



M70i ISO

Forged Stainless Steel Ball Valve for Sanitary Applications

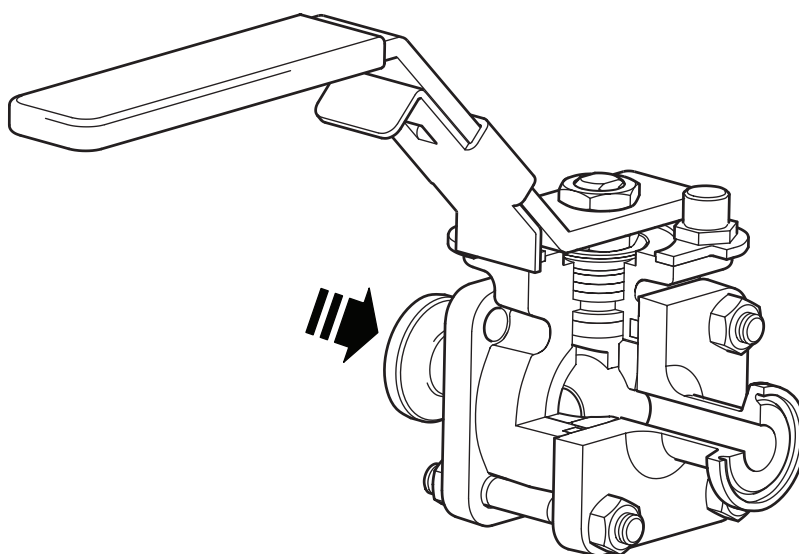
Description

The M70i forged 316L stainless steel, three-piece body ball valve has ISO mounting as standard. It has been designed and built in general accordance with ASME BPE for use on applications like liquid and gas utility and process support applications, such as clean steam*.

The M70i should be used as an isolation valve, not a control valve.

Principal features:

- **True port design** - The internal diameter of the end connections and ball precisely match that of the connecting tubing to guarantee drainability.
- **Forged material** - The M70i is manufactured from high integrity ASTM A182 F316L.
- **Low ferrite** - Body and end connections have 3% to 5% ferrite content to help prevent rouge.
- **Designed with orbital welding in mind** - Extended tube weld end connections means that automatic orbital welding can be performed without valve disassembly.
- **Designed for automation** - ISO 5211 mounting pad as standard enabling simple actuator mounting.
- **Lockable handle** - A spring loaded lockable handle allows the valve to be locked in the chosen position – ensuring system integrity.



Surface finish

Standard internal surface finish is 0.5 micron Ra (20 micro inch), ASME BPE SF1 compliant.

Electropolishing to 0.375 micron Ra (15 micro inch), ASME BPE SF4 compliant, is available to special order. External surface finishes are as forged/machined.

Available types

M70iV ISO	Virgin PTFE TFM 1600
M70iVEP ISO	Virgin PTFE TFM 1600 electropolished to 0.375 micron Ra
M70iG ISO	Mineral filled PTFE
M70iGEP ISO	Mineral filled PTFE electropolished to 0.375 micron Ra
M70iV CF ISO	Virgin PTFE TFM 1600, with Cavity Fillers
M70iVEP CF ISO	Virgin PTFE TFM 1600 electropolished to 0.375 micron Ra, with Cavity Fillers
M70iG CF ISO	Mineral filled PTFE, with Cavity Fillers
M70iGEP CF ISO	Mineral filled PTFE electropolished to 0.375 micron Ra, with Cavity Fillers

Optional extras:

- Extended stem 100 mm (4") to allow for insulation.
- Cavity fillers are not provided as standard and are not recommended for steam service. If cavity fillers are required please specify when placing an order.
- Low ferrite < 1% under special request.

Standards

This product fully complies with the requirements of the Pressure Equipment Directive (PED).

Certification

This product is available with the following certification:

- EN 10204 3.1 material certificates (body and caps)
- EN 10204 3.1 material certificates (wetted parts, seat and seals) subject to additional cost.
- Typical Internal surface finish certificates.
- Specific internal surface finish certificates available at point of order request, and may be subject to additional cost.
- Certificate of compliance for ADI free (seats and seals)
- TSE/BSE Free Statement.
- Declaration of compliance EC1935:2004 Food Contact Materials.

The seal part is Compliant with:

- FDA CFR Title 21. Paragraph 177. 1550.
- USP Class VI.
- ADI Free (Animal Derived Ingredients) for materials used, manufacturing processes involved in producing the part.

Note: All certification/inspection requirements must be stated at the time of order placement, and may be subject to additional cost.

Packaging

Each valve is end capped and sealed in a plastic bag to avoid the ingress of dirt and other contaminants.

Sizes and pipe connections

½", ¾", 1", 1½", 2" sanitary clamp (ASME BPE/BS 4825/DIN 32676-C).

½", ¾", 1", 1½", 2" extended O/D tube weld ends (ETO) (ASME BPE).

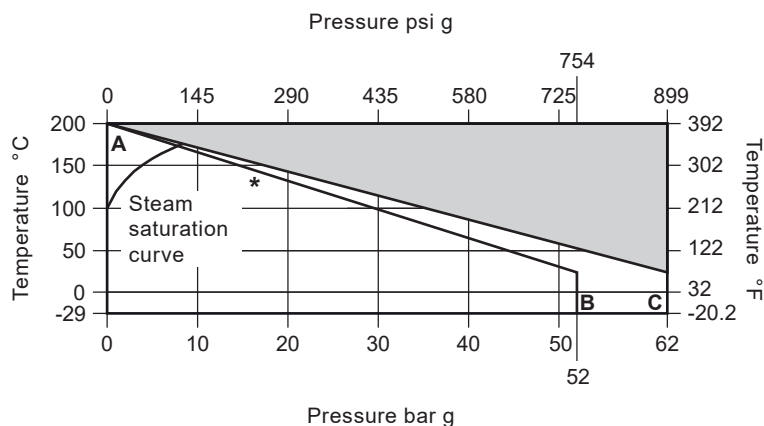
Sanitary clamp/ETO combinations are also available.

Alternatively: 2½", 3" and 4" investment cast sanitary ball valves are available through our M80i range - see TI-P172-01-EN-ISS1.

Note: Other connection options are available on request. Please consult Spirax Sarco.

***Steam Service:** For steam applications cavity filler is not recommended.

Pressure/temperature limits



* **Steam Service:** For steam applications cavity filler is not recommended.

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

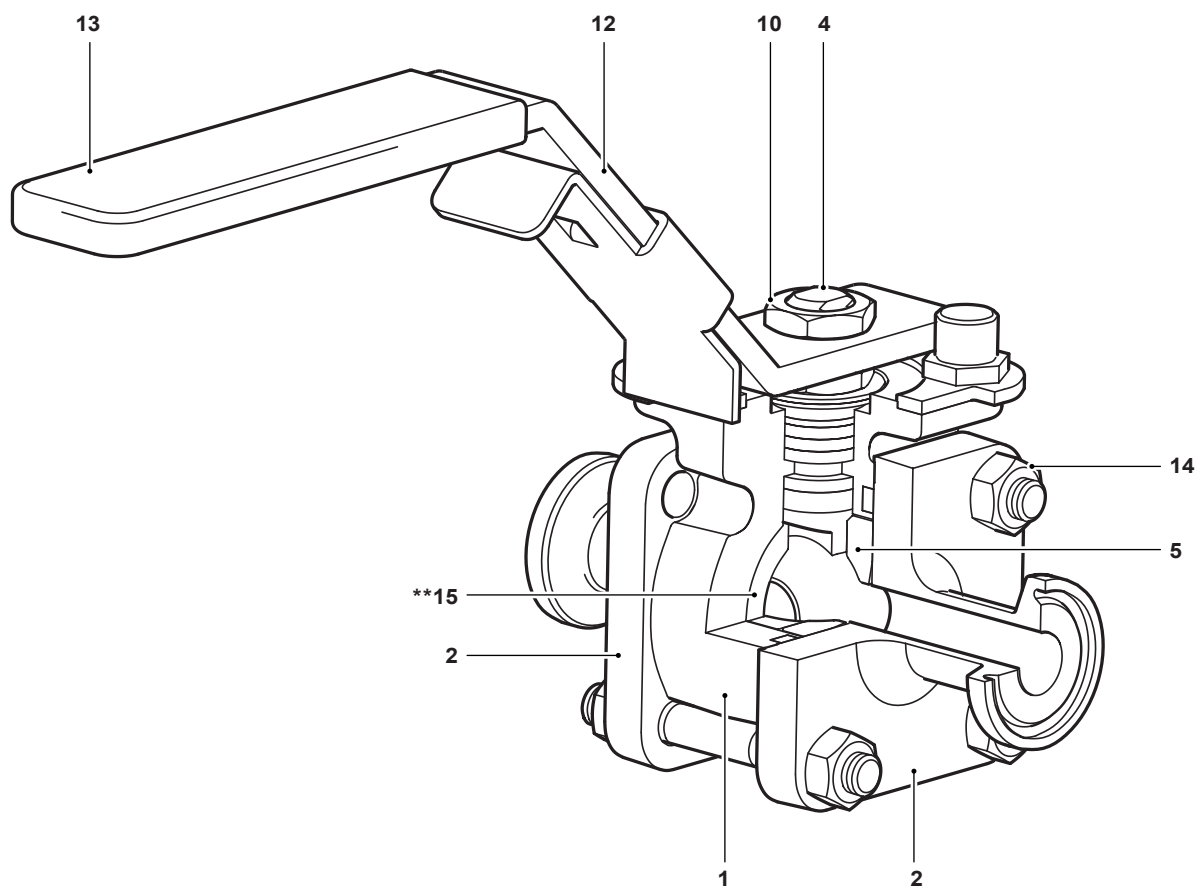
A - B Virgin PTFE TFM 1600.

A - C Mineral filled PTFE.

For valves with clamp connections, the maximum operating conditions could be limited by the type of clamp selected. For further information, consult Spirax Sarco.

Body design conditions		PN63	
PMA	Maximum allowable pressure	62 bar g @ 20 °C	899 psi g @ 68 °F
TMA	Maximum allowable temperature	200 °C @ 0 bar g	392 °F @ 0 psi g
Minimum allowable temperature		-29 °C	-20.2 °F
PMO	Maximum operating pressure for saturated steam service *	TFM 1600	7.0 bar g
		Mineral filled PTFE	8.5 bar g
TMO	Maximum operating temperature	200 °C @ 0 bar g	392 °F @ 0 psi g
Minimum operating temperature		-29 °C	-20.2 °F
Note: For lower operating temperatures consult Spirax Sarco			
Δ PMX Maximum differential pressure is limited to the PMO			
Designed for a maximum cold hydraulic test pressure of		93 bar g	1349 psi g

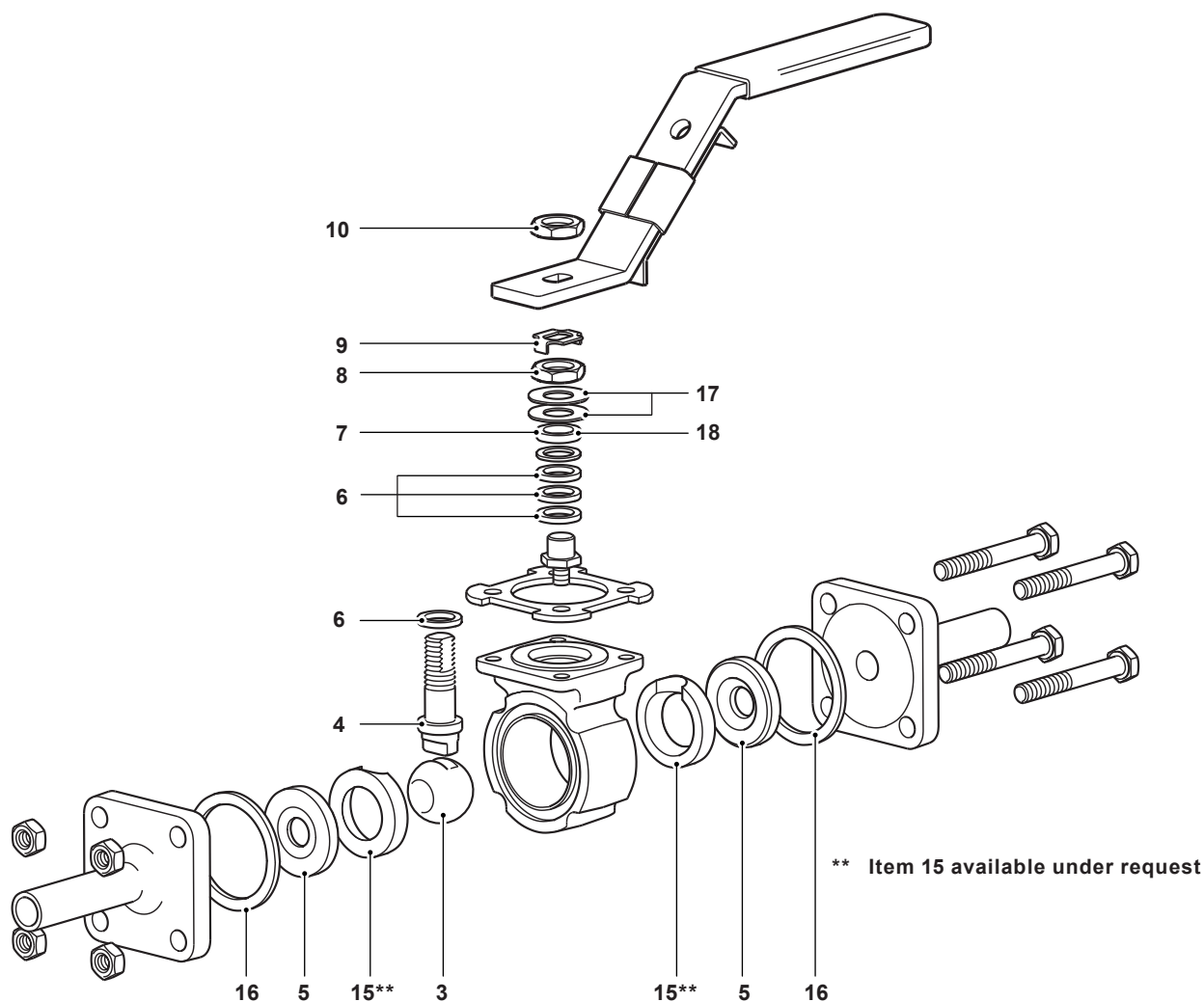
Materials



No.	Part	Material	
1	Body	Stainless steel	ASTM A 182 F 316L
2	End connection	Stainless steel	ASTM A 182 F 316L
11	Nameplate (not shown)	Stainless steel	AISI 430
12	Handle	Stainless steel	AISI 316
13	Cover	Vinyl	
14	Stud and nut	Stainless steel	AISI 316

Materials - exploded internals

The internals have been exploded below to help identify the position of some of the parts in the materials list.



No.	Part	Material
3	Ball	Stainless steel AISI 316L
4	Stem	Stainless steel AISI 316L
5	Seat	M70iG Mineral filled PTFE
		M70iV Virgin PTFE TFM 1600
6	Stem seal	Virgin PTFE TFM 1600
7	Spacer	Stainless steel AISI 316
8	Compression nut	Stainless steel AISI 316
9	Lock washer	Stainless steel AISI 316
10	Stem nut	Stainless steel AISI 316
15	Cavity filler (on request)	Virgin PTFE TFM 1600
16	Body cap gasket	Virgin PTFE TFM 1600
17	Belleville washer	Stainless steel AISI 316
18	Stem seal	Stainless steel

Technical data

Leakage test procedure to ISO 5208 (Rate A)/EN 12266-1 (Rate A)

Stem seal and seat	Materials comply with:	- FDA CFR title 21 part 177, section 1550. - USP23 Class VI
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Flow characteristic	Modified linear
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Port	True port design
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Kv values

Size	½"	¾"	1"	1½"	2"
Kv	7	25	56	164	360

For conversion

$C_v \text{ (UK)} = K_v \times 0.963$

$C_v \text{ (US)} = K_v \times 1.156$

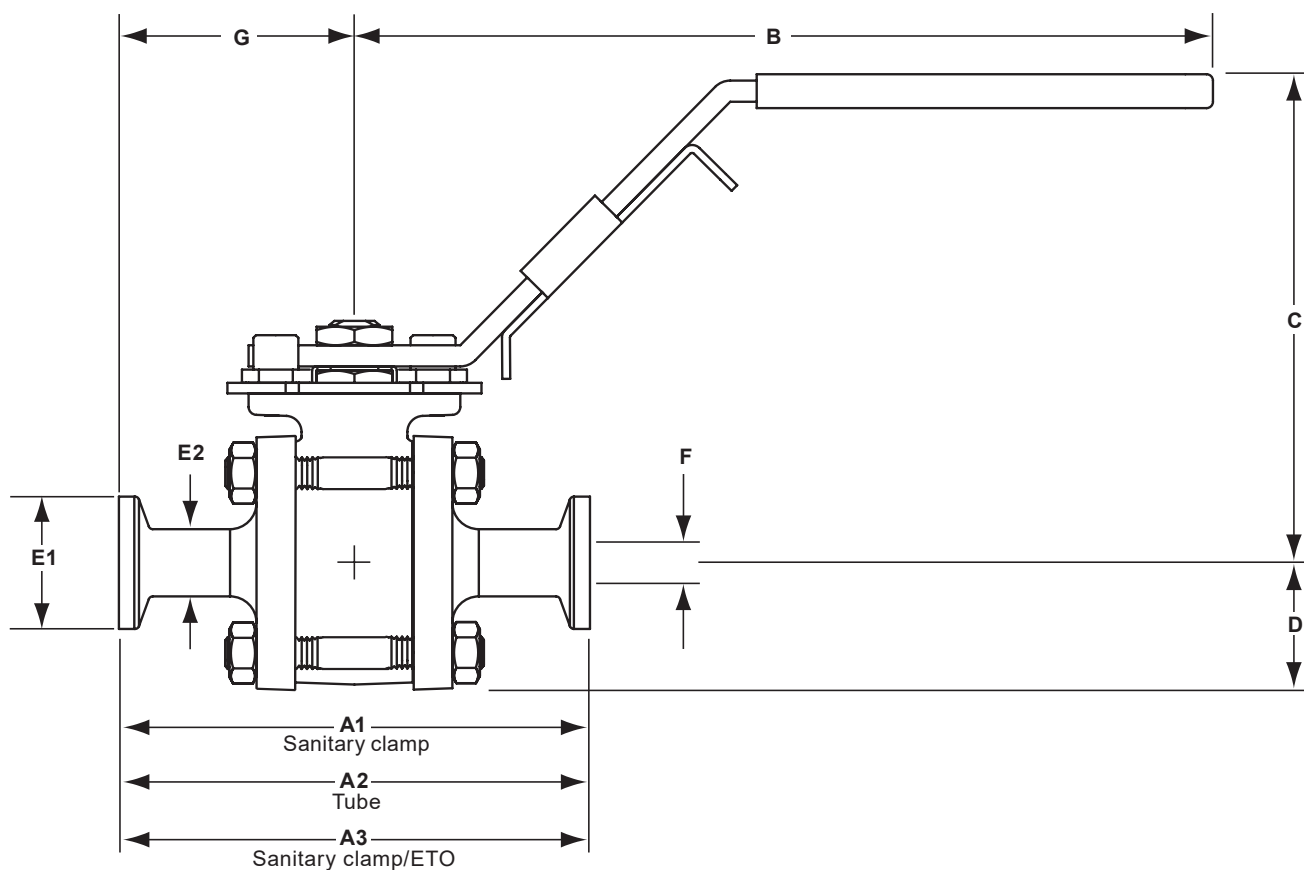
Torque value

Size	½"	¾"	1"	1½"	2"
N m (lbf ft)	13 (10)	15 (11)	19 (14)	70 (52)	100 (74)

The torque figures shown are for a valve at maximum operating pressure that is operated frequently.

Valves that are subject to long static periods, may require greater break-out torque.

Dimensions/weights (approximate) in mm (inches) and kg (lbs)



Size	A1	A2	A3	B	C	D	E1	E2	F	G (Clamp)	G (ETO)	Weight
1/2"	89.0 (3.50)	140.0 (5.51)	114.5 (4.51)	161 (6.34)	92 (3.62)	24 (0.94)	25.0 (0.98)	12.70 (0.50)	9.4 (0.37)	44.5 (1.75)	70.0 (2.76)	0.80 (1.76)
3/4"	101.6 (4.00)	152.4 (6.00)	127.0 (5.00)		94 (3.70)	26 (1.02)		19.05 (0.75)	15.8 (0.62)	50.8 (2.00)	76.2 (3.00)	1.00 (2.20)
1"	114.2 (4.50)	165.0 (6.50)	139.6 (5.50)	185 (7.28)	101 (3.98)	31 (1.22)	50.5 (1.99)	25.40 (1.00)	22.2 (0.87)	57.1 (2.25)	82.5 (3.25)	1.55 (3.42)
1 1/2"	139.6 (5.50)	190.4 (7.50)	165.0 (6.50)		126 (4.96)	48 (1.89)		38.10 (1.50)	34.8 (1.37)	69.8 (2.75)	95.2 (3.75)	4.50 (9.92)
2"	158.7 (6.25)	203.1 (8.00)	180.9 (7.12)	250 (9.84)	141 (5.55)	57 (2.24)	64.0 (2.52)	50.80 (2.00)	47.5 (1.87)	79.4 (3.13)	101.6 (4.00)	7.70 (17.0)

Safety information, installation and maintenance

For full details see the Installation and Maintenance Instructions supplied with the product.

Welding

Only the models that have connections designed for welding (ETO) should be welded. Valves with clamp connections must not be welded to avoid damage to soft parts.

How to order

The M70i has a number of features that must be specified at the time of order placement; they are size, end connection, seat material, internal surface finish, and any certification that is required.

Note: Cavity fillers are not provided as standard. If cavity fillers are required please specify so at the time of order placement.

Example: 1 off Spirax Sarco ½" M70iV ISO forged sanitary ball valve complete with sanitary clamp connections (ASME BPE) and an internal surface finish of 0.5 micron Ra (20 micro inch).

The unit is to be supplied complete with EN 10204 3.1 material certification.

Spare parts

The spare parts available are shown in solid outline.

Parts drawn in a grey line are not supplied as spares.

Available spares

Seat and seal set	5, 6, 16, 18
Seat and seal set with cavity filler	5, 6, 15, 16, 18

How to order spares

Always order spares by using the description given in the column headed 'Available spares' and state the size and type of ball valve.

Example: 1 - Virgin PTFE TFM 1600 seat and seal set with cavity filler for a Spirax Sarco ½" M70iV ISO forged stainless steel ball valve.

