

the weight of the valve is entirely distributed to the joint area, the valve will deform and cause leakage

6.5. Installation of Threaded End Valve

- a. Use conventional sealant, such as hemp core, PFA-lined, etc
- b. Use wrench and apply force on the hexagon end of the valve only. Apply force to other area of valve may seriously damage the valve
- c. For applications where threaded end valves are back-welded on site, the valves must be dismantled according to instructions for weld end valves

6.6. Installation of Weld End Valve

- a. Tack-weld the valve on the pipe in four points on both end caps.
- b. With the valve in open position (see valve position diagram on page 4), loosen all the nuts on the body bolts
- c. Remove all the bolts except one
- d. Swing the body outside the pipe
- e. Turn the handle to the half open position to assist in the removal of the seats and body gaskets
- f. Turn the handle to the closed position and remove the ball
- g. Place all removed parts in a clean and secure place
- h. Replace the body and the removed bolt. Tighten all nuts slightly. To prevent any leakage to the body joints after welding, make sure that the body and the end caps remain perfectly parallel
- i. Finish welding both end caps onto the pipe
- j. After the pipeline and valve cool, clean end caps then remove the previous replace bolt. Swing out the body. Turn the valve to the closed position, then replace the ball. Turn valve in open position and replace seats and body gaskets
- k. After seats, body gaskets and ball are replaced, swing the body into position, replace the removed bolts and nuts, and tighten the nuts according to the valve assembly torque table on page 6

6.7. Systems Hydrostatic Test

Before delivery, our valves are tested to 1.5 times the allowable pressure at ambient temperature in the open position. After installation, the pipeline may be subjected to system test pressure of no more than 1.5 times the rated pressure

7. Valve Operation

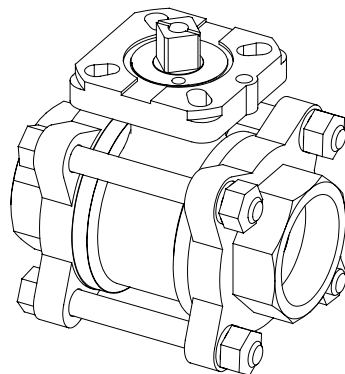
7.1. Manual Operation

Handle is offered as an option

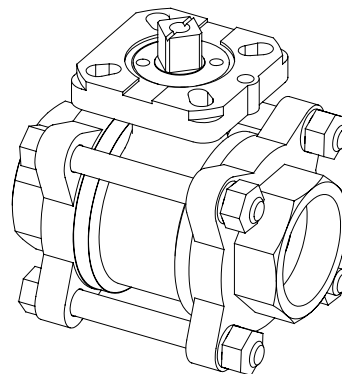
- a. Valve in Open Position is indicated by handle in parallel (in-line) with the valve or pipeline
- b. Valve in Closed Position is indicated by handle in perpendicular (crossed with the valve or pipeline)

7.2. Automatic Operation

- a. Prior to actuator installation the position of the valve is indicated as shown in the illustrations below with a line indicator on top of the valve stem



OPEN



CLOSE

- b. After Actuator installation, valve should be check for valve stem alignment. Angular or linear misalignment will result in high operational torque and unnecessary wear on the stem seal

8. Maintenance

8.1. Maintenance Frequency

User should determine the maintenance frequency depending on specific application. If there is sign of leakage from the stem, it is time to replace the stem sealing components. If there is sign of internal leakage, it is time to replace the seats and gasket components. Life of the valve can be maximized if the valve is used within the rated range, in accordance with pressure, temperature, and corrosion data

8.2. Disassembling and Cleaning the Valve

Ball valve can trap fluids in ball cavity when it is in the closed position. If the valve has been used in hazardous media, it must be decontaminated before disassembly.

- a. Relieve the line pressure
- b. Place valve in half-open position and flush the line to remove any hazardous material from valve
- c. All persons involved in the removal and disassembly of the valve should wear proper protective clothing, such as face shield, glove, apron, etc

8.3. Replacing Seats and Joint Gaskets

Seat and joint gaskets should be replaced at the same time. Once the valve is disassembly for seat service, the gasket should also be replaced to ensure proper body sealing

- a. Follow the direction on Disassembling & Cleaning the valve. Make sure the pipeline is de-pressurized
- b. With the valve in open position (see valve position diagram on page [4](#)), loosen all the nuts on the body bolting. Remove all the bolts except one. Swing the body outside the pipe.
- c. Turn the handle to the half open position to assist in the removal of the seats
- d. Replace with a new set of seats and body gaskets
- e. Swing the body back into position. Replace the removed bolts, and tighten the bolts according the valve assembly torque table on page [6](#)

8.4. Replacing Stem Sealing Components

- a. Follow the direction for replacing the seats and joint gaskets from a. to c.
- b. To assist in loosening of the disc plate, place a rod of diameter smaller than the ball orifice into the ball orifice. Loosen and remove the disc plate with two-prone tool. Remove the set of Belleville washers and the gland. Place all removed parts in a clean and secure place
- c. Remove the rod. Turn the valve to the closed position (see valve position diagram on page [4](#)). Remove the seats and body gaskets. The ball should slide out with a gentle push. Place all removed parts in a clean and secure place
- d. Push the stem downward. It should come out through the center body. Remove the stem then remove the pyramidal stem seal. Thoroughly clean the stem. Replace with a new pyramidal stem seal.
- e. Remove the v-ring stem packing from the center body cavity. Thoroughly clean the center body. Replace with a new v-ring stem packing.
- f. Replace the stem, the Belleville washers and the gland. Replace the disc plate. To tighten the disc plate, hold the stem in place and tighten the disc plate with two-prone tool. Refer to the stem disc torque in the valve assembly torque table on page [6](#) for the correct torque value.
- g. Turn the valve to the closed position (see valve position diagram on page [4](#)).. Replace the ball. Turn the valve to the open position. Replace the seats and joint gaskets.
- h. Swing the center body back into position. Replace the removed bolts and nuts. Tighten the nuts according to valve assembly torque table on page [6](#).

9. Torque Data

9.1. Valve Assembly Torque Table

This torque table shows the required torque that is needed to tighten the valve stem and valve body bolt. It is very important that these torque values are applied with tolerance of no more or no less than 10%. Incorrect torque values might result in improper sealing of the valve or deformation of the bolts.

Size	Stem Disc Torque (NM)	Body Bolt Torque (NM)
1/4" DN8	12	8
3/8" DN10	12	8
1/2" DN15	12	18
3/4" DN20	12	18
1" DN25	17	18
1 1/4" DN32	17	34
1 1/2" DN40	24	34
2" DN50	24	59
2 1/2" DN65	35	113
3" DN80	35	113
4" DN100	40	113

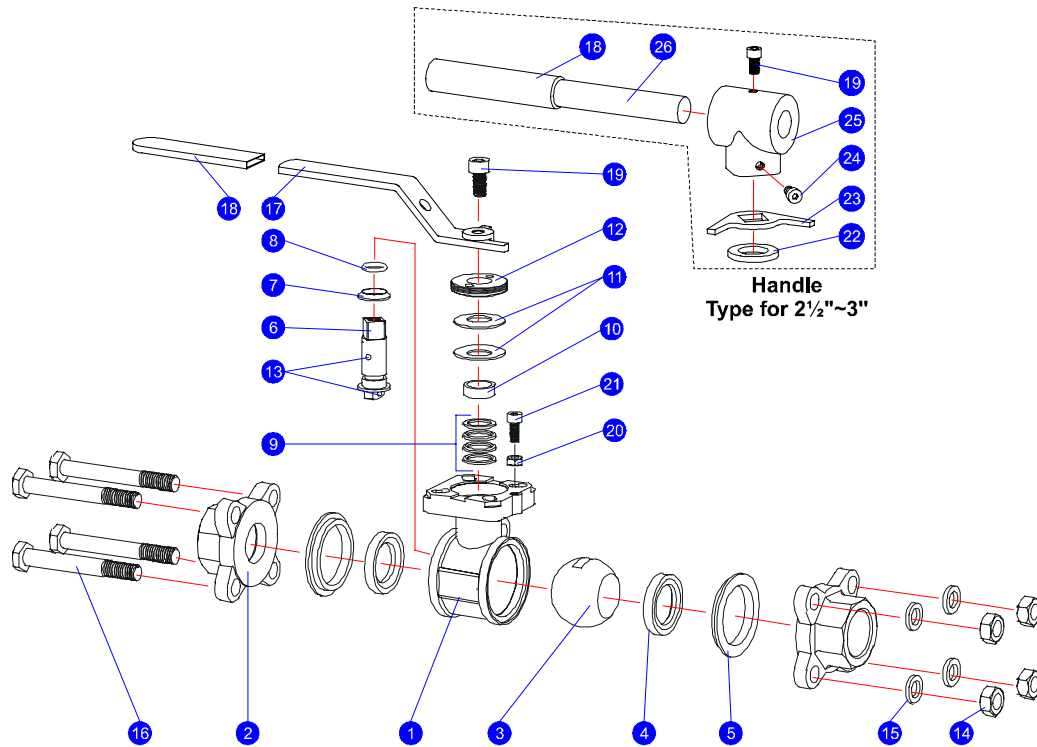
9.2. Valve Operation Torque Table

The table below lists break torque values for PTFE seat in clear non-viscous fluid. Torque value can vary depending on temperature, pressure, line medium, and seat material

Differential Pressure	75 PSI		150 PSI		300 PSI		700 PSI		1000 PSI	
	5 BAR		10 BAR		20 BAR		50 BAR		63 BAR	
Valve Size	IN-LB	NM	IN-LB	NM	IN-LB	NM	IN-LB	NM	IN-LB	NM
1/4", 3/8" DN8/10	45	5.1	45	5.1	45	5.1	45	5.1	45	5.1
1/2" DN15	60	6.8	60	6.8	60	6.8	60	6.8	60	6.8
3/4" DN20	80	9.0	80	9.0	80	9.0	80	9.0	80	9.0
1" DN25	130	14.7	130	14.7	130	14.7	130	14.7	130	14.7
1 1/4" DN32	160	18.1	160	18.1	160	18.1	180	20.3	190	21.5
1 1/2" DN40	200	22.6	200	22.6	260	29.4	300	33.9	350	39.5
2" DN50	280	31.6	375	42.4	400	45.2	450	50.8	480	54.2
2 1/2" DN65	500	56.5	600	67.8	620	70.1	800	90.4	-	-
3" DN80	650	73.4	800	90.4	900	101.7	1300	146.9	-	-
4" DN100	1100	124.3	1500	169.5	1900	214.7	2400	271.2	-	-

- For dry gas, increase the above torque value by 15%
- For viscous fluid or fluids with solid or abrasive contents, increase the above torque value by 35%
- For 15% glass fiber filled PTFE (RPTFE) seats, increase the above torque value by 15%
- For 25% carbon fiber filled PTFE (CTFE) seats, increase the above torque value by 25%
- For 50% stainless steel powder filled PTFE seats, increase the above torque value by 25%
- A safety factory of 20% is recommended for actuator sizing

10. Assembly Diagram



MATERIALS LIST

NO.	PART NAME	MATERIAL	Q'TY
1	Body	1.4408 or 1.0619	1
2	End Cap	1.4408 or 1.0619	2
3	Ball	SUS316	1
4	Seat	PTFE	2
5	Body Gasket	PTFE	2
6	Stem	SUS316	1
7	Pyramidal Stem Seal	PTFE	1
8	O-Ring	Viton	1
9	V-Ring Stem Packing	PTFE	†
10	Gland	SUS304	1
11	Belleville Washer	SUS301	2
12	Disc Plate	SUS304	1
13	Anti-Static Device	SUS316	2
14	Body Nut	ISO-3506 (A2-70)	§
15	Body Washer	ISO-3506 (A2-70)	§
16	Body Bolt	ISO-3506 (A2-70)	‡

§ ¼" to 2" = 4pcs; 2 ½" = 8pcs; 3" & 4" = 12pcs
 ‡ ¼" to 2" = 4pcs; 2 ½" = 4pcs studs; 3" & 4" = 6pcs studs
 † ¼" to ¾" a set = 2pcs; 1" to 4" a set = 4pcs

Material List for Optional Handle Kit

NO.	PART NAME	MATERIAL	Q'TY
17	Handle	SUS304	1
18	Handle Sleeve	Vinyl	1
19	Handle Bolt	SUS304	1
20	Stop Bolt	SUS304	1
21	Stop Nut	SUS304	1
22	Handle Spacer	PTFE	1
23	Stop Plate	SUS304	1
24	Adapter Bolt	SUS304	1
25	Handle Adapter	SUS304	1
26	Round Handle	SUS304	1

Items 17 to 19 are for ½" to 2" valves. Items 18 to 26 are for 2 ½" to 4" valves

11. Corrosion Data

The chart in Appendix is intended to serve as a guide to material selection for your particular application. No one material can be expected to resist corrosive action of wide variety of chemical that is used in the industry today. The physical properties of a material are affected differently by each corrosive medium. It is sometimes necessary to sacrifice values in one property to gain the maximum value in another property. It is, therefore, important for user to decide which property is of prime importance for the particular application.

Explanation of Rating

A = Excellent B = Good C = Poor D = Do not use X = No Information

*A = Excellent with PTFE but Do not use with filled PTFE

Internal moving parts that are in contact with the media ideally should carry an "A" rating. Body materials in direct contact with the media can carry a "B" rating because the rate of corrosion is not fast enough to become a serious problem.

Note: Rating are based on media at room temperature. When Using the chart, please remember that factors such as solution concentration, temperature, degree of agitation and presence of impurities can effect rate of corrosion. Apex Controls Co., Ltd. can not accept responsibility for problems arising from use of these data. We suggest that in critical applications, tests be conducted to verify suitability of material prior to usage.

Appendix: Corrosion Data Chart

Chemicals	Carbon Steel (DIN1.0619)	316 Stainless Steel (DIN1.4408)	EPDM / EPR	Viton	PTFE & Filled PTFE
Acetaldehyde	C	A	B	C	A
Acetamine	B	B	X	X	A
Acetate Solvents	B	A	X	D	A
Acetic Acid, aerated	D	A	X	C	A
Acetic Acid, Air Free	B	A	X	D	A
Acetic Acid, crude	C	A	X	D	A
Acetic Acid, glacial	X	D	B	C	A
Acetic Acid, pure	C	A	X	D	A
Acetic Acid, 10%	C	A	B	D	A
Acetic Acid, 80%	C	A	C	D	A
Acetic Acid Vapors	D	D	X	X	A
Acetic Anhydride	D	B	C	D	A
Acetone	A	A	A	D	A
Other Ketones	A	A	D	D	A
Acetyl Chloride	A	C	D	D	A
Acetylene	B	A	A	A	A
Acid Fumes	D	B	X	X	A
Acrylonite	A	A	D	C	A
Air	A	X	A	A	A
Alcohol, Amyl	B	A	A	B	A
Alcohol, Butyl	B	A	C	A	A
Alcohol, Diacetone	A	A	B	D	A
Alcohol, Ethyl	B	B	A	A	A
Alcohols, Fatty	B	A	X	X	A
Alcohol, Isopropyl	B	B	A	A	A
Alcohol, Methyl	B	A	A	C	A
Alcohol, Propyl	A	A	A	A	A
Alumina	A	A	A	X	A
Aluminum Acetate	D	A	A	D	A
Aluminum Chloride dry	B	C	A	A	A
Aluminum Chloride solution	X	D	X	A	A
Aluminum Fluoride	X	C	A	A	A
Aluminum Hydroxide	A	A	A	A	A
Aluminum Nitrate	D	C	B	AD	A
Aluminum Oxalate	X	D	X	X	A
Alum (Aluminum Potassium Sulfate)	D	B	X	B	A
Aluminum Sulfate	C	B	A	A	A
Amines	B	A	C	D	A
Ammonia, Alum	X	A	X	X	A
Ammonia, Anhydrous Liquid	D	A	B	D	A
Ammonia, Aqueous	D	A	X	A	A
Ammonia, Gas, hot	D	A	A	D	A
Ammonia Liquor	X	A	X	X	A
Ammonia Solutions	D	A	B	D	A
Ammonium Acetate	D	B	A	D	A
Ammonium Bicarbonate	B	B	A	A	A

A = Excellent B = Good C = Poor D = Do not use
 *A = Excellent with PTFE but Do not use with filled PTFE

Appendix: Corrosion Data Chart

Chemicals	Carbon Steel (DIN1.0619)	316 Stainless Steel (DIN1.4408)	EPDM / EPR	Viton	PTFE & Filled PTFE
Ammonium Bromide 5%	X	B	X	X	A
Ammonium Carbonate	B	B	A	B	A
Ammonium Chloride	D	C	A	A	A
Ammonium Hydroxide 28%	D	B	B	A	A
Ammonium Hydroxide Concentrated	C	B	A	A	A
Ammonium Monosulfate	X	A	X	X	A
Ammonium Nitrate	D	A	A	A	A
Ammonium Oxalate 5%	X	A	X	X	A
Ammonium Persulfate	X	A	B	B	A
Ammonium Phosphate	D	B	A	A	A
Ammonium Phosphate Di-basic	D	B	X	A	A
Ammonium Phosphate Tri-basic	D	B	X	A	A
Ammonium Sulfate	C	B	A	B	A
Ammonium Sulfide	D	B	A	D	A
Ammonium Sulfite	C	A	B	A	A
Amyl Acetate	C	B	B	D	A
Amyl Chloride	X	A	D	D	A
Aniline	C	B	C	C	A
Aniline Dyes	C	A	C	B	A
Apple Juice	D	B	B	A	A
Aqua Regia (Strong Acid)	D	B	D	D	A
Aromatic Solvents	C	A	D	X	A
Arsenic Acid	D	B	B	A	A
Asphalt Emulsion	B	A	D	A	A
Asphalt liquid	B	A	D	A	A
Barium Carbonate	B	B	A	A	A
Barium Chloride	C	B	A	A	A
Barium Cyanide	X	B	B	AB	A
Barium Hydrate	X	A	X	X	A
Barium Hydroxide	C	B	B	A	A
Barium Nitrate	X	A	X	X	A
Barium Sulfate	C	A	B	A	A
Barium Sulfide	C	B	A	A	A
Beer	D	A	B	A	A
Beet Sugar Liquors	B	A	B	A	A
Benzaldehyde	A	A	A	D	A
Benzene (Benzol)	B	B	D	B	A
Benzoic Acid	D	B	D	B	A
Beryllium Sulfate	X	B	B	B	A

A = Excellent B = Good C = Poor D = Do not use
 *A = Excellent with PTFE but Do not use with filled PTFE

Appendix: Corrosion Data Chart

Chemicals	Carbon Steel (DIN1.0619)	316 Stainless Steel (DIN1.4408)	EPDM / EPR	Viton	PTFE & Filled PTFE
Bleaching Powder wet	X	C	B	B	A
Blood (Meat Juices)	X	A	B	B	A
Borax (Sodium Borate)	C	A	A	A	A
Bordeaux Mixture	X	A	X	X	A
Borax Liquors	C	B	A	A	A
Boric Acid	D	B	B	A	A
Brake Fluid	X	B	B	D	A
Brines, saturated	D	B	A	A	A
Bromine, dry	D	D	D	B	A
Bunker Oils (Fuel)	B	A	X	A	A
Butadiene	B	A	C	B	D
Butane	B	A	D	A	A
Butter	X	A	X	X	A
Buttermilk	D	A	B	A	A
Butyl Acetate	X	B	D	D	A
Butylene	A	A	D	D	A
Butyric Acid	D	B	C	C	A
Calcium Bisulfite	D	B	D	A	A
Calcium Carbonate	D	B	B	A	A
Calcium Chlorate	X	B	B	B	A
Calcium Chloride	C	B	B	A	A
Calcium Hydroxide	C	B	A	A	A
Calcium Nitrate	X	B	B	X	A
Calcium Phosphate	X	B	B	B	A
Calcium Silicate	X	B	B	B	A
Calcium Sulfate	C	B	B		A
Caliche Liquor	B	A	X	X	A
Camphor	X	B	B	B	A
Cane Sugar Liquors	X	A	B	B	A
Carbonated Beverages	D	B	B	B	A
Carbonated Water	B	A	A	A	A
Carbon Bisulfide	B	B	D	A	A
Carbon Dioxide, Dry	A	A	B	B	A
Carbolic Acid	D	B	B	A	A
Carbon Monoxide	X	A	B	B	A
Carbon Tetrachloride, dry	B	A	D	B	A
Carbon Tetrachloride, wet	D	B	D	B	A
Casein	X	B	B	B	A
Caster Oil	B	A	B	A	A
Caustic Potash	X	A	X	X	A
Caustic Soda	B	A	B	B	A
Cellulose Acetate	X	B	B	D	A
China Wood Oil (Tung)	C	A	D	A	A
Chlorinated Solvents	C	A	D	C	A
Chlorinated Water	X	C	X	A	A
Chlorine Gas, dry	B	B	D	B	A

A = Excellent B = Good C = Poor D = Do not use
 *A = Excellent with PTFE but Do not use with filled PTFE

Appendix: Corrosion Data Chart

Chemicals	Carbon Steel (DIN1.0619)	316 Stainless Steel (DIN1.4408)	EPDM / EPR	Viton	PTFE & Filled PTFE
Chlorobenzene, dry	B	A	D	A	A
Chloroform, dry	B	A	D	B	A
Chlorophyll, dry	X	B	B	B	A
Chlorosulfonic Acid, dry	B	B	D	D	A
Chrome Alum	B	A	B	B	A
Chromic Acid < 50%	D	C	C	C	A
Chromic Acid > 50%	D	C	C	C	A
Chromium Sulfate	X	B	B	B	A
Cider	X	A	X	X	A
Citric Acid	D	B	B	A	A
Citrus Juices	D	B	X	A	A
Coca-Cola Syrup	X	A	X	B	A
Coconut Oil	C	B	A	A	A
Coffe	X	A	A	A	B
Coffe Extracts, hot	C	A	X	X	A
Coke Oven Gas	B	A	D	B	A
Cooking Oil	B	A	D	A	A
Copper Acetate	D	A	B	D	A
Copper Carbonate	X	A	X	X	A
Copper Cyanide	X	A	B	B	A
Copper Nitrate	D	B	B	A	A
Copper Sulfate	D	B	A	A	A
Corn Oil	C	B	C	A	A
Cottonseed Oil	C	B	C	B	A
Cresol	X	B	D	D	A
Creosote Oil	B	B	D	A	A
Cresylic Acid	C	B	D	B	A
Crude Oil, sour	B	A	D	A	A
Crude Oil, sweet	B	A	X	A	A
Cupric Nitrate	X	A	X	X	A
Cutting Oils, Water Emulsions	B	A	X	A	A
Cyanide Plating Solution	X	B	B	B	A
Cyclohexane	A	A	D	A	A
Cyclohexanone	X	A	X	X	A
Detergents, synthetic	X	B	B	A	A
Dextrin	X	B	B	B	A
Dichloroethane	X	C	D	X	A
Dichloroethyl Ether	X	B	D	D	A
Diesel Oil Fuels	A	A	D	A	A
Diethylamine	A	A	C	D	A
Diethyl Benzene	X	B	D	X	A
Diethylene Glycol	X	A	A	B	A
Diethyl Sulfate	X	B	C	B	A
Dimethyl Formamide	X	A	D	D	A
Dimethyl Phthalate	X	D	X	D	A
Dioxane	X	B	C	D	A
Dipentane (Pinene)	X	A	D	B	A
Disodium Phosphate	X	B	X	B	A
Dowtherm	B	A	D	A	A

A = Excellent B = Good C = Poor D = Do not use
 *A = Excellent with PTFE but Do not use with filled PTFE

Appendix: Corrosion Data Chart

Chemicals	Carbon Steel (DIN1.0619)	316 Stainless Steel (DIN1.4408)	EPDM / EPR	Viton	PTFE & Filled PTFE
Drilling Mud	B	A	A	A	A
Dry Cleaning Fluids	B	A	X	B	A
Drying Oil	C	B	X	X	A
Enamel	X	A	D	X	A
Epsom Salts (MgSo4)	C	B	X	A	A
Ethane	C	B	D	A	A
Ethers	A	A	C	C	A
Ethyl Acetate	B	B	C	D	A
Ethyl Acrylate	C	A	C	D	A
Ethyl Benzene	X	B	D	X	A
Ethyl Bromide	X	B	B	B	A
Ethyl Chloride, dry	B	A	C	B	B
Ethyl Chloride, wet	D	B	B	B	A
Ethylene Chloride	X	A	X	D	A
Ethylene Dichloride	X	B	D	D	A
Ethylene Glycol	B	B	A	A	A
Ethylene Oxide	B	B	D	D	A
Ethyl Ether	X	A	D	D	A
Ethyl Silicate	X	B	B	B	A
Ethyl Sulfate	X	B	C	A	A
Fatty Acid	D	A	D	A	A
Ferric Hydroxide	X	A	X	X	A
Ferric Nitrate	D	C	A	A	A
Ferric Sulfate	D	B	A	A	A
Ferrous Ammonium Citrate	X	B	X	X	A
Ferrous Chloride	D	D	A	A	A
Ferrous Sulfate	D	B	A	A	A
Ferrous Sulfate, Saturated	C	A	B	B	A
Fertilizer Solutions	B	B	X	X	A
Fish Oils	B	A	D	A	A
Flourine Gas, dry	X	B	X	X	A
Flue Gases	X	A	D	C	A
Fluoboric Acid	X	B	X	X	A
Fluorosilicic Acid	D	B	C	C	A
Flormaldehyde, cold	A	A	B	D	A
Formaldehyde, hot	D	C	X	X	A
Formic Acid, cold	D	B	X	B	A
Formic Acid, hot	D	B	X	A	A
Freon Gas, dry	B	A	C	C	A
Freon 11, MF, 112, BF	X	A	C	D	A
Freon 12, 13, 32, 114,115	X	A	A	D	A
Freon 21, 31	X	A	D	D	A
Freon 22	X	A	D	D	A
Freon 113, TF	X	A	C	C	A
Freon, wet	X	C	B	D	A
Fruit Juices	D	A	A	A	A
Fuel Oil	B	A	D	A	A

A = Excellent B = Good C = Poor D = Do not use
 *A = Excellent with PTFE but Do not use with filled PTFE

Appendix: Corrosion Data Chart

Chemicals	Carbon Steel (DIN1.0619)	316 Stainless Steel (DIN1.4408)	EPDM / EPR	Viton	PTFE & Filled PTFE
Fumaric Acid	X	X	X	X	A
Furfural	A	A	C	D	A
Gallic Acid 5%	D	B	C	A	A
Gas, Manufactured	B	B	X	A	A
Gas, Natural	B	A	D	A	A
Gas, Odorizers	B	B	X	A	A
Gasoline, Aviation	A	A	X	A	A
Gasoline, Leaded	A	A	X	A	A
Gasoline, Motor	A	A	D	A	A
Gasoline, Refined	B	A	D	A	A
Gasoline, Sour	B	A	D	A	A
Gasoline, Unleaded	A	A	X	A	A
Gelatin	D	A	A	A	A
Glucose	B	A	A	A	A
Glue	A	B	B	A	A
Glycerine (Glycerol)	C	A	A	B	A
Glycol Amine	X	B	D	D	X
Glycol	C	B	A	A	A
Graphite	X	B	B	B	A
Grease	A	A	D	A	A
Helium Gas	X	A	B	B	A
Heptane	B	A	D	A	A
Hexane	B	A	D	A	A
Hexanol, Tertiary	A	A	D	B	A
Hydraulic Oil, Petroleum Base	A	A	D	A	A
Hydrazine	X	B	B	D	A
Hydrocyanic Acid	D	A	B	A	A
Hydrofluosilicic Acid	D	C	B	A	A
Hydrogen Gas, cold	B	A	B	A	A
Hydrogen Gas, hot	B	B	B	X	A
Hydrogen Peroxide, Concentrated	D	B	B	B	A
Hydrogen Peroxide, Dilute	D	B	B	A	A
Hydrogen Sulfide, Dry	B	A	A	A	A
Hydrogen Sulfide, Wet	C	B	B	A	A
Hypo (Sodium Thiosulfate)	D	B	A	A	A
Illuminating Gas	A	A	D	A	A
Ink-Newsprint	D	A	B	A	A
Iodoform	B	A	X	A	A
Iso-Butane	X	B	D	X	A
Iso-Octane	A	A	D	A	A
Isopropyl Acetate	X	B	D	X	A
Isopropyl Ether	A	A	D	D	A
J P-4 Fuel	A	A	X	A	A
J P-5 Fuel	A	A	X	A	A
J P-6 Fuel	A	A	X	A	A
Kerosene	B	A	D	A	A

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Appendix: Corrosion Data Chart

Chemicals	Carbon Steel (DIN1.0619)	316 Stainless Steel (DIN1.4408)	EPDM / EPR	Viton	PTFE & Filled PTFE
Ketchup	D	A	X	A	A
Ketones	A	A	D	D	A
Laquer (and Solvent)	C	A	D	D	A
Lactic Acid Concentrated cold	D	A	B	A	A
Lactic Acid Concentrated hot	D	B	B	B	A
Lactic Acid Dilute cold	D	A	B	A	A
Lactic Acid Dilute hot	D	A	X	D	A
Lactose	X	B	B	B	A
Lard	X	A	C	X	A
Lard Oil	C	B	B	A	A
Lead Acetate	D	B	B	B	A
Lead Sulfate	X	B	B	B	A
Lecithin	X	B	D	B	A
Linoleic Acid	B	A	D	B	A
Linseed Oil	A	A	D	A	A
Lithium Chloride	X	B	B	B	A
LPG	B	B	D	A	A
Lubricating Oil Petroleum Base	A	A	D	A	A
Ludox	X	B	B	B	A
Magnesium Bisulfate	B	A	B	B	A
Magnesium Bisulfide	X	B	B	B	A
Magnesium Carbonate	X	A	B	B	A
Magnesium Chloride	C	B	A	A	A
Magnesium Hydroxide	B	A	A	A	A
Magnesium Hydroxide Hot	B	A	X	A	A
Magnesium Nitrate	X	A	X	B	A
Magnesium Sulfate	B	A	A	A	A
Maleic Acid	B	B	D	A	A
Maleic Anhydride	X	B	D	B	A
Malic Acid	D	B	X	A	A
Malt Beverages	X	A	B	A	A
Manganese Carbonate	X	B	X	X	A
Manganese Sulfate	X	A	B	B	A
Mayonnaise	D	A	X	A	A
Meat juices	X	A	X	X	A
Melamine Resins	X	C	X	X	A
Methanol	X	A	D	B	A
Mercuric Chloride	D	B	A	A	A
Mercuric Cyanide	D	A	A	A	A
Mercurous Nitrate	X	A	X	B	A
Mercury	A	A	A	A	A
Methane	B	A	X	A	A
Methyl Acetate	B	A	B	D	A
Methyl Acetone	A	A	A	D	A

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Appendix: Corrosion Data Chart

Chemicals	Carbon Steel (DIN1.0619)	316 Stainless Steel (DIN1.4408)	EPDM / EPR	Viton	PTFE & Filled PTFE
Methylamine	B	A	B	D	A
Methyl Bromide 100%	X	B	D	B	A
Methyl Cellosolve	B	A	B	D	A
Methyl Cellulose	X	A	X	X	A
Methyl Chloride	B	A	D	B	A
Methyl Ethyl Ketone	A	A	B	D	A
Methylene Chloride	B	A	D	C	A
Methyl Formate	C	B	B	D	A
Methyl Isobutyle Ketone	X	A	X	X	A
Milk & Milk Products	D	A	A	A	A
Mineral Oils	B	A	D	A	A
Mineral Spirits	B	B	X	A	A
Mixed Acids (cold)	C	B	D	B	A
Molasses, crude	A	A	X	A	A
Molasses, Edible	C	A	X	A	A
Molybdc Acid	X	A	X	X	A
Monochloro Benzene Dry	X	B	X	X	A
Morpholine	X	A	B	D	A
Mustard	B	A	X	A	A
Naptha	B	B	D	A	A
Napthalene	B	B	D	A	A
Natural Gas, Sour	B	A	D	A	A
Nickel Ammonium Sulfate	D	A	B	D	A
Nickel Chloride	D	B	B	A	A
Nickel Nitrate	D	B	A	A	A
Nickel Sulfate	D	B	B	A	A
Nicotinic Acid	B	A	D	B	A
Nitric Acid 10%	D	A	X	A	A
Nitric Acid 30%	D	A	B	A	A
Nitric Acid 80%	D	C	D	B	A
Nitric Acid 100%	D	A	D	B	A
Nitric Acid Anhydrous	D	A	D	A	A
Nitrobenzene	B	A	C	C	A
Nitrogen	A	A	B	A	A
Nitrous Acid 10%	D	B	X	A	A
Nitrous Gases	B	A	X	X	A
Nitrous Oxide	B	B	X	A	A
Oils & Fats	X	A	D	X	A
Oils, Animal	A	A	B	B	A
Oils, Petroleum Refined	A	A	D	A	A
Oils, Petroleum Sour	B	A	D	A	A
Oils, Water Mixture	B	A	X	A	A
Olaic Acid	X	B	X	C	A
Oleic Acid	C	B	D	A	A
Oleum	B	B	D	C	*A
Oleum Spirits	X	B	D	A	A

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Appendix: Corrosion Data Chart

Chemicals	Carbon Steel (DIN1.0619)	316 Stainless Steel (DIN1.4408)	EPDM / EPR	Viton	PTFE & Filled PTFE
Olive Oil	B	A	B	A	A
Oxalic Acid	D	B	B	A	A
Oxygen	B	A	A	A	A
Ozone, Dry	A	A	A	B	A
Ozone, Wet	C	A	B	B	A
Paints & Solvents	A	A	D	B	A
Palmitic Acid	C	B	B	A	A
Palm Oil	C	B	D	A	A
Paper Pulp	X	A	B	B	A
Paraffin	B	A	D	A	A
Paraformaldehyde	B	B	D	X	A
Paraldehyde	X	B	D	X	A
Pentane	B	A	D	A	A
Perchlorethylene, dry	B	A	D	A	A
Petrolatum (Vaseline Petroleum Jelly)	C	B	X	A	A
Phenol	D	A	D	B	A
Phosphate Ester	A	A	A	X	A
Phosphoric Acid 10%	D	D	B	A	A
Phosphoric Acid 50% Cold	D	B	B	A	A
Phosphoric Acid 50% Hot	D	D	B	A	A
Phosphoric Acid 85% Cold	B	A	X	B	A
Phosphoric Acid 85% Hot	C	B	X	X	A
Phosphoric Anhydride	X	A	X	B	A
Phosphorous Trichloride	B	A	B	B	A
Phthalic Acid	C	B	X	A	A
Phthalic Anhydride	C	B	X	A	A
Picric Acid	D	B	B	B	A
Pineapple Juice	C	A	X	A	A
Pine Oil	B	A	D	A	A
Pitch (Bitumen)	X	A	D	X	A
Polysulfide Liquor	X	B	B	B	A
Polyvinyl Acetate	X	B	B	X	A
Polyvinyl Chloride	X	B	B	X	A
Potassium Bicarbonate	X	A	X	X	A
Potassium Bichromate	X	A	X	B	A
Potassium Bisulfate	X	A	X	A	A
Potassium Bisulfite	D	B	B	A	A
Potassium Bromide	D	A	B	A	A
Potassium Carbonate	B	B	B	A	A
Potassium Chlorate	B	B	B	A	A
Potassium Chloride	C	B	A	A	A

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Appendix: Corrosion Data Chart

Chemicals	Carbon Steel (DIN1.0619)	316 Stainless Steel (DIN1.4408)	EPDM / EPR	Viton	PTFE & Filled PTFE
Potassium Chromate	X	B	B	B	A
Potassium Cyanide	B	B	A	A	A
Potassium Dichromate	C	B	B	A	A
Potassium Ferricyanide	C	A	B	A	A
Potassium Ferrocyanide	C	B	X	A	A
Potassium Hydroxide Dilute Cold	A	B	X	D	*A
Potassium Hydroxide to 70%, Cold	B	B	B	D	*A
Potassium Hydroxide Dilute Hot	B	B	X	X	*A
Potassium Hydroxide to 70%, Hot	A	B	A	X	*A
Potassium Iodide	C	B	B	A	A
Potassium Nitrate	B	B	B	A	A
Potassium Oxalate	X	A	X	X	A
Potassium Permanganate	B	B	B	A	A
Potassium Phosphate	X	B	A	A	A
Potassium Phosphate Di-basic	A	A	B	A	A
Potassium Phosphate Tri-basic	A	B	B	X	A
Potassium Sulfate	B	A	A	A	A
Potassium Sulfide	B	A	B	B	A
Potassium Sulfite	B	A	A	B	A
Producer Gas	B	B	D	A	A
Propane Gas	B	B	D	A	A
Propyl Bromide	X	B	B	B	A
Propylene Glycol	B	B	B	A	A
Pyridine	X	B	X	D	A
Pyrolgalic Acid	B	B	X	A	A
Quench Oil	B	A	X	A	A
Quinine, Sulfate, dry	X	A	X	X	A
Resins & Rosins	C	A	X	A	A
Resorcinol	X	B	X	X	A
Road Tar	A	A	D	A	A
Roof Pitch	A	A	X	A	A
Rosin Emulsion	C	A	X	B	A
R P-1 Fuel	A	A	X	A	A
Rubber Latex Emulsions	B	A	X	A	A
Rubber Solvents	A	A	X	D	A
Salad Oil	C	B	B	A	A
Salicylic Acid	D	A	B	A	A
Salt (NaCl)	C	B	X	A	A
Salt Brine	X	B	B	B	A
Sauerkraut Arine	X	B	X	X	A

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Appendix: Corrosion Data Chart

Chemicals	Carbon Steel (DIN1.0619)	316 Stainless Steel (DIN1.4408)	EPDM / EPR	Viton	PTFE & Filled PTFE
Sea Water	D	B	A	A	A
Sewage	C	B	B	B	A
Shellac	A	A	X	X	A
Silicone Fluids	X	B	X	B	A
Silver Bromide	X	A	X	X	A
Silver Cyanide	X	A	X	B	A
Silver Nitrate	D	A	A	A	A
Silver Plating Sol.	X	A	X	X	A
Soap Solutions (Stearates)	A	A	A	A	A
Sodium Acetate	C	B	B	A	A
Sodium Aluminate	C	A	B	A	A
Sodium Benzoate	X	B	X	X	A
Sodium Bicarbonate	C	B	A	A	A
Sodium Bichromate	X	B	X	X	A
Sodium Bisulfate 10%	D	A	B	A	A
Sodium Bisulfite 10%	D	A	B	A	A
Sodium Borate	C	B	B	A	A
Sodium Bromide 10%	C	B	B	A	A
Sodium Carbonate (Soda Ash)	B	A	B	A	A
Sodium Chlorate	C	B	B	A	A
Sodium Chloride	C	B	B	A	A
Sodium Chromate	B	A	B	A	A
Sodium Citrate	X	B	X	X	A
Sodium Cyanide	B	A	B	A	A
Sodium Ferricyanide	X	A	X	X	A
Sodium Fluoride	D	B	B	A	A
Sodium Hydroxide 20% Cold	A	A	B	B	*A
Sodium Hydroxide 20% Hot	B	A	B	C	*A
Sodium Hydroxide 50% Cold	A	A	B	C	*A
Sodium Hydroxide 50% Hot	B	A	X	C	*A
Sodium Hydroxide 70% Cold	A	A	B	C	*A
Sodium Hydroxide 70% Hot	B	A	B	C	*A
Sodium Hypochlorite (Bleach)	D	D	X	A	A
Sodium Hyposulfite	X	B	X	X	A
Sodium Lactate	X	A	X	X	A
Sodium Metaphosphate	B	B	B	X	A
Sodium Metasilicate Cold	C	A	X	B	A
Sodium Metasilicate Hot	D	A	X	X	A

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Appendix: Corrosion Data Chart

Chemicals	Carbon Steel (DIN1.0619)	316 Stainless Steel (DIN1.4408)	EPDM / EPR	Viton	PTFE & Filled PTFE
Sodium Nitrate	B	A	B	A	A
Sodium Nitrite	X	B	A	B	A
Sodium Perborate	B	B	A	A	A
Sodium Peroxide	C	B	A	A	A
Sodium Phosphate	C	B	A	A	A
Sodium Phosphate Di- basic	C	B	A	A	A
Sodium Phosphate Tri- basic	C	B	A	A	A
Sodium Polyphosphate	X	B	A	X	A
Sodium Salicylate	X	A	X	X	A
Sodium Silicate	B	B	B	A	A
Sodium Silicate, hot	C	B	B	X	A
Sodium Sulfate	B	A	A	A	A
Sodium Sulfide	B	B	B	A	A
Sodium Sulfite	X	A	B	B	A
Sodium Tetraborate	X	A	B	X	A
Sodium Thiosulfate	B	B	A	A	A
Soybean Oil	C	A	B	A	A
Starch	C	B	C	A	A
Steam (100°C/212°F)	A	A	B	C	A
Stearic Acid	C	B	B	A	A
Styrene	A	A	D	B	A
Sugar Liquids	B	A	B	A	A
Sugar, Syrups & Jam	X	A	X	X	A
Sulfate, Black Liquor	C	B	B	C	A
Sulfate, Green Liquor	C	B	X	C	A
Sulfate, White Liquor	C	B	X	C	A
Sulfur	C	B	B	B	A
Sulfur Chlorides	D	D	C	A	A
Sulfur Dioxide, dry	B	A	A	A	A
sulfur Dioxide, wet	X	A	B	X	A
Sulfur Hexafluoride	X	A	X	X	A
Sulfur, Molten	C	B	B	B	A
Sulfur Trioxide	B	B	X	B	A
Sulfur Trioxide, dry	B	B	B	A	A
Sulfuric Acid 0 to 77%	D	C	X	A	A
Sulfuric Acid 100%	C	A	C	B	A
Sulfurous Acid	D	B	C	A	A
Tall Oil	B	B	D	A	A
Annic Acid (Tannin)	C	B	B	A	A
Tanning Liquors	X	B	X	X	A
Tar & Tar Oils	A	A	D	A	A
Tartaric Acid	D	A	B	A	A
Tetraethyl Lead	C	B	X	X	A
Toluol (Toluene)	A	A	D	B	A
Tomato Juice	C	A	X	A	A
Transformer Oil	A	A	X	A	A
Tributyl Phosphate	A	A	B	D	A
Trichlorethylene	B	B	D	B	A

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Appendix: Corrosion Data Chart

Chemicals	Carbon Steel (DIN1.0619)	316 Stainless Steel (DIN1.4408)	EPDM / EPR	Viton	PTFE & Filled PTFE
Trichloroacetic Acid	X	D	X	D	A
Triethanolamine	X	B	B	X	A
Triethylamine	X	B	X	X	A
Trisodium Phosphate	X	B	B	B	A
Tung Oil	B	A	D	A	A
Turpentine	B	B	D	A	A
Urea	C	B	B	D	A
Uric Acid	X	A	X	X	A
Varnish	C	A	D	B	A
Vegetable Oils	B	A	D	A	A
Vinegar	D	A	A	D	A
Vinyl Acetate	X	B	A	X	A
Water, Distilled	D	A	B	A	A
Water, Fresh	C	A	B	A	A
Water, Acid Mine	D	B	A	D	A
Waxes	A	A	C	A	A
Whiskey & Wine	D	A	A	A	A
Xylene (Xylol), Dry	B	A	D	B	A
Zinc Bromide	X	B	B	B	A
Zinc Hydrosulfite	A	A	A	A	A
Zinc Sulfate	D	B	A	A	A

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