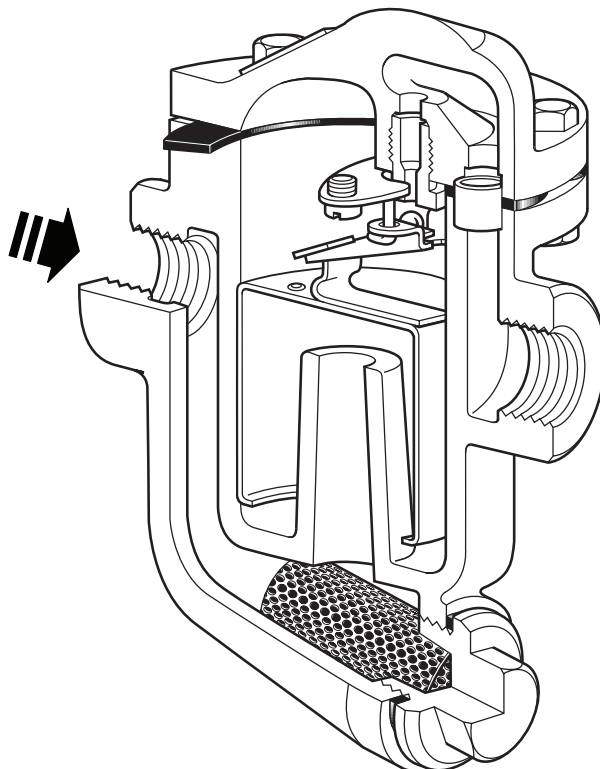


# spirax sarco

## HM Series Cast Iron Inverted Bucket Steam Traps



### Description

The Spirax Sarco HM Series of cast iron inverted bucket steam traps are designed for installation in horizontal pipework. They are available in screwed connections, with an optional blowdown valve.

### Sizes and pipe connections

½" - HM00, ¾" - HM10 and 1" - HM12  
Screwed BSP T Rp (ISO 7-1) or NPT

### Optional extras

**Integral blowdown valve:-** The HM Series inverted bucket steam traps can be supplied with integral blowdown valves to remove debris from the inlet strainer. For further details see the relevant Technical Information Sheet.

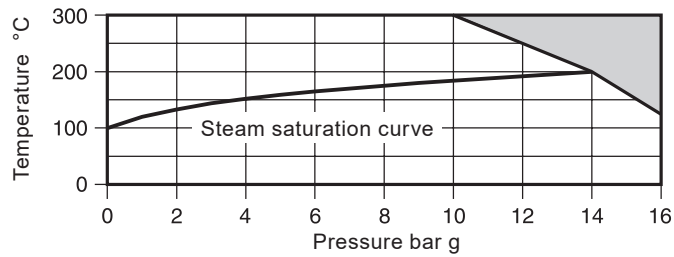
### External air vents

When required, HM Series inverted bucket steam traps can be supplied with separate thermostatic air vents to provide the efficient and quick release of air. Various models, both balanced pressure and bimetallic, are available. Details for the range up to 30 bar g are shown in the relevant sales brochure.

### Diffusers

Where steam traps discharge to atmosphere a diffuser should be fitted to reduce the effect of the blast discharge. The diffuser not only reduces the risk of groundwork erosion and condensate splashback, but also reduces sound pressure levels as well. Available models are detailed in the relevant sales brochure.

## Pressure/temperature limits



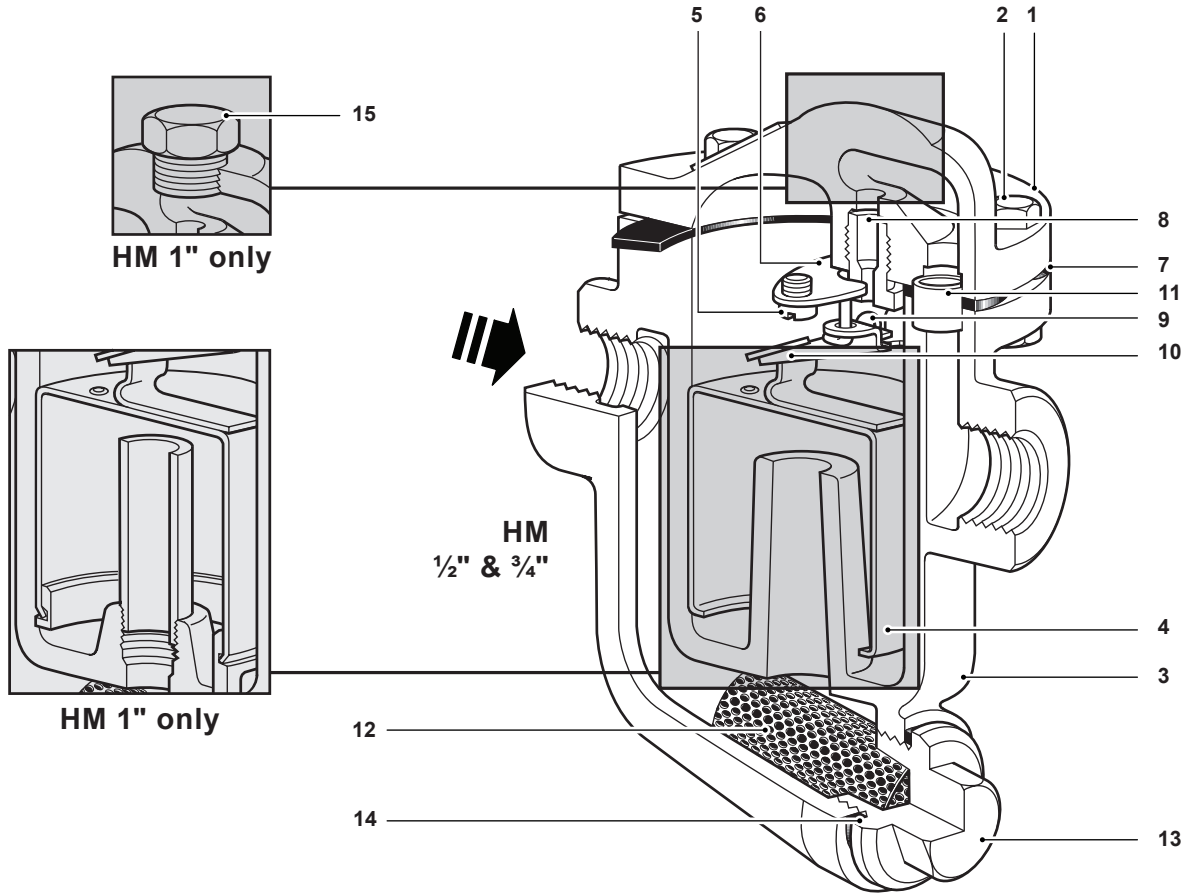
The product **must not** be used in this region.

Body design conditions	PN16
PMA Maximum allowable pressure	16 bar g
TMA Maximum allowable temperature	300 °C
PMO Maximum operating pressure	16 bar g
TMO Maximum operating temperature	300 °C
Designed for a maximum cold hydraulic test pressure of:	24 bar g

### ΔPMX - Maximum differential pressure

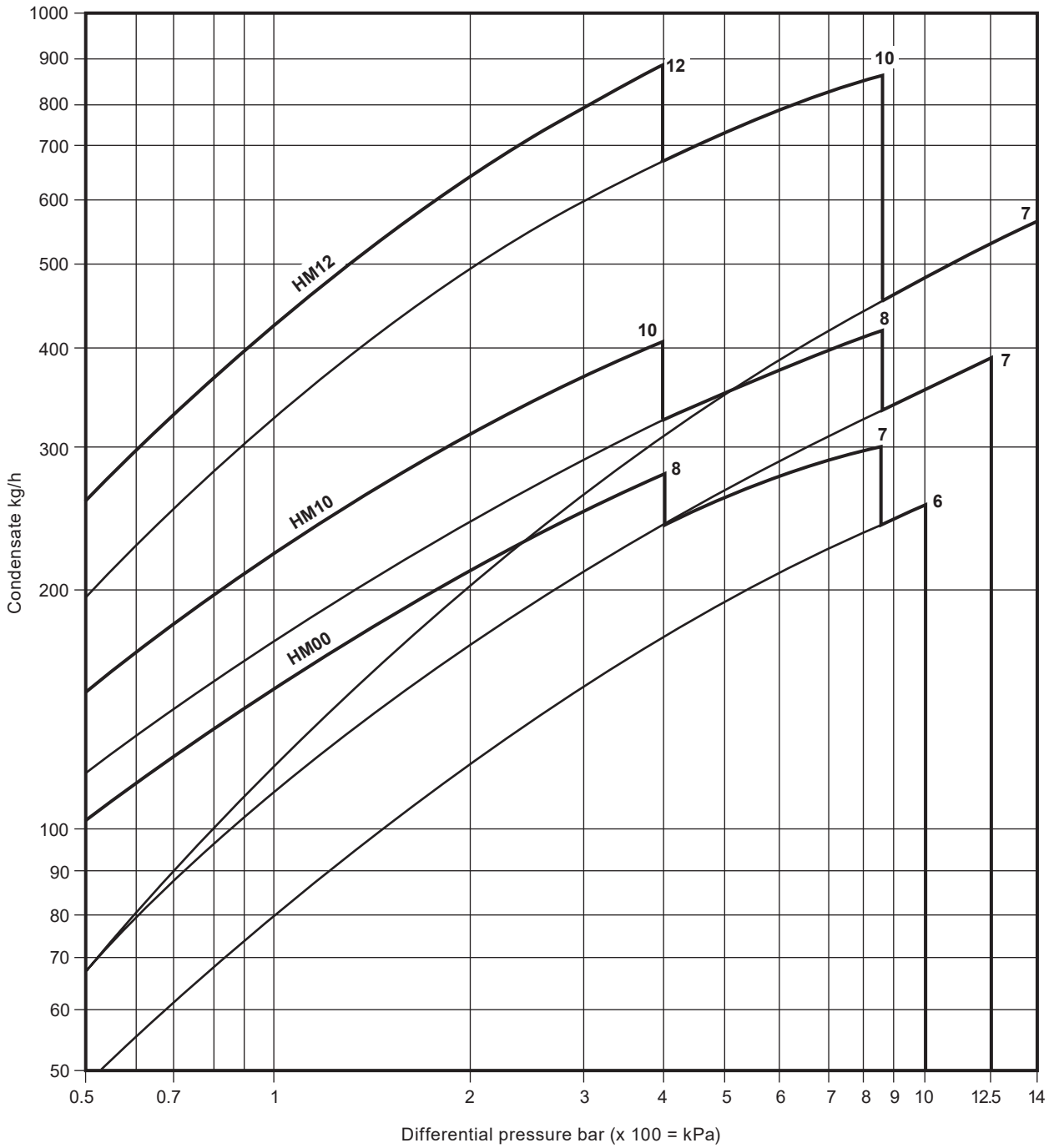
Size	ΔPMX - Maximum differential pressure bar					
	4	8.5	10	12.5	14	
Screwed	½"	HM00/8	HM00/7	HM00/6	-	-
	¾"	HM10/10	HM10/8	-	HM10/7	-
	1"	HM12/12	HM12/10	-	-	HM12/7

# Materials



No.	Part	Material	
1	Cover	Cast Iron	DIN 1691 GG 20
	Cover bolts	1/2", 3/4"	Steel BS 3692 Gr.10
	Cover nuts	1/2", 3/4"	Steel BS 3692 Gr.10.9
2	Cover bolts	1"	Steel BS 3692 Gr. 8.8
	Cover nuts	1"	Steel BS 692 Gr. 8
3	Body	Cast iron	DIN 1691 GG 20
4	Bucket	Stainless steel	BS 1449 304 S16
5	Valve guide plate screw	Stainless steel M4.5 x 10	BS 4183 18/8
6	Valve guide plate	Stainless steel	BS 1449 304 S11
7	Cover gasket	Reinforced exfoliated graphite	
8	Valve seat	Stainless steel	AISI 431
9	Valve	Stainless steel	AISI 440B
10	Valve lever	Stainless steel	BS 1449 321 S31
		HM00/10	Stainless steel BS 970 321 S31
11	Ferrule	HM12	Stainless steel BS 3605 (CFS) 304 S14
12	Strainer screen	HM00	Stainless steel ASTM A240 316L
		1/2" and 3/4"	SG iron DIN 1693 GGG 40
13	Strainer cap	1"	Cast iron DIN 1691 GG 25
14	Strainer gasket	Reinforced exfoliated graphite	
15	Plug	Stainless steel	BS 970 416-537

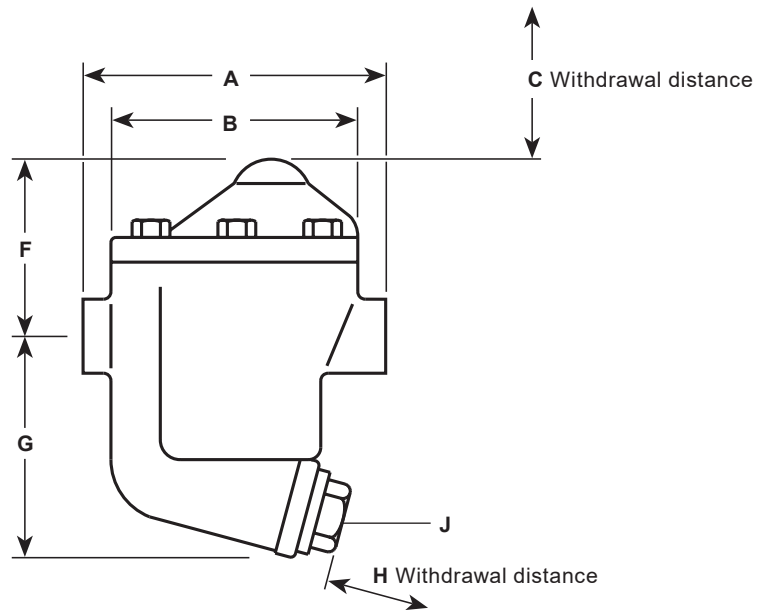
# Capacities



**Note: Traps should be selected for the most appropriate working pressure differential and not on the basis of load.**

## Dimensions/weights (approximate) in mm and kg

Size		A	B	C	F	G	H	J	Weight
DN15	1/2"	120	100	100	73.5	89	65	M28	2.6
DN20	3/4"	120	100	140	94.5	107	65	M28	3.2
DN25	1"	180	160	160	145.0	120	85	M32	8.8



## Safety information, installation and maintenance

For full safety information and installation and maintenance instructions see IM-S03-11.

## Disposal

This product is recyclable. No ecological hazard is anticipated with the disposal of this product, providing due care is taken.

## How to order

**Example:** 1 off Spirax Sarco 3/4" HM10/7 inverted bucket steam trap with screwed BSP T Rp (ISO 7-1) connections.

## Spare parts

The spare parts available are shown in heavy outline. Parts drawn in a grey line are not supplied as spares.

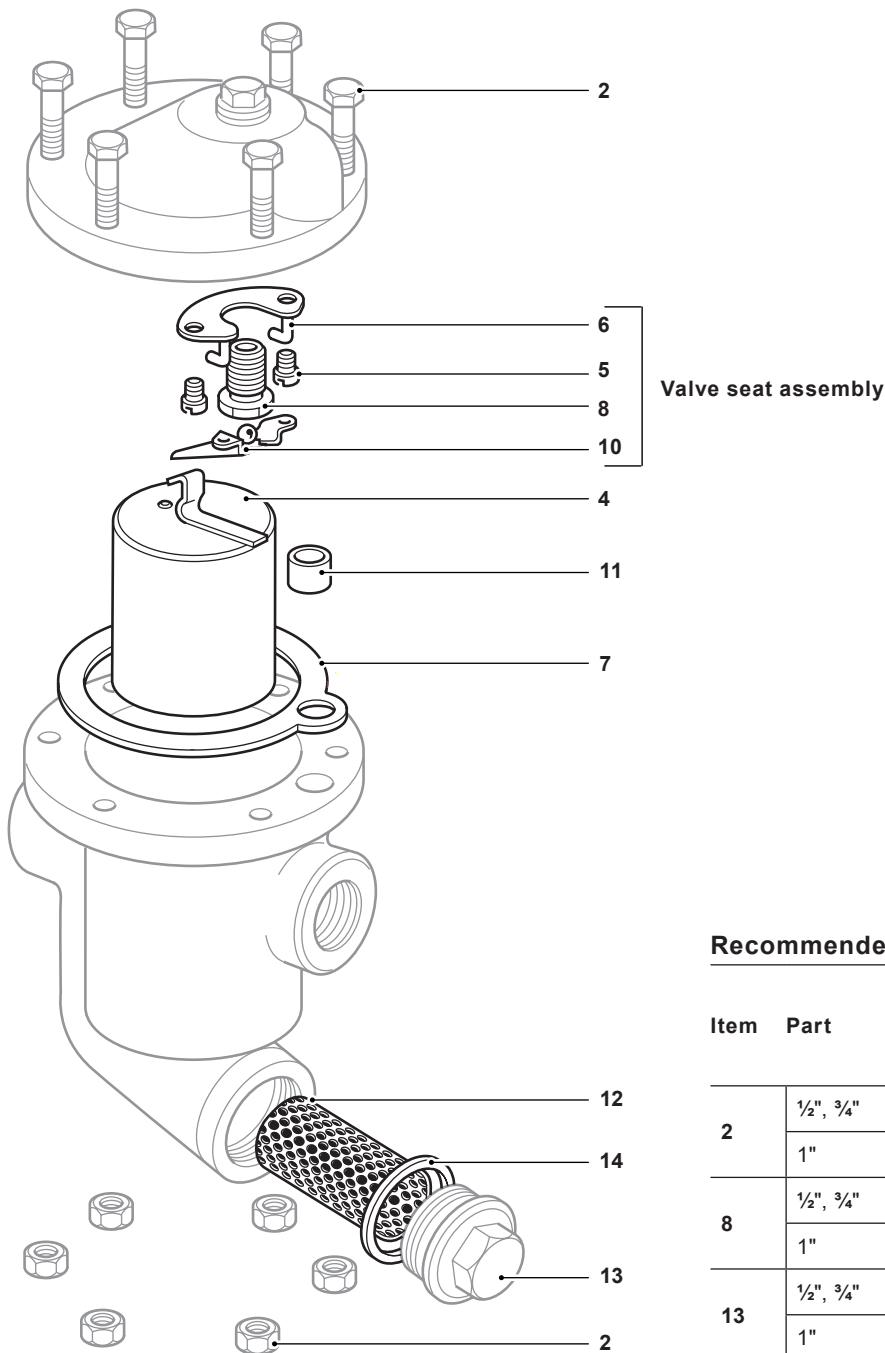
### Available spares

Valve and seat assembly	5 (2 off), 6, 8, 10
Bucket	4
Cover gasket and ferrule (packet of 3 each)	7, 11
Strainer screen	12
Strainer screen gasket (packet of 3 each)	14



### How to order spares

Always order spares by using the description given in the column headed 'Available spares' and state the size and series of the trap.

**Example:** 1 - Valve and seat assembly for a Spirax Sarco 1/2" HM00/7 inverted bucket steam trap.



### Recommended tightening torques

Item	Part	 or 	mm	N m
2	1/2", 3/4"		M6 x 25	15 - 16
	1"		M12 x 45	85 - 95
8	1/2", 3/4"	13		50 - 55
	1"	17		80 - 88
13	1/2", 3/4"	22	M28	50 - 55
	1"	27	M32	125 - 145