

Serial number	Maintenance items	Process points	Quality requirements
1	Valve body inspection	<ol style="list-style-type: none"> 1. Remove dirt and remove insulation 2. Check the surface of the valve body for defects such as heavy skin, cracks and trachoma 	No heavy skin, cracks, sand holes on the surface of the valve body
2	Valve disintegration	<ol style="list-style-type: none"> 1. Make a record of cooperation before disassembly. 2. The valve is open when it is disassembled. 3. Pay attention to the disassembly order. 4. Do not damage parts. 5. Clean the removed bolts and parts. 6. Spectral review of internal parts of alloy steel valves 	<ol style="list-style-type: none"> 1. The bolts and parts should be intact. 2. The internal parts of the alloy steel valve are qualified by spectrum inspection.
3	Valve stem inspection and repair	<ol style="list-style-type: none"> 1. Clean up the dirt on the surface of the valve stem and check the defects of the valve stem. 2. Straighten or replace if necessary. 3. Carry out surface nitriding treatment as appropriate. 	<ol style="list-style-type: none"> 1. The curvature of the valve stem is not more than 1% of the total length of the valve stem, and the out-of-roundness is less than 0.05mm. 2. The valve stem should be smooth, free of pits, scratches and cracks. The uniform pitting depth of the contact part between the valve stem and the packing is not more than 0.3mm, and there is no defect in other parts. 3. The thread of the valve stem is intact and should be replaced when the wear exceeds 1/3 of the original thickness.
4	Inspection and repair of valve plate, valve seat and valve body	<ol style="list-style-type: none"> 1. Check the valve plate, valve seat and valve body for cracks, grooves and other defects. 2. Check the matching degree of the sealing surface with red powder, determine the repair process and grinding method according to the inspection situation. 3. Polish the joint surface of the valve body and the self-sealing gasket, and replace the detachable seat which cannot be repaired. 4. Check whether the joint surface of the valve seat and the valve body is firm. 	<ol style="list-style-type: none"> 1. The valve plate, valve seat and valve body are free of cracks and grooves. 2. The sealing surface should be straight, the roughness of the sealing surface should be less than 0.1μm, the radial anastomosis should not be less than 80%, and the circumferential contact of the sealing surface should be uniform without disconnection. 3. There are no foreign objects and other defects in the valve body. 4. The joint surface of the valve body and the self-sealing gasket is smooth without grooves. 5. The valve body and the valve seat are firmly combined without loosening.
5	Inspection and repair of valve cover	<ol style="list-style-type: none"> 1. Clean the stuffing box and polish the inner wall of the stuffing box, packing gland and seat ring. 2. Polish the joint surface of the valve cover and sealing washer. 	<ol style="list-style-type: none"> 1. The inner wall of the stuffing box, the gland of the stuffing box and the seat ring are smooth. 2. The joint surface of the valve cover and the sealing gasket is smooth and smooth.
6	Inspection and repair of bracket	<ol style="list-style-type: none"> 1. Clean the thrust bearing and check the bearing for wear. Corroded and broken. 2. Check the stem nut on the bracket. 3. Check the bracket for damage. 4. Polish the joint surface of the valve body. 	<ol style="list-style-type: none"> 1. The bearing quality meets the requirements, otherwise it must be replaced. 2. The stem nut is intact. 3. No damage to the bracket. 4. The joint surface of the valve body is smooth.
7	Repair of Sihe	<ol style="list-style-type: none"> 1. Polish the quadruple ring and 	<ol style="list-style-type: none"> 1. The quadruple ring and gasket are smooth and free of

	ring (Lihe ring), washer, washers, etc.	2. Check the material and hardness of the Sihe ring.	rust. The thickness of the quadruple ring is uniform, without damage or deformation. The gasket has no defects such as deformation and cracks. 2. The material and hardness of the quadruple ring meet the requirements.
8	Valve assembly	<ol style="list-style-type: none"> 1. When the valve is assembled, the valve should be in the open state. 2. Assemble in the order of cooperation. 3. Replenish lubricant. 4. Replace the packing. 5. Adjust the contact area between the gate and the valve seat. 6. Load the Sihe ring in order. 7. Tighten the connecting parts evenly. 8. Check the gap of each part 	<ol style="list-style-type: none"> 1. The center line of the valve plate should be higher than the center of the valve seat when the valve is closed. 2. The valve stem is firmly connected to the valve plate, and the valve stem is in good agreement. 3. The gap between the gasket and the valve body cover is 0.1-0.3mm. 4. The gap between valve stem and gland is 0.1-0.3mm. 5. The gap between filler and gland is 0.1-0.15mm. 6. The gap between valve stem and seat ring is 0.1-0.2mm. 7. The gap between the seat ring and the stuffing box is 0.1-0.15mm. 8. The accessories and signs are complete, and the valve body is well insulated.
9	Switch test	Proof of switch degree indication, check switch condition	The valve has no jamming and virtual stroke during the full stroke of the switch
10	Replace with a new valve	<ol style="list-style-type: none"> 1. Disassembly inspection and necessary spectral inspection of the valve 2. 100% flaw detection of the welded joint. 3. Water pressure test when necessary. 	<ol style="list-style-type: none"> 1. The components are intact, and the materials and gate valve quality meet the requirements. 2. Welding quality is qualified. 3. There is no leakage on the joint surface and sealing surface during the hydrostatic test.