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## Product Alert 190502

May 6th, 2019

**Subject:** Potential disengagement of Gear Box Drive Adapter from Plug Valve Plug

**To:** Customers who have 3" and 4" Gear Operated Plug Valves with Gear Operators built between October 1<sup>st</sup>, 2018 and April 20<sup>th</sup>, 2019.

It has come to our attention that the Gear Box Drive Adaptor that rotates the Plug Valve's Plug can travel upwards into the base of the Gear Operator far enough to become completely disengaged from the Plug Valve Plug hex end in the affected product population. This situation could create a false indication that the high-pressure flow has been cut off while in reality is still present in the upstream system. This may, in conjunction with other factors or circumstances, result in a risk of personal injury or death.

Kemper Valve has identified the root cause and implemented a corrective action plan to eliminate this failure mode. **See attached pages for affected valve serial numbers and Rework Instructions.**

If you have an affected Valve that is:

- currently in use, then remove it from service and tag "Do Not Use" until Rework has been completed
- not in use, then do NOT install until rework has been completed
- on the shelf and hasn't been sold, then do NOT sell item until Rework has been completed

A Kemper Valve representative will be contacting all affected customers as quickly as possible to discuss rework options. However, if you have any questions or concerns please contact your Kemper Valve Sales Representative or our National Sales Office at 1-800-231-2724.

Sincerely,

**Nickolas Gretz** - Product Service Engineer  
**Avijit Khurana** - Quality Manager



**A Caterpillar Company**

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The following affected assemblies require Rework, Part# GRO-P-DT36-BUSHING must be installed in order to bring back to safe operating condition.

Assembly Part #	Serial #	Assembly Part #	Serial #	Assembly Part #	Serial #
3PV733MFRAC	K740420STD	4PV744MFBAC-01	K732673STD	4PV744MFBAC-01	K747669STD
3PV733MFRAC	K740421STD	4PV744MFBAC-01	K732674STD	4PV744MFBAC-01	K747672STD
3PV733MFRAC	K740623STD	4PV744MFBAC-01	K732675STD	4PV744MFBAC-01	K750746STD
3PV733MFRAC	K740624STD	4PV744MFBAC-01	K732676STD	4PV744MFBAC-01	K750747STD
3PV733MFRAC	K740625STD	4PV744MFBAC-01	K732677STD	4PV744MFBAC-01	K750748STD
3PV733MFRAC	K740626STD	4PV744MFBAC-01	K732678STD	4PV744MFBAC-01	K750749STD
3PV733MFRAC	K740627STD	4PV744MFBAC-01	K732679STD	4PV744MFBAC-01	K750751STD
3PV733MFRAC	K740628STD	4PV744MFBAC-01	K732680STD	4PV744MFBAC-01	K750752STD
3PV733MFRAC	K740629STD	4PV744MFBAC-01	K732681STD	4PV744MFBAC-01	K750753STD
3PV733MFRAC	K740630STD	4PV744MFBAC-01	K732682STD	4PV744MFBAC-01	K750754STD
3PV733MFRAC	K740631STD	4PV744MFBAC-01	K732683STD	4PV744MFBAC-01	K750755STD
3PV733MFRAC	K740632STD	4PV744MFBAC-01	K732684STD	4PV744MFBAC-01	K750756STD
3PV733MFRAC	K740633STD	4PV744MFBAC-01	K732685STD	4PV744MFBAC-01	K750757STD
3PV733MFRAC	K740634STD	4PV744MFBAC-01	K732686STD	4PV744MFBAC-01	K750759STD
3PV733MFRAC	K740635STD	4PV744MFBAC-01	K732687STD	4PV744MFBAC-01	K750760STD
3PV733MFRAC	K740636STD	4PV744MFBAC-01	K732688STD	4PV744MFBAC-01	K750761STD
3PV733MFRAC	K742253STD	4PV744MFBAC-01	K733902STD	4PV744MFBAC-01	K752663STD
3PV733MFRAC	K742255STD	4PV744MFBAC-01	K733903STD	4PV744MFBAC-01	K753253STD
3PV733MFRAC	K742257STD	4PV744MFBAC-01	K733904STD	4PV744MFBAC-01	K753254STD
3PV733MFRAC	K742263STD	4PV744MFBAC-01	K733905STD	4PV744MFBAC-01	K753257STD
3PV733MFRAC	K742268STD	4PV744MFBAC-01	K733906STD	4PV744MFRAC-01	K729475STD
3PV733MFRAC	K742270STD	4PV744MFBAC-01	K733907STD	4PV744MFRAC-01	K747655STD
3PV733MFRAC	K742277STD	4PV744MFBAC-01	K733908STD	4PV744MFRAC-01	K747656STD
3PV733MFRAC	K742278STD	4PV744MFBAC-01	K733909STD	4PV744MFRAC-01	K747657STD
3PV733MFRAC	K742279STD	4PV744MFBAC-01	K733910STD	4PV744MFRAC-01	K747660STD
3PV733MFRAC	K747860STD	4PV744MFBAC-01	K733911STD	4PV744MFRAC-01	K747661STD
3PV733MFRAC	K748896STD	4PV744MFBAC-01	K733912STD	4PV744MFRAC-01	K747662STD
3PV733MFRAC	K748921STD	4PV744MFBAC-01	K733913STD	4PV744MFRAC-01	K747663STD
3PV733MFRAC	K748924STD	4PV744MFBAC-01	K733914STD	4PV744MFRAC-01	K747664STD
3PV733MFRAC	K748925STD	4PV744MFBAC-01	K733915STD	4PV744MFRAC-01	K747667STD
3PV733MFRAC	K749595STD	4PV744MFBAC-01	K733916STD	4PV744MFRAC-01	K747668STD
3PV733MFRAC	K749599STD	4PV744MFBAC-01	K733917STD	4PV744MFRAC-01	K750886STD
3PV733MFRAC	K749601STD	4PV744MFBAC-01	K734722STD	4PV744MFRAC-01	K750887STD
3PV733MFRAS-01	K747816STD	4PV744MFBAC-01	K734723STD	4PV744MFRAC-01	K750889STD
3PV733MFRAS-01	K747818STD	4PV744MFBAC-01	K734724STD	4PV744MFRAC-01	K750891STD
3PV733MFRAS-01	K747819STD	4PV744MFBAC-01	K734725STD	4PV744MFRAC-01	K750892STD
3PV733MFRAS-01	K747821STD	4PV744MFBAC-01	K734726STD	4PV744MFRAC-01	K750893STD
3PV733MFRAS-01	K747822STD	4PV744MFBAC-01	K734727STD	4PV744MFRAC-01	K750894STD
3PV733MFRAS-01	K747823STD	4PV744MFBAC-01	K734728STD	4PV744MFRAC-01	K750895STD
3PV733MFRAS-01	K747824STD	4PV744MFBAC-01	K734729STD	4PV744MFRAC-01	K750897STD
4PV744MFBAC-01	K731707STD	4PV744MFBAC-01	K742113STD	4PV744MFRAC-01	K753240STD
4PV744MFBAC-01	K731708STD	4PV744MFBAC-01	K742114STD	4PV744MFRAC-01	K753241STD
4PV744MFBAC-01	K731709STD	4PV744MFBAC-01	K742115STD	4PV744MFRAC-01	K753243STD
4PV744MFBAC-01	K731710STD	4PV744MFBAC-01	K742116STD	4PV744MFRAC-01	K753245STD
4PV744MFBAC-01	K731711STD	4PV744MFBAC-01	K742117STD	4PV744MFRAC-01	K753246STD
4PV744MFBAC-01	K731712STD	4PV744MFBAC-01	K742118STD	4PV744MFRAC-01	K753247STD
4PV744MFBAC-01	K731713STD	4PV744MFBAC-01	K742119STD	4PV744MFRAC-01	K753248STD
4PV744MFBAC-01	K731714STD	4PV744MFBAC-01	K742120STD	4PV744MFRAC-01	K753249STD

## DISASSEMBLY & REASSEMBLY OF GEAR OPERATED 3" & 4" LOW TORQUE PLUG VALVE ASSEMBLIES WITH 'GROP-DT36-BUSHING'

**Scope:** All 3" and 4" Plug Valve Assemblies with Gear Operators built between October 1<sup>st</sup>, 2018 and April 20<sup>th</sup>, 2019

### ⚠ WARNING

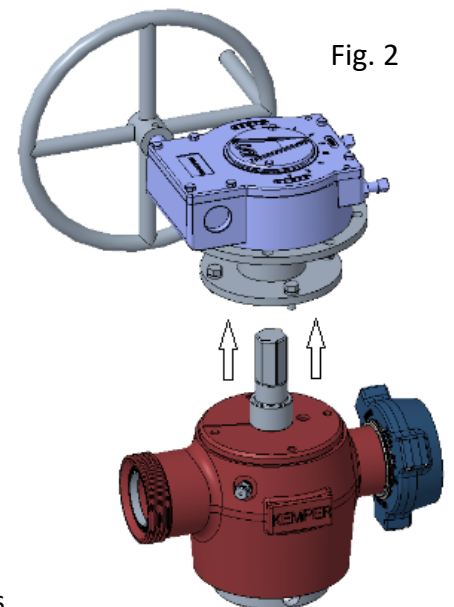
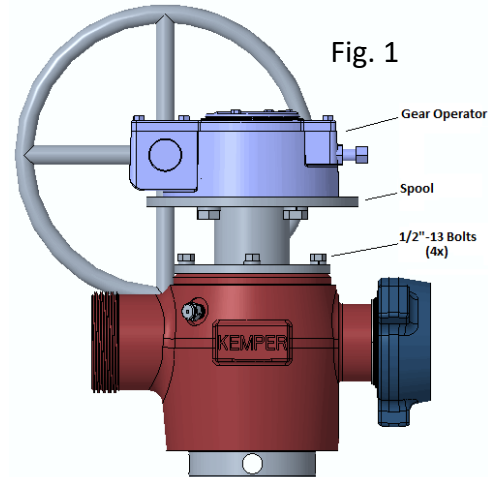
Never work on a high pressure component while it is in service. Always remove from service before beginning work. Fluid that is under pressure can penetrate body tissue. Fluid penetration can cause serious injury and possible death. If fluid is injected into skin tissue, get treatment immediately.

### ⚠ WARNING

Items weigh over 50lbs, team lift and appropriate lifting methods are necessary. Follow all site safety practices, including the appropriate personal protective equipment. Failure to follow site safety requirements can lead to injury or death.

## DISASSEMBLY PROCEDURE

1. Secure Gear Operated Plug Valve Assembly to suitable work station in the vertical position
  - Note Serial # of valve assembly and handwheel position
2. Open valve completely by rotating hand wheel counter-clockwise until wheel stop is contacted.
  - Visually verify that valve is open by looking through flow bore
3. Remove the four 1/2"-13 grade 8 bolts that attach Spool to Plug Valve Body (Fig. 1)
  - Do not remove bolts that attach gear operator to spool
  - Note orientation of handwheel to nut/female end for reassembly
4. With assistance lift Gear Op and Spool vertically 12" to disengage from Gear Box Drive Adapter (Fig. 2)
  - Set aside on clean surface



## REASSEMBLY PROCEDURE

1. Ensure Gear Box Drive Adapter is installed onto the Plug Hex End (Fig. 3)
  - 3" Valve shown, 4" slightly different
2. Install (by hand) GRO-P-DT36-BUSHING over hex end of Gear Box Drive Adapter (Fig. 4)
  - Bushing will be loose fitting, must bottom out on adapter as shown
3. Maintaining the same orientation as disassembly, re-install Gear Operator and Spool by lowering vertically onto Gear Box Drive Adapter (Fig. 5)
  - Do not rotate hand wheel
4. Apply high temperature anti-seize lubricant to bottom 3/4" of thread on 1/2"-13 bolts (4x)
  - Use LPS 04108 anti-seize lubricant or equivalent
5. Re-Install the 1/2"-13 (Grade 8) bolts (4x) that attach Spool to Plug Valve Body
  - Torque bolts to 75ft/lbs
6. Verify internal plug is not obstructing flow path
  - Look through male or female end
  - Contact Kemper Product Service with any concerns
7. Mark both serial band and name plate
  - Stamp an 'X' at the end of the serial # with low stress stamp
    - Identifies assembly as being reworked if questioned later
8. Update 'Master List' and Serial Number
  1. Email serial numbers of reworked valve assemblies to your Kemper Sales Rep and [product\\_support@kempervalue.com](mailto:product_support@kempervalue.com)

