

# Float Controlled Steam Trap Integrated with Sight Glass

User Manual



# 1 Important Safety Instructions to the Users

- This manual presents information that will help to install, operate and maintain the equipment properly. It is expected that the contents be carefully read before handling the equipment.
- All safety instructions and warnings given in these mounting and operating instructions, particularly those concerning installation, start-up and maintenance, must be strictly observed.
- To ensure appropriate use, only use the Float Trap in applications where the operating pressure and temperatures do not exceed the specifications used for sizing at the ordering stage.
- The manufacturer does not assume any responsibility for damage caused by external forces or any other external factors.
- Any hazards that could be caused in the float trap by the process medium, operating pressure or by moving parts are to be prevented by taking appropriate precautions.
- A good installation is a permanent asset while a bad one can be a constant source of trouble. It can cost much more to correct a bad installation than to put a new one.
- The float trap is a product of many years of knowledge, field experience & engineering effort, to provide long life & excellent service to the users. This unit will provide continued trouble-free service, if instructions on installation, operation and maintenance are properly followed.
- It is expected that the personal involved in Installation, Operation & Maintenance possess necessary qualification, competence, license & authority (if applicable) only should handle the product. It is solely the responsibility of the equipment owner & user to ensure that all applicable statutory (if applicable) norms are adhered to during Installation, Operation & Maintenance of this equipment.
- The mechanical devices supplied as a part of the unit are chosen because of their known ability to perform, with proper operating techniques and maintenance procedures.

Tampering with the safeties & controls or bypassing any of these is not permissible at any time.

- Any “Automatic” features included in the design do not relieve the attendant of any responsibility. Such features may free him of certain repetitive chores and give him more time to devote to the proper upkeep of the equipment.
- No amount of written communication can replace intelligent thinking & reasoning.

**The following symbols/terms have been used in this manual at the end of some chapters for the attention of the users:**



This is a symbol of “**warning**” to the equipment user & provides information about practices or circumstances that should never be allowed as can lead to personal injury or death, property damage, or economic loss.



This symbol is for hot surface areas where there is chance of temperatures above ambient temperatures which causes injuries.



This symbol is to avoid hand/fingers getting crushed with the flange joints/pipes.



Avoid the injuries while working in steam leaking areas.



This is a symbol of “**Caution**” to the equipment user & provides information about the care to be taken on the actions or procedures which if not performed correctly may lead to personal injury or incorrect function of the instrument or connected equipment.



Recommended action

## 2 Abstract

Thank you for choosing sustainable solutions in energy and environment which helps in conserving resources and preserving the future. This manual describes the principle of operation, instructions for installation, operation & maintenance of Float Trap integrated with Sight Glass supplied by Thermax Ltd. The General Instructions which

are not detailed out in this document to be performed in accordance with standard and safe acceptable practices as may be required by local codes, specifications and or regulations. The instruction contained within this manual must be read before undertaking any work on the equipment supplied and for any queries please contact Thermax Limited.

## 3 Product Identification

The product and its specifications, details are identified as per the figure 3.1A. The same will be shown on the name plate on the product.



For all maintenance, service & spares requests, it is important to mention the serial identification number as mentioned in the name plate details of your product to Thermax Ltd.



Figure 3.1A



## 4 Unloading Receiving and Inspection

The Float Traps are supplied in assembled condition, duly packed which can be directly installation at site.



Ensure that the wooden cases should not be dropped or turned to any other position other than marked on the cases.

At the time of receipt at site, a thorough visual inspection of the product should be made for evidence of damage during shipment. Packaging slip should be referred for checking the items supplied for the system.

On receipt of the consignment at site, check that all the cases have been received per delivery documents & packing slip.

By careful inspection, determine whether any damage/loss has occurred in transit, in spite of proper Checking and loading of each component/equipment, at our factory before dispatch.

In the event of any damage is noted, the company should be notified at once so they can start claims procedure for repairs or replacements as per applicable clauses of contract.

Your product is carefully manufactured, assembled and inspected at each level before dispatch. Sometimes during transit there is possibility of piping connections getting loose. The same to be tightened at site during installation if found loose.

## 5 Storage

The place of storage of these equipment should be:

- Dust free, Clean, Dry and well ventilated

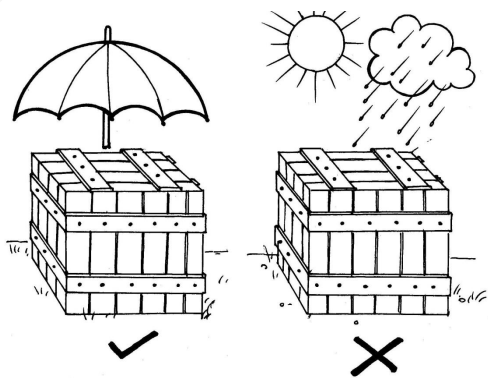
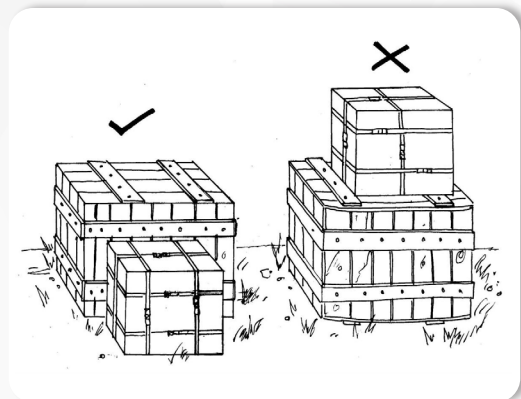


Figure No 5.1A: Material should be stored under roof.

B) Do not pile up cases.



A) All the material should be stored under roof and should be protected from rain, water or direct sunlight.

Figure No 5.1B: Do not pile up cases.

C) Do not store heavy material on soft soil.

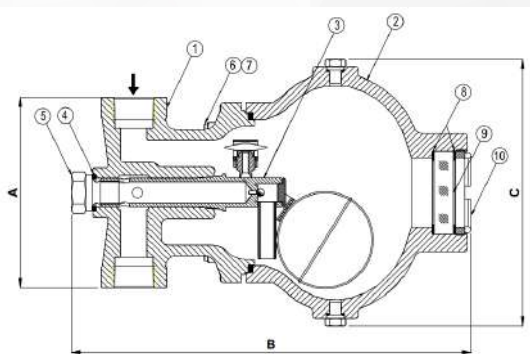
D) Parts should not be stored under corrosive atmosphere.

E) Periodically, the unit should be inspected to make sure no damage, such as corrosion, is taking place.

## 6 General description and use

The float controlled condensate trap is designed for the discharge of condensate from steam, compressed air and pressurized gas systems.

### 6.1 Design of Float controlled steam trap



Ball Float Trap Integrated With Sight Glass

Sr.	Components	Material	Specification
01	Housing	Screwed Cast Iron	IS210 FG260
02	Body Housing	Cast Iron	IS210 FG260
03	Control Unit	St. Steel	ASTM A276 Tp.304
04	Support Screw	Gasket Soft Steel	ASTM A1008
05	Supporting Screw	St. Steel	ASTM A276 Tp.304
06	Stud	St. Steel	ASTM A193 Tp. B7
07	Hex Nut	St. Steel	ASTM A194 Tp. 2H
08	Glass Gasket	Graphite	SS304+Graphite
09	Toughened Glass	Borosilicate Glass	DIN7080
10	Glass Retainer	Brass	ASTM B124

## 6.2 Operating conditions (Design)

PMO: Maximum operating pressure &  
TMO: Maximum operating temperature

Material	PMO (kg/cm <sup>2</sup> )	TMO (°C)
IS 210 FG 260	13.2	220

## 6.3 Functional limits of control unit

Type of control unit	A	B	E	H	I
Steam /Condensate Pressure (kg/cm <sup>2</sup> )	13.2	13.2	13.2	13.2	4.1

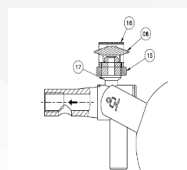
## 6.4 Function / Installation & venting

Due to its gravity, the condensate flows down to the deepest point, i.e. to the steam trap body housing (2). A rising condensate level lifts the float which turns the rotary slide valve to open the outlet port discharging the condensate. In the case of steam, automatic venting must be provided through Capsule venting.

## 9 Maintenance

### 9.1 Opening the steam trap and dismantling the float control unit assembly

1. The condensate trap must be depressurized. Shut off the system securely in front of and behind the steam trap.
2. Apply lifting device for housing size DN 40/ DN 50. Steam trap weight is approximately 35 kg.
3. Loosen screwed/flange connections and lift out of the pipeline carefully.
4. Loosen hexagon nuts (7) evenly crosswise.
5. Remove the main housing section (2).



## 7 Assembly

The Float controlled steam trap is assembled at the plant in the horizontal flow direction. However, modification for another flow direction can be carried out on site quickly and without any problem.

### 7.1 Screw tightening torque

(at room temperature, coat thread with temperature-resistant lubricant)

Type	Supporting Screw	Glass Retainer	Hex. Nut
DN15/ DN 20/ DN 25	75 Nm	65 Nm	40 Nm
DN40/ DN 50	75 Nm	100 Nm	40 Nm

## 8 Start-up

The pressure build-up and heating-up of the housing should not take place abruptly. If leaks occur due to so-called settling after the first start-up, the screws can be retightened taking into account the indicated torque.

Retightening may only be carried out when the housing is depressurized and warm to touch.

### 9.2 Disassembling and cleaning of control unit assembly

1. After moving the split pin, the rotary slide valve is simply pulled out to the side.
2. Clean the parts using media like benzene.
3. Check the rotary slide valve for wear along the sealing edge. If wear is detected, the entire control unit assembly must be replaced by using genuine spares.
4. During assembly ensure that the notch in the rotary slide valve points to the punch mark on the drain tube (3) and the split pin is inserted and secured again carefully.
5. It must be possible to move the float up and down easily by hand.
6. Clean the Toughened Glass (9) with cotton or suitable liquid cleaner for better visualization of Float movement in side the trap.

### 9.3 Installing the control unit and assembling the float trap

1. After moving the split pin, the rotary slide valve is simply pulled out to the side.
2. Clean the parts using media like benzene.
3. Check the rotary slide valve for wear along the sealing edge. If wear is detected, the entire control unit assembly must be replaced by using genuine spares.
4. During assembly ensure that the notch in the rotary slide valve points to the punch mark on the drain tube (3) and the split pin is inserted and secured again carefully.
5. It must be possible to move the float up and down easily by hand.
6. Clean the Toughened Glass (9) with cotton or suitable liquid cleaner for better visualization of Float movement in side the trap.

## 9.4 Installing the control unit and assembling the float trap

1. The complete control unit is inserted into the conical housing seat and aligned in such a way that the immersion tube points vertically down.
2. Screw in the supporting screw (5) with gasket (4) and tighten evenly crosswise using a standard ring wrench. For tightening torque see 7.1.
3. Check the housing gasket, Glass gasket and replace, if necessary.
4. Place the Toughened Glass (9) along with gaskets (8). Assemble the body housing (2).
5. Tighten the housing bolts (6 and 7) evenly crosswise. For tightening torque see 7.1
6. The trap is screwed into the pipeline or bolted between the flanges.
7. Remove protective caps from inlet and outlet.
8. Position the trap according to the figure, section 7.1. The condensate flow is in the direction of the arrow (note arrow on

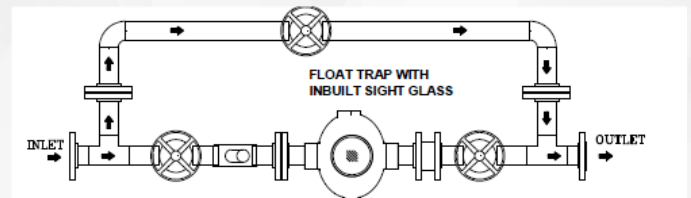
Screwed/Flanged Housing (1). The housing is positioned to the side and the word TOP on the Body housing (2) is at the top and must be legible horizontally.

9. The size DN 40/ DN 50 has a weight of approx. 35 kg. Ensure proper fixing of the pipeline in front and behind the trap.

10. To avoid down times, it is recommended that a shut-off device with a bypass line be installed in front of and behind the trap.

11. It is strongly recommended to use of Y-Strainer with 40-mesh size before every Float Trap.

**We recommend branded Float Trap module for better performance**



## 9 Warranty

Only trained or instructed personnel may be assigned to operation or servicing.

All our equipment is thoroughly inspected before dispatch and therefore can be depended upon for long and trouble-free services. We undertake to make goods by replacement or repair, defects arising out of faulty design, materials or workmanship within 12 (Twelve) months of the date of commissioning or 18 (Eighteen) months from the date of dispatch whichever is earlier subjected to mentioned in your purchase order warranty terms. The parts, in respect of which a claim is made, must be sent to our works at buyer's expenses. If the claim is found to be legitimate, we shall refund such expenses.

### Warranty Excludes

- a) Normal Wear & Tear
- b) Damages/defects due to wrong operation at the purchaser's end, and/or arising out of forced major.
- c) Bought out components are guaranteed by us only to the extent of guarantees given to us by our suppliers.
- d) Electrical components such as heaters, motors, contactors etc. Rubber components and instruments such as pressure gauges, thermometers, Controllers, etc. are however, not covered under this warranty.

### This warranty is valid subject to the following conditions: -

- a) Installation completed within three months from the date of dispatch of the equipment and as per our installation instructions.
- b) The supply/ installation formally accepted as per the handing over clause.
- c) Use of specified utilities in technical quotation.
- d) The equipment being operated and maintained as per our

Operation and maintenance Manual.

- e) The equipment or part thereof not being subject to accident, alteration, abuse or misuse.
- f) Any replacements/repairs required under provisions of the above warranty will be carried out at our's option either at site or at works. In the latter case, Buyer will send the defective parts to our works at Buyer's cost & liability.
- g) Warranty period for the entire equipment including replaced or repaired parts will be limited to the unexpired portion of the total warranty period.
- h) Accessories and fittings not manufactured by us, form an integral part of the equipment supplied, the warranty for such accessories & fitting will be in line with main equipment.
- i) If the purchaser delays to lift the equipment up its readiness, the warranty will be limited to 18 months from the date of readiness at our works.
- j) Any repair / replacement on our equipment during the warranty period shall be carried out by authorized representatives in writing from us.
- k) The warranty obligations will be honoured by us provided Buyer has fulfilled obligations under the order relating to release of due payments, etc.
- l) After repairs/replacement, warranty period for the entire equipment including replaced or repaired parts will be limited to the unexpired portion of the total warranty period.
- m) Any short supply or damages to the equipment to be intimated to Thermax within 15 days of receipt of material at site. Any late report will void the warranty.
- n) If the transit insurance is in client scope, damages and missing items during transit to be claimed by clients directly.
- o) Any improper use, intervention in the design and deviation from the design data will automatically lead to termination of the warranty.

## 10 Critical Spares

1. Control unit assembly with capsule venting

2. Set of Gaskets (Packet of 2)

3. Toughened Glass



Conserving Resources,  
Preserving the Future.



Air Pollution  
Control



Boiler and  
Heater



Build-Own  
-Operate



Chemical



Cooling



Projects and  
Energy  
Solutions



Process  
Heating



Renewable  
Energy



Water and Waste  
Solutions

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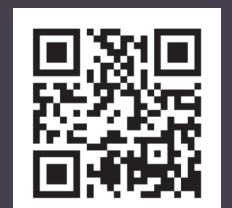
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