

Energy Efficient Because It's So Reliable

The inverted bucket is the most reliable steam trap operating principle known. The heart of its simple design is a unique leverage system that multiplies the force provided by the bucket to open the valve against pressure. Since the bucket is open at the bottom, it resists damage from water hammer, and wear points are heavily reinforced for long life.

The inverted bucket has only two moving parts – the valve lever assembly and the bucket. That means no fixed points, no complicated linkages. Nothing to stick, bind or clog.

Wear and corrosion resistance

Free-floating guided lever valve mechanism is "frictionless," and all wear points are heavily reinforced. All working parts are stainless steel. Valve and seat are stainless steel, individually ground and lapped together in matched sets.

Virtually no steam loss

Steam does not reach the water-sealed discharge valve.

Continuous air and CO₂ venting

Vent in top of bucket provides continuous automatic air and CO₂ venting with no cooling lag or threat of air binding. Steam passing through vent is less than that required to compensate for radiation losses from the trap so it's not wasted.

Purging action

Snap opening of the valve creates a momentary pressure drop and turbulence in the unit drained. This breaks up films of condensate and air and speeds their flow to the trap.

Excellent operation against back pressure

Since trap operation is governed by the difference in density of steam and water, back pressure in the return line has no effect on the ability of the trap to open for condensate and close against steam.

Dependable operation

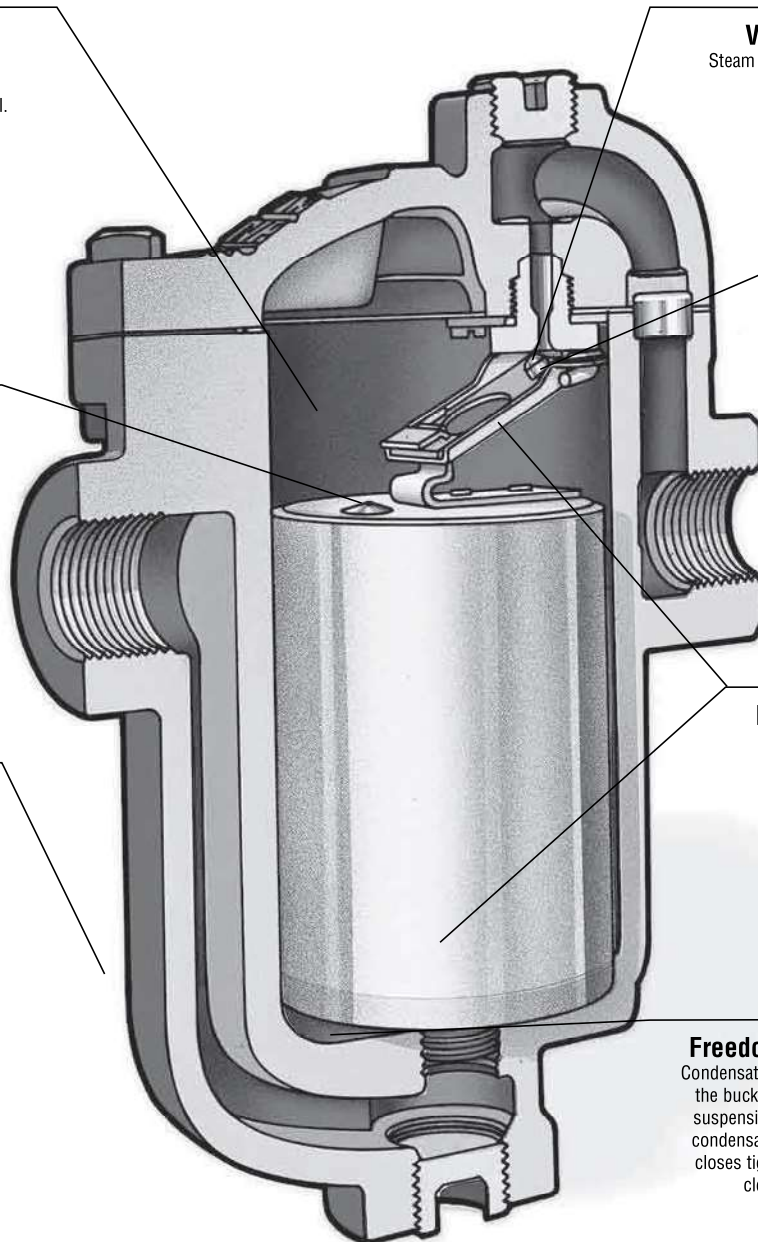
Simple, direct operation with nothing to stick, bind or clog. Only two moving parts – the valve lever and the bucket.

Freedom from dirt problems

Condensate flow under the bottom edge of the bucket keeps sediment and sludge in suspension until it is discharged with the condensate. Valve orifice opens wide and closes tightly. No buildup of dirt or close clearances to be affected by scale.

Resistance to damage from water hammer

Open bucket or float will not collapse as a result of water hammer.



Inverted Bucket Steam Trap

Conserves Energy Even in the Presence of Wear

Armstrong inverted bucket steam traps open and close based on the difference in density between condensate and steam – the inverted bucket principle. They open and close gently, minimizing wear. This simple fact means that inverted buckets are subject to less wear than some other types of traps.

In fact, as an Armstrong inverted bucket trap wears, its tight seal actually improves. The ball valve and seat of the Armstrong trap provide essentially line contact – resulting in a tight seal because the entire closing force is concentrated on one narrow seating ring.

An Armstrong inverted bucket trap continues to operate efficiently with use. Gradual wear slightly increases the diameter of the seat and alters the shape and diameter of the ball valve. But, as this occurs, a tight seal is still preserved – the ball merely seats itself deeper.

Corrosion-Resistant Parts

The stainless steel valve and seat of the Armstrong inverted bucket steam trap are individually ground and lapped together in matched sets. All other working parts are wear- and corrosion-resistant stainless steel.

Venting of Air and CO₂

The Armstrong inverted bucket provides continuous automatic air and CO₂ venting with no cooling lag or threat of air binding.

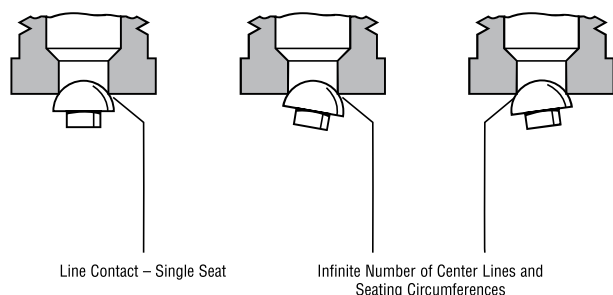
Operation Against Back Pressure

The Armstrong inverted bucket has excellent performance against back pressure. It has no adverse effect on inverted bucket operation other than to reduce its capacity by the low differential. The bucket simply requires less force to pull the valve open and cycle the trap.

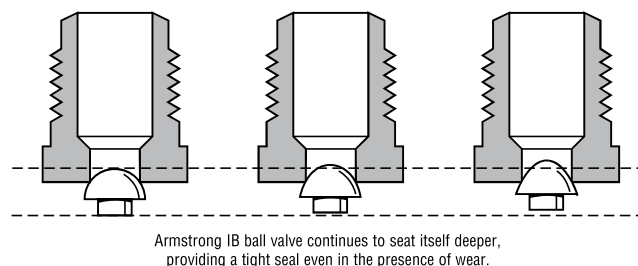
Freedom From Dirt Problems

Armstrong designed its inverted bucket to be virtually free of dirt problems. The valve and seat are at the top of the trap, far away from the larger particles of dirt, which fall to the bottom. Here the up-and-down action of the bucket pulverizes them. Since the valve of an inverted bucket is either fully closed or open, dirt particles pass freely. And the swift flow of condensate from under the bucket's edge creates a unique self-scrubbing action that sweeps dirt out of the trap.

Armstrong IB Valve Seating/Ball Valve



IB Valve Wear Characteristics



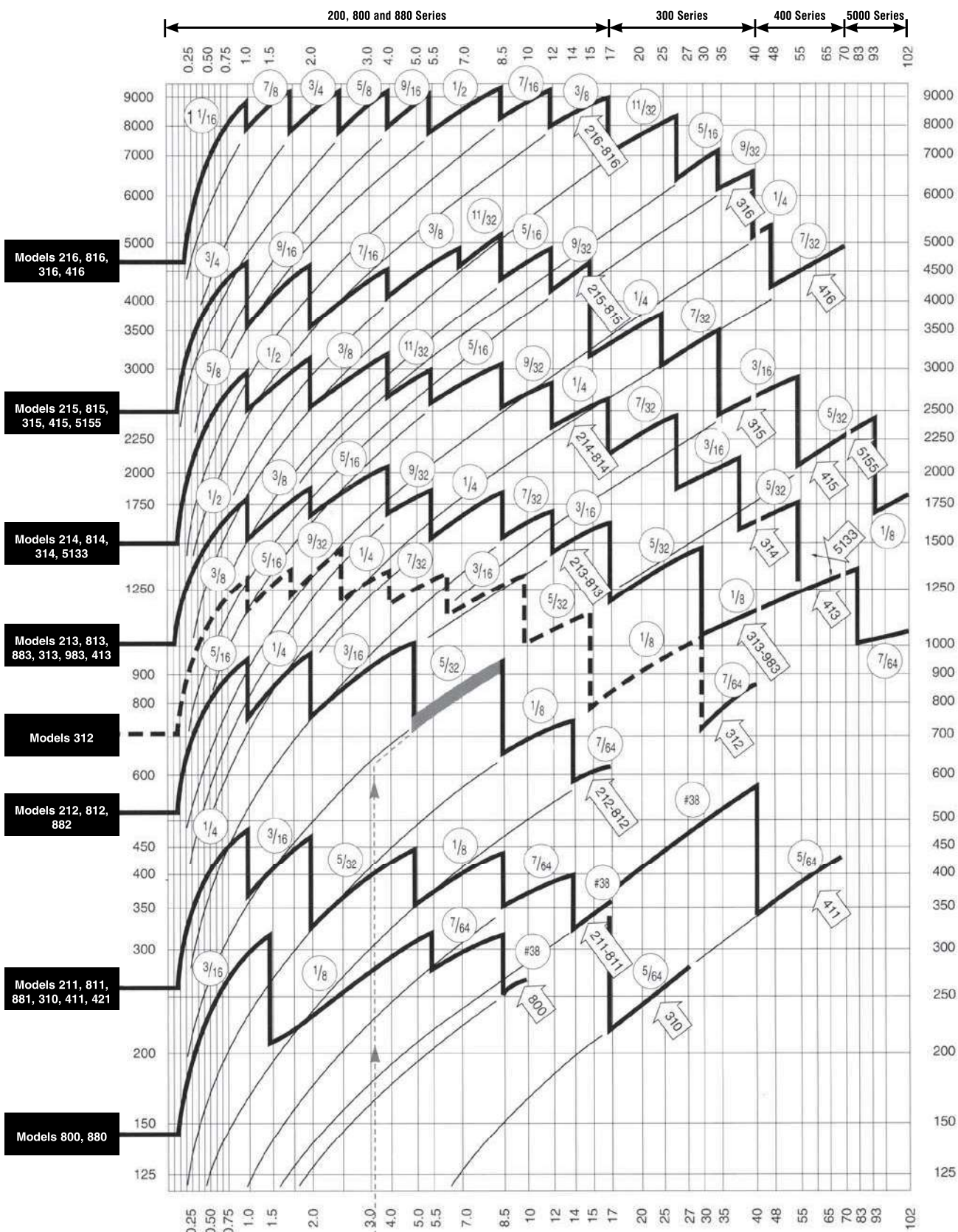
All dimensions and weights are approximate. Use certified print for exact dimensions. Design and materials are subject to change without notice.

IB Steam Trap Summary Capacity Chart

Pressure difference in bar between steam line and return line with trap valve closed

Note: Above capacity chart does not include all models available. Refer to specific page of trap required for capacities not covered above.

Steam Trapping and
Steam Tracing Equipment



Pressure difference in bar between steam line and return line with trap valve closed

Note: Above capacity chart does not include all models available. Refer to specific page of trap required for capacities not covered above.

How to Use the IB Steam Trap Summary Capacity Chart



How the Capacity Chart was made

The Armstrong capacity chart shows continuous discharge capacities of Armstrong traps under actual operating conditions as determined by literally hundreds of tests. In these tests condensate at the steam temperature corresponding to the test pressure was used. The choking effect of flash steam through the orifice, as well as the back pressure created by flash steam, were automatically taken into account. Actual installation hookups were used so that pipe friction in both inlet and discharge lines also were reflected in the results.

Trap capacity ratings based on cold water tests which produce no flash steam would be much too high. Orifice tests also are too high because they ignore pipe friction. Theoretical calculations of trap capacities have never been conservative. You can rely on Armstrong capacity ratings because they show actual capacities of hot condensate.

Heavy "sawtooth" curves

show capacities for traps using maximum possible diameter orifices for the pressures shown.

Thin line curves

extending down to the left of the heavy curves show the capacities of Armstrong traps at pressures below their maximum ratings. For example: a model 216 trap with 1/2" orifice good for a maximum working pressure of 8,5 bar will have a continuous discharge capacity of a little less than 6 000 kg/h at 2,8 bar.

How to use the inverted bucket trap capacity chart

To select an inverted bucket steam trap using the Armstrong capacity chart, you must know the condensate load, safety factor and pressure differential. Remember, the objective is always to select a trap that can 1) operate at the maximum differential pressure and 2) handle the capacity at the minimum differential pressure. Consider the following typical problems:

Example 1:

Constant Pressure and Condensing Rate

Given:

Maximum pressure differential: 5 bar
Operating differential: 4 bar
Condensate load: 133 kg/h
times 3:1 safety factor or: 400 kg/h

Enter chart at 4 bar and go up to 400 kg/h capacity. This is directly on the 5/32" orifice line as shown in Chart ST-77-1. The capacity of this 5/32" orifice at pressures less than 2 bar is indicated by the thin line. Follow the line to the right to the vertical drop at 5 bar. This means this orifice will operate to a maximum of 5 bar differential - the other requirement for this application. Follow the heavy line back to the left and note that it's attached to the arrow indicating that the 211, 811 or 881 traps (1811 and 1011 are other possibilities) with the 5/32" orifice will yield this capacity. This is the trap to use.

Example 2:

Constant Pressure and Condensing Rate but with Possible High Back Pressure

Assume for example:

Maximum pressure differential: 6 bar
Operating differential minimum: 3 bar
Operating differential normally: 4 bar
Condensate load: 133 kg/h
times 3:1 safety factor or: 400 kg/h

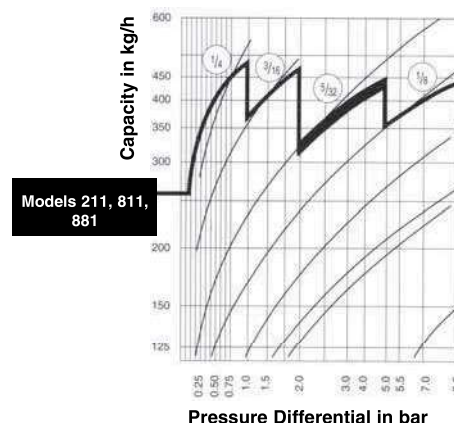
To solve the problem, refer to the sawtooth chart, page ST-76. Enter at the minimum differential pressure (3 bar) and move up until you intersect a line that is above 400 kg/h capacity, which is the first thin line above the heavy "sawtooth" for the 211, 811 and 881 traps. Note

that this is the continuation of the capacity line for the 5/32" orifice for the 212, 812 and 882 traps. Now follow the line to the right until the vertical drop at 8,5 bar differential. This is within our requirement of 6 bar. Therefore a 5/32" orifice can handle the 400 kg/h condensate load when fitted into a 212, 812 or 882 trap and that it will not lock shut at the 6 bar maximum differential. This is the trap to use since it will handle the load at both the minimum and maximum operating differentials, even though it has a maximum operating pressure differential of 8,5 bar.

Orifice sizes:

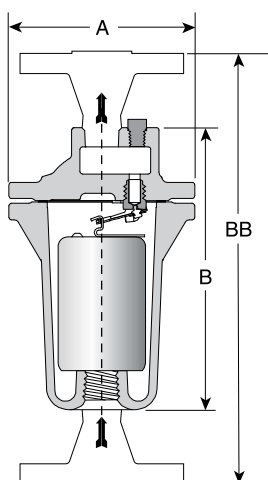
1 7/8"	= 47,0 mm	5/16"	= 7,9 mm
1 5/8"	= 41,0 mm	19/64"	= 7,5 mm
1 17/32"	= 39,0 mm	9/32"	= 7,1 mm
1 1/8"	= 28,0 mm	17/64"	= 6,7 mm
1 1/16"	= 27,0 mm	1/4"	= 6,4 mm
7/8"	= 22,2 mm	7/32"	= 5,6 mm
3/4"	= 19,0 mm	13/64"	= 5,1 mm
11/16"	= 17,5 mm	3/16"	= 4,8 mm
5/8"	= 15,9 mm	11/64"	= 4,4 mm
9/16"	= 14,3 mm	5/32"	= 4,0 mm
1/2"	= 12,7 mm	1/8"	= 3,2 mm
7/16"	= 11,2 mm	7/64"	= 2,8 mm
3/8"	= 9,5 mm	# 38	= 2,5 mm
11/32"	= 8,7 mm	5/64"	= 2,0 mm

Chart ST-77-1: Selection Curve Example 1



200 Series Inverted Bucket Steam Traps

Cast Iron for Vertical Installation
For Pressures to 17 bar...Capacities to 9 000 kg/h



Model 211



Model 211

Description

The most reliable steam trap known – the inverted bucket – provides efficient condensate drainage of virtually all types of steam-using equipment. Put the inverted bucket to work in a tough cast iron package, and you have the best of both worlds. Because they operate efficiently for longer periods of time, Armstrong cast iron inverted buckets add solid energy savings to lower replacement/labor costs.

A unique leverage system multiplies the force provided by the bucket to open the valve against system pressure. The mechanism is free-floating, and has no fixed pivots to create wear or friction.

Because the mechanism is located at the top of the trap, no dirt can collect on the orifice. Small particles of dirt are held in suspension until discharged by the full differential purging action when the bucket sinks, pulling the valve off the seat.

The discharge orifice is surrounded by a water seal, preventing live steam loss. Automatic air venting is provided by a small vent hole in the bucket, which provides continuous automatic air and CO₂ venting at steam temperature.

Inverted bucket traps drain continuously, although discharging intermittently, allowing no condensate backup. They are also resistant to water hammer.

Maximum Operating Conditions

Maximum allowable pressure
(vessel design)†: 17 bar @ 232°C
Maximum operating pressure: 17 bar
Maximum back pressure: 99% of inlet pressure

Connections

Screwed BSPT and NPT
Flanged DIN or ANSI (screw on)

Materials

Body: ASTM A48 Class 30
Cap: ASTM A48 Class 30
Internals: All stainless steel – 304
Valve and seat: Stainless Steel 17-4PH
Test plug: Carbon steel

Options

- Stainless steel internal check valve
- Thermic vent bucket
- Scrub wire

Specification

Inverted bucket steam trap, type ... in cast iron, with continuous air venting at steam temperature, free floating stainless steel mechanism, and discharge orifice at the top of the trap. Maximum allowable back pressure 99% of inlet pressure.

How to Order

Specify:

- Model number
- Size and type of pipe connection
- Maximum working pressure that will be encountered or orifice size
- Any options required

Table ST-78-1. 200 Series, Bottom Inlet, Top Outlet Trap (dimensions in mm)

Add suffix "CV" to model number for internal check valve, "T" for thermic vent bucket.

Model No.	211	212	213	214	215	216
Pipe Connections	15	15 – 20	15 – 20 – 25	25 – 32	25 – 32 – 40	40 – 50
Test plug	1/8"	3/8"	1/2"	1/2"	3/4"	1"
"A" Flange Diameter	108	133	162	190	216	259
"B" Face-to-Face (screwed)	164	218	292	315	361	455
"BB" Face-to-Face (flanged PN40*)	284	338 - 347	412 - 421 - 412	435 - 439	481 - 485 - 491	585 - 593
Number of Bolts	6	8	6	8	8	12
Weight in kg (screwed)	2,7	5,2	9,2	15,0	20,3	35,2
Weight in kg (flanged PN40*)	4,1	7,0 – 7,6	11 – 11,6 – 12	18,6 – 20,2	21 – 22,7 – 23	39,6 – 41,2

* Other flange sizes, ratings and face-to-face dimensions are available on request.

Shade indicates products that are CE Marked according to the PED (97/23/EC). All the other models comply with the Article 3.3 of the same directive.

† May be derated depending on flange rating and type.

All dimensions and weights are approximate. Use certified print for exact dimensions. Design and materials are subject to change without notice.

200 Series Inverted Bucket Steam Traps

Cast Iron for Vertical Installation

For Pressures to 17 bar...Capacities to 9 000 kg/h



Table ST-79-1. Model 211 Capacity

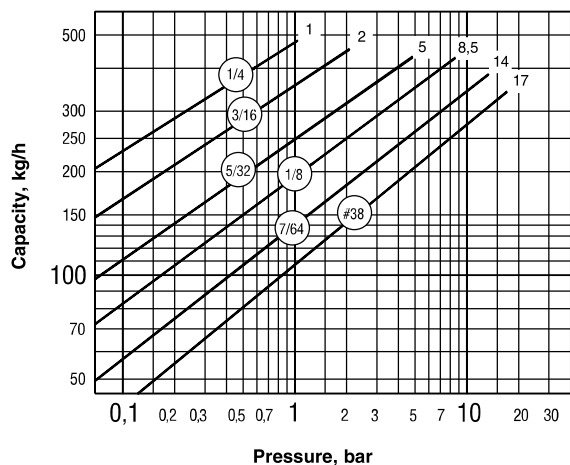


Table ST-79-2. Model 212 Capacity

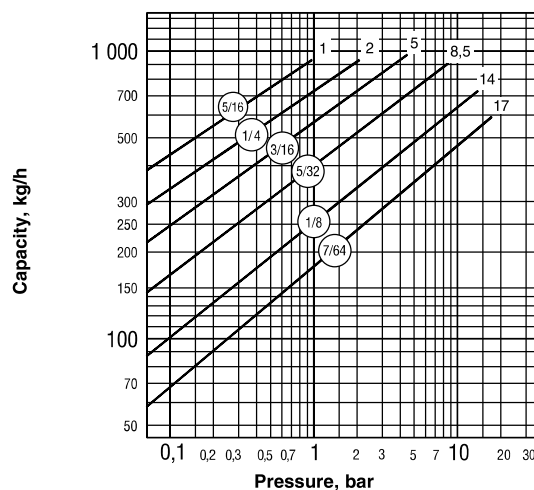


Table ST-79-3. Model 213 Capacity

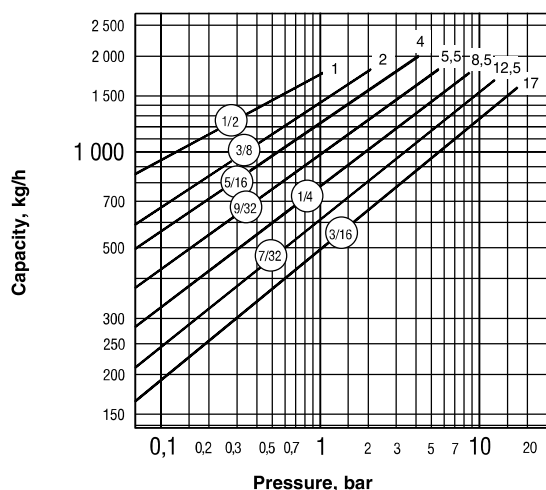


Table ST-79-4. Model 214 Capacity

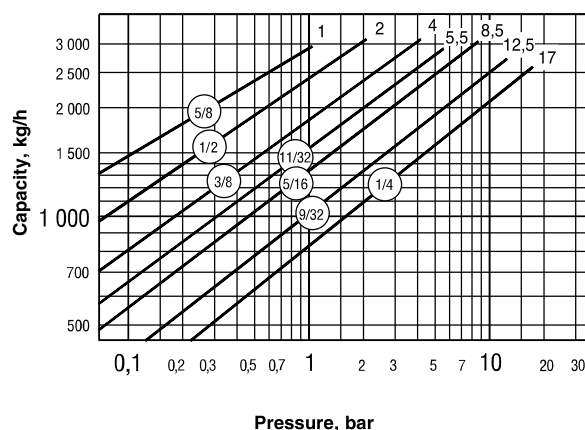


Table ST-79-5. Model 215 Capacity

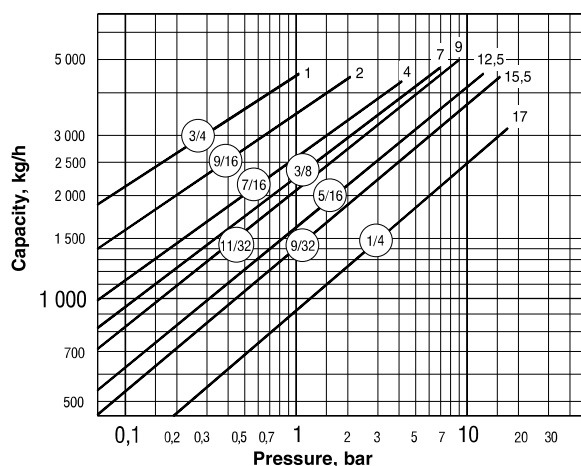
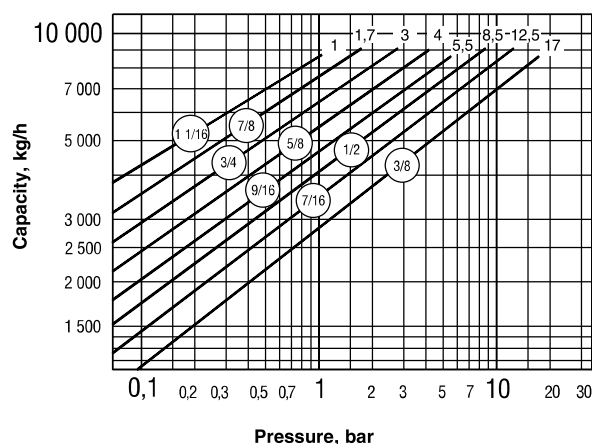


Table ST-79-6. Model 216 Capacity



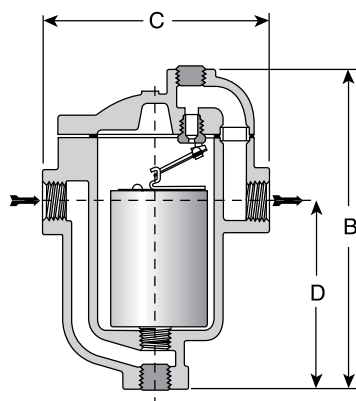
All dimensions and weights are approximate. Use certified print for exact dimensions. Design and materials are subject to change without notice.



800-813 Series Inverted Bucket Steam Traps

Cast Iron for Horizontal Installation
For Pressures to 17 bar...Capacities to 2 000 kg/h

Steam Trapping and
Steam Tracing Equipment



Description

The most reliable steam trap known – the inverted bucket – provides efficient condensate drainage of virtually all types of steam-using equipment. Put the inverted bucket to work in a tough cast iron package, and you have the best of both worlds. Because they operate efficiently for longer periods of time, Armstrong cast iron inverted buckets add solid energy savings to lower replacement/labor costs. All Armstrong cast iron inverted bucket steam traps are repairable for even bigger maintenance savings.

A unique leverage system multiplies the force provided by the bucket to open the valve against system pressure. The mechanism is free-floating, and has no fixed pivots to create wear or friction.

Because the mechanism is located at the top of the trap, no dirt can collect on the orifice. Small particles of dirt are held in suspension until discharged by the full differential purging action when the bucket sinks, pulling the valve off the seat.

The discharge orifice is surrounded by a water seal, preventing live steam loss. Automatic air venting is provided by a small vent hole in the bucket, which provides continuous automatic air and CO₂ venting at steam temperature.

Inverted bucket traps drain continuously, although discharging intermittently, allowing no condensate backup. They are also resistant to water hammer.

Maximum Operating Conditions

Maximum allowable pressure
(vessel design)†: 17 bar @ 232°C
Maximum operating pressure: Model 800: 10 bar
Model 811-813: 17 bar
Maximum back pressure: 99% of inlet pressure

Connections

Screwed BSPT and NPT
Flanges ANSI (screw on) available on request

Materials

Body: ASTM A48 Class 30
Internals: All stainless steel – 304
Valve and seat: Stainless Steel 17-4PH
Test plug: Carbon steel

Options

- Stainless steel internal check valve
- Thermic vent bucket
- Stainless steel pop drain
- Thermo drain
- Scrub wire

Specification

Inverted bucket steam trap, type ... in cast iron, with continuous air venting at steam temperature, free-floating stainless steel mechanism, and discharge orifice at the top of the trap. Maximum allowable back pressure 99% of inlet pressure.

How to Order

Specify:

- Model number
- Size and type of pipe connection
- Maximum working pressure or orifice size
- Any options required

Table 80-1. 800-813 Series Side Inlet, Side Outlet Trap (dimensions in mm)
Add suffix «CV» to model number for internal check valve, «T» for thermic vent bucket.

Model No.	800*	811	812	813
Pipe Connections	1/2" – 3/4"	1/2" – 3/4" – 1"	1/2" – 3/4"	3/4" – 1"
Test plug	1/4"	1/4"	1/2"	3/4"
«B» Height	138	175	230	298
«C» Face-to-Face (screwed)	127	127 – 127 – 133	165	197
«D» Bottom to C Inlet	70	108	137	179
Number of Bolts	6			
Weight in kg	2,3	2,7	6,8	12,5

* Cannot be furnished with both thermic vent bucket and check valve.

All models comply with the article 3.3 of the PED (97/23/EC).

† May be derated depending on flange rating and type.

All dimensions and weights are approximate. Use certified print for exact dimensions. Design and materials are subject to change without notice.

Armstrong International SA • Parc Industriel des Hauts-Sarts (2^e Avenue) • 4040 Herstal • Belgium

Tel.: +32 (0)4 240 90 90 • Fax: +32 (0)4 240 40 33

www.armstronginternational.eu • info@armstronginternational.eu

800-813 Series Inverted Bucket Steam Traps

Cast Iron for Horizontal Installation

For Pressures to 17 bar...Capacities to 2 000 kg/h



Table 81-1. Model 800 Capacity

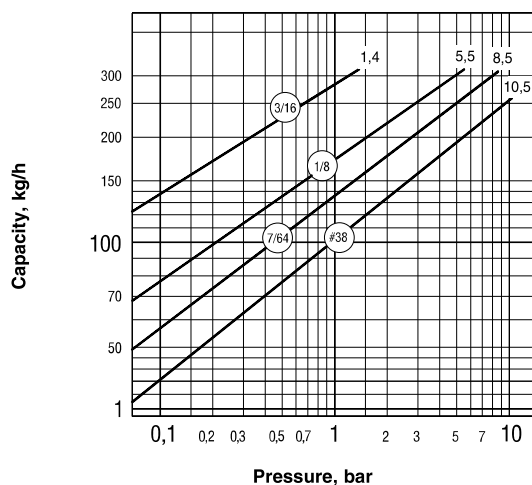


Table 81-2. Model 811 Capacity

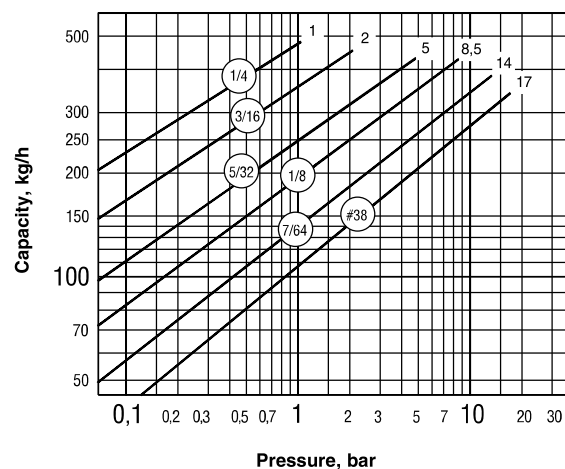


Table 81-3. Model 812 Capacity

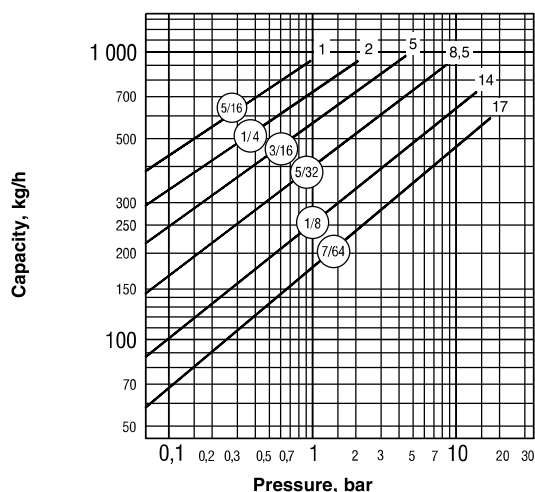
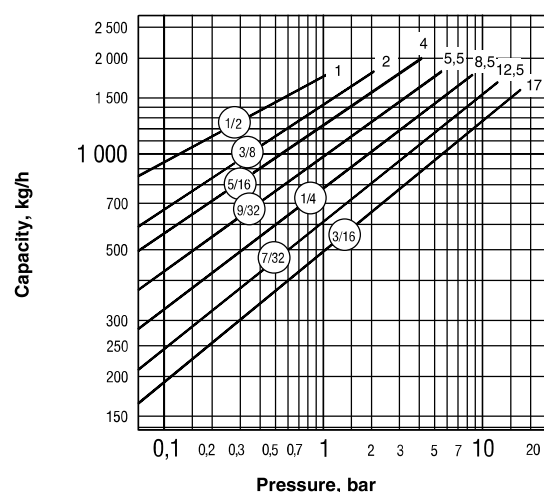


Table 81-4. Model 813 Capacity



All dimensions and weights are approximate. Use certified print for exact dimensions. Design and materials are subject to change without notice.

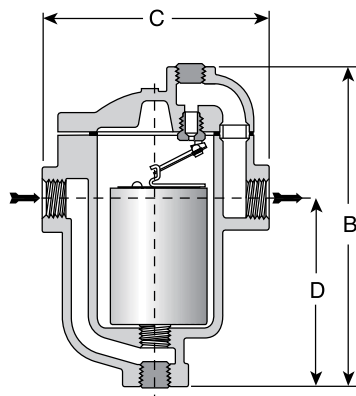
Armstrong International SA • Parc Industriel des Hauts-Sarts (2^e Avenue) • 4040 Herstal • Belgium

Tel.: +32 (0)4 240 90 90 • Fax: +32 (0)4 240 40 33

www.armstronginternational.eu • info@armstronginternational.eu

814-816 Series Inverted Bucket Steam Traps

Cast Iron for Horizontal Installation
For Pressures to 17 bar...Capacities to 9 000 kg/h



Description

The most reliable steam trap known – the inverted bucket – provides efficient condensate drainage of virtually all types of steam-using equipment. Put the inverted bucket to work in a tough cast iron package, and you have the best of both worlds. Because they operate efficiently for longer periods of time, Armstrong cast iron inverted buckets add solid energy savings to lower replacement/labor costs. All Armstrong cast iron inverted bucket steam traps are repairable for even bigger maintenance savings.

A unique leverage system multiplies the force provided by the bucket to open the valve against system pressure. The mechanism is free-floating, and has no fixed pivots to create wear or friction.

Because the mechanism is located at the top of the trap, no dirt can collect on the orifice. Small particles of dirt are held in suspension until discharged by the full differential purging action when the bucket sinks, pulling the valve off the seat.

The discharge orifice is surrounded by a water seal, preventing live steam loss. Automatic air venting is provided by a small vent hole in the bucket, which provides continuous automatic air and CO₂ venting at steam temperature.

Inverted bucket traps drain continuously, although discharging intermittently, allowing no condensate backup. They are also resistant to water hammer.

Maximum Operating Conditions

Maximum allowable pressure
(vessel design)†: 17 bar @ 232°C
Maximum operating pressure: 17 bar
Maximum back pressure: 99% of inlet pressure

Connections

Screwed BSPT and NPT
Flanges ANSI (screw on) available on request

Materials

Body: ASTM A48 Class 30
Internals: All stainless steel – 304
Valve and seat: Stainless Steel 17-4PH
Test plug: Carbon steel

Options

- Stainless steel internal check valve
- Thermic vent bucket
- Stainless steel pop drain
- Thermo drain
- Scrub wire

Specification

Inverted bucket steam trap, type ... in cast iron, with continuous air venting at steam temperature, free-floating stainless steel mechanism, and discharge orifice at the top of the trap. Maximum allowable back pressure 99% of inlet pressure.

How to Order

- Specify:
- Model number
 - Size and type of pipe connection
 - Maximum working pressure or orifice size
 - Any options required

Table ST-82-1. 814-816 Series Side Inlet, Side Outlet Trap (dimensions in mm)

Add suffix «CV» to model number for internal check valve, «T» for thermic vent bucket.

Model No.	814	815	816
Pipe Connections	1" – 1 1/4"	1 1/2" – 2"	2" – 2 1/2"
Test plug	1"	1 1/2"	2"
«B» Height	346	413	541
«C» Face-to-Face (screwed)	229 – 355	260	330
«D» Bottom to $\varnothing$ Inlet	198	203	279
Number of Bolts	8		
Weight in kg (screwed)	20,0	32,2	59,4

* Other flange sizes, ratings and face-to-face dimensions are available on request.
All models are CE Marked according to the PED (97/23/EC), but PMA for 816 is 15 bar.
† May be derated depending on flange rating and type.

All dimensions and weights are approximate. Use certified print for exact dimensions. Design and materials are subject to change without notice.

814-816 Series Inverted Bucket Steam Traps

Cast Iron for Horizontal Installation

For Pressures to 17 bar...Capacities to 9 000 kg/h



Table ST-83-1. Model 814 Capacity

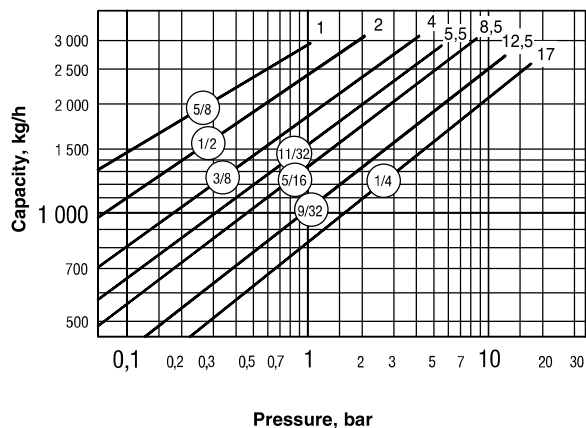


Table ST-83-2. Model 815 Capacity

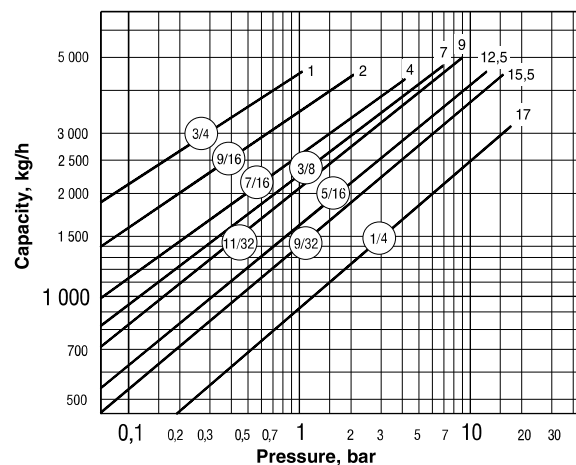
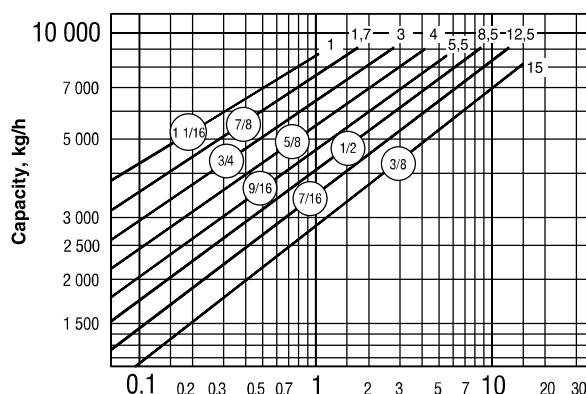


Table ST-83-3. Model 816 Capacity



All dimensions and weights are approximate. Use certified print for exact dimensions. Design and materials are subject to change without notice.

Armstrong International SA • Parc Industriel des Hauts-Sarts (2^e Avenue) • 4040 Herstal • Belgium

Tel.: +32 (0)4 240 90 90 • Fax: +32 (0)4 240 40 33

www.armstronginternational.eu • info@armstronginternational.eu

614F-616F Series Inverted Bucket Steam Traps

Ductile Iron for Horizontal Installation
For Pressures to 17 bar...Capacities to 9 072 kg/h

Description

The most reliable steam trap known – the inverted bucket – provides efficient condensate drainage of virtually all types of steam-using equipment. Put the inverted bucket to work in a tough ductile iron package, and you have the best of both worlds. Because they operate efficiently for longer periods of time, Armstrong ductile iron inverted buckets add solid energy savings to lower replacement/labor costs. All Armstrong ductile iron inverted bucket steam traps are repairable for even bigger maintenance savings.

A unique leverage system multiplies the force provided by the bucket to open the valve against system pressure. The mechanism is free-floating, and has no fixed pivots to create wear or friction.

Because the mechanism is located at the top of the trap, no dirt can collect on the orifice. Small particles of dirt are held in suspension until discharged by the full differential purging action when the bucket sinks, pulling the valve off the seat.

The discharge orifice is surrounded by a water seal, preventing live steam loss. Automatic air venting is provided by a small vent hole in the bucket, which provides continuous automatic air and CO₂ venting at steam temperature.

Inverted bucket traps drain continuously, although discharging intermittently, allowing no condensate backup. They are also resistant to water hammer.

Maximum Operating Conditions

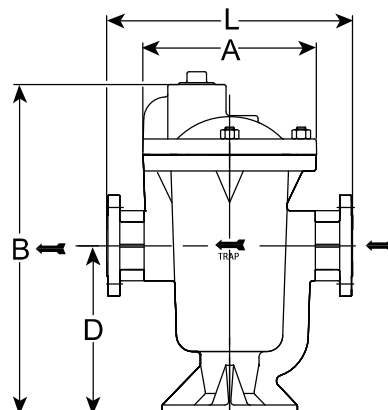
Maximum allowable pressure (vessel design):	17 bar @ 232°C
Maximum operating pressure:	17 bar
Maximum back pressure:	99% of inlet pressure

Connections

Integral Flanged EN1092-2 PN25

Materials

Body:	ASTM A395 Gr. 60-40-18
Internals:	All stainless steel – 304
Valve and seat:	Stainless Steel 17-4PH H900



Options

- Stainless steel internal check valve (add suffix CV)
- Thermic vent bucket (add suffix T)
- Large venting orifice (add suffix LV)
- Scrub wire (add suffix BVSU)

Specification

Inverted bucket steam trap, type ... in ductile iron, with continuous air venting at steam temperature, free-floating stainless steel mechanism, and discharge orifice at the top of the trap. Maximum allowable back pressure 99% of inlet pressure.

How to Order

Specify:

- Model number
- Size and type of pipe connection
- Maximum working pressure or orifice size
- Any options required

Table 84-1. 614F-616F Series Side Inlet, Side Outlet Trap (dimensions in mm)

Add suffix «CV» to model number for internal check valve, «T» for thermic vent bucket.

Model No.	614F	615F	616F
Pipe Connections	25 – 32	40 – 50	50 – 65
Test plug	1"	1 1/2"	2"
«A» Face-to-Face	203	229	292
«B» Height	346	413	541
«D» Bottom to $\varnothing$ Inlet	198	205	279
«L» Face-to-Face (Integral Flanged EN1092-2 PN25)	315 – 320	345 – 355	415 – 420
Number of Bolts	8	8	8
Weight in kg	24 – 26	39 – 41	68 – 70

All models are CE Marked according to the PED (97/23/EC).

All dimensions and weights are approximate. Use certified print for exact dimensions. Design and materials are subject to change without notice.

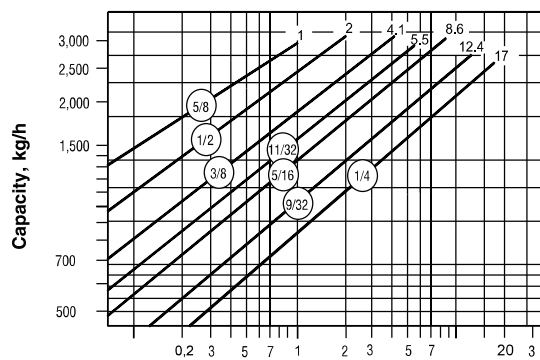
614F-616F Series Inverted Bucket Steam Traps

Ductile Iron for Horizontal Installation

For Pressures to 17 bar...Capacities to 9 072 kg/h

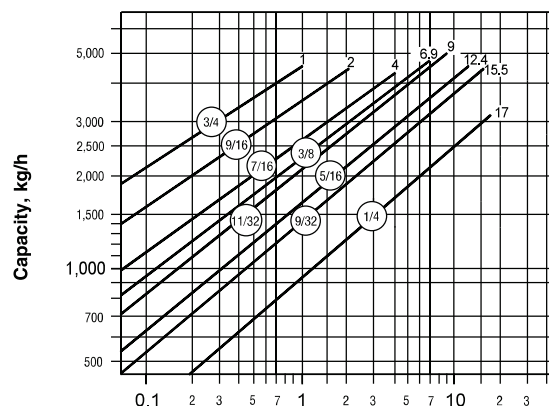


Table 85-1. Model 614F Capacity



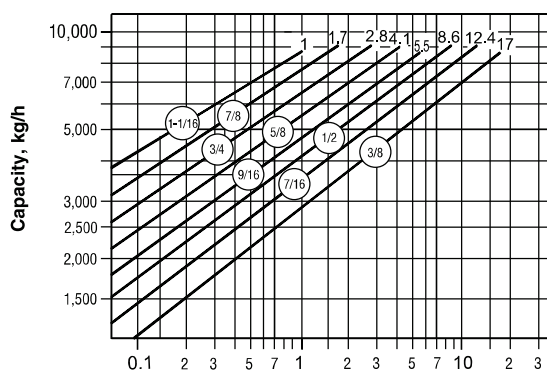
Pressure, bar

Table 85-2. Model 615F Capacity



Pressure, bar

Table 85-3. Model 616F Capacity

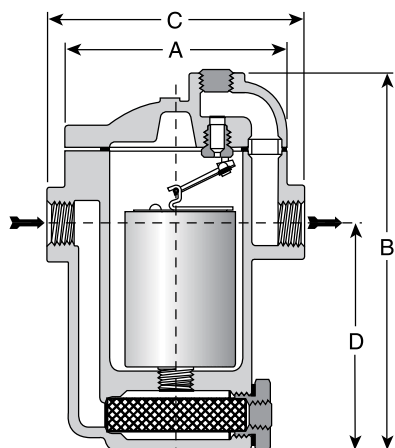


Pressure, bar

880 Series Inverted Bucket Steam Traps

Cast Iron for Horizontal Installation, with Integral Strainer

For Pressures to 17 bar...Capacities to 2 000 kg/h



Description

The most reliable steam trap known – the inverted bucket – provides efficient condensate drainage of virtually all types of steam-using equipment. Put the inverted bucket to work in a tough cast iron package with an integral strainer, and you have the best of both worlds. Because they operate efficiently for longer periods of time, Armstrong cast iron inverted buckets add solid energy savings to lower replacement/labor costs. All Armstrong cast iron inverted bucket steam traps are repairable for even bigger maintenance savings.

A unique leverage system multiplies the force provided by the bucket to open the valve against system pressure. The mechanism is free-floating, and has no fixed pivots to create wear or friction.

Because the mechanism is located at the top of the trap, no dirt can collect on the orifice. Small particles of dirt are held in suspension until discharged by the full differential purging action when the bucket sinks, pulling the valve off the seat.

The discharge orifice is surrounded by a water seal, preventing live steam loss. Automatic air venting is provided by a small vent hole in the bucket, which provides continuous automatic air and CO₂ venting at steam temperature.

Inverted bucket traps drain continuously, although discharging intermittently, allowing no condensate backup. They are also resistant to water hammer.

Connections

Screwed BSPT and NPT

Flanged ANSI (screw on)**

Maximum Operating Conditions

Maximum allowable pressure

(vessel design) †:

Maximum operating pressure:

17 bar @ 232°C

Model 880: 10 bar

Model 881 - 883: 17 bar

Maximum back pressure:

99% of inlet pressure

Materials

Body:

ASTM A48 Class 30

Internals:

All stainless steel – 304

Valve and seat:

Stainless Steel 17-4PH

Test plug:

Carbon steel

Strainer:

Stainless steel – 304

Options

- Stainless steel internal check valve
- Thermic vent bucket
- Scrub wire

Specification

Inverted bucket steam trap, type ... in cast iron with integral strainer, with continuous air venting at steam temperature, with free-floating stainless steel mechanism, and discharge orifice at the top of the trap. Maximum allowable back pressure 99% of inlet pressure.

How to Order

Specify:

- Model number
- Size and type of pipe connection
- Maximum working pressure that will be encountered or orifice size
- Any options required

Table ST-86-1. 880 Series Side Inlet, Side Outlet Trap with Integral Strainer (dimensions in mm)

Add suffix «CV» to model number for internal check valve, «T» for thermic vent bucket.

Model No.	880*	881	882	883
Pipe Connections	15 – 20	15 – 20 – 25	15 – 20	20 – 25 – 32
Test plug	1/4"	1/4"	1/2"	3/4"
«A» Diameter	95	95	143	179
«B» Height	154	179	244	314
«C» Face-to-Face	127	127	165	200
«D» Bottom to C Inlet	87	113	146	187
Number of Bolts	6			
Weight in kg	2,5	2,7	7	14,1

* Cannot be furnished with both thermic vent bucket and check valve.

** Dimensions on request.

All models comply with the article 3.3 of the PED (97/23/EC).

† May be derated depending on flange rating and type.

All dimensions and weights are approximate. Use certified print for exact dimensions. Design and materials are subject to change without notice.

880 Series Inverted Bucket Steam Traps

Cast Iron for Horizontal Installation, with Integral Strainer
For Pressures to 17 bar...Capacities to 2 000 kg/h



Table ST-87-1. Model 880 Capacity

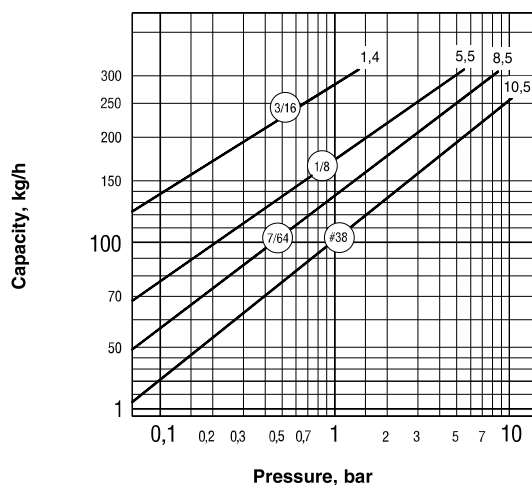


Table ST-87-2. Model 881 Capacity

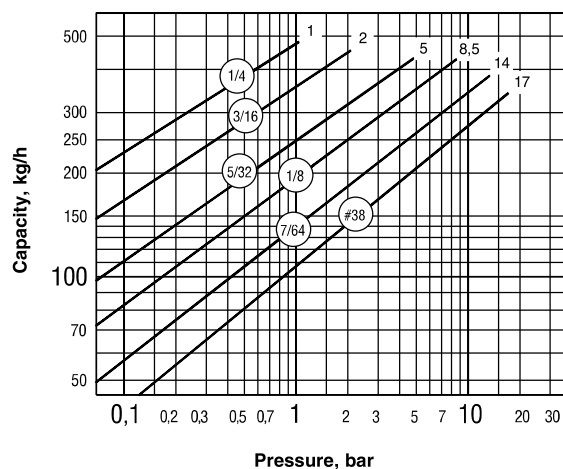


Table ST-87-3. Model 882 Capacity

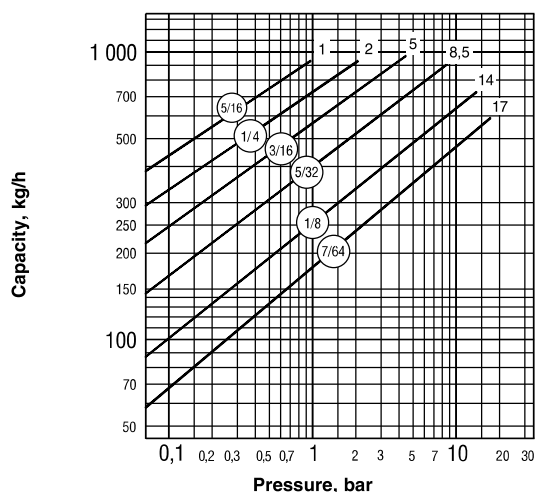
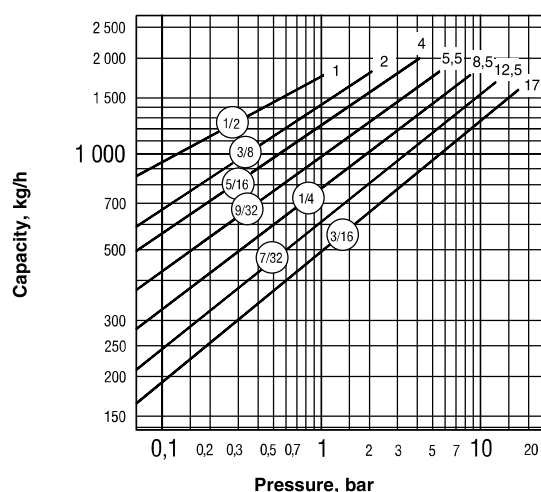


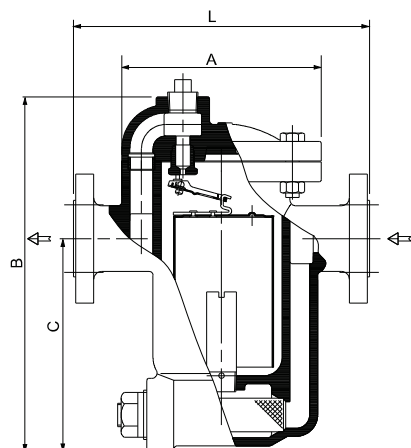
Table ST-87-4. Model 883 Capacity



All dimensions and weights are approximate. Use certified print for exact dimensions. Design and materials are subject to change without notice.

680F Series Inverted Bucket Steam Traps

Ductile Iron for Horizontal Installation, with Integral Strainer
For Pressures to 17 bar...Capacities to 2 000 kg/h



Description

The most reliable steam trap known – the inverted bucket – provides efficient condensate drainage of virtually all types of steam-using equipment. Put the inverted bucket to work in a tough ductile iron package with an integral strainer, and you have the best of both worlds. Because they operate efficiently for longer periods of time, Armstrong ductile iron inverted buckets add solid energy savings to lower replacement/labor costs. All Armstrong ductile iron inverted bucket steam traps are repairable for even bigger maintenance savings.

A unique leverage system multiplies the force provided by the bucket to open the valve against system pressure. The mechanism is free-floating, and has no fixed pivots to create wear or friction.

Because the mechanism is located at the top of the trap, no dirt can collect on the orifice. Small particles of dirt are held in suspension until discharged by the full differential purging action when the bucket sinks, pulling the valve off the seat.

The discharge orifice is surrounded by a water seal, preventing live steam loss. Automatic air venting is provided by a small vent hole in the bucket, which provides continuous automatic air and CO₂ venting at steam temperature.

Inverted bucket traps drain continuously, although discharging intermittently, allowing no condensate backup. They are also resistant to water hammer.

Connections

Integral Flanged EN1092-2 PN25

Maximum Operating Conditions

Maximum allowable pressure : 17 bar @ 232°C
Maximum operating pressure: 17 bar
Maximum back pressure: 99% of inlet pressure

Materials

Body: ASTM A395 Gr.60-40-18
Internals: All stainless steel – 304
Valve and seat: Stainless Steel 17-4PH H900
Strainer: Stainless steel – 304

Options

- Stainless steel internal check valve (add suffix CV)
- Thermic vent bucket (add suffix T)
- Large venting orifice (add suffix LV)
- Scrub wire (add suffix BVSW)

Specification

Inverted bucket steam trap, type ... in ductile iron with integral strainer, with continuous air venting at steam temperature, with free-floating stainless steel mechanism, and discharge orifice at the top of the trap. Maximum allowable back pressure 99% of inlet pressure.

How to Order

Specify:

- Model number
- Size and type of pipe connection
- Maximum working pressure or orifice size
- Any options required

Table 88-1. 680F Series Side Inlet, Side Outlet Trap with Integral Strainer (dimensions in mm)

Add suffix «CV» to model number for internal check valve, «T» for thermic vent bucket.

Model No.	681F	682F	683F
Pipe Connections	15 – 20 – 25	15 – 20 – 25	20 – 25 – 32
Test plug	1/4"	1/2"	3/4"
«A» Face-to-Face	95,2	143	178
«B» Height	179	244	314
«C» Bottom to � Inlet	113	146	187
«L» Face-to-Face (Integral Flanged EN1092-2 PN25)	150 – 150 – 160	230	260
Number of Bolts	6	6	6
Weight in kg	3,8 – 4,1 – 4,5	9 – 10 – 10,5	22,5 – 23,5 – 24

All models comply with the article 3.3 of the PED (97/23/EC).

All dimensions and weights are approximate. Use certified print for exact dimensions. Design and materials are subject to change without notice.

680F Series Inverted Bucket Steam Traps

Ductile Iron for Horizontal Installation, with Integral Strainer
For Pressures to 17 bar...Capacities to 2 000 kg/h



Table 89-1. Model 681F Capacity

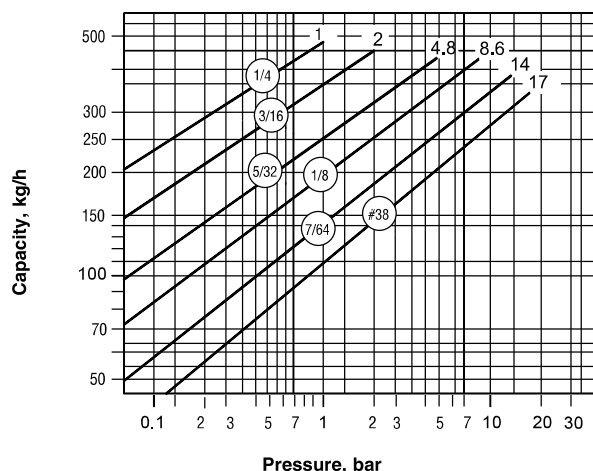


Table 89-2. Model 682F Capacity

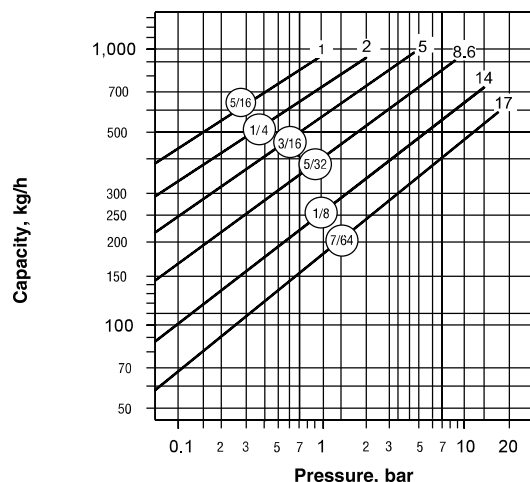
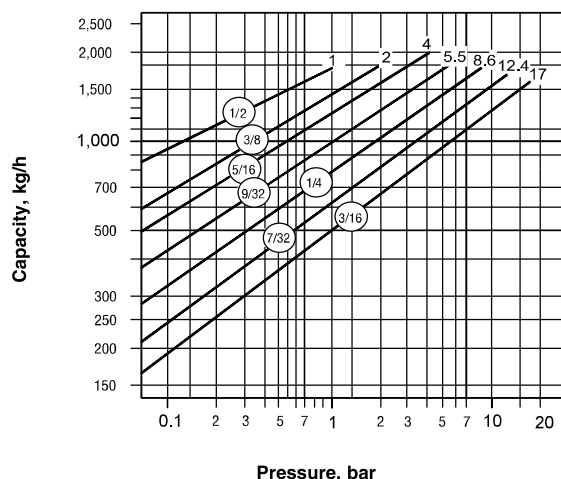


Table 89-3. Model 683F Capacity



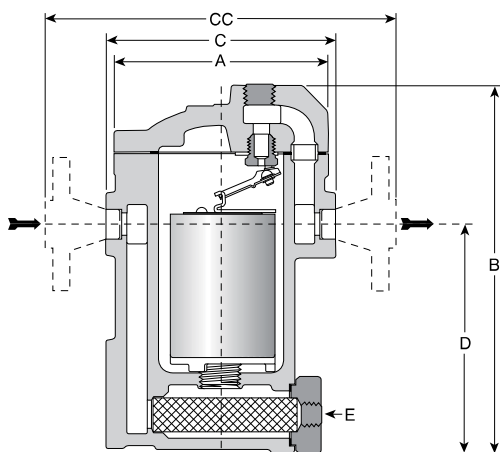
All dimensions and weights are approximate. Use certified print for exact dimensions. Design and materials are subject to change without notice.



980 Series Inverted Bucket Steam Traps

Cast Steel for Horizontal Installation, with Integral Strainer
For Pressures to 41 bar...Capacities to 2 000 kg/h

Steam Trapping and
Steam Tracing Equipment



Description

Armstrong offers two sizes of cast steel traps with in-line horizontal pipe connections and integral strainers with a choice of screwed, socketweld or flanged connections.

A unique leverage system multiplies the force provided by the bucket to open the valve against system pressure. The mechanism is free-floating, and has no fixed pivots to create wear or friction.

Because the mechanism is located at the top of the trap, no dirt can collect on the orifice. Small particles of dirt are held in suspension until discharged by the full differential purging action when the bucket sinks, pulling the valve off the seat.

The discharge orifice is surrounded by a water seal, preventing live steam loss. Automatic air venting is provided by a small vent hole in the bucket, which provides continuous automatic air and CO₂ venting at steam temperature.

Inverted bucket traps drain continuously, although discharging intermittently, allowing no condensate backup. They are also resistant to water hammer.

Maximum Operating Conditions

Maximum allowable pressure
(vessel design)†: 41 bar @ 343°C
Maximum operating pressure: 41 bar
Maximum back pressure: 99% of inlet pressure

Connections

Screwed BSPT and NPT
Socketweld
Flanged DIN or ANSI (welded)

Materials

Body: ASTM A216 WCB
Internals: All stainless steel – 304
Valve and seat: Stainless Steel 17-4PH (<35 bar)
Titanium (>35 bar)
Strainer: Stainless steel – 304
Test plug: Carbon steel

Options

- Stainless steel internal check valve
- Thermic vent bucket 17 bar maximum
- Scrub wire

Specification

Inverted bucket steam trap, type ... in cast steel, with continuous air venting at steam temperature, free-floating stainless steel mechanism, integral strainer, and discharge orifice at the top of the trap. Maximum allowable back pressure 99% of inlet pressure.

How to Order

- Specify:
- Model number
 - Size and type of pipe connection. When flanges are required, specify type of flange in detail
 - Maximum working pressure that will be encountered or orifice size
 - Any options required

Table ST-90-1. 980 Series Side Inlet, Side Outlet Trap with Integral Strainer (dimensions in mm)

Model No.	981	983
Pipe Connections	15 – 20	20 – 25
Test plug	1/2"	3/4"
"A" Flange Diameter	114	184
"B" Height	219	313
"C" Face-to-Face (screwed & SW)	137	197
"CC" Face-to-Face (flanged PN40*)	196 – 194	282
"D" Bottom to $\varnothing$ Inlet	122	193
"E" Blowdown Connection	3/8"	3/4"
Weight in kg (screwed & SW)	5,2	19,5
Weight in kg (flanged PN40*)	7,0	26,0

* Other flange sizes, ratings and face-to-face dimensions are available on request.

Shade indicates products that are CE Marked according to the PED (97/23/EC). All the other models comply with the Article 3.3 of the same directive.

† May be derated depending on flange rating and type.

All dimensions and weights are approximate. Use certified print for exact dimensions. Design and materials are subject to change without notice.

Armstrong International SA • Parc Industriel des Hauts-Sarts (2^e Avenue) • 4040 Herstal • Belgium

Tel.: +32 (0)4 240 90 90 • Fax: +32 (0)4 240 40 33

www.armstronginternational.eu • info@armstronginternational.eu

980 Series Inverted Bucket Steam Traps

Cast Steel for Horizontal Installation, with Integral Strainer
For Pressures to 41 bar...Capacities to 2 000 kg/h



Table ST-91-1. Model 981 Capacity

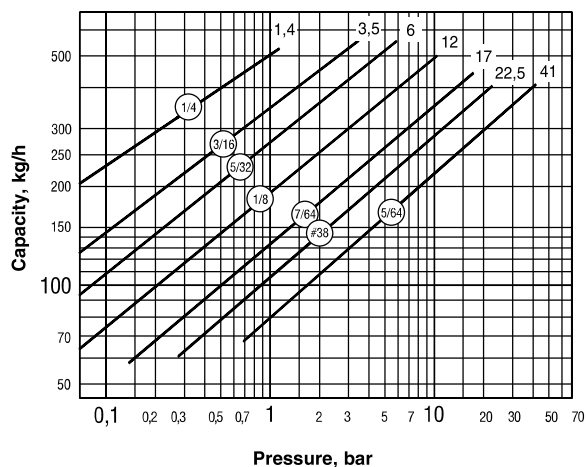
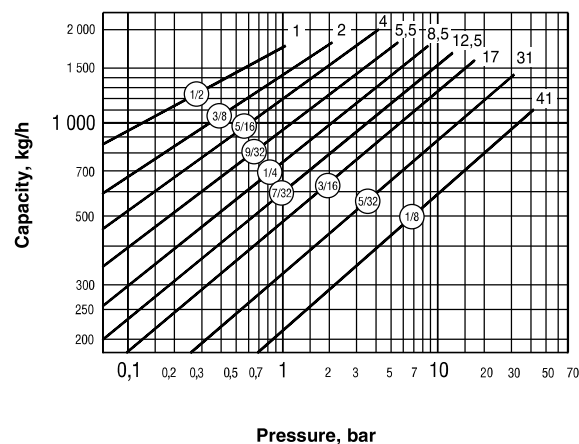


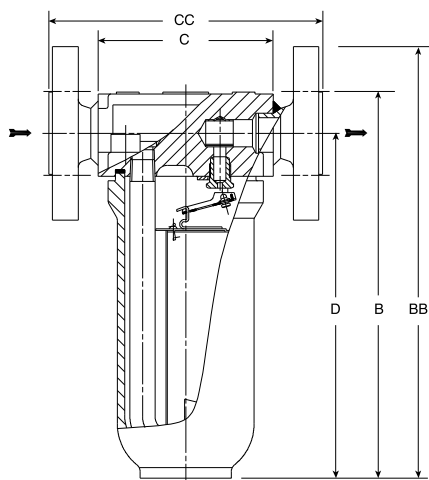
Table ST-91-2. Model 983 Capacity



All dimensions and weights are approximate. Use certified print for exact dimensions. Design and materials are subject to change without notice.

EM Inverted Bucket Steam Trap

Forged Carbon Steel for Horizontal Installation
For Pressures to 32 bar... Capacities to 480 kg/h



Description

Armstrong's type EM forged steel inverted bucket steam trap combines the most reliable steam trap operating principle known in a body, which can be opened for Easy Maintenance.

- High resistance to wear, corrosion and water hammer.
- The free-floating guided lever valve mechanism is "frictionless" with all wear points heavily reinforced. All working parts are stainless steel; valve and seat are hardened chrome steel, individually ground and lapped.
- Freedom from dirt problems. Condensate flow under bottom edge of bucket keeps sediment and "sludge" in suspension until discharged by full differential purging action. Valve orifice opens wide - closes tight. There is no buildup of dirt, no close clearances to be affected by scale. Under normal conditions of reasonably "clean steam", a strainer is not necessary. However, this is left to the user's discretion.
- Air handling ability. Vent in bucket top provides continuous automatic air and CO₂ venting with no cooling leg and prevents air binding. Wiggle wire ensures clean vent hole at all times. Any steam passing through vent is condensed and discharged as liquid.
- No steam loss. Steam does not reach the water-sealed valve.
- Inverted bucket traps require no adjustment and no live steam to operate.

Maximum operating conditions

Maximum allowable pressure
(vessel design)†: 32 bar - 250°C
Maximum operating pressure: 32 bar
Maximum back pressure: 99% of inlet pressure

Connections

Screwed BSPT and NPT
Socketweld
Flanged DIN or ANSI (welded)

Materials

Body: Forged carbon steel
Internals: All stainless steel – 304
Valve and seat: Stainless Steel 17-4PH
Gasket: Spiral wound graphite
Bolts: 24 CrMo5

Options

- Bucket vent scrubbing wire for heavy dirt/oil conditions
- Probe connection (3/8") for use of TrapAlert™, the self-diagnostic steam traps
- For superheated steam we advise stellited valve and seat

Specification

Inverted bucket steam trap, type EM in forged steel, with automatic air vent, free-floating lever mechanism, with the orifice in the top. Maximum allowable back pressure 99% of inlet pressure.

How to order

- Specify:
- Size and type of pipe connection
 - Maximum working pressure that will be encountered or orifice size
 - Maximum condensate load
 - Any options required

Table ST-92-1. Model EM Side Inlet, Side Outlet Trap (dimensions in mm)

Pipe Connections	15	20	25
"C" Face-to-Face (screwed & SW)	98	98	—
"CC" Face-to-Face (flanged PN40*)	150	150	160
"D" Bottom to $\varnothing$ Inlet	189	189	189
"B" Height (screwed & SW)	210	210	—
"BB" Height (flanged PN40*)	235	240	245
Weight in kg (screwed & SW)	3,1	3,1	—
Weight in kg (flanged PN40*)	5,5	7,1	8,1

* Other flange sizes, ratings and face-to-face dimensions are available on request.

All sizes comply with the article 3.3 of the PED (97/23/EC).

† May be derated depending on flange rating and type.

All dimensions and weights are approximate. Use certified print for exact dimensions. Design and materials are subject to change without notice.

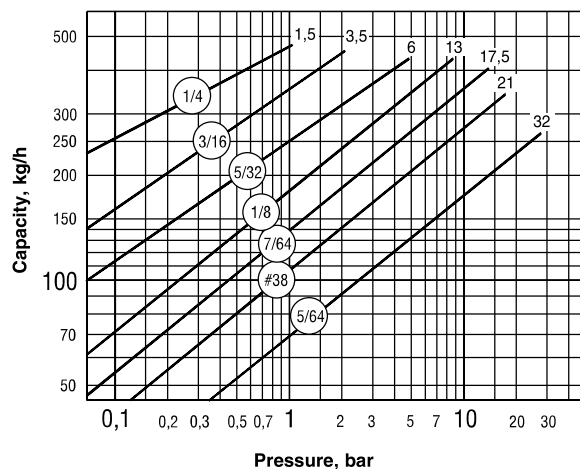
EM Inverted Bucket Steam Trap

Forged Carbon Steel for Horizontal Installation

For Pressures to 32 bar... Capacities to 480 kg/h



Table ST-93-1. Model EM Capacity



All dimensions and weights are approximate. Use certified print for exact dimensions. Design and materials are subject to change without notice.

Armstrong International SA • Parc Industriel des Hauts-Sarts (2^e Avenue) • 4040 Herstal • Belgium

Tel.: +32 (0)4 240 90 90 • Fax: +32 (0)4 240 40 33

www.armstronginternational.eu • info@armstronginternational.eu



300 Series Inverted Bucket Steam Traps

Forged Carbon Steel for Vertical Installation
For Pressures to 45 bar...Capacities to 9 000 kg/h

Description

Armstrong offers its 300 Series forged carbon steel traps for vertical installation with a choice of screwed, socketweld or flanged connections.

A unique leverage system multiplies the force provided by the bucket to open the valve against system pressure. The mechanism is free-floating, and has no fixed pivots to create wear or friction.

Because the mechanism is located at the top of the trap, no dirt can collect on the orifice. Small particles of dirt are held in suspension until discharged by the full differential purging action when the bucket sinks, pulling the valve off the seat.

The discharge orifice is surrounded by a water seal, preventing live steam loss. Automatic air venting is provided by a small vent hole in the bucket, which provides continuous automatic air and CO₂ venting at steam temperature.

Inverted bucket traps drain continuously, allowing no condensate backup. They are also resistant to water hammer.

For Superheat Service:

1. Don't oversize the orifice; a restricted orifice may be advisable.
2. Specify a burnished valve and seat and an extended inlet tube and check valve.
3. Provide a drip leg of adequate diameter and length.
4. Provide a generous length (600-900 mm) of inlet piping, with the trap below the main.
5. Don't insulate the trap or the inlet piping.

Connections

Screwed BSPT and NPT
Socketweld
Flanged DIN or ANSI (welded)

Materials

Body: ASTM A105
Models 312, 313, 316 are also available with cast 316 stainless steel bodies and all stainless steel internals
Internals: All stainless steel – 304 (larger sizes have cast iron bucket weights)
Valve and seat: Stainless Steel 17-4PH (<35 bar)
Titanium (>35 bar)

Options

- Stainless steel internal check valve
- Thermic vent bucket 17 bar maximum
- Scrub wire

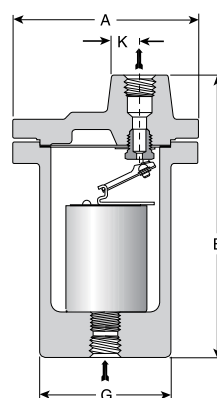
Specification

Inverted bucket steam trap, type ... in forged carbon steel, with continuous air venting at steam temperature, free-floating stainless steel mechanism, and discharge orifice at the top of the trap. Maximum allowable back pressure 99% of inlet pressure.

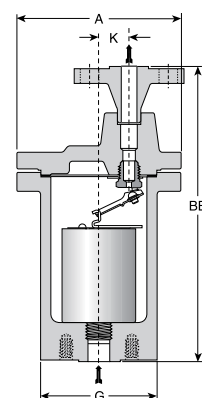
How to Order

Specify:

- Model number
- Size and type of pipe connection. When flanges are required, specify type of flange in detail
- Maximum working pressure that will be encountered or orifice size
- Any options required



Model 300 Trap



Series 300 FW Trap

Table ST-94-1. Pressure-Temperature Rating for Forged Steel Traps

Model No.	Maximum Oper. Pr., Saturated Steam	Maximum Allowable Pressure (Vessel Design)† of Pressure - Containing Parts at Indicated Temperature			
		-28°C / +343°C	371°C	399°C	427°C
	bar	bar			
310	27,5	53	53	50	41
312	41,5	41	41	38,5	34,5
313	45	74	74	67	54
314	45	78	77	68	56
315	45	70	66,5	59	47,5
316	45	76	72	65	52

Notes: Maximum operating pressure to be marked on nameplate will be determined by actual orifice used.

Maximum allowable pressures shown in boldface will be marked on nameplate, unless otherwise requested.

Traps with flanges may have different pressure-temperature ratings.

Maximum back pressure is 99% of inlet pressure.

Table ST-94-2. 300 Series Bottom Inlet, Top Outlet Trap (dimensions in mm)

Add suffix "CV" to trap number for internal check valve.

Model No. Screwed or SW Model No. Flanged	310 310-FW	312 312-FW	313 313-FW	314 314-FW	315 315-FW	316 316-FW
Pipe Connections	15 – 20	15 – 20 – 25	15 – 20 – 25	25 – 32	25 – 32 – 40	40 – 50
"A" Flange Diameter	114	171	203	219	248	302
"B" Face-to-Face (screwed & SW)	202	259	295	348	381	435
"BB" Face-to-Face (flanged PN100*)	282 – 287	307 – 314 – 320	343 – 349 – 355	409 – 411	442 – 444 – 446	499 – 505
"G" Body Outside Diameter	78	121	130	146	168	213
"K" Outlet to Inlet	14,3	31,7	36,5	36,5	44,4	54,0
Number of Bolts (junction cap - body)	6	6	8		9	10
Weight in kg (screwed & SW)	4,5	13,6	22,0	31,8	44,5	81,2
Weight in kg (flanged PN100*)	5,5 – 6,5	14,5 – 15,5 – 16	22,5 – 23,5 – 24	36,5 – 37,0	45,5 – 47,5 – 49	85,8 – 87,8

* Other flange sizes, ratings and face-to-face dimensions are available on request.

Shade indicates products that are CE Marked according to the PED (97/23/EC). All the other models comply with the Article 3.3 of the same directive.

† May be derated depending on flange rating and type.

All dimensions and weights are approximate. Use certified print for exact dimensions. Design and materials are subject to change without notice.

Armstrong International SA • Parc Industriel des Hauts-Sarts (2^e Avenue) • 4040 Herstal • Belgium

Tel.: +32 (0)4 240 90 90 • Fax: +32 (0)4 240 40 33

www.armstronginternational.eu • info@armstronginternational.eu

300 Series Inverted Bucket Steam Traps

Forged Carbon Steel for Vertical Installation
For Pressures to 45 bar...Capacities to 9 000 kg/h



Table ST-95-1. Model 310 Capacity

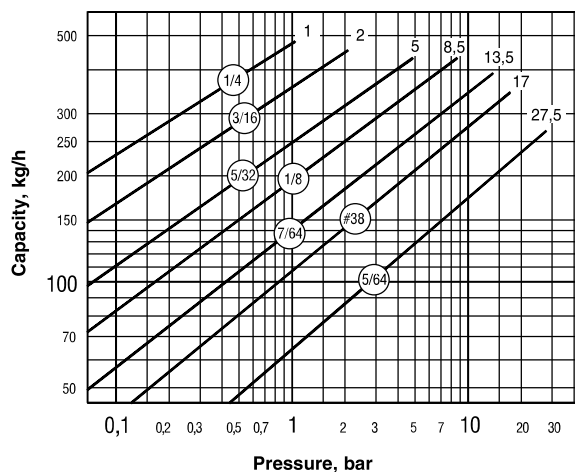


Table ST-95-2. Model 312 Capacity

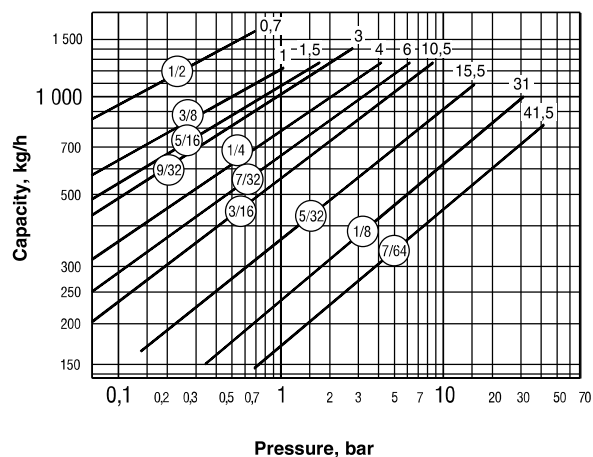


Table ST-95-3. Model 313 Capacity

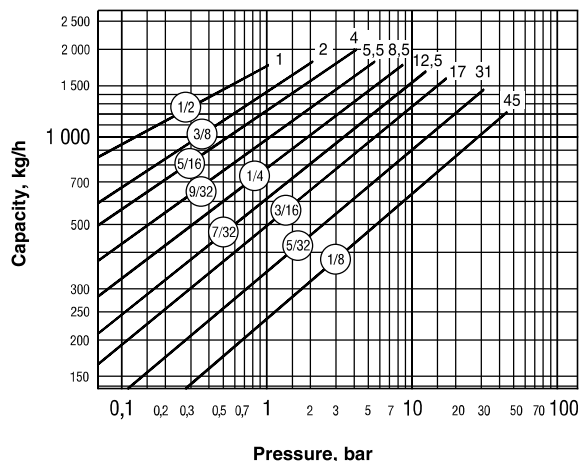


Table ST-95-4. Model 314 Capacity

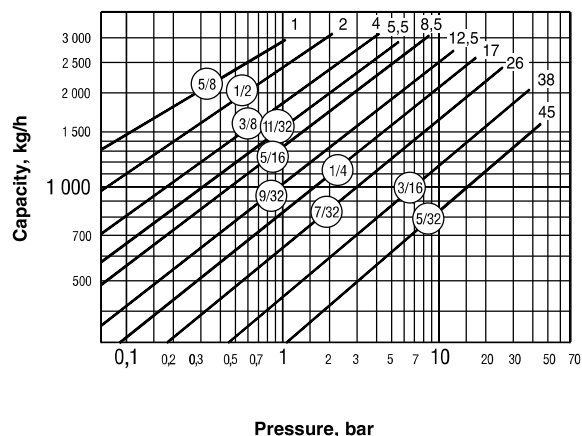


Table ST-95-5. Model 315 Capacity

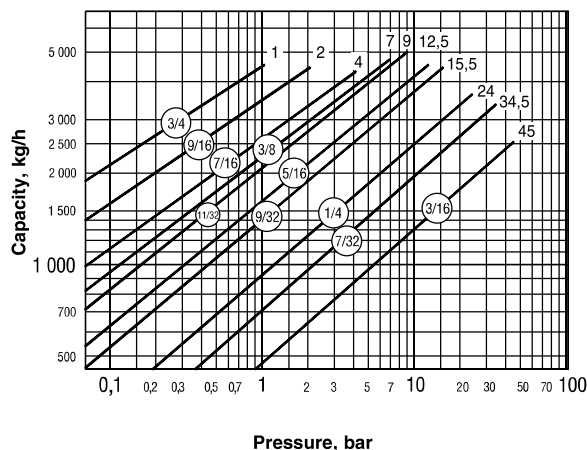
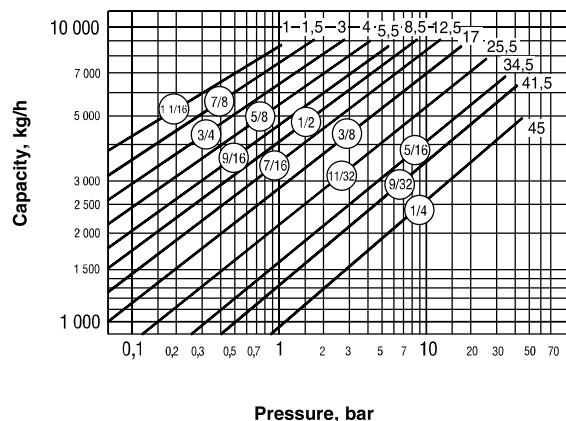


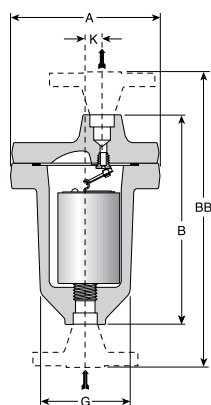
Table ST-95-6. Model 316 Capacity



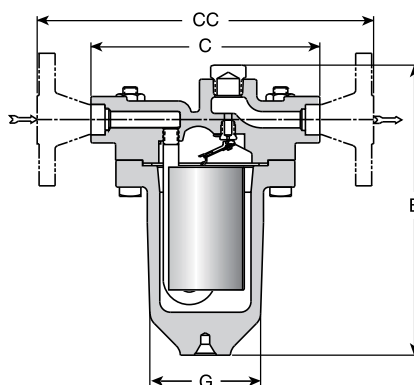
All dimensions and weights are approximate. Use certified print for exact dimensions. Design and materials are subject to change without notice.

411G/421 Inverted Bucket Steam Traps

Forged Carbon Steel for Vertical and Horizontal Installation
For Pressures to 69 bar...Capacities to 590 kg/h



Model 411G Trap



Model 421 Trap



Description

Armstrong Model 411G vertical installation and Model 421 horizontal installation offer smaller capacities at higher pressures.

A unique leverage system multiplies the force provided by the bucket to open the valve against system pressure. The mechanism is free-floating and has no fixed pivots to create wear or friction.

Because the mechanism is located at the top of the trap, no dirt can collect on the orifice. Small particles of dirt are held in suspension until discharged by the full differential purging action when the bucket sinks, pulling the valve off the seat.

The discharge orifice is surrounded by a water seal, preventing live steam loss. Automatic air venting is provided by a small vent hole in the bucket.

Inverted bucket traps drain continuously to prevent condensate backup. They are also resistant to water hammer.

Model 421 adds the convenience and savings of in-line reparability and is designed to meet today's energy management requirements efficiently and economically over a long, trouble-free service life.

Connections

Screwed BSPT and NPT

Socketweld

Flanged DIN or ANSI (welded), (consult factory for material specification)

Materials

Body:

411G Cap:

421 Cap:

Internals:

Valve and seat:

ASTM A105

Stainless steel

Stainless steel

All stainless steel – 304

Titanium

Options

Stainless steel internal check valve (411G only)

Specifications

Inverted bucket steam trap, type ... in forged carbon steel, with continuous air venting at steam temperature, free-floating stainless steel mechanism, with the discharge orifice at the top of the trap. Maximum allowable back pressure 99% of inlet pressure.

How to Order

Specify:

- Model number
- Size and type of pipe connection. When flanges are required, specify type of flange in detail
- Maximum working pressure that will be encountered or orifice size
- Any options required

Table ST-96-1. Model 411G Bottom Inlet, Top Outlet Trap; Model 421 Side Inlet, Side Outlet Trap (dimensions in mm)

Add suffix "CV" to trap number for internal check valve.

Model No. Screwed or SW Model No. Flanged	411G 411G-FW	421 421-FW
Pipe Connections	15 – 20	15 – 20
"A" Flange Diameter	160	—
"B" & "C" Face-to-Face (screwed & SW)	224	203
"BB" & "CC" Face-to-Face (flanged PN100*)	298 – 304	277 – 283
"G" Body Outside Diameter	103	98
"K" $\varnothing$ Outlet to $\varnothing$ Inlet	19	—
Number of Bolts	8	8
Weight in kg (screwed & SW)	11,3	12,6
Weight in kg (flanged PN100*)	14,4 – 15,4	15,1 – 16,1

* Other flange sizes, ratings and face-to-face dimensions are available on request.

All models comply with the article 3.3 of the PED (97/23/EC).

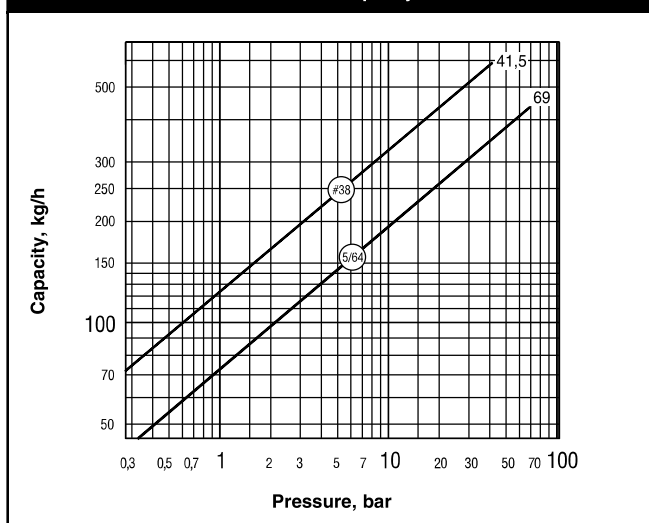
All dimensions and weights are approximate. Use certified print for exact dimensions. Design and materials are subject to change without notice.

411G/421 Inverted Bucket Steam Traps

Forged Carbon Steel for Vertical and Horizontal Installation
For Pressures to 69 bar...Capacities to 590 kg/h



Table ST-97-1. Model 411G and 421 Capacity



Note: #38 orifice in Model 421 is limited to 39 bar.

Table ST-97-2. Pressure-Temperature Rating for Forged Steel Traps

Model No.	Maximum Operating Pressure, Saturated Steam bar	Max. Allowable Pressure (Vessel Design)† of Pressure-Containing Parts at Indicated Temp.		
		-21 / +371°C	399°C	427°C
411G / 421	69	69	65,5	58

Notes: Maximum operating pressure to be marked on nameplate will be determined by actual orifice used.
Maximum allowable pressures shown in boldface will be marked on nameplate, unless otherwise requested.
Traps with flanges may have different pressure-temperature ratings.
Maximum back pressure is 99% of inlet pressure.

† May be derated depending on flange rating and type.

All dimensions and weights are approximate. Use certified print for exact dimensions. Design and materials are subject to change without notice.



400 Series Inverted Bucket Steam Traps

Forged Chrome-moly Steel for Vertical Installation
For Pressures to 69 bar...Capacities to 9 000 kg/h

Description

Armstrong offers its 400 Series forged chrome-moly steel traps for vertical installation with a choice of screwed, socketweld or flanged connections.

A unique leverage system multiplies the force provided by the bucket to open the valve against system pressure. The mechanism is free-floating and has no fixed pivots to create wear or friction.

Because the mechanism is located at the top of the trap, no dirt can collect on the orifice. Small particles of dirt are held in suspension until discharged by the full differential purging action when the bucket sinks, pulling the valve off the seat.

The discharge orifice is surrounded by a water seal, preventing live steam loss. Automatic air venting is provided by a small vent hole in the bucket. This provides continuous automatic air and CO₂ venting at steam temperature.

Inverted bucket traps drain continuously to prevent condensate backup. They are also resistant to water hammer.

Operation on Superheat. A normally operating bucket trap is filled with saturated steam and condensate. Superheated steam can enter only as fast as the steam inside can condense. As a result, the temperature of the trap is at (or slightly below) saturated steam temperature, regardless of the degree of superheat.

Trap Selection. The pressure-containing parts of the steam trap should safely withstand the maximum pressure and temperature conditions of the system. For example, a trap is required for a 62 bar main at 482°C. The normal operating temperature of the trap will be about 278°C. A Model 415 trap should be selected, even though several smaller traps are capable of handling the working pressure.

For Superheat Service:

1. Don't oversize the orifice; a restricted orifice may be advisable.
2. Specify a burnished valve and seat and an extended inlet tube and check valve.
3. Provide a drip leg of adequate diameter and length.
4. Provide a generous length (600-900 mm) of inlet piping, with the trap below the main.
5. Don't insulate the trap or the inlet piping.

Connections

Screwed BSPT and NPT

Socketweld

Flanged DIN or ANSI (welded)

Materials

Body:

ASTM A182 F22 Class 3

Models 413 and 415 are available with cast 316 stainless steel bodies and all stainless steel internals

Internals:

All stainless steel – 304

Valve and seat:

Stainless Steel 17-4PH (<35 bar)

Titanium (>35 bar)

Options

Stainless steel internal check valve

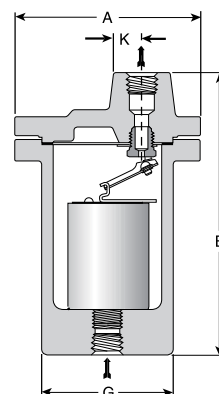
Specification

Inverted bucket steam trap, type ... in forged chrome-moly steel, with continuous air venting at steam temperature, free-floating stainless steel mechanism, with the discharge orifice at the top of the trap. Maximum allowable back pressure 99% of inlet pressure.

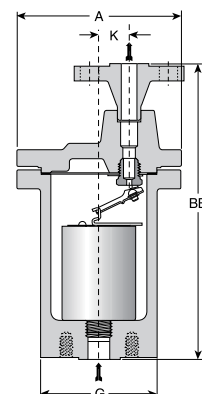
How to Order

Specify:

- Model number
- Size and type of pipe connection. When flanges are required, specify type of flange in detail
- Maximum working pressure that will be encountered or orifice size
- Any options required



Model 400 Trap



Series 400 FW Trap

Table ST-98-1. 400 Series Bottom Inlet, Top Outlet Trap (dimensions in mm)

Add suffix "CV" to trap number for internal check valve.

Model No. Screwed or SW Model No. Flanged	413 413-FW	415 415-FW	416 416-FW
Pipe Connections	15 – 20 – 25	25 – 32 – 40	40 – 50
"A" Flange Diameter	219	273	317
"B" Face-to-Face (screwed & SW)	305	379	448
"BB" Face-to-Face (flanged PN100*)	353 – 360 – 366	440 – 444 – 446	513 – 519
"G" Body Outside Diameter	137	175	216
"K" Ø Outlet to Ø Inlet	36,5	44,4	54
Number of Bolts	8	9	12
Weight in kg (screwed & SW)	29,5	57,2	88,0
Weight in kg (flanged PN100*)	31,5 – 32,5 – 33,0	58,0 – 60,0 – 61,5	92,5 – 94,5

* Other flange sizes, ratings and face-to-face dimensions are available on request.

All models are CE Marked according to the PED (97/23/EC).

All dimensions and weights are approximate. Use certified print for exact dimensions. Design and materials are subject to change without notice.

Armstrong International SA • Parc Industriel des Hauts-Sarts (2^e Avenue) • 4040 Herstal • Belgium

Tel.: +32 (0)4 240 90 90 • Fax: +32 (0)4 240 40 33

www.armstronginternational.eu • info@armstronginternational.eu

400 Series Inverted Bucket Steam Traps

Forged Chrome-moly Steel for Vertical Installation
For Pressures to 69 bar...Capacities to 9 000 kg/h



Table ST-99-1. Model 413 Capacity

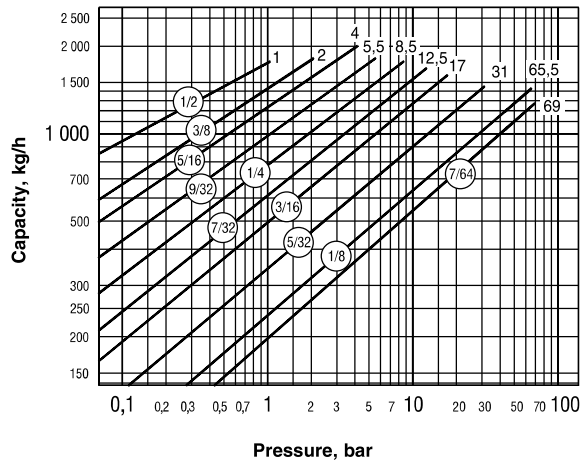


Table ST-99-2. Model 415 Capacity

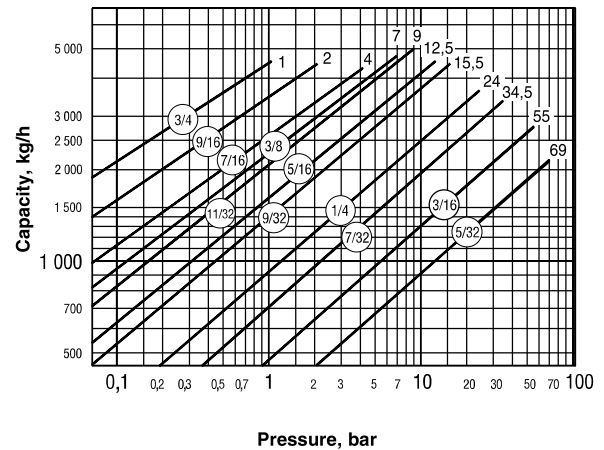


Table ST-99-3. Model 416 Capacity

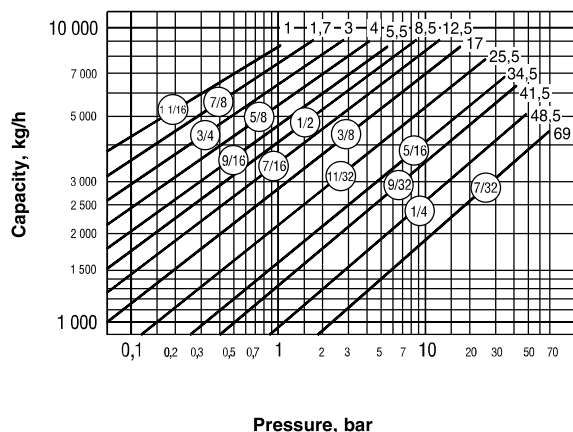


Table ST-99-4. Pressure-Temperature Rating for Forged Steel Traps

Model No.	Maximum Operating Pressure, Saturated Steam	Max. Allowable Pressure (Vessel Design)† of Pressure-Containing Parts at Indicated Temp.			
		-28 / +399°C	427°C	454°C	482°C
	bar	bar			
413	69	83	83	72	54
415	69	76	76	74,5	66,5
416	69	117	114	93	68

Notes: Maximum operating pressure to be marked on nameplate will be determined by actual orifice used.
Maximum allowable pressures shown in boldface will be marked on nameplate, unless otherwise requested.
Traps with flanges may have different pressure-temperature ratings.
Maximum back pressure is 99% of inlet pressure.

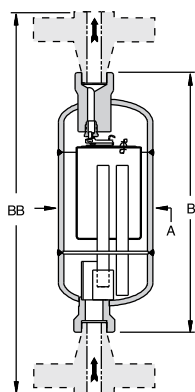
† May be derated depending on flange rating and type.

All dimensions and weights are approximate. Use certified print for exact dimensions. Design and materials are subject to change without notice.

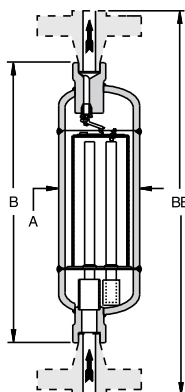
401-SH/501-SH Inverted Bucket Superheated Steam Traps

Carbon Steel or Stainless Steel for Vertical Installation

For Pressures to 106 bar...Capacities to 430 kg/h



Model 401-SH



Model 501-SH



Description

Armstrong's 401-SH/501-SH Series inverted bucket steam trap line **is made for overcoming the difficult combination of superheat and high pressure/low load service.**

To survive this most severe steam service, Armstrong created an inverted bucket trap with a unique accumulation chamber. The chamber collects sufficient condensate to ensure full discharge cycles. A cup in the chamber floats up and down on the steam inlet tube, sealing it off as the condensate level rises. At the same time as the chamber collects condensate, steam continues to flow under the bucket, making sure that the discharge valve closes tightly until the condensate rises into the trap body and the bucket falls down. The operation is on/off, no throttling or dribbling.

Furthermore, it combines all the advantages of an inverted bucket steam trap:

- High resistance to wear, corrosion and water hammer with **no gaskets.**
- A unique leverage system multiplies the force provided by the bucket, to open the valve against system pressure.
- The mechanism is located at the top. No dirt can collect on the orifice. Small particles of dirt will be held in suspension until discharged by the full differential purging action.
- The discharge orifice is surrounded by a water seal, preventing live steam loss. Automatic air venting is provided by a small hole in the bucket.
- Inverted bucket traps require no adjustment. They do not allow condensate backup and are resistant to water hammer.

Connections

Screwed BSPT and NPT (401-SH only)

Socketweld

Flanged DIN or ANSI (welded)

Maximum Operating Conditions

Maximum allowable pressure (vessel design)†:

Model 401-SH: 69 bar @ 427°C

Model 501-SH: 106 bar @ 454°C

Maximum operating pressure:

Model 401-SH: 69 bar

Model 501-SH: 106 bar

Maximum back pressure: 99% of inlet pressure

Materials

Body:

Model 401-SH Carbon steel ASTM A106 Gr. B Sch. 80 pipe

Model 501-SH Stainless steel 316L ASTM A312 Sch. 80 pipe

Internals:

Stainless steel – 304

Valve and seat:

Titanium

Connections:

Model 401-SH Stainless steel – 304

Model 501-SH Stainless steel – 316L

Specification

Inverted bucket steam trap, type 401-SH in carbon steel or 501-SH in stainless steel, with accumulation chamber, continuous air venting at steam temperature, stainless steel leverage system, with the discharge orifice at the top of the trap. Maximum allowable back pressure 99% of inlet pressure.

How to Order

Specify:

- Model number
- Size and type of pipe connection. When flanges are required, specify type of flange in detail
- Maximum working pressure that will be encountered or orifice size

Table ST-100-1. Model 401-SH and Model 501-SH Bottom Inlet, Top Outlet Trap (dimensions in mm)

Model No.	401-SH	501-SH
Pipe Connections	15 – 20	15 – 20
"A" Body Outside Diameter	100	100
"B" Face-to-Face (screwed & SW)	279	350
"BB" Height (flanged 401-SH PN100 & 501-SH PN250*)	356 – 390	476 – 480
Weight in kg (screwed & SW)	5,5	7
Weight in kg (flanged 401-SH PN100 & 501-SH PN250*)	6,7 – 7,3	13 – 13,5

* Other flange sizes, ratings and face-to-face dimensions are available on request.

All models are CE Marked according to the PED (97/23/EC).

† May be derated depending on flange rating and type.

All dimensions and weights are approximate. Use certified print for exact dimensions. Design and materials are subject to change without notice.

401-SH/501-SH Inverted Bucket Superheated Steam Traps

Carbon Steel or Stainless Steel for Vertical Installation

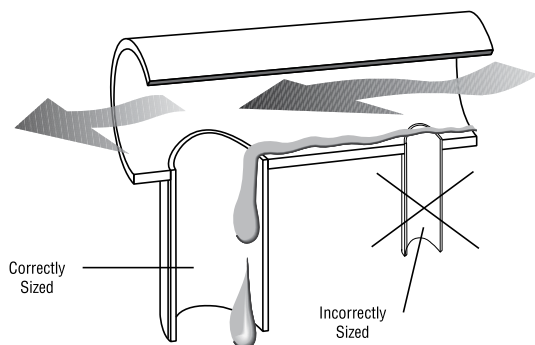
For Pressures to 106 bar...Capacities to 590 kg/h



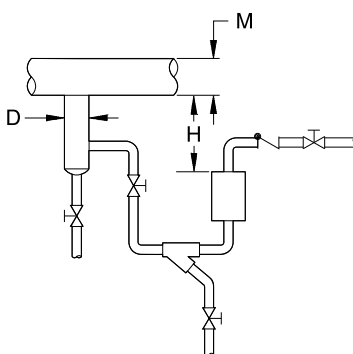
Installation Recommendations

What little condensate there is on superheat and high pressure/low load service usually forms in drip legs and in the traps themselves. Therefore proper piping and drip legs of adequate size and diameter are essential for the successful operation of the Armstrong superheat trap.

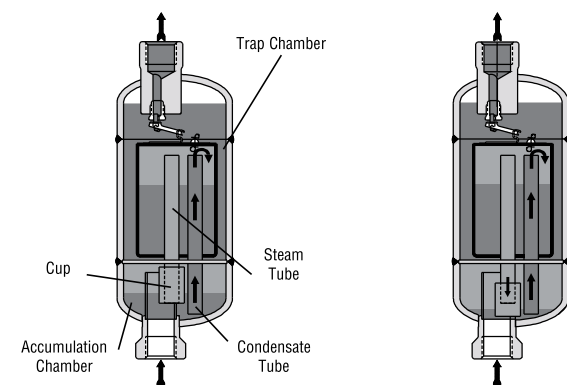
Drip Leg Sizing



The properly sized drip leg will capture condensate. Too small a drip leg can actually cause a venturi "piccolo" effect where pressure drop pulls condensate out of the drip leg and trap.



Trap Draining Drip Leg on Steam Main



Cycling – Discharge Valve Wide Open

With the steam feed tube to the trap chamber sealed, condensate flows through the condensate feed tube (from accumulation chamber) into the trap chamber. This sinks the inverted bucket, which opens the discharge valve, cycling the trap.

Cycle Ending

As the level of condensate in the accumulation chamber falls, the cup sealing the steam feed tube moves downward, opening a passage for steam to flow into trap chamber.

Trap Closed

As steam begins to flow through the accumulation chamber and up the steam feed tube under the inverted bucket in the trap chamber, the discharge valve closes tightly.

Cycle About to Repeat

As the level of condensate rises in the accumulation chamber, the cup floats up until it again seals the steam feed tube, and the cycle repeats.

Table ST-101-1. Model 401/501 Capacity

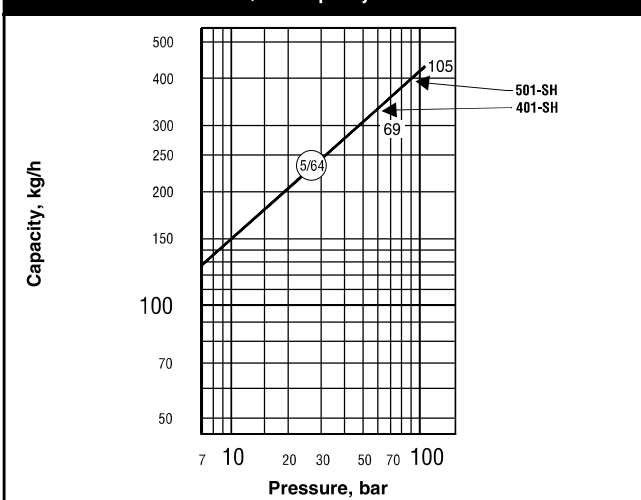


Table ST-101-2. Recommended Steam Main and Branch Line Drip Leg Tracing

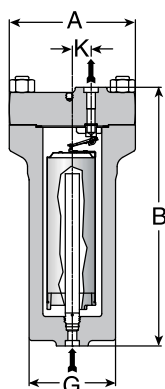
M		D		H Drip Leg Length Minimum			
Steam Main Size		Drip Leg Diameter		Supervised Warm-Up		Automatic Warm-Up	
mm	in.	mm	in.	mm	in.	mm	in.
15	1/2"	15	1/2"	250	10"	710	28"
20	3/4"	20	3/4"	250	10"	710	28"
25	1"	25	1"	250	10"	710	28"
50	2"	50	2"	250	10"	710	28"
75	3"	75	3"	250	10"	710	28"
100	4"	100	4"	250	10"	710	28"
150	6"	100	4"	250	10"	710	28"
200	8"	100	4"	300	12"	710	28"
250	10"	150	6"	380	15"	710	28"
300	12"	150	6"	450	18"	710	28"
350	14"	200	8"	530	21"	710	28"
400	16"	200	8"	600	24"	710	28"
450	18"	250	10"	685	27"	710	28"
500	20"	250	10"	760	30"	760	30"
600	24"	300	12"	910	36"	910	36"

All dimensions and weights are approximate. Use certified print for exact dimensions. Design and materials are subject to change without notice.

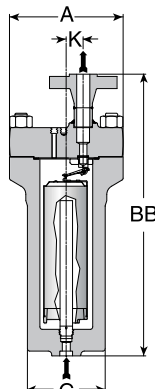


5000 Series Inverted Bucket Steam Traps

Forged Chrome-moly Steel for Vertical Installation
For Pressures to 124 bar...Capacities to 2 340 kg/h



Series 5133G & 5155G Traps



Series 5133G-FW & 5155G-FW Traps



Description

Armstrong offers its 5000 Series forged chrome-moly steel traps for vertical installation with a choice of screwed, socketweld or flanged connections.

A unique leverage system multiplies the force provided by the bucket to open the valve against system pressure. The mechanism is free-floating and has no fixed pivots to create wear or friction.

Because the mechanism is located at the top of the trap, no dirt can collect on the orifice. Small particles of dirt are held in suspension until discharged by the full differential purging action when the bucket sinks, pulling the valve off the seat.

The discharge orifice is surrounded by a water seal, preventing live steam loss. Automatic air venting is provided by a small vent hole in the bucket. This provides continuous automatic air and CO₂ venting at steam temperature.

Inverted bucket traps drain continuously, although discharging intermittently, to prevent condensate backup. They are also resistant to water hammer.

Operation on Superheat. A normally operating bucket trap is filled with saturated steam and condensate. Superheated steam can enter only as fast as the steam inside can condense. As a result, the temperature of the trap is at (or slightly below) saturated steam temperature, regardless of the degree of superheat.

Trap Selection. The pressure-containing parts of the steam trap should safely withstand the maximum pressure and temperature conditions of the system. For example, a trap is required for a 68 bar main at 510°C. The normal operating temperature of the trap will be about 286°C.

A Model 5133G trap should be selected, even though several smaller traps are capable of handling the working pressure.

For Superheat Service:

1. Don't oversize the orifice; a restricted orifice may be advisable.
2. Specify a burnished valve and seat and an extended inlet tube and check valve.
3. Provide a drip leg of adequate diameter and length.
4. Provide a generous length (600-900 mm) of inlet piping, with the trap below the main.
5. Don't insulate the trap or the inlet piping.

Connections

Screwed BSPT and NPT
Socketweld
Flanged DIN or ANSI (welded)

Materials

Body: ASTM A182 F22 Class 3
Internals: All stainless steel – 304
Valve and seat: Titanium

Options

- Stainless steel internal check valve
- Burnished valve and seat

Table ST-102-1. 5000 Series Bottom Inlet, Top Outlet Trap (dimensions in mm)

Add suffix "CV" to trap number for internal check valve.

Model No. Screwed or SW Model No. Flanged	5133G 5133G-FW	5155G 5155G-FW
Pipe Connections	15 – 20 – 25	20 – 25 – 32
"A" Flange Diameter	216	264
"B" Face-to-Face (screwed & SW)	362	412
"BB" Face-to-Face (flanged PN160*)	457 – 463 – 470	540 – 540 – 540
"G" Body Outside Diameter	140	194
"K" Ø Outlet to Ø Inlet	33,0	44,5
Number of Bolts	8	10
Weight in kg (screwed & SW)	44,5	77,5
Weight in kg (flanged PN160*)	47,0 – 47,5 – 48,0	89,0 – 89,5 – 90,0

* Other flange sizes, ratings and face-to-face dimensions are available on request.
All models are CE Marked according to the PED (97/23/EC).

All dimensions and weights are approximate. Use certified print for exact dimensions. Design and materials are subject to change without notice.

Armstrong International SA • Parc Industriel des Hauts-Sarts (2^e Avenue) • 4040 Herstal • Belgium

Tel.: +32 (0)4 240 90 90 • Fax: +32 (0)4 240 40 33

www.armstronginternational.eu • info@armstronginternational.eu

5000 Series Inverted Bucket Steam Traps

Forged Chrome-moly Steel for Vertical Installation

For Pressures to 124 bar...Capacities to 2 340 kg/h



Table ST-103-1. Model 5133G Capacity

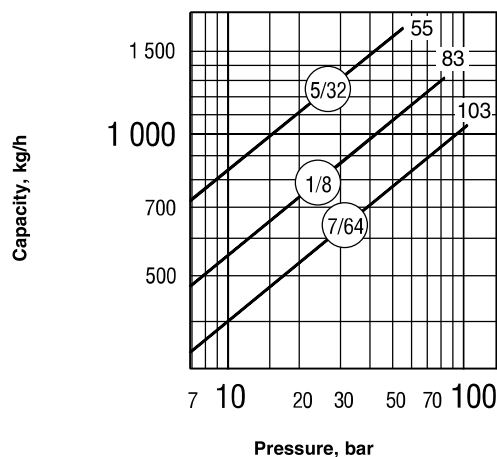


Table ST-103-2. Model 5155G Capacity

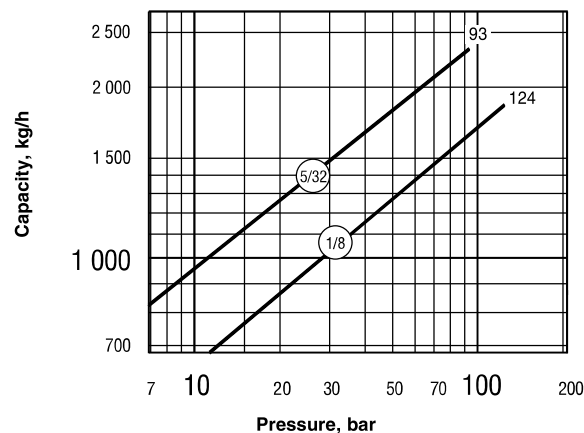


Table ST-103-3. Pressure-Temperature Rating for Forged Steel Traps

Model No.	Maximum Operating Pressure, Saturated Steam	Maximum Allowable Pressure (Vessel Design) [†] of Pressure-Containing Parts at Indicated Temperature							
		-28 / +343°C	371°C	399°C	427°C	454°C	482°C	510°C	538°C
	bar	bar							
5133G	103	146	146	146	146	137	119	93	64
5155G	124	174	174	174	174	163	143	111	76.5

Notes: Maximum operating pressure to be marked on nameplate will be determined by actual orifice used.

Maximum allowable pressures shown in boldface will be marked on nameplate, unless otherwise requested.

Traps with flanges may have different pressure-temperature ratings.

Maximum back pressure is 99% of inlet pressure.

Options

Internal Check Valves are spring loaded stainless steel and screw into an extended inlet tube having a pipe coupling at the top to save fittings, labor and money. Internal check valves may result in slightly reduced capacities.

Screwed Connections are available in all sizes for pressures of 63 bar or less. Traps for pressures of 63 bar or higher are available with socketweld or flanged connections.

Specification

Inverted bucket steam trap, type ... in forged chrome-moly steel, with continuous air venting at steam temperature, free-floating stainless steel mechanism, with the discharge orifice at the top of the trap. Maximum allowable back pressure 99% of inlet pressure.

How to Order

Specify:

- Model number
- Size and type of pipe connection. When flanges are required, specify type of flange in detail
- Maximum working pressure that will be encountered or orifice size
- Any options required

[†] May be derated depending on flange rating and type.

All dimensions and weights are approximate. Use certified print for exact dimensions. Design and materials are subject to change without notice.



6000 Series Inverted Bucket Steam Traps

Forged Chrome-moly Steel for Vertical Installation
For Pressures to 186 bar...Capacities to 2 950 kg/h

Description

Armstrong offers its 6000 Series forged chrome-moly steel traps for vertical installation with a choice of socketweld or flanged connections.

A unique leverage system multiplies the force provided by the bucket to open the valve against system pressure. The mechanism is free-floating and has no fixed pivots to create wear or friction.

Because the mechanism is located at the top of the trap, no dirt can collect on the orifice. Small particles of dirt are held in suspension until discharged by the full differential purging action when the bucket sinks, pulling the valve off the seat.

The discharge orifice is surrounded by a water seal, preventing live steam loss. Automatic air venting is provided by a small vent hole in the bucket. This provides continuous automatic air and CO₂ venting at steam temperature.

Inverted bucket traps drain continuously, although discharging intermittently, to prevent condensate backup. They are also resistant to water hammer.

Operation on Superheat. A normally operating bucket trap is filled with saturated steam and condensate. Superheated steam can enter only as fast as the steam inside can condense. As a result, the temperature of the trap is at (or slightly below) saturated steam temperature, regardless of the degree of superheat.

Trap Selection. The pressure-containing parts of the steam trap should safely withstand the maximum pressure and temperature conditions of the system. For example, a trap is required for a 102 bar main at 538°C. The normal operating temperature of the trap will be about 299°C. A Model 6155G trap should be selected, even though several smaller traps are capable of handling the working pressure.

For Superheat Service:

1. Don't oversize the orifice; a restricted orifice may be advisable.
2. Specify a burnished valve and seat and an extended inlet tube and check valve.
3. Provide a drip leg of adequate diameter and length.
4. Provide a generous length (600-900 mm) of inlet piping, with the trap below the main.
5. Don't insulate the trap or the inlet piping.

Connections

Socketweld
Flanged DIN or ANSI (welded)

Materials

Body: ASTM A182 F22 Class 3
Internals: All stainless steel – 304
Valve and seat: Titanium

Options

- Stainless steel internal check valve
- Burnished valve and seat

Screwed connections are available in all sizes for pressures of 62 bar or less. Traps for pressures of 62 bar or higher are available with socketweld or flanged connections.

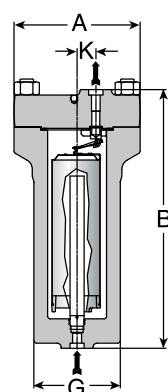
Specification

Inverted bucket steam trap, type 6155 in forged chrome-moly steel, with continuous air venting at steam temperature, free-floating stainless steel mechanism, with the discharge orifice at the top of the trap. Maximum allowable back pressure 99% of inlet pressure.

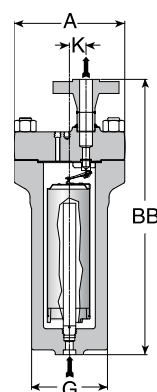
How to Order

Specify:

- Model number
- Size and type of pipe connection. When flanges are required, specify type of flange in detail
- Maximum working pressure that will be encountered or orifice size
- Any options required



Model 6000 Trap



Series 6000 FW Trap

Table ST-104-1. 6000 Series Bottom Inlet, Top Outlet Trap (dimensions in mm)

Add suffix "CV" to trap number for internal check valve.

Model No. Screwed or SW Model No. Flanged	6155G 6155G-FW
Pipe Connections	25 – 32
"A" Flange Diameter	300
"B" Face-to-Face (SW)	613
"BB" Face-to-Face (flanged PN250*)	740 – 740
"G" Body Outside Diameter	213
"K" Ø Outlet to Ø Inlet	44,5
Number of Bolts	10
Weight in kg (SW)	147,4
Weight in kg (flanged PN250*)	151,0 – 154,0

* Other flange sizes, ratings and face-to-face dimensions are available on request.

All models are CE Marked according to the PED (97/23/EC).

All dimensions and weights are approximate. Use certified print for exact dimensions. Design and materials are subject to change without notice.

Armstrong International SA • Parc Industriel des Hauts-Sarts (2^e Avenue) • 4040 Herstal • Belgium

Tel.: +32 (0)4 240 90 90 • Fax: +32 (0)4 240 40 33

www.armstronginternational.eu • info@armstronginternational.eu

6000 Series Inverted Bucket Steam Traps

Forged Chrome-moly Steel for Vertical Installation

For Pressures to 186 bar...Capacities to 2 950 kg/h



Table ST-105-1. Model 6155G Capacity

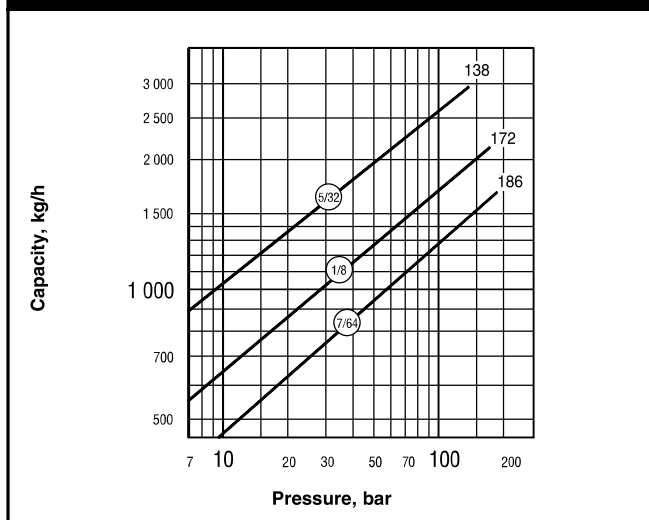


Table ST-105-2. Pressure-Temperature Rating for Forged Steel Traps

Model No.	Maximum Operating Pressure, Saturated Steam	Maximum Allowable Pressure (Vessel Design)† of Pressure-Containing Parts at Indicated Temperature							
		-28 / +343°C	371°C	399°C	427°C	454°C	482°C	510°C	538°C
	bar	bar							
6155G	186	241	241	241	241	241	213	166	114

Notes: Maximum operating pressure to be marked on nameplate will be determined by actual orifice used.

Maximum allowable pressures shown in boldface will be marked on nameplate, unless otherwise requested.

Traps with flanges may have different pressure-temperature ratings.

Maximum back pressure is 99% of inlet pressure.

Options

Internal Check Valves are spring loaded stainless steel and screw into an extended inlet tube having a pipe coupling at the top to save fittings, labor and money. Internal check valves may result in slightly reduced capacities.

† May be derated depending on flange rating and type.

All dimensions and weights are approximate. Use certified print for exact dimensions. Design and materials are subject to change without notice.



2000 Series Stainless Steel Steam Traps

The Armstrong stainless steel traps – Series 1000, Series U-1000, Series 1800 and Series 2000 – have high resistance to damage from freeze-ups. They also offer high resistance to wear and corrosion for longer service reliability, and they provide continuous air venting.

Armstrong stainless steel traps provide maximum ease and economy of installation, inspection or replacement. What's more, an Armstrong stainless steel trap is the ideal solution for trapping applications such as tracer lines, steam mains and heating and processing applications.

Wear and corrosion resistance

Free-floating guided lever valve mechanism is "frictionless," and all wear points are heavily reinforced. All working parts are stainless steel. Valve and seat are stainless steel, individually ground and lapped together in matched sets.

360° universal 304 stainless steel connector

Provides quick, easy in-line renewability along with all the proven advantages of an inverted bucket operation. Also available with optional IS-2 integral strainer connector with 20 x 20 mesh stainless steel strainer.

Virtually no steam loss

Steam does not reach the water-sealed discharge valve.

Purging action

Snap opening of the valve creates a momentary pressure drop and turbulence in the unit drained. This breaks up films of condensate and air and speeds their flow to the trap.

Sealed, tamperproof 304-L stainless steel package

Able to withstand freeze-ups without damage.

Continuous air and CO₂ venting

Vent in top of bucket provides continuous automatic air and CO₂ venting with no cooling lag or threat of air binding. Steam passing through vent is less than that required to compensate for radiation losses from the trap, so it's not wasted.

Dependable operation

Simple, direct operation with nothing to stick, bind or clog.

Only two moving parts – the valve lever and the bucket.

Excellent operation against back pressure

Since trap operation is governed by the difference in density of steam and water, back pressure in the return line has no effect on the ability of the trap to open for condensate and close against steam.

Freedom from dirt problems

Condensate flow under the bottom edge of the bucket keeps sediment and sludge in suspension until it is discharged with the condensate. Valve orifice opens wide and closes tightly. No buildup of dirt or close clearances to be affected by scale.

Resistance to damage from water hammer

Open bucket or float will not collapse as a result of water hammer.

2000 Series Stainless Steel Steam Traps

For Pressures to 45 bar...Capacities to 590 kg/h

With the Series 2000 360° universal connector, you can install inverted bucket efficiency and long service life in any piping configuration with little or no repiping. You get the reliability of the inverted bucket operating principle, plus all the benefits of all-stainless steel construction:

- A sealed, tamperproof package
- A compact, lightweight trap
- The ability to withstand freeze-ups without damage
- Exceptional corrosion resistance
- A three-year guarantee against defective materials or workmanship

Series 2000 steam traps combine savings in three important areas: energy, installation and replacement. The 360° universal connector provides quick, easy in-line renewability along with all the proven advantages of an inverted bucket operation. Choice of NPT or BSPT screwed connections, or socketweld connections.

Also available with optional IS-2 integral strainer connector.



Available with Standard Connector
Material: 304 Stainless Steel



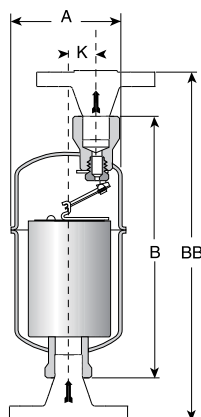
Available with
IS-2 Integral Strainer Connector
(shown with optional blowdown valve)
Material: 304 Stainless Steel



Available with
IS-4 Connector
Material: ASTM A351 Gr. CF8M

1000 Series Inverted Bucket Steam Traps

All Stainless Steel for Vertical Installation
For Pressures to 45 bar...Capacities to 2 000 kg/h



Description

Armstrong 1000 Series stainless steel inverted bucket steam traps normally last three to four times longer than conventional traps used in identical services. Heat-treated stainless steel valves and seats are of the same design, material and workmanship as those used in traps for pressures up to 62 bar and temperatures to 482°C. More compact than cast iron or carbon steel equivalents, 1000 Series traps are ideal for trapping applications such as tracer lines, steam mains and heating/process applications.

The 1000 Serie is **guaranteed for three years**.

Maximum Operating Conditions

Maximum allowable pressure (vessel design)†:

Model 1010, 1011:	28 bar @ 427°C
Model 1022:	45 bar @ 316°C
Model 1013:	31 bar @ 427°C

Maximum operating pressure:

Model 1010:	10,3 bar
Model 1011:	28 bar
Model 1022:	45 bar
Model 1013:	31 bar

Maximum back pressure: 99% of inlet pressure

Connections

Screwed BSPT and NPT

Socketweld

Flanged EN1092-1 PN40 or ANSI (welded)*

Materials

Body:	ASTM A240 Grade 304L
Internals:	All stainless steel – 304
Valve and seat:	Stainless Steel 17-4PH (<35 bar) Titanium (>35 bar)
Strainer body:	Carbon steel
Strainer screen:	Stainless steel

Options

- Stainless steel internal check valve
- Thermic vent bucket 17 bar maximum
- Wiggle wire
- With the 1000N Series inverted bucket, copper oxide plugging problems can be eliminated.

Specification

Inverted bucket steam trap, type ... in all stainless steel, freeze resistant, without gaskets, with continuous air venting at steam temperature, free-floating stainless steel mechanism, and orifice at the top of the trap. Maximum allowable back pressure 99% of inlet pressure.

How to Order

Specify:

- Model number
- Size and type of pipe connection
- Maximum working pressure that will be encountered or orifice size
- Any options required

Table 108-1. 1000 Series Bottom Inlet, Top Outlet Trap (dimensions in mm)

Model No.	1010	1011	1022	1013
Pipe Connections	15 – 20	15 – 20	20	25
«A» Body Outside Diameter	70	70	100	114
«B» Face-to-Face (screwed & SW)	152 – 152 / 146 – 138	183 – 183 / 169 – 176	221 / 214	289 / 289
«BB» Face-to-Face (flanged EN1092-1 PN40*)	195 – 200	225 – 230	271	375
«K» Ø Outlet to Ø Inlet	14	14	23	30
Weight in kg (screwed & SW)	0,7	0,8	2	3,4
Weight in kg (flanged EN1092-1 PN40*)	2,1 – 2,8	2,2 – 2,9	4,1	6,0

* Standard flanges are in carbon steel, stainless steel flanges are optional. Other flange sizes, ratings and face-to-face dimensions are available on request.

Shade indicates products that are CE Marked according to the PED (97/23/EC). All the other models comply with the Article 3.3 of the same directive.

† May be derated depending on flange rating and type.

All dimensions and weights are approximate. Use certified print for exact dimensions. Design and materials are subject to change without notice.

Armstrong International SA • Parc Industriel des Hauts-Sarts (2^e Avenue) • 4040 Herstal • Belgium

Tel.: +32 (0)4 240 90 90 • Fax: +32 (0)4 240 40 33

www.armstronginternational.eu • info@armstronginternational.eu

1000 Series Inverted Bucket Steam Traps

All Stainless Steel for Vertical Installation
For Pressures to 45 bar...Capacities to 2 000 kg/h



Table 109-1. Model 1010 Capacity

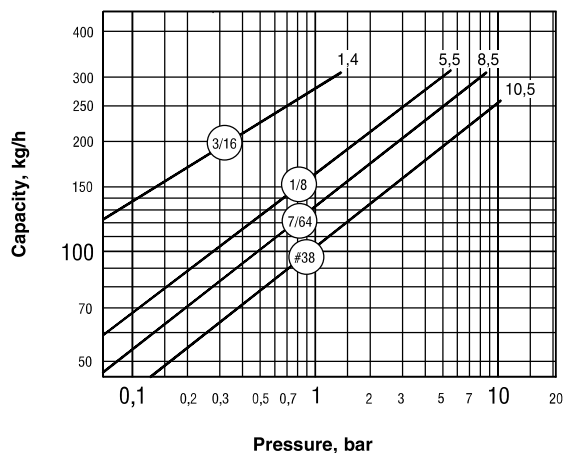


Table 109-2. Model 1011 Capacity

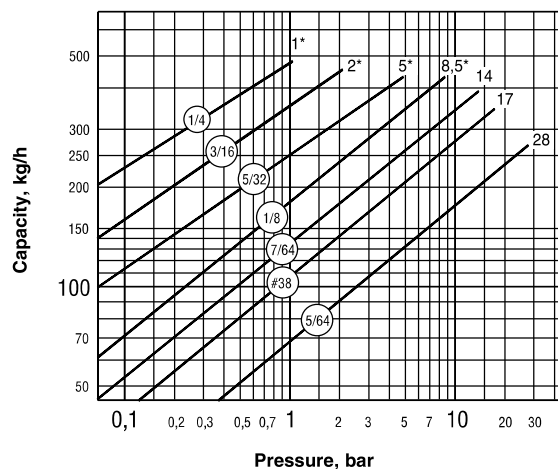


Table 109-3. Model 1022 Capacity

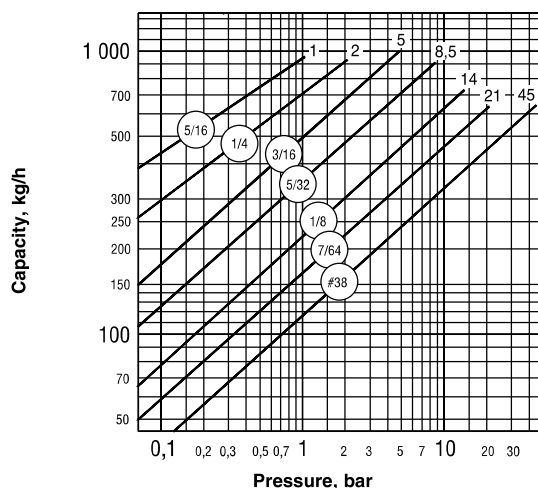
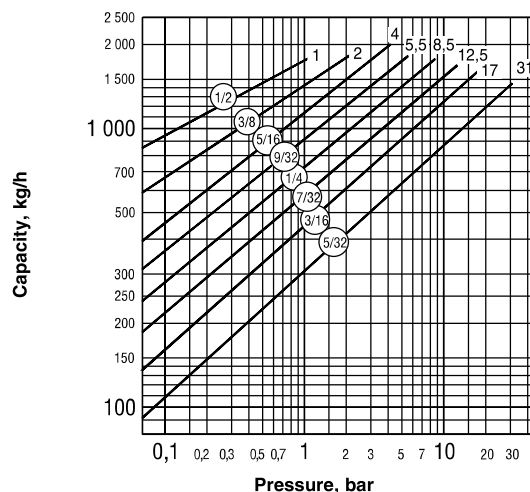


Table 109-4. Model 1013 Capacity



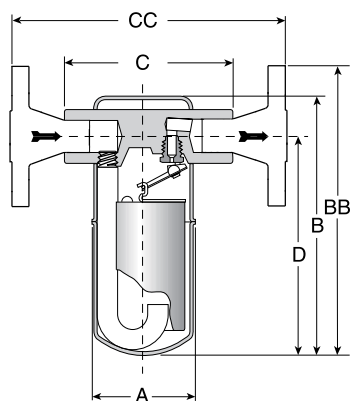
All dimensions and weights are approximate. Use certified print for exact dimensions. Design and materials are subject to change without notice.



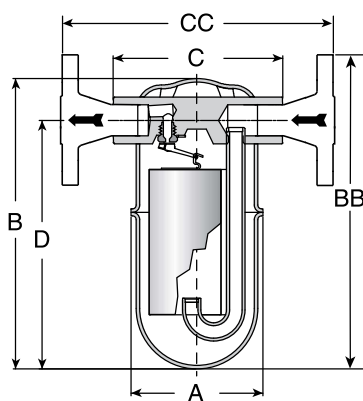
1800 Series Inverted Bucket Steam Traps

All Stainless Steel for Horizontal Installation
For Pressures to 45 bar...Capacities to 1 090 kg/h

Steam Trapping and
Steam Tracing Equipment



Model 1811 Trap



Model 1822 Trap



Description

A quick and easy "in-line" replacement for other types of side inlet/side outlet traps, the Armstrong 1800 Series brings together all the benefits of energy-efficient inverted bucket operation. Side inlet/outlet all-welded construction means an inverted bucket trap that will operate efficiently on applications such as tracer lines, drips, heating, processing and similar applications.

With the 1800 Series you get freeze-resistant, all-stainless steel construction, with a **three-year guarantee**, plus all the benefits of inverted bucket operation:

- Long, trouble-free service life
- Excellent purging action
- Continuous air venting
- Ease and flexibility of in-line installation

Maximum Operating Conditions

Maximum allowable pressure (vessel design)†:

Model 1810, 1811: 28 bar @ 427°C
Model 1822: 45 bar @ 315°C

Maximum operating pressure:

Model 1810: 14 bar
Model 1811: 28 bar
Model 1822: 45 bar @ 316°C
43 bar @ 371°C
41,6 bar @ 427°C

Maximum back pressure: 99% of inlet pressure

Connections

Screwed BSPT and NPT

Socketweld

Flanged DIN or ANSI (welded)

Materials

Body:

ASTM A240 Grade 304L

Internals:

All stainless steel – 304

Valve and seat:

Stainless Steel 17-4PH (<35 bar)

Titanium (>35 bar)

Options

- Insu-Pak™ insulation for Models 1810/1811
- Stainless steel pop drain for Models 1811/1822
- Probe connection
- With the in-line 1800N Series inverted bucket, copper oxide plugging problems can be eliminated.

Specification

Inverted bucket steam trap, type ... in all stainless steel, freeze resistant, without gaskets, with continuous air venting at steam temperature, free-floating stainless steel mechanism, and orifice at the top of the trap. Maximum allowable back pressure 99% of inlet pressure.

How to Order

Specify:

- Model number
- Size and type of pipe connection
- Maximum working pressure that will be encountered or orifice size
- Any options required

Table ST-110-1. 1800 Series Side Inlet, Side Outlet Trap (dimensions in mm)

Model No.	1810	1811	1822
Pipe Connections	10 – 15 – 20 – 25**	15 – 20 – 25**	15 – 20 – 25
"A" Body Outside Diameter	70	70	99
"B" Height	136	167	218
"C" Face-to-Face (screwed & SW)	110	110	127
"CC" Face-to-Face (flanged PN40*)	N/A – 150 – 150 – 160	150 – 150 – 160	190 – 190 – 200
"D" Bottom to Q Inlet	113	138 – 141	186 – 181
Weight in kg (screwed & SW)	0,8	0,9 – 1,0	3
Weight in kg (flanged PN40*)	2,3 – 2,3 – 2,8	2,5 – 3,2	4,5 – 5,2 – 5,6

* Standard flanges are in carbon steel, stainless steel flanges are optional. Other flange sizes, ratings and face-to-face dimensions are available on request.

** pipe connections only available if flanged.

All models comply with the article 3.3 of the PED (97/23/EC). † May be derated depending on flange rating and type.

All dimensions and weights are approximate. Use certified print for exact dimensions. Design and materials are subject to change without notice.

Armstrong International SA • Parc Industriel des Hauts-Sarts (2^e Avenue) • 4040 Herstal • Belgium

Tel.: +32 (0)4 240 90 90 • Fax: +32 (0)4 240 40 33

www.armstronginternational.eu • info@armstronginternational.eu

1800 Series Inverted Bucket Steam Traps

All Stainless Steel for Horizontal Installation
For Pressures to 45 bar...Capacities to 1 090 kg/h



Table ST-111-1. Model 1810 Capacity

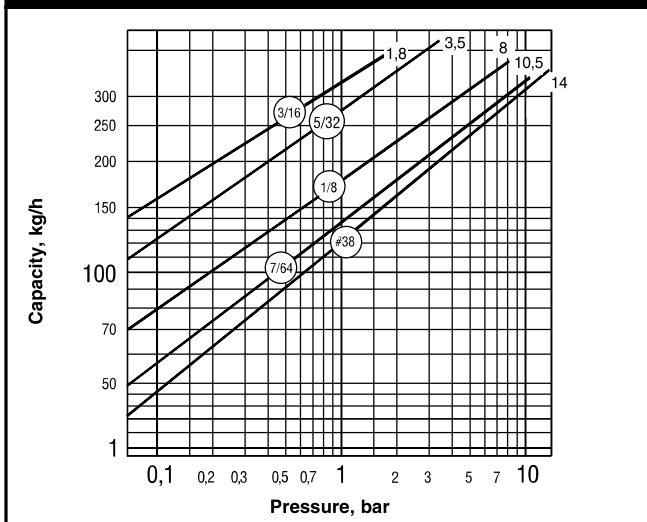
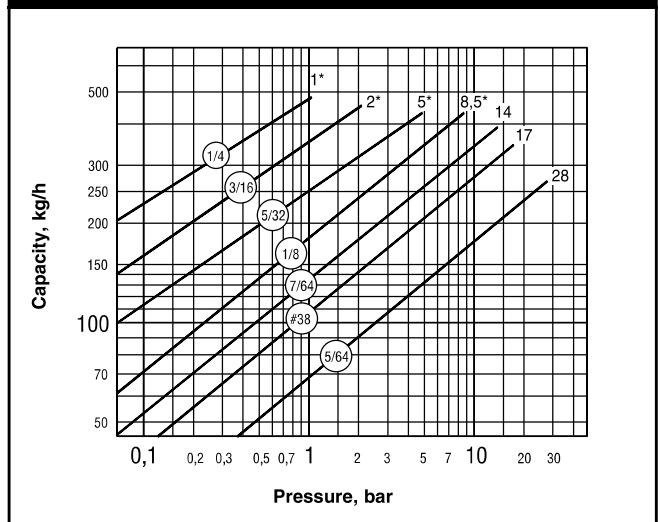


Table ST-111-2. Model 1811 Capacity



* Orifices available only with 3/4" connections.

Options

Pop Drain for Freeze Protection

In general, a properly selected and installed Armstrong trap will not freeze as long as steam is coming to the trap. If the steam supply is shut off, a pop drain should be used to automatically drain the trap. Stainless steel pop drain available for Models 1811 and 1822.

Maximum Operating Conditions

Pressure: 41 bar
Temperature: 177°C

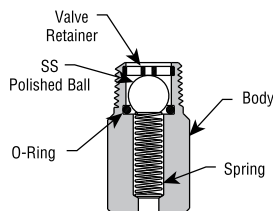
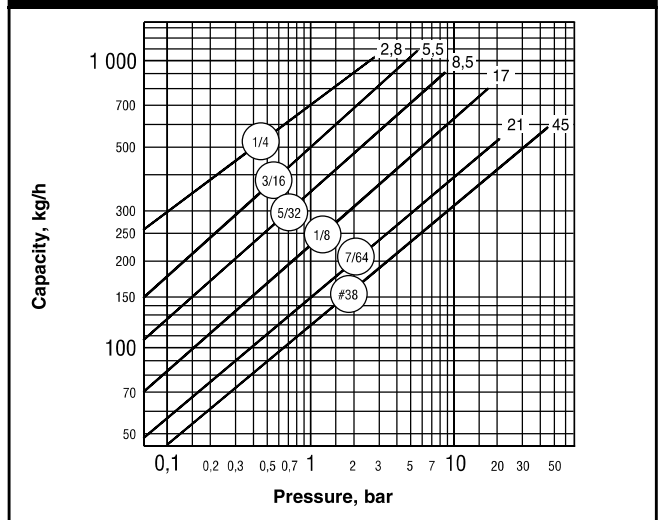


Table ST-111-3. Model 1822 Capacity



Insu-Pak™

Now you can insulate the in-line traps in your plant without complicating regular trap maintenance. Insu-Pak, a simple reusable insulation package, cuts the time and cost of in-field installation because it goes on in a snap. And it comes off just as easily. Insu-Pak can prevent trap freeze-up when used with a properly designed condensate manifold. Designed for use with Model 1810 and Model 1811 traps.

Probe connections are available for trap monitoring on Models 1811 and 1822.



All dimensions and weights are approximate. Use certified print for exact dimensions. Design and materials are subject to change without notice.



2000 Series Inverted Bucket Steam Traps

All Stainless Steel with 360° Connector
For Pressures to 45 bar...Capacities to 590 kg/h

Description

With the 2000 Series' 360° universal connector, you can install inverted bucket efficiency and long service life in any piping configuration with little or no repiping. You get the reliability of the inverted bucket operating principle, plus all the benefits of all-stainless steel construction:

- A sealed, tamperproof package
- A compact, lightweight trap
- The ability to withstand freeze-ups without damage
- Exceptional corrosion resistance
- A **three-year guarantee** against defective materials, defective workmanship.

2000 Series steam traps combine savings in three important areas: energy, installation and replacement. The 360° universal connector provides quick, easy in-line replacement along with all the proven advantages of inverted bucket operation. Also available with optional IS-2 integral strainer connector.

Maximum Operating Conditions

Maximum allowable pressure (vessel design)†:

Model 2010, 2011: 28 bar @ 427°C
Model 2022: 45 bar @ 315°C

Maximum operating pressure:

Model 2010: 14 bar
Model 2011: 28 bar
Model 2022: 45 bar @ 316°C
43 bar @ 371°C
41,6 bar @ 427°C

Maximum back pressure: 99% of inlet pressure

Connections

Screwed BSPT and NPT
Socketweld
Flanged DIN or ANSI (welded)

Materials

Body: ASTM-A 240 Grade 304L
Loose Flange: Zinc Plated Steel
Internals: All stainless steel – 304
Valve and seat: Stainless Steel 17-4PH (<35 bar)
Titanium (>35 bar)
Stainless steel – 304
Standard connector: IS-2 connector with integral strainer: ASTM A351 Gr.CF8
20 x 20 mesh 304 SS Screen

Specification

Inverted bucket steam trap, type ... in all stainless steel, freeze resistant, with 360° universal connector, having continuous air venting at steam temperature, free-floating stainless steel mechanism, and orifice at the top of the trap.
Maximum allowable back pressure 99% of inlet pressure.

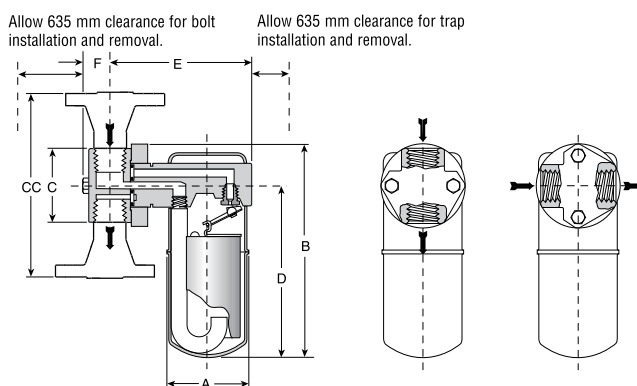
How to Order

Specify:

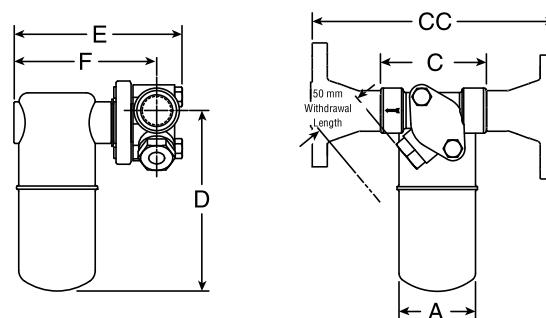
- Model number
- Size and type of pipe connection
- Type of 360° connector (with or without strainer)
- Maximum working pressure that will be encountered or orifice size
- Any options required

Options

- Insu-Pak™ insulation for Models 2010/2011
- Stainless steel pop drain for Models 2011/2022
- Stainless steel loose flange
- Probe connection for Models 2011/2022
- Standard connector
- IS-2 connector with integral strainer
- With the 2000N Series 360° universal connector, copper oxide plugging problems can be eliminated.



Model 2011 Trap with Standard Connector



Model 2010-2022 with IS-2 Connector

Table ST-112-1. 2000 Series Traps with Standard Connector

Model No.	2010	2011	2022
Pipe Connections	15 – 20 – 25		
"A" Body Outside Diameter	68	68	98
"B" Height**	152	176	221
"C" Face-to-Face (screwed & SW)	60	60	60
"CC" Face-to-Face (flanged PN40*)	150 – 150 – 160		
"D" Bottom to $\varnothing$ Inlet	117	142	187
"E" $\varnothing$ to Outside (Standard)***	116	116	146
"F" $\varnothing$ to Bolt	25	25	25
Weight in kg (screwed & SW)	1,9	2,0	3,0
Weight in kg (flanged PN40*)	3,6 – 4,2 – 4,7	3,7 – 4,3 – 4,8	4,7 – 5,3 – 5,7

*Standard flanges are in carbon steel, stainless steel flanges are optional. Other flange sizes, ratings and face-to-face dimensions are available on request.

** For IS-2 connector, add 15 mm to "B" and "D" dimensions when optional probe connections is required.

*** When trap is installed in vertical position on flanged connector, the "Export - Long Neck" version should be used.

All models comply with the article 3.3 of the PED (97/23/EC).

† May be derated depending on flange rating and type.

Table ST-112-1. 2000 Series Traps with IS-2 Integral Strainer Connector

Model No.	2010		2011		2022	
Pipe Connections	15 – 20	25	15 – 20	25	15 – 20	25
"C" Face-to-Face (screwed & SW)	89	102	89	102	89	102
"CC" Face-to-Face (flanged PN40*)	150	160	150	160	150	160
"D" Bottom to $\varnothing$ Inlet**	127	127	152	152	197	197
"E" Outside to Bolt	140	144	140	144	170	175
"F" $\varnothing$ to Outside	117	122	117	122	148	152
Weight in kg (screwed & SW)	2,2	2,4	2,3	2,5	3	3
Weight in kg (flanged PN40*)	3,9 – 4,5	5,1	4,0 – 4,6	5,2	4,7 – 5,3	5,7

All dimensions and weights are approximate. Use certified print for exact dimensions. Design and materials are subject to change without notice.

Armstrong International SA • Parc Industriel des Hauts-Sarts (2^e Avenue) • 4040 Herstal • Belgium

Tel.: +32 (0)4 240 90 90 • Fax: +32 (0)4 240 40 33

www.armstronginternational.eu • info@armstronginternational.eu

2000 Series Inverted Bucket Steam Traps

All Stainless Steel with 360° Connector
For Pressures to 45 bar...Capacities to 590 kg/h



Table ST-113-1. Model 2010 Capacity

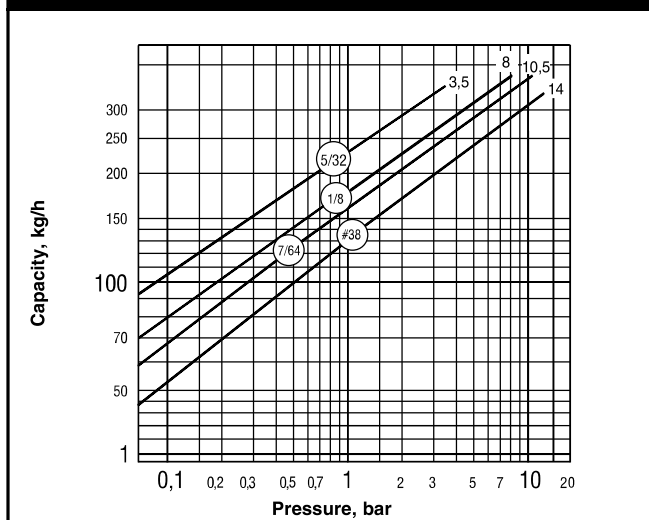
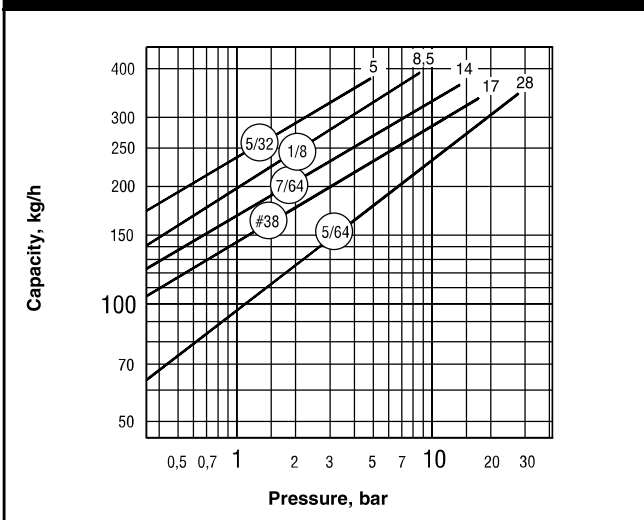


Table ST-113-2. Model 2011 Capacity



Connectors

Besides the inverted bucket traps, the standard connector, IS-2 connector with integral strainer and TVS-4000 can also be used on thermostatic, thermostatic wafer and disc traps.



Options

Pop Drain for Freeze Protection

In general, a properly selected and installed Armstrong trap will not freeze as long as steam is coming to the trap. If the steam supply is shut off, a pop drain should be used to automatically drain the trap. Stainless steel pop drain available for Models 2011 and 2022.

Maximum Operating Conditions

Pressure: 41 bar
Temperature: 177°C

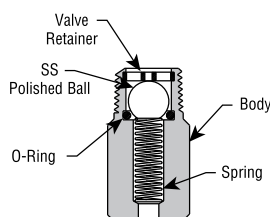
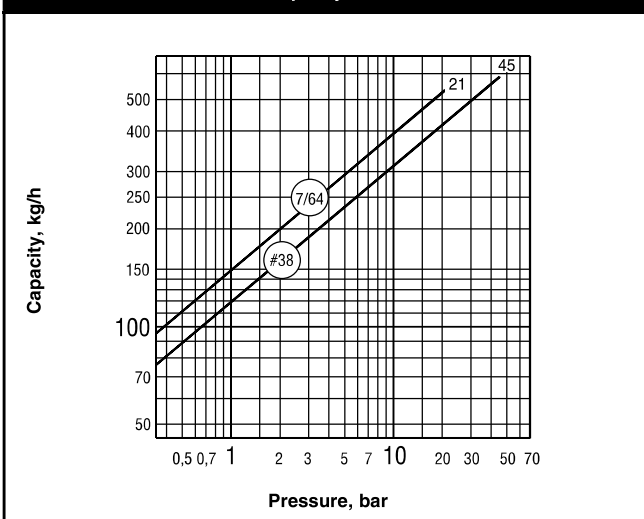


Table ST-113-3. Model 2022 Capacity



Insu-Pak™

Now you can insulate the in-line traps in your plant without complicating regular trap maintenance. Insu-Pak, a simple reusable insulation package, cuts the time and cost of in-field installation because it goes on in a snap. And it comes off just as easily. The Insu-Pak can prevent trap freeze-up when used with a properly designed condensate manifold. Designed for use with Model 2010 and Model 2011 traps.

Probe connections are available for trap monitoring for Models 2011 and 2022.



All dimensions and weights are approximate. Use certified print for exact dimensions. Design and materials are subject to change without notice.



4000 Series Inverted Bucket Steam Trap

All Stainless Steel With IS-4 Connector

For Pressures to 45 bar...Capacities to 590 kg/hr

Description

With the 4000 Series IS-4 connector, you can install 4-bolt compatible inverted bucket efficiency and long service life in any piping configuration with little or no repiping. You get the reliability of the inverted bucket operating principle, plus all the benefits of all-stainless steel construction:

- A sealed, tamperproof package
- A compact, lightweight trap
- The ability to withstand freeze-ups without damage
- Exceptional corrosion resistance
- A three-year guarantee against defective materials, defective workmanship.

4000 Series steam traps combine savings in three important areas: energy, installation and replacement. The 4-bolt connector provides quick, easy in-line replacement along with all the proven advantages of inverted bucket operation.

Maximum Operating Conditions

Maximum allowable pressure (vessel design):

Model IB4011: 28 bar @ 427°C

Model IB4022: 45 bar @ 315°C

43 bar @ 371°C

41 bar @ 427°C

Maximum operating pressure:

Model IB4011: 28 bar

Model IB4022: 45 bar

Connections

Screwed NPT

Socketweld

Flanged (consult factory)

Materials

Body: ASTM-A 240 Grade 304L

Internals: All stainless steel—304

Valve and seat: Hardened chrome steel—17-4PH or Titanium

Connector body: ASTM A351 Gr. CF8M

Options

- Stainless steel pop drain for Models 4011/4022
- Probe connection for Models 4011/4022
- Wiggle wire

Connector Styles

- Standard with strainer
- With strainer blowdown valve
- With block/bleed valves

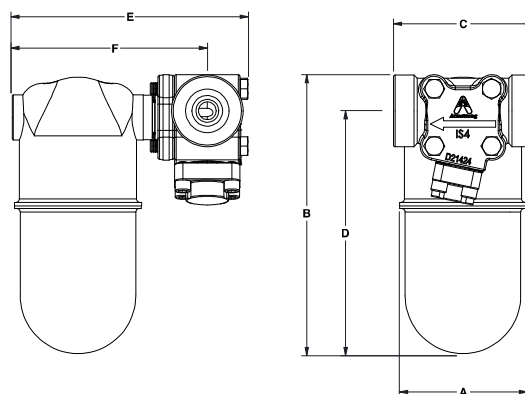
Specification

Inverted bucket steam trap, type ... in all stainless steel, freeze resistant, with 360° universal connector, having continuous air venting at steam temperature, free-floating stainless steel mechanism, and orifice at the top of the trap.

How to Order

Specify:

- Model number
- Size and type of pipe connection
- Maximum working pressure that will be encountered or orifice size
- Any options required



Model IB4022 Trap With IS-4 Connector

Table ST-114-1. 4000 Series Traps With Standard IS-4 Connector

Model No.	IB4011		IB4022	
Pipe Connections	mm	mm	mm	mm
	20	25	20	25
"A" (Diameter)	68	68	98	98
"B" (Height)*	176	176	221	221
"C" (Face to Face)	108	108	108	108
"D" (Bottom to C)*	152	152	197	197
"E" (Outside to Bolt)	156	156	186	186
"F" (C to Outside)	125	125	156	156
Weight kg	3,5		4,9	

*Add 15 mm to "B" and "D" dimensions when optional probe connection is required.

All dimensions and weights are approximate. Use certified print for exact dimensions. Design and materials are subject to change without notice.

Armstrong International SA • Parc Industriel des Hauts-Sarts (2^e Avenue) • 4040 Herstal • Belgium

Tel.: +32 (0)4 240 90 90 • Fax: +32 (0)4 240 40 33

www.armstronginternational.eu • info@armstronginternational.eu

4000 Series Inverted Bucket Steam Trap

All Stainless Steel With IS-4 Connector

For Pressures to 45 bar...Capacities to 590 kg/hr



Table ST-115-1. Model IB4011 Capacity

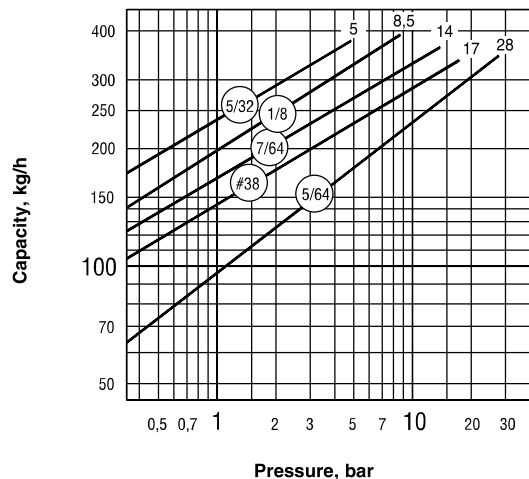
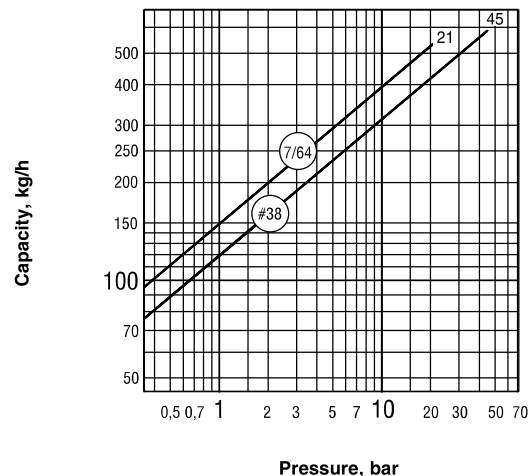


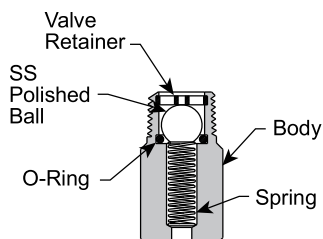
Table ST-115-2. Model IB4022 Capacity



Options

Pop Drain for Freeze Protection

In general, a properly selected and installed Armstrong trap will not freeze as long as steam is coming to the trap. If the steam supply is shut off, a pop drain should be used to automatically drain the trap. Stainless steel pop drain available for Models 4011 and 4022.



Maximum Operating Conditions

Pressure: 41 bar
Temperature: 177°C

All dimensions and weights are approximate. Use certified print for exact dimensions. Design and materials are subject to change without notice.