolio of point level switches contains various different detection technologies, to provide a solution for various liquids and application requirements.

- **Type 2280**
Vibration Forks detect a liquid level with two vibrating stainless steel wings. In air they vibrate with a specific, calibrated frequency. By the contact with a liquid the frequency changes which forces an electrical output to switch. GF Piping Systems vibration forks are equipped with digital PNP/NPN or relay output. Versions with ATEX or WHG approval are available.
- **Type 2281**
Conductive Multipoint Switch contains up to 5 stainless steel electrodes, which allow to detect 4 different liquid levels in a tank. Up to 2 external relay pairs allow to switch pumps or valves. GF Piping Systems conductive multipoint switches work with liquids of min. 10 μ S conductivity.
Their four-in-one design allows fast installation and provides attractive solutions concerning costs.
- **Type 2282**
Guided Float Switches are equipped with an air filled float with embedded magnet. Rising liquid lifts up the float. The magnetic field forces a reed contact to switch. GF Piping Systems guided float switches are available in PP and PVDF to provide best chemical compatibility to corrosive liquids.
- **Type 2284**
Ultrasonic Gap Switches are equipped with an ultrasonic transducer and receiver in their fork tips. Based on the switch design, the sound waves are damped in air. Thus the output is disabled. In contact with liquid the sound waves start to travel from transmitter to receiver, which enables the output. GF Piping Systems ultrasonic gap switches provide an electronic relay output which allows to control pumps and valves. Thanks to their PPS full-plastic body they provide a very high resistance against mechanical impacts and corrosive liquids. They work with no moving parts, so they do not require any maintenance.
- **Type 2285**
Float Switches are primarily used in open basins and pump shafts for detecting liquid level. In an empty tank they hang in vertical position, attached to the tank wall at their cable. Rising liquid carry them on the liquid surface. At an angle of approximately 45° an integrated switch is enabled. GF Piping Systems float switches are double chambered and equipped with a mercury-free switch. Hence they may be used for drinking and for waste water applications.

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8.5 Analytic

8.5.1 pH Sensors

All pH sensors from GF Piping Systems SIGNET are constructed commonly called combination electrodes. The measuring cell is constructed of hydrogen sensitive glass that can detect the concentration of hydrogen ions (+H) in a solution. The concentration of +H ions directly determines the pH of the fluid. The reference cell is used to provide a stable reference signal. The pH signal is measured against the stable reference signal. The reference junction allows the reference cell to come in contact with the fluid being measured. The measured signals are then conditioned and sent as a blind 4-20 mA or as a digital S3L signal to the GF Piping Systems SIGNET Transmitter unit.

8.5.2 ORP Sensors

All ORP sensors from GF Piping Systems SIGNET are constructed similar to the pH sensors, except that a noble metal like platinum or gold replaces the silver chloride element of the measuring and reference cell of the pH electrode. Temperature compensation is not used in ORP measurements as well. ORP is an abbreviation for Oxidation-Reduction Potential. Oxidation is a term used to denote the occurrence of a molecule losing an electron. Reduction occurs as a molecule gains an electron. The “potential” is simply an indication of a solution’s propensity to contribute or accept electrons. ORP reactions (sometimes referred to as REDOX) always take place simultaneously. There is never oxidation without reduction, and ORP electrodes are used to detect electrons exchanged by molecules as these reactions occur. The measured signals are then conditioned and sent as a blind 4-20 mA or as a digital S3L signal to the GF Piping Systems SIGNET Transmitter unit.

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8.5.3 Conductivity Sensors

All Conductivity sensors from GF Piping Systems SIGNET are manufactured using two stainless steel electrodes. Alternative materials are available in case of chemical incompatibility. Conductivity sensors measure the ability of a fluid to conduct an electrical current between two electrodes. The proper term for this ability of a solution is electrolytic conductivity, since only ions conduct electric current in solution. Electrolytic conductivity (or simply conductivity) is therefore an indirect measure of the ionic concentration of a solution. Generally, conductivity increases and decreases with the concentration of ions.

Most conductivity electrodes consist of two measuring half-cells. The geometry of the half-cells can be tailored to provide highly accurate measurements over a specific conductivity range. Cell constants help to describe electrode geometry for the purpose of selecting the appropriate electrode for a given application.

A cell constant is defined as the length between the two half cells divided by the area of the cells. All conductivity sensors have a temperature compensation circuits in order to increase the sensors accuracy.

The measured signals are then conditioned and sent as a blind 4-20mA or as a digital S3L signal to the GF Piping Systems SIGNET Transmitter unit.

8.6 Multi Parameter Instruments

8.6.1 Transmitters

The GF Piping Systems Signet 9900 Transmitter provides a single channel interface for many different parameters including Flow, pH/ORP, Conductivity/Resistivity, Salinity, Pressure, Temperature, Level and other sensors that output a 4 to 20 mA signal. The display shows separate lines for units, main and secondary measurements as well as a dial-type digital bar graph.

The 9900 is offered in both panel or field mount versions. Both configurations can run on 12 to 32 VDC power (24 VDC nominal). The 9900 can also be loop powered with compatible sensors.

Designed for complete flexibility, plug-in modules allow the unit to easily adapt to meet changing customer needs. Optional modules include Relay, Direct Conductivity/Resistivity, H COMM and a PC COMM configuration tool.

- 1 sensor input (Flow, pH/ORP, Conductivity/Resistivity, Salinity, Pressure, Temperature, Level and other sensors that output a 4 to 20 mA signal, Signet 8058 i-Go™ Signal Converter required)
- 1 analogue output (4-20 mA)
- 1 Open Collector output
- Optional relay module with 2 Dry Contact Relay SPDT
- Power supply 12-32 VDC

The GF Piping Systems Signet 8900 Multi-Parameter Controller takes the concept of modularity. Each 8900 is field commissioned with the users specified combination of inputs, outputs, and relays using simple-to-install modular boards into the base unit. Configure the system by selecting either two, four, or six input channels which accepts any of the Signet sensors listed below, and/or other manufacturer's sensors via a 4 to 20 mA signal converter (Signet Model 8058). To complete your unit, choose a power module with universal AC line voltage or 12 to 24 VDC. Analog output and relay modules are available and easily installed. Derived measurements include difference, sum, ratio, percent recovery, percent rejection, percent passage and BTU.

The menu system can be programmed to display in multi-languages including English, German, French, Spanish, Italian, and Portuguese.

- 2,4 or 6 sensor input (Flow, Level, pH-ORP, Conductivity, Pressure Temperature)
- 0,2 or 4 analogue output (4-20 mA or 0-10 Volts)
- 0,2,4,6 or 8 relay output
- Power supply 12-30 VDC or 110-230 VAC

8.7 Batch Control

The batch controller manufactured by GF Piping Systems Signet Type 5600 allows batching a pre-selected quantity of liquid. After selection of the quantity to be dosed, a start signal (local or remote) will close a batch controller contact to energize or de-energize a valve and/or switch on a pump. The batch controller count the pulses coming from any Signet sensor with frequency output and stop the batch process as the pre-selected quantity is reached. Advanced features include a user-set security code, an automatic calibration option, and overrun compensation The batch process is repeatable and is designed for intensive industrial applications.

9. Quality

9.1 Production Conditions

Pipes, fittings, solvent cement, cleaner, valves and accessories shall be manufactured in an environment operating a Quality Assurance System to ISO 9001 and an Environmental Management System conform to ISO 14001.

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9.2 Marking

All components are embossed with a permanent identification during the production process to ensure full traceability. The following information will be mentioned:

- Manufacturer's name or trade mark
- Production lot number
- Material
- Dimension
- Pressure rating

9.3 Uniformity

Pipes, fittings, valves, solvent cement and cleaner shall be supplied from one manufacturer, namely Georg Fischer Piping Systems, to ensure correct and proper jointing between components and uniform chemical and physical properties of the piping system.

9.4 CAD Library

All components shall be available in an online CAD library.

9.5 Training, Certification and Installation

Site personnel, involved with **ABS** piping installation, shall undergo training and certification from an authorised local institution prior to performing any jointing operations on site. For further information and training please contact Georg Fischer Piping Systems support under

Contact:

Georg Fischer Piping Systems Ltd.

Phone: +41 52 631 1111 or

e-mail: info.ps@georgfischer.com

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