



Valve Concepts, Inc.
ISO Registered Company

Model 3600

Vacuum Relief Vent

Side-Mounted Connection

SECTION I

I. 3000 SERIES DESIGN AND FUNCTION

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

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

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

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

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

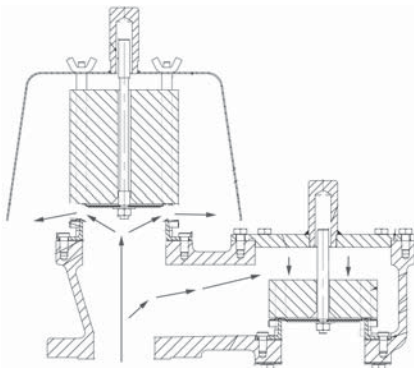


Figure 1 - Pressure Relief

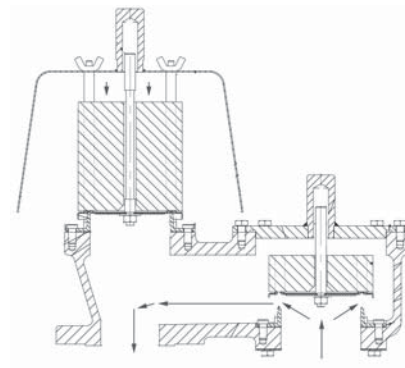


Figure 2 - Vacuum Relief

SECTION II

II. SAFETY WARNINGS

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

When Pipe-Away relief vents are used, back pressure in the header system will affect the set point of weight loaded vents by the amount of the header pressure. Maximum possible header pressure must be considered when sizing the pressure relief vent.



CAUTION

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



CAUTION

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

SECTION III

III. INSPECTION AND STORAGE

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

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

SECTION IV

IV. INSTALLATION



WARNING

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

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

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

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

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

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

Make sure the gasket is suitable for the application.



WARNING

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

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

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

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

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

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

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

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

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

MOUNTING FLANGE SIZE	BOLT TORQUE - Ft. lbs.	NUMBER BOLTS
2"	47	4
3"		4
4"		8
6"	83	8
8"		8
10"	134	12
12"		12

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

MOUNTING FLANGE SIZE	BOLT TORQUE - Ft. lbs.	NUMBER BOLTS
	FLAT FACE	
2"	20	4
3"	20	4
4"	20	8
6"	30	8
8"	30	8
10"	30	12
12"	30	12

SECTION V

V. MAINTENANCE

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

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

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

To Dis-assemble: Remove cap screws (10), cover (8) and the TFE tape / rope seal (34).

Inspect cover for corrosion, damage, or product build up. Clean with a suitable solvent, replace as necessary.

NOTE: During re-assembly, install new TFE tape / rope (34).

Remove pallet assembly, including any loading weights (28) that may be on the pallet (26).

Clean and inspect pallet assembly. Inspect the diaphragms (25) and replace if necessary.

To Replace Diaphragm: Secure stem assembly (30) in a soft-jawed vise with short, threaded end up. Remove washer and nut (14).

Lift up to remove diaphragm retainer (24) and diaphragm (25). Clean stem assembly and diaphragm retainer with a suitable solvent, replace as necessary. **NOTE:** Before re-assembly, apply TFE paste to threads of the stem and around center hole on the pallet (26).

Install new diaphragm (25). Re-install diaphragm retainer (24) and washer, secure nut (14) tight on stem.

Inspect and clean seat ring (16). **NOTE:** FRP seat surfaces are integral inside the body. Check seat surface for any nicks, corrosion, pitting or product

build up. Seat surface must be clean and smooth for vent to perform properly.

To Remove Seat Ring: Make a match mark between the flange (1) and the upper body (13). Rotate cap screws (15) CCW and remove. Remove guides (29). (Use the slot on top of the guides and rotate CCW to remove.) Mark the location of each guide on the seat ring (16) flange for reference at re-assembly.



CAUTION

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

Lift up to remove seat ring (16) and TFE tape / rope seal (34.1). Inspect guides (29) and inside of the body cavity for any corrosion or product build up. Clean all parts as necessary.

To Remove Pipeaway Tape Seals: Separate pipeaway upper body (13) from flange (1). Remove TFE tape seals (34.1 & 34.2) and clean sealing surface of both parts. Place new TFE tape seals (34.1 & 34.2) in grooves on flange (1) face. See Figure 8.

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

Place new seat ring TFE tape seal (34.1) in groove in upper body (13). See Figure 8

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

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

Place pallet stem assembly on seat ring (16).



WARNING

When assembling the vent, ensure that the stem is straight and fits into the guide in the cover. If the stem is cocked at an angle, pallet lift may be completely blocked. This could result in an increase in vacuum pressure in the tank and cause a tank failure, severe personal injury and material damage.

Carefully install loading weights on the pallet stem assembly. Exercise care so as not to damage the pallet diaphragm and seat surface.

NOTE: When installing the cover (8), ensure the pressure stem assembly (30) is inserted in the cover guide.

Place a new piece of TFE tape / rope seal (34.0) on the face of the body cover flange. See Figure 8. Place cover (8) over stem of pallet assembly, align bolt holes with the body (1) and install cap screws (10). Using a star crossing pattern, tighten nuts to 15 ft. lbs. (20.3 Nm).

To Remove Flame Screen: Rotate cap screws (42) CCW and remove cap screws and ring (41). Inspect and clean screen (40) and reinstall to body (1). See Figure 5.

SECTION VI

VI. TEST PROCEDURE

To Calculate Weight of Pallet Assembly:

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

For Example:

4" Model 3604 CS - if the desired setting is 5 oz/in²

Table 2 shows that for a 4" vent, the pallet would weigh 2.05 lb per oz/in²

So the pallet assembly for a 5 oz/in² setting would weigh: 2.05 lbs/oz/in² x 5.0 oz./in² - 10.25 lbs

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

To Determine Diaphragm/Seat Leakage:

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

ACCEPTANCE CRITERIA:

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

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

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

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

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

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

**TABLE 3
Maximum Setting in oz/in² Vs. Diaphragm mil**

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

SECTION VII

VII. ORDERING INFORMATION

NEW REPLACEMENT UNIT vs PARTS "KIT" FOR FIELD REPAIR

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

NEW REPLACEMENT UNIT:

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

PARTS "KIT" for FIELD REPAIR:

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



CAUTION

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

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

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

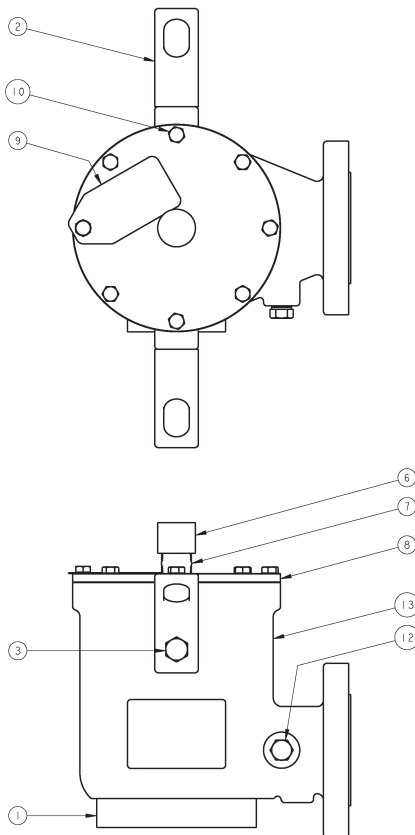
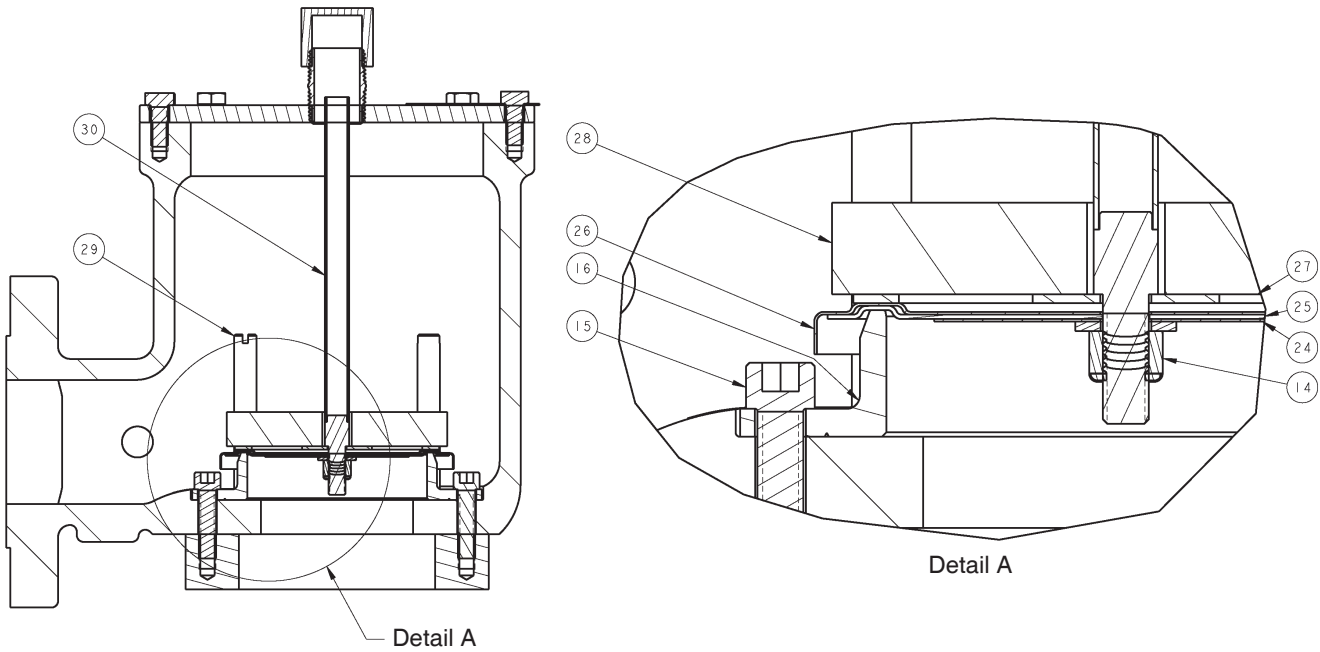


Figure 3 - Side View with Lifting brackets

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



ITEM NO.	DESCRIPTION
1	Flange
2	Lift Brackets
3	Cap Screws
6	Cap
7	Nipple
8	Cover
9	Name Plate
10	Cap Screws
12	Pipe Plug
13	Upper Body
14	Nut *

ITEM NO.	DESCRIPTION
15	Socket Cap Screw
16	Seat Ring
24	Diaphragm Retainer
25	Pallet Diaphragm ‡
26	Pallet
27	Stiffner Plate
28	Pallet Weights
29	Pallet Guide
30	Stem Assy
‡	Recommended Spare Part

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

Figure 5 - Bug / Flame Screen

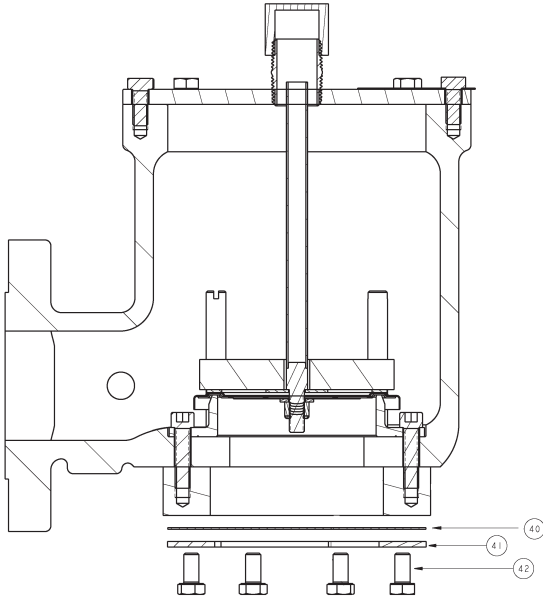


Figure 6 - Indicator

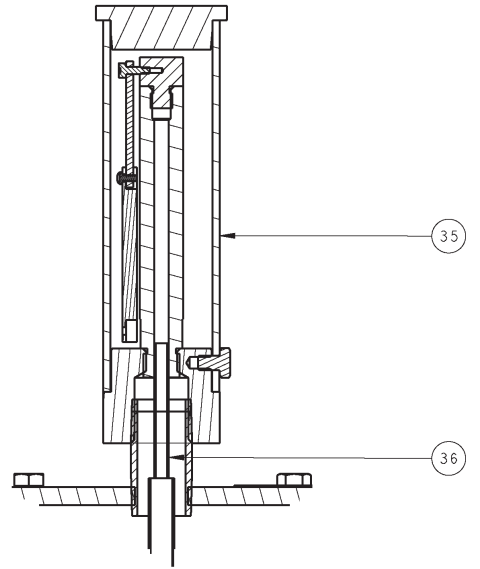
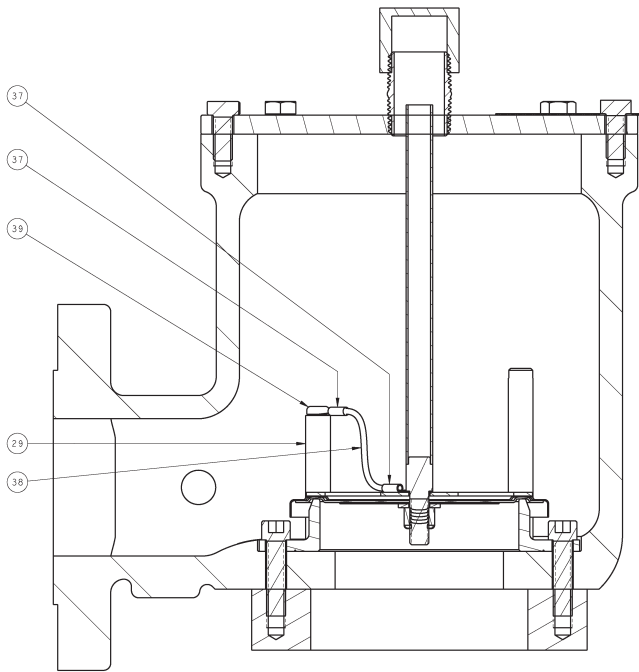
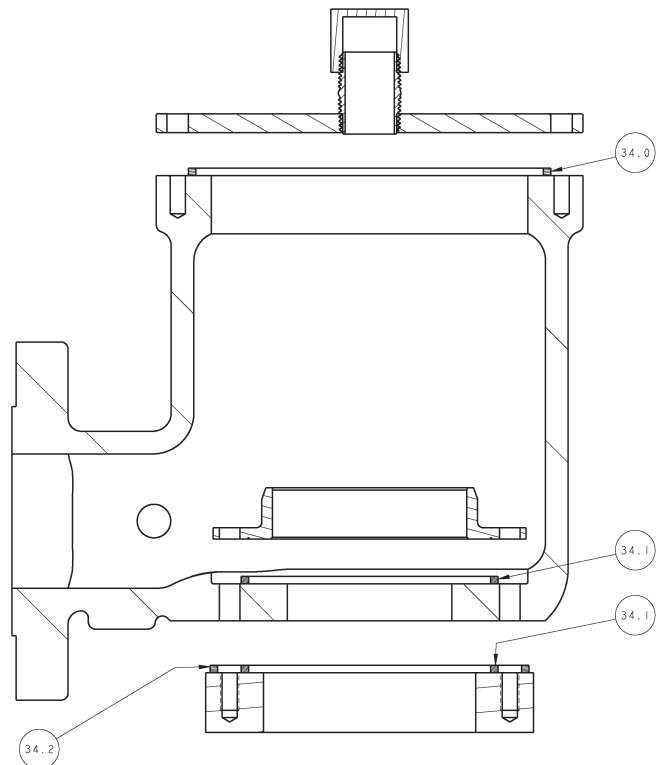


Figure 7 - ATEX Cable Connection



- | ITEM NO. | DESCRIPTION |
|----------|--------------------|
| 29 | Pallet Guide |
| 35 | Indicator Housing |
| 36 | Indicator |
| 37 | Cable Connector |
| 38 | Cable - ATEX |
| 39 | Cap Screw |
| 40 | Flame / Bug Screen |
| 41 | Flame Screen Ring |
| 42 | Cap Screws |

Figure 8 - Joint Tape Application



Size	TFE TAPE LENGTH		
	Item 34.0	Item 34.1 *	Item 34.2
2"	23"	17"	20"
3"	25"	20"	22"
4"	33"	28"	26"
6"	38"	34"	32"
8"	38"	34"	32"
10"	46"	41"	39"
12"	56"	47"	47"
14"	58"	51"	55"

* Quantity 2 per unit.

The contents of this publication are presented for informational purposes only, and while every effort has been made to ensure their accuracy, they are not to be construed as warranties or guarantees, express or implied, regarding the products or services described herein or their use or applicability. We reserve the right to modify or improve the designs or specifications of such product at any time without notice. Cashco, Inc. does not assume responsibility for the selection, use or maintenance of any product. Responsibility for proper selection, use and maintenance of any Cashco, Inc. product remains solely with the purchaser.

Cashco, Inc.
P.O. Box 6
Ellsworth, KS 67439-0006
PH (785) 472-4461
Fax. # (785) 472-3539
www.cashco.com
email: sales@cashco.com
Printed in U.S.A. 3600-IOM

Cashco GmbH
Handwerkerstrasse 15
15366 Hoppegarten, Germany
PH +49 3342 30968 0
Fax. No. +49 3342 30968 29
www.cashco.com
email: germany@cashco.com

Cashco do Brasil, Ltda.
Al.Venus, 340
Indaiatuba - Sao Paulo, Brazil
PH +55 11 99677 7177
Fax. No.
www.cashco.com
email: brazil@cashco.com