



LEAD FREE BRASS BALL VALVES SOLDER ENDS

Installation

When the ball valve contacts a copper pipe during soldering, the mid-portion of the valve body should not exceed 300°F. This can be monitored using an infrared temperature sensor. Depending on the fuel selected and the orientation of the installation it may be necessary to wrap the valve body with wet rags or employ other heat absorbing techniques. Select a torch tip size appropriate for the tube size being soldered. The flame must be directed away from the valve body and concentrated on the solder cup. The cup should be heated evenly. Allow heated joints to cool naturally. Quenching with water will cause unnecessary stress on the joint. After soldering, it may be necessary to adjust the stem packing due to the temperatures involved.

