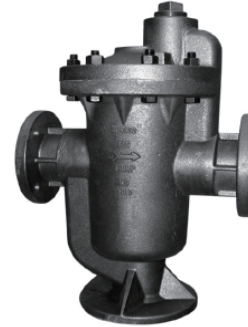
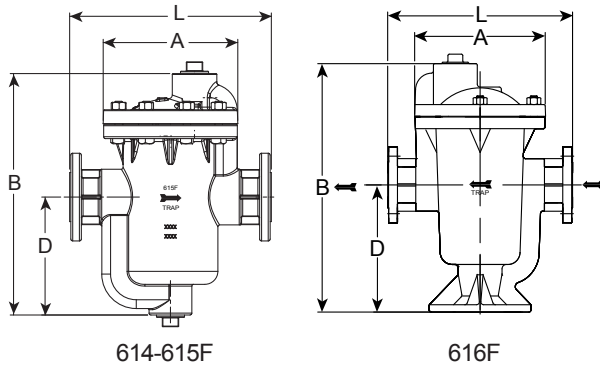


600F Series Inverted Bucket Steam Trap

Ductile Cast Iron for Horizontal Installation

For Pressures to 316 psig (21.8 bar)...Capacities to 20 000 lb/hr (9 072 kg/hr)



Description

The most reliable steam trap known—the inverted bucket—provides efficient condensate drainage of virtually all types of steam pipeline, tracing line and 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. It has an integral strainer to enhance the reliability of trap operation and prolong its service life.

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):

CL150 Flanged : 200 psig @ 400°F (13.7 bar @ 205°C)
 PN25 Flanged : 316 psig @ 482°F (21.8 bar @ 250°C)

Maximum operating pressure: 320 psig (21.8 bar)

Connections

Integral flanged

Materials

Body, cap: ASTM A395 GR.60-40-18
 Internals: All stainless steel-304
 Valve and seat: Hard chrome steel 17-4PH H900
 Screen: All stainless steel-304

Options

- Stainless steel internal check valve (add suffix CV)
- Thermic vent bucket (add suffix T)
- Large venting orifice (add suffix LV)
- Probe connection (add suffix BVSW)
- Drain plug (NPT connection, add suffix W/PLUG)

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

600F Series Dimensions and Weights						
Model No.	614F		615F		616F	
Pipe Connections	DN25	DN32	DN40	DN50	DN50	DN65
Test Plug	DN25		DN40		DN50	
A mm	203		229		292	
B mm	346		413		541	
C mm	198		205		279	
L mm	315	320	345	355	415	420
Number of Bolts	8		8		8	
Weight (kg)	22.5	23.9	33.1	36.5	66.4	67.7

Note: The flange is in accordance with HG20592 PN25 and ASME B16.5 CL150 standard.



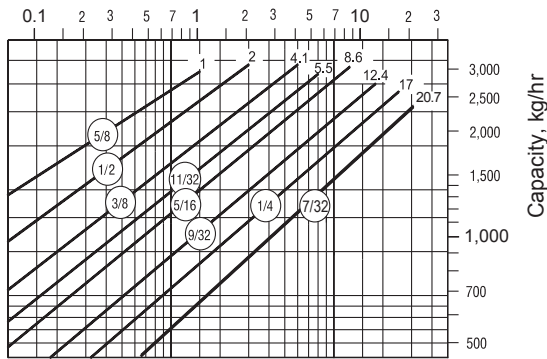
600F Series Inverted Bucket Steam Trap

Ductile Cast Iron for Horizontal Installation

For Pressures to 316 psig (21.8 bar)...Capacities to 20 000 lb/hr (9 072 kg/hr)

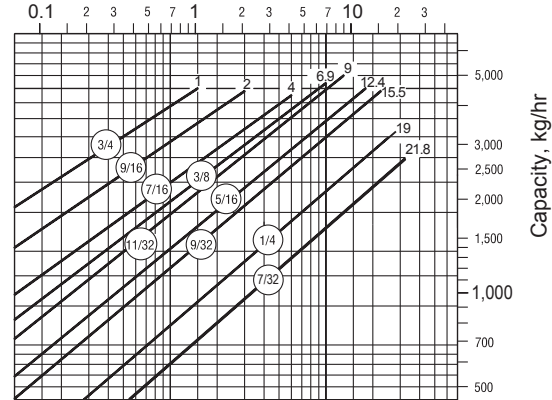
614F Capacity

Pressure, bar (1bar=0.1 MPa)



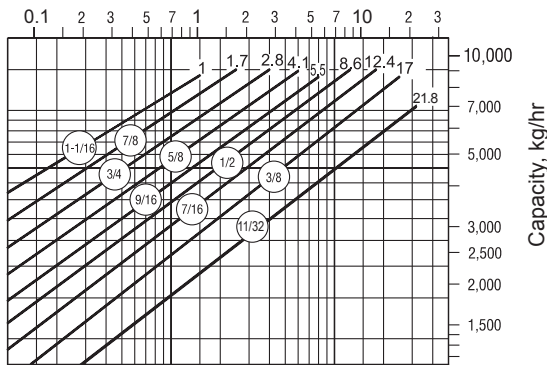
615F Capacity

Pressure, bar (1bar=0.1 MPa)



616F Capacity

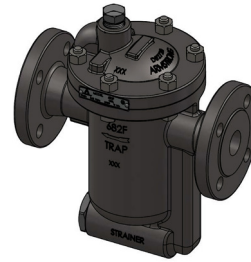
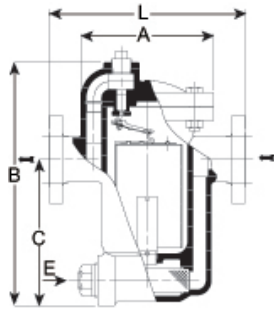
Pressure, bar (1bar=0.1 MPa)



680F Series Inverted Bucket Steam Trap

Ductile Cast Iron for Horizontal Installation, 681F-683F with Integral Strainer

For Pressures to 316 psig (21.8 bar)...Capacities to 4 400 lb/hr (2 000 kg/hr)



Description

The most reliable steam trap known—the inverted bucket—provides efficient condensate drainage of virtually all types of steam pipeline, tracing line and 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. It has an integral strainer to enhance the reliability of trap operation and prolong its service life.

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):

CL150 Flanged : 200 psig @ 400°F (13.7 bar @ 205°C)
 PN25 Flanged : 316 psig @ 482°F (21.8 bar @ 250°C)

Maximum operating pressure: 320 psig (21.8 bar)

Connections

Integral flanged

Materials

Body, cap: ASTM A395 GR.60-40-18

Internals: All stainless steel-304

Valve and seat: Hard chrome steel 17-4PH H900

Screen: All stainless steel-304

Options

- Stainless steel internal check valve (add suffix CV)
- Thermic vent bucket (add suffix T)
- Large venting orifice (add suffix LV)
- Probe connection (add suffix BVSU)
- Drain plug (NPT connection, add suffix W/PLUG)

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

680F Series Dimensions and Weights										
Model No.	681F			682F			683F			
Pipe Connections	DN15	DN20	DN25	DN15	DN20	DN25	DN20	DN25	DN32	DN40
Test Plug	DN6			DN15			DN20			
A mm	95.2			143			178			
B mm	179			244			314			
C mm	113			146			187			
E (Blow down)	3/8NPT			3/8NPT			1/2NPT			
L mm	150	150	160	230			260			
Number of Bolts	6			6			6			
Weight (kg)	4.1	4.3	5.3	8.4	8.9	9.3	15.2	15.4	17.1	17.4

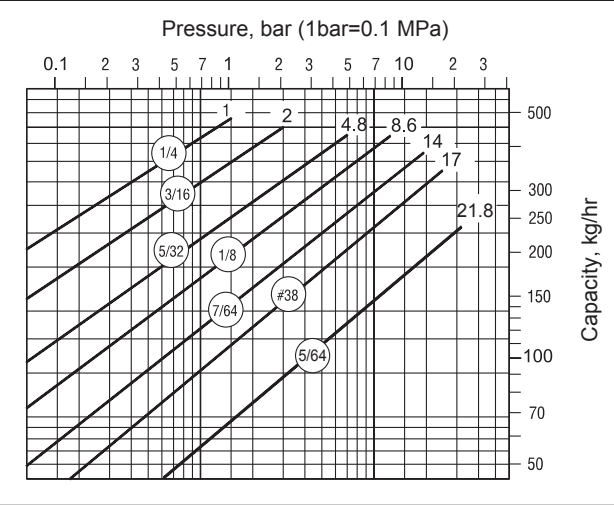
Note: The flange is in accordance with HG20592 PN25 and ASME B16.5 CL150 standard.



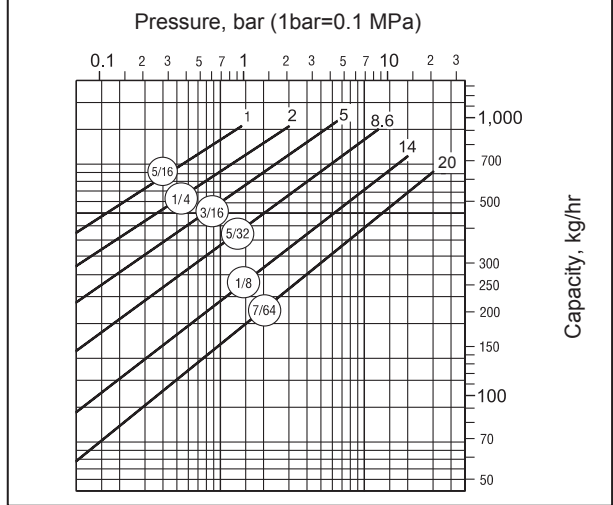
680F Series Inverted Bucket Steam Trap

Ductile Cast Iron for Horizontal Installation, 681F-683F with Integral Strainer
For Pressures to 316 psig (21.8 bar)...Capacities to 4 400 lb/hr (2 000 kg/hr)

681F Capacity



682F Capacity



683F Capacity

