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Standardization Division

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Iranian Gas Standards

Specification for :

مشخصات فنی :

Domestic 2-PSI Regulators

رگولاتور گاز-خانگی مناسب برای فشاردوپوند

APPROVED

FOREWORD

This standard is intended to be mainly used by **NIGC** and contractors and has been prepared on interpretation of recognized standards , technical documents , knowledge ,backgrounds and experiences in gas industries at national and international levels.

Iranian Gas Standards (**IGS**) are prepared , reviewed and ammended by technical standard committees within NIGC Standardization Div. and submitted to the **NIGC's "STANDARDS COUNCIL"** for approval .

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Throughout this standard the following definitions , where applicable , should be followed :

1- "**STANDARDIZATION DIV.**" has been organized to deal with all aspects of industrial standards in NIGC . Therefore , all queries for clarification or amendments are requested to be directed to the mentioned div.

2- "**COMPANY** " : refers to national iranian gas company .

3- "**SUPLIER**" : refers to a firm who will supply the service , equipment or material to igs specification whether as the prime producer or manufacturer or a trading firm .

4- "**SHALL**" : is used where a provision is mandatory.

5- "**SHOULD**" : is used where a provision is advised only.

6- "**MAY**" : is used where a provision is completely discretionary.

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پیشگفتار

- ۱- این استاندارد/دستورالعمل بمنظور استفاده اختصاصی در شرکت ملی گاز ایران و شرکتهای فرعی وابسته تهیه شده است.
- ۲- شرکت ملی گاز ایران در مورد نیازهای عمومی از استانداردهای وزارت نفت (IPS) و در مورد نیازهای اختصاصی از استانداردهای اختصاصی خود (IGS) استفاده می نماید.
- ۳- استانداردهای شرکت ملی گاز ایران (IGS) توسط کمیته های تخصصی استاندارد متشکل از کارشناسان بخش های مختلف و یا مشاور تهیه می شود و توسط شورای استاندارد (منتخب هیئت مدیره شرکت ملی گاز ایران) به تصویب میرسند.
- ۴- در تنظیم متن استانداردهای (IGS) از کلیه منابع شناخته شده استاندارد، اطلاعات فنی - تخصصی مربوط به صنایع گاز دنیا، مشخصات فنی تولیدات سازندگان معتبر جهانی و نیز از نتیجه تحقیقات و تجربیات کارشناسان و متخصصان داخلی بر حسب مورد استفاده می شود. همچنین بمنظور استفاده هر چه بیشتر از تولیدات داخلی قابلیت های سازندگان داخلی نیز مورد توجه قرار میگیرد.
- ۵- استانداردها از طریق پایگاه اینترنتی شرکت * و یالوح فشرده (CD) در اختیار واحدها و کاربران قرار می گیرد .
- ۶- استانداردها بطور متوسط هر ۵ سال یکبار و یادر صورت ضرورت زودتر، مورد بازنگری و بروزرسانی قرار میگیرند. بنابراین کاربران باید همیشه آخرین نگارش را مورد استفاده قرار دهند.
- ۷- هرگونه نظر و یا پیشنهاد اصلاح در مورد استانداردها مورد استقبال و بررسی قرار خواهد گرفت و در صورت تأیید، استاندارد مربوطه نیز مورد تجدیدنظر قرار خواهد گرفت .

تعاریف عمومی

در متن استانداردهای (IGS) از تعاریف و اصطلاحات زیر استفاده میشود.

- ۱- "شرکت" (COMPANY): منظور از شرکت "شرکت ملی گاز ایران" و یا شرکتهای فرعی وابسته میباشد.
- ۲- "فروشنده" (SUPPLIER/VENDOR): به فرد یا موسسه ای اطلاق میگردد که تعهدی رانسبت به شرکت تقبل نموده است.
- ۳- "خریدار" (PURCHASER): منظور از خریدار "شرکت ملی گاز ایران" و یا شرکتهای فرعی وابسته میباشد.
- ۴- "SHALL": در مواردی بکاربرده میشود که انجام خواسته مورد نظر اجباری است
- ۵- "SHOULD": در مواردی بکاربرده میشود که انجام خواسته مورد نظر ترجیحی و درعین حال اختیاری است
- ۶- "MAY": در مواردی بکاربرده میشود که انجام کار به شکل مورد بحث نیز قابل قبول میباشد

IGS-IN-203

TABLE OF CONTENT

	PAGE
1. SCOPE	2
2. REFERENCES	3
3. DEFINITIONS	4
4. REQUIREMENTS	7
4-1 SERVICE & DESIGN CONDITIONS	7
4-2 MATERIALS	10
5. INSPECTION , TEST & CERTIFICATION	12
6. PAINTING	22
7. MARKING	22
8. PACKING & PACKAGING	22
9. DOCUMENTATION	23
10. APPENDIX “A” : DATA SHEET	25-28

1. SCOPE

This Specification covers the minimum design, material, fabrication , testing , marking and packing requirements of gas pressure regulators for commercial and industrial usages with inlet pressure 1.03-7 BAR (15-100 PSIG) outlet pressure range 103-172 MBAR (1.5-2.5 PSIG), sizes 1½ inches and maximum capacities of 160 SCM/H. For specific requirements see appendix “A”.

In case of any exception to this specification , it shall be clearly stated on the technical quotation submitted by supplier.

2. REFERENCES

Throughout this standard specification the following standards and codes are referred to. The editions of these standards and codes that are in effect at the time of publication of this standard specification (1999) shall , to the extent specified herein , form a part of this standard specification . The applicability of changes in standards and codes that occur after the date of this standard specification shall be mutually agreed upon by the purchaser and supplier and/or manufacturer.

- 1- ASTM B85-1981 standard specification for aluminium alloy DIE castings.
- 2- ASTM B117-1985 standard method of salt spray (fog) testing
- 3- ASTM B16-1985 standard specification for free- cutting brass rod , bar , and shapes for use in screw machines
- 4- ANSI B1.20.1-1983 pipe threads, general purpose
- 5- ANSI B1.1 unified inch screw threads
- 6- ANSI Z 21.15-1992 manually operated gas valves for appliances & appliances connector valves & holes end valves.
- 7- ANSI B16.4-1977 cast iron threaded fittings class 125 and 250
- 8- ANSI B16.33 –1981 manually operated metallic gas valves for use in gas piping system upto 125 PSIG
- 9- BS 3900: part E6:1992 methods of test for paints cross-cut test.

- 10- BS 4161 : part 5 : 1990 specification for diaphragm meters for working pressures up to 7 bar.
- 11- BS-EN- 549: 1995 rubber materials for seals and diaphragms for gas appliances and gas equipment.
- 12- ISO 1817 rubber vulcanized- determination of the effect of liquids.
- 13- ISO 2409 : 1992 methods of test for paints and varnishes.
- 14- American gas association for service regulator specification.

3. **DEFINITIONS**

PRESSURE REGULATOR: Device which maintains the outlet pressure constant independent of the variation in inlet pressure and/or flow rate within defined limits.

INLET PRESSURE : Pressure at the inlet of the regulator.

OUTLET PRESSURE:Pressure of the outlet of the regulator.

AMBIENT TEMPERATURE: The temperature of the surrounding air, at which the regulator may be operated.

DIAPHRAGM: A flexible member which , under the influence of the forces arising from loading and pressure, operates the valve.

DIAPHRAGM PLATE : A rigid disc in contact with the diaphragm, which transmits the force of fixed weight , fixed spring or adjustable springs to the diaphragm.

VALVE: The part of a gas pressure regulator actuated by the mechanism tending to control the outlet pressure.

VALVE SEAT : The stationary portion of an assembly which , in conjunction with the valve, controls the outlet pressure.

VALVE STEM : A rod which position the valve relative to the diaphragm and seat , directly or through linkage.

ORIFICE : The opening in an orifice cap , orifice spud or other device where by the flow of gas is limited , and through which the gas is discharged.

LOW-PRESSURE SHUT –OFF DEVICE: A device that shuts off the gas supply in the event of the gas pressure falling below a predetermined value, manual resetting of the valve is required.

HIGH-PRESSURE SHUT-OFF DEVICE: A device that shuts off the gas supply in the event of the gas pressure rises above a predetermined value , manual resetting of the valve is required.

RELIEF VALVE: A device used to protect piping and components from overpressure.

VALVE BODY : The part of regulator which the diaphragm casing and shut off device(s) have connected to it.

BASE CONDITION : Fixed conditions to which a volume of gas is converted (i.e base gas temperature 15°C , base gas pressure 1013.25 MBAR)

CAPACITY : The rate of flow through a regulator under stated test condition.

4. REQUIREMENTS

4.1 DESIGN & SERVICE CONDITIONS

The regulator shall have easy moving parts without stresses and be constructed of quality materials in a workmanlike

manner in order to attain gas tightness, stability of performance and sustained accurate regulation over a period of time and over the range of operating conditions with minimum of maintenance , when regulating natural gas . such regulator shall have the general characteristics listed below:

- 4.1.1 The regulator shall be for outdoor installation and all its parts shall be resistant to atmospheric corrosion as well as the continuous attack of odorized natural gas & methanol.
- 4.1.2 The inlet pressure 1.03-7 BAR (15-100 PSIG) , outlet pressure range 103-172 MBAR (1.5-2.5 PSIG).
- 4.1.3 The ambient temperature range for the regulator –29 to 60 DEG.C (-20 to 140 DEG.F)
- 4.1.4 Standard volume measured at 1.013 BAR (14.696 PSIA) and 15.6 DEG.C (60 DEG.F)
- 4.1.5 Regulator performance shall comply with the following :
The outlet pressure of regulator shall not rise above 172 MBAR (2.5 PSIG) or fall below 103 MBAR (1.5 PSIG) with flow variation between zero and full capacity of regulator at 1.03 and 7 BAR (15 and 100 PSIG) inlet pressures.
- 4.1.6 The regulator shall be equipped with low pressure shut off device (L.P.S.O) , high pressure shut off device (H.P.S.O) & full capacity internal relief valve (F.I.R.V). The three safety devices and the regulator itself shall be assembled together and comprise one unit only .
- 4.1.7 The setting of the low and high pressure shut off devices (L.P.S.O and H.P.S.O)and full capacity internal relief valve (F.I.R.V) shall be adjustable and their adjustments shall be

readily accessible for ease of adjustment . Low and high pressure shut off devices (L.P.S.O and H.P.S.O) shall be independent of the main diaphragm case and valve seat of the regulator.

Both high & low pressure devices shall be resetable manually.

4.1.8 The setting ranges of the three safety devices of the regulator shall be as following:

4.1.8.1 Low pressure shut off (L.P.S.O) setting 69 ± 14 MBAR (1 ± 0.2 PSIG).

4.1.8.2 High pressure shut off (H.P.S.O) setting 240 ± 20 MBAR (3.5 ± 0.3 PSIG).

4.1.8.3 Full internal relief valve (F.I.R.V) setting 345 ± 35 MBAR (5 ± 0.5 PSIG)

4.1.9 Full internal relief valve (F.I.R.V) shall be designed in such away that in case of failure of any internal parts of regulator , it shall be able to discharge through flow at 7 bar (100 PSIG)inlet pressure without increasing outlet pressure of regulator above 550 MBAR (8 PSIG).

4.1.10 The inlet and outlet connections of regulator shall be in-line . Direction of flow shall be permanently embossed on the valve body

4.1.11 All inlet , outlet and vent connections shall be threaded N.P.T. , female acc. To ANSI B 1.20.1.

4.1.12 Vent shall be located on the top cover of the diaphragm case at farthest point with respect to the valve body and embossed “vent” permanently. Vent size shall be either $\frac{1}{2}$,

$\frac{3}{4}$, 1 , $1\frac{1}{2}$ or 2 inch and suitable for relieving full flow of regulator. Vent shall be provided with a secured replaceable bug screen.

- 4.1.13 The valve linkage shall be solid type , pivot pins or rivets so designed that they can not work loose in the assembled regulator.
- 4.1.14 The valve orifice shall not be variable type , the valve orifice thread shall be gas tight and orifice shall be accessible by removing diaphragm case from body and shall be easily removable without required special tools.
- 4.1.15 The valve shall be so mounted such that it will align for complete contact with the seating surface of the valve orifice. The valve disc shall be securely fastened to its actuator so that it can not become separated during shipping , handling or operation.
- 4.1.16 Diaphragm casing shall be constructed such as to allow 0 to 180 degree rotation with respect to the valve body.
- 4.1.17 In case threaded plastic parts are used for the regulator ,

they shall be constructed by injection and the thread shall be provided on moulds.

4.2 MATERIAL

- 4.2.1 Valve body material and construction shall be cast iron acc. To ANSI B16.4 class 125.
- 4.2.2 Diaphragm cases material shall be die cast aluminium acc. To ASTM B 85 . Diaphragm case shall be strong enough to

withstand 750 MBAR (11 PSIG) air pressure without any failure.

4.2.3 Diaphragm shall be made of reinforced synthetic material. Diaphragm and other rubber parts material of regulator (such as “o” ring, valve disc seat, ...) , shall be homogenous , free from porosity, grit , blisters and defects. Test requirements shall be acc. To test no.5.11 of inspection, test & certification section.

4.2.4 The following information shall be permanently marked on the moulded diaphragm or master sheet of diaphragm:

- The manufacturer name or trade mark.
- Batch number.
- Date of manufacture.

4.2.5 The springs, stems , valve linkage and vent screen shall be durably constructed of a corrosion resistant material with stainless steel or corrosion resistant plated steel to meet the requirement of salt spray test (test no.5.12)

4.2.6 Orifice shall be made of brass acc. To ASTM B16 or stainless steel type 316.

The valve orifice thread shall be gas tight , if a thread sealant is used it shall be permanent and of the nondrying type.

The regulator shall withstand heating to 121 DEG. C (250 DEG.F) without affecting the gas tightness of any thread sealant used.

4.2.7 screws (except the adjusting screws), bolts and nuts shall be stainless steel or corrosion resistant plated steel to meet

the requirement of salt spray test (test no.5.12) and threading shall conform to ANSI B1.1

4.2.8 All adjusting screws, caps , diaphragm plate , valve disc and relief valve cup shall be made of suitable material to withstand any mechanical , chemical and thermal adverse conditions as following to which they may be subjected during services:

4.2.8.1 Full opening & closing for 100 times (for adjusting screws and caps).

4.2.8.2 Low and high temperature –29 DEG.C and 100 DEG.C (-20 DEG.F and 212 DEG.F) for 24 HOURS.

4.2.8.3 Odorized natural gas.

5. INSPECTION, TEST & CERTIFICATION

The complete assembled regulator shall be inspected and the inspection shall cover the following stages as specified in this specification and according to terms and conditions of purchase order and manufacturer's drawing.

Approximately 3% of each item and lot ready for presentation (unless otherwise specified by mutually agreed inspection procedure based on capacity and quantity of each lot) shall be selected randomly by identified NIGC inspector.

Manufacturer shall provide and present to NIGC inspector test results for different examinations and material test certificates according to requirements of NIGC specification:

5.1 VISUAL INSPECTION

Visual inspection including checking of colour, thread , nameplate , internal parts. No apparent or imperfection shall be observed.

5.2 DIMENSIONS CHECKS

Overall dimensions shall be checked for randomly selected samples.

5.3 PERFORMANCE TEST (AT 21±1 DEG.C ROOM TEMP.)

5.3.1 LOCK-UP TEST : with applying air with pressure of 1.03 BAR (15 PSIG) to the inlet of regulator , the outlet of the valve is closed (Q=0) , after 2 MINUTES the outlet pressure (lock-up pressure) shall not exceed 172 MBAR (2.5 PSIG)

5.3.2 DROOP TEST : with inlet pressure of 1.03 BAR (15 PSIG) , the outlet of the valve shall be opened until the passing flow from regulator equal the maximum capacity (160 SCM/H) . At this time the outlet pressure shall not dropt below 103 MBAR (1.5 PSIG).

5.3.3 PERFORMANCE CURVE : with inlet pressure of 1.03 BAR (15 PSIG) the outlet pressure of regulator shall be recorded for 10,20,30,40,50,60,70,80,90, and 100 percent of regulator capacity . The performance curve thus obtained shall show the suitability operation of regulator within the mentioned limits in this standard.

5.3.4 Tests as 5.3.1 , 5.3.2 and 5.3.3 shall be performed with 7 BAR (100 PSIG) inlet pressure. The results shall be the same as outlined in the set paragraph.

5.4 SAFETY DEVICES TESTS (AT 21±1 DEG.C ROOM TEMP.)

5.4.1 When the outlet pressure of regulator is increasing, the high pressure shut off device (H.P.S.O) should act when outlet

pressure reaches (240± 20 MBAR) (3.5±0.3 PSIG) at both 1.03 BAR (15 PSIG) and 7 BAR (100 PSIG) inlet pressures . The manually resetting of this device shall be checked.

5.4.2 When the regulator outlet is subjected to (345±35) MBAR (5±0.5 PSIG) , the full internal relief valve should act both at 1.03 BAR (15 PSIG) and 7 BAR (100 PSIG) inlet pressures. At full flow condition with 7 BAR(100 PSIG) inlet pressure (as described in 4.1.9) , the outlet pressure shall not increase above 550 MBAR (8 PSIG) .

5.4.3 The low pressure shut off device (L.P.S.O) of regulator should act when outlet pressure is dropt below (69±14) MBAR (1±0.2 PSIG) at each of the following conditions:

- 1- While closing the inlet valve.
- 2- While increasing flow with inlet pressures 1.03 and 7 bar (15 and 100 PSIG) .

The manually resetting of this system shall be checked.

5.5 TIGHTNESS TEST

Samples shall be tested for tightness when with closed vent port applying 7 BAR (100 PSIG) air pressure for 2 MINUTES to the inlet and 550 MBAR (8 PSIG) to the outlet. No leakage and failure shall be witnessed.

5.6 AMBIENT TEMPERATURE TEST

5.6.1 Regulator shall be kept in 60 DEG.C (140 DEG.F) environment for Approximately 12 hours . At this temperature, the regulator shall be tested in accordance with paragraphs 5.3.1 , 5.3.2 ,5.4.1 , 5.4.2 , 5.4.3 with inlet pressure 1.03 and 7 BAR (15

and 100 PSIG) and the tests results shall stay within limits specified in this standard. Meanwhile the regulator shall operate without objectionable noise, malfunction, pulsation or chattering. Then the regulator shall be put in room temperature for about 30 MINUTES and it shall be tested in accordance with paragraph 5.5 (tightness test).

5.6.2 Same as above but at temperature –29 DEG.C (-20 DEG.F) .

5.7 LIFE TEST

With inlet pressure of 7 BAR (100 PSIG) and maximum capacity of regulator, the outlet of regulator shall be opened and closed 100,000 times at cycle of 10 operation per minutes. Then the regulator shall be tested for performance and tightness tests (tests No.5.3 and 5.5) , the results shall be acceptable .

5.8 VALVE BODY PRESSURE RATING TEST

By closing the ports of regulator valve body sample while applying 12 BAR (175 PSIG) hydrostatic pressure via inlet / outlet port for 2 HOURS, it shall withstand the pressure. no leakage failure or cracks shall be witnessed.

5.9 TWIST TEST

For cast iron body of regulator, the twist test shall be applied acc.to ANSI B16.33 section 3.4.2.

5.10 LOAD TEST

Regulator , installed with diaphragm housing in horizontal position , shall withstand a cantilevered load of at least 115kg applied at the edge farthest from the connections , without

affecting performance, or causing leakage , fracture or permanent deformation of any component.

5.11 DIAPHRAGMS AND OTHER RUBBER PARTS
CHECKS AND TEST

5.11.1 DIAPHRAGMS

5.11.1.1 DIAPHRAGM CHECKING : Diaphragm material shall be checked as paragraph 4.2.3. of material section . The thickness variation of diaphragm on the same sections shall be $\pm 10\%$.

5.11.1.2 IDENTIFICATION: Identification checking shall be carried out as paragraph 4.2.4.

5.11.1.3 TEST ON DIAPHRAGM MATERIAL:

NOTE. TEST PIECES: Test pieces shall be taken from a diaphragm or from the diaphragm material, if from the later they shall be of the same thickness and cured under the same conditions as the diaphragm.

5.11.1.3.1 HYDROCARBON MIXTURE TEST : when a test piece is immersed and allowed to swell freely in a mixture of toluene and heptane in the proportion 1:1 by volume at $(20\pm 5^{\circ}\text{c})$ for 7 days , the change in area shall not be greater than 5% of the original area . after immersion and drying to constant mass at room temperature , the extracted material shall not exceed 12% by mass of the original mass of the test piece, and the area shall not differ from the original area by more than 5% . The material shall not show any sign of delamination or blistering.

NOTE: The volume ratio of liquid to test piece shall not be less than 50:1.

5.11.1.3.2 WATER TEST: when the test piece is immersed in distilled or deionized water and allowed to swell freely at $(20\pm 5)^{\circ}\text{C}$ for 7 days , the change in area of the material shall not be greater than 5% of the original area of the test piece.

After immersion and drying to constant mass in air at room temperature, the extracted material shall not exceed 12% by mass of the original mass of the test piece and the area shall not differ from the original area by more than 5%.

The material shall not show any sign of delamination or blistering.

5.11.1.3.3 ACCELERATED AGEING TEST : The stiffness of the test piece shall be measured at $(20\pm 5)^{\circ}\text{C}$, by torsion apparatus (App."F" of BS 4161 : part 5 : 1990) The stiffness, when remeasured at $(20\pm 5)^{\circ}\text{C}$ shall not have increased by more than 25% after the test piece has been subjected to a temperature of $(70\pm 2)^{\circ}\text{C}$ in an air – circulating oven for 4 weeks. In addition , the test piece shall not show any sign of delamination , blistering or significant deterioration.

5.11.1.3.4 LOW TEMPERATURE FLEXIBILITY TEST: the stiffness of the test piece shall be measured at $(20\pm 5)^{\circ}\text{C}$ by torsion apparatus (App."F" of BS 4161: part 5: 1990) the stiffness when measured at $(-20\pm 1)^{\circ}\text{C}$ shall not have increased by more than 25% after the test piece has been subjected to this temperature in an environmental chamber for 20 minutes.

5.11.1.4 DIAPHRAGM TIGHTNESS TEST : diaphragm test piece

shall be located between the two halves. Air at a pressure of 280 MBAR (4 PSIG) shall be applied to the underside of it . Then inlet pressure shall be locked off and no leakage shall be observed by controlling inlet pressure.

5.11.2 OTHER RUBBER PARTS (VALVE SEATS , SEALS AND “O” RINGS

5.11.2.1 GENERAL:The tests shall be carried out with the finished component or with parts of the finished component.

The elastomeric material shall be homogeneous , free from porosity , inclusions , grit , blisters and surface imperfections visible with the naked eye , even after cutting.

5.11.2.2 RESISTANCE TO LUBRICANT : The test shall be carried out according to 8.2 of ISO 1817 : 1985 concerning the gravimetric method but the duration of immersion shall be (168±2) HOURS in oil No.2 (ISO 1817 : 1985) at the (100±2)°c ambient temperature.

Determine the relative change of mass , ΔM , using the following formula:

$$\Delta M = \frac{M_3 - M_1}{M_1} \times 100$$

Where

M_1 is the initial mass of the test piece in air,

M_3 is the mass of the test piece in air after immersion.

After this test, the change of mass shall be between -10% and +10% .

the test piece shall not show any sign of delamination ,
blistering or significant deterioration .

5.11.2.3 RESISTANCE TO GAS : The test shall be carried out according to 8.2 of ISO 1817 : 1985 concerning the gravimetric method and clause 9 concerning the determination of extracted soluble matter, but under the following conditions:

(A)- Immerse the test pieces for (72±2)°C HOURS at (23±2)°C in N-pentane (98% minimum N-pentane by mass estimated by gas chromatography)

(B)- After removal from liquid , wipe dry rapidly and weight immediately

(C)- Dry the test pieces for a period of (168±2) HOURS in an oven at (40±2)°C at atmospheric pressure.

Determine the relative change of mass , ΔM_1 , ΔM_2 , with reference to the initial mass of the test piece, using the following formulas :

$$\Delta M_1 = \frac{M_2 - M_1}{M_1} \times 100$$

$$\Delta M_2 = \frac{M_3 - M_1}{M_1} \times 100$$

Where:

ΔM_1 is the change in mass after immersion.

ΔM_2 is the change in mass after drying.

M_1 is the initial mass of the test piece in air.

M_2 is the mass of the test piece in air after removal from liquid

M_3 is the mass of the test piece in air after drying.

After this test the changes of mass shall be as following:

ΔM_1 from -5% to $+10\%$.

ΔM_2 from -8% to $+5\%$.

The test piece shall not show any sign of delamination , blistering or significant deterioration.

5.11.2.4 The elastomer material shall be placed in chamber maintained at $(-29\pm 1)^\circ\text{C}$ for 1 HOUR At this temperature , the test piece shall have sufficient flexibility for its services . The test piece shall not show any sign of delamination , blistering or significant deterioration.

5.11.2.5 After the elastomer material has been subjected to a temperature of $(70\pm 2)^\circ\text{C}$ in an air-circulating oven for (168 ± 2) HOURS the test piece shall not show any sign of delamination , blistering or significant deterioration.

5.12 SALT SPRAY TEST

Salt spray test in accordance with ASTM B117 for 500 HOURS shall be carried out for all corrodible metallic parts of regulator such as levers, springs, pins, nut & bolts, etc.

5.13 PAINT TEST

Painting of regulator shall be checked as follows:

5.13.1 The colour of paint shall be grey according to requirements as mentioned at “ painting “ section .

5.13.2 **THICKNESS** : The thickness of paint shall be measured at fivepoints on each diaphragm regulator casing. None of each individual point shall be differ from (50±10) microns.

5.13.3 **PAINT ADHESION** : The test shall be done in accordance with BS 3900 part E6 (1992) equivalent to ISO 2409 (1992).

5.14 **ADHESION AND LEGIBILITY TEST OF MARKING**

The following tests acc. To ANSI Z21.15 : 1992 shall be conducted on samples . the manufacturer shall have applied the marking materials to the regulators as they would be applied in mass production.

5.14.1 **ADHESIVE TYPE MARKING MATERIALS SHALL EXHIBIT:**

5.14.1.1 Good adhesion and no curling at edges.

5.14.1.2 No illegible or defaced printing when rubbed with thumb or finger pressure.

5.14.1.3 Good adhesion when a dull metal blade (as the back of a pocketknife blade) is held at 90 degrees (1.57 rad) to the applied marking and scraped across the edges of the marking.

5.14.2 Nonadhesive type marking materials shall exhibit no illegible or defaced printing when rubbed with thumb or finger pressure.

5.14.3 The marking materials shall then be placed in an oven for a period of 2 weeks with the oven temperature maintained at +60°C . Following the oven test , adhesion and legibility of the samples shall be checked again as specified in 5.14.1 or 5.14.2 above .Samples shall then be immersed in water for a period of 24 hours , after which adhesion and legibility shall be rechecked as specified in 5.14.1 or 5.14.2 above.

6. PAINING

The regulator body shall be properly surface prepared and cleaned to allow subsequent treatment and uniform painting. Aluminium casing of regulator that could be exposed to the atmosphere shall receive a chromate conversion coating.

The exterior surface of the regulator shall have an enamel coating and painting with a dry thickness of (50±10) MICRONS. Final colour shall be grey acc. To ANSI Z55.1 , colour No.49 (or equivalent).Test requirements for painting shall be in accordance. With paint test (test No.5.13).

7. MARKING

Each regulator shall bear on its body or on name plate(s) permanently attached/affixed on to the following information in farsi or English:

- 7.1 **Manufacturer's name or trade mark.**
- 7.2 **Manufacturer's serial No. , type and model No.**
- 7.3 **N.I.G.C P/O No. .**
- 7.4 **Year of manufacture.**
- 7.5 **Regulator max. capacity in SCM/H.**
- 7.6 **Inlet & outlet pressure range.**
- 7.7 **Inlet , outlet and vent sizes.**
- 7.8 **Orifice size.**
- 7.9 **NIGC indication embossed on the valve body .**

The adhesive quality and legibility of marking materials shall not be adversely affected when marking materials are exposed to heat, sunlight and moisture as specified in adhesion and legibility test of marking (test No. 5.14).

8. PACKING & PACKAGING

- 8.1 **Each individual regulator shall be closed in a plastic bag with all openings (such as inlet, outlet and vent) plugged by plastic caps.**
- 8.2 **Each Plastic bag shall be housed in a cardboard box.**
- 8.3 **The cardboard boxes shall be housed in wooden cases of appropriate size and with provisions for lifting by fork as per the requirement of NIGC order.**

9. DOCUMENTATION

Supplier is required to fill completely and sign the attached data sheet and submit samples in quantities needed for each regulator against each individual item of inquiry in the process of technical evaluation as well as 2 sets of the following documentation in English with technical quotations:

- 9.1 All technical information such as material specifications and standards , regulator performance data and original printed catalogues(s).
- 9.2 Complete parts list catalogues(s).
- 9.3 General drawing (s) showing outline dimensions.
- 9.4 Manuals for installation , commissioning , operation and maintenance.

NOTE: in case of order placement , the supplier shall submit 5 sets of above information (items 9.1 to 9.4) for each order.

APPENDIX “A”
DATA SHEET⁽¹⁾

To be filled in by NIGC	To be filled in by supplier
Inquiry No. :	Quotation No.:
Inquiry date :	Quotation date :
NIGC standard :IGS-MS-IN-203(0):2002	Catalogue No. :

Inquiry data				Offered data		
Item	Indent Item No.	Max. capacity (SCM/H)	Quantity required	Max. capacity (SCM/H)	Quantity offered	Type-modle

(1):This data sheet is an integrated part of STD. No. IGS-MS-IN-203(0):2002 and should not be used separately.

APPENDIX “A” (CONTINUED)

DATA SHEET

	Data	Required by NIGC	To be filled by supplier
REQUIREMENTS	Gas inlet pressure	1.03-7 BAR (15-100 PSIG)BAR (.....PSIG)
	Outlet pressure at max. capacity and min. inlet pressure 1.03 BAR (15 PSIG)	Min. 103 MBAR (Min. 1.5 PSIG)MBAR(.....PSIG)
	Max. lock-up pressure with inlet pressure 7 BAR (100 PSIG)	172 MBAR (2.5 PSIG)MBAR (.....PSIG)
	Low pressure shut off device (L.P.S.O) setting	69± 14MBAR (1±0.2 PSIG)	YES <input type="checkbox"/> NO <input type="checkbox"/>
	High pressure shut off device (H.P.S.O)setting	240±20 MBAR (3.5±0.3 PSIG)	YES <input type="checkbox"/> NO <input type="checkbox"/>
	Full internal relief valve (F.I.R.V) setting	345±35 MBAR (5±0.5 PSIG)	YES <input type="checkbox"/> NO <input type="checkbox"/>

Inlet/outlet, size and thread STD. Of connection	1½” x 1½” , threaded NPT, female acc. To ANSI B1.20.1	YES <input type="checkbox"/> NO <input type="checkbox"/>
Ambient temperature Range	-29 to 60 DEG.CtoDEG.C
STD for material of body/diaphragm casing / orifice/diaphragm & seats / screws/nut & bolts and etc.	Acc. To material section (section 4.2)	YES <input type="checkbox"/> NO <input type="checkbox"/>

APPENDIX “A” (CONTINUED)

DATA SHEET

	Data	Required by NIGC	To be filled in by supplier
SUPPLIER REMARKS ON TEST, CERTIFICATES,	Visual inspection	For the samples selected by NIGC inspector	YES <input type="checkbox"/> NO <input type="checkbox"/>
	Dimensions checks	For the samples selected by NIGC inspector	YES <input type="checkbox"/> NO <input type="checkbox"/>
	Safety devices and performance tests	For the samples selected by NIGC inspector	YES <input type="checkbox"/> NO <input type="checkbox"/>
	Performance curve	Type test	YES <input type="checkbox"/> NO <input type="checkbox"/>
	Tightness test	For the samples selected by NIGC inspector.	YES <input type="checkbox"/> NO <input type="checkbox"/>
	Ambient temperature test	Test certificate	YES <input type="checkbox"/> NO <input type="checkbox"/>
	Life test	Test certificate	YES <input type="checkbox"/> NO <input type="checkbox"/>
	Valve body pressure rating test	For the samples selected by NIGC inspector	YES <input type="checkbox"/> NO <input type="checkbox"/>
Twist test	For the samples selected by NIGC inspector.	YES <input type="checkbox"/> NO <input type="checkbox"/>	

Load test	For the samples selected by NIGC inspector.	YES <input type="checkbox"/>	NO <input type="checkbox"/>
Diaphragm and other rubber parts material	Test certificate	YES <input type="checkbox"/>	NO <input type="checkbox"/>
Salt spray test	Test certificate	YES <input type="checkbox"/>	NO <input type="checkbox"/>
Paint test	For the samples selected by NIGC inspector.	YES <input type="checkbox"/>	NO <input type="checkbox"/>
Adhesion and legibility test of marking	Test certificate	YES <input type="checkbox"/>	NO <input type="checkbox"/>

APPENDIX “A”

DATA SHEET

Data	Required by NIGC	To be filled in by supplier
Guarantee	24 months after shipment or 1 year after putting in service whichever comes earlier	YES <input type="checkbox"/> NO <input type="checkbox"/>
Manufacturer signature and stamp.		