

Global Standard	<b>LESER Global Standard</b> Final visual inspection of repaired valves	LGS 4117
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### 1 Purpose

This LESER Global Standard (LGS) provides instruction on the visual final inspection of LESER safety valves. The required work steps and materials are described.

### 2 Scope

This document must be observed in the visual final inspection of safety valves in agencies and subsidiaries of LESER GmbH & Co. KG.

### 3 Disclaimer

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## 4 Qualified fitting personnel

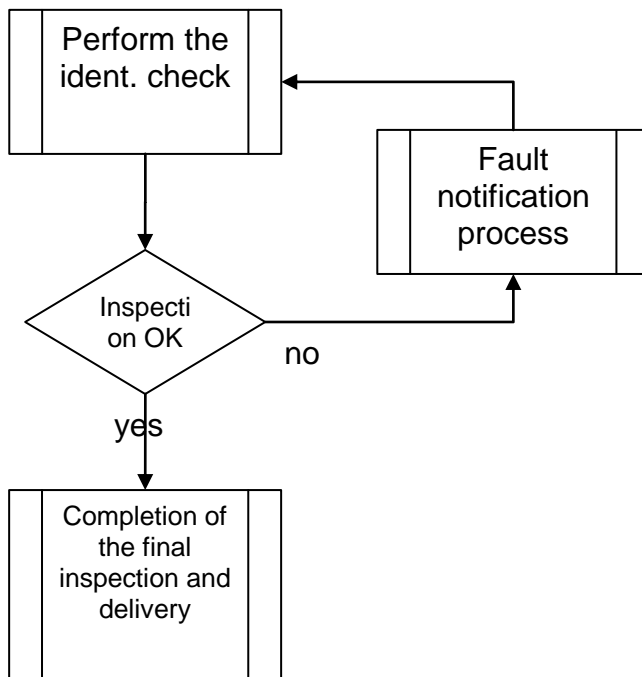
The visual final inspection of LESER safety valves may only be performed by trained or qualified fitters. The qualifications must be obtained through the appropriate training measures.

## 5 General Information



- Gloves must be worn during the final inspection of oil and grease-free safety valves.

## 6 Flow chart for the visual inspection (final inspection)



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Figure 6-1

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## 7 Performing the final inspection

### 7.1 General inspections

a) Compare the content of the valve inspection plan or repair order to the valve model.

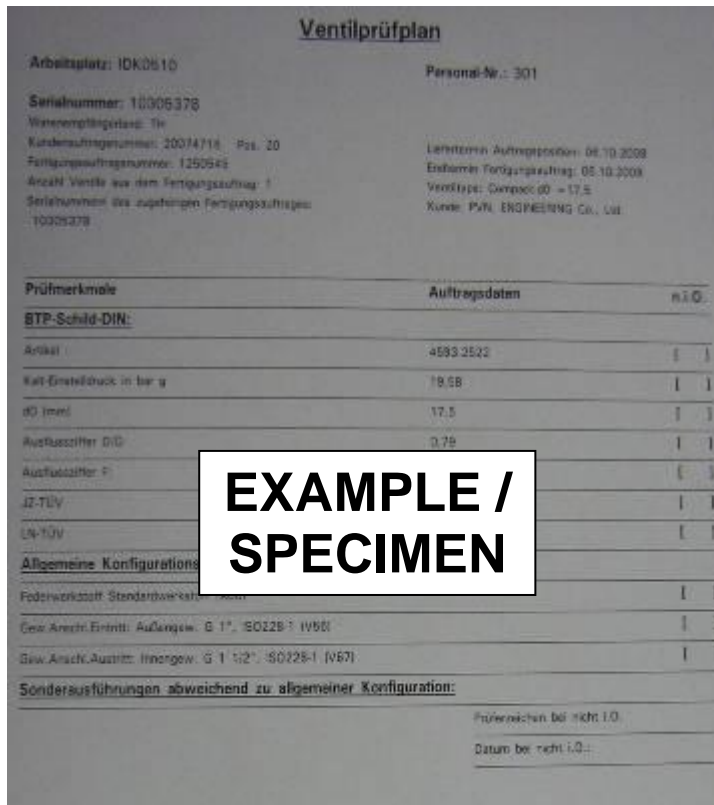


Figure 7.1-1

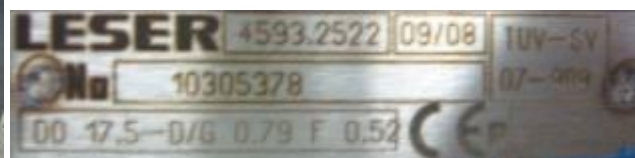


Figure 7.1-2: Check the type number against the valve inspection plan / repair order

Figure 7.1-3: Check the BT plate / customer ID plate data against the valve inspection plan / repair order


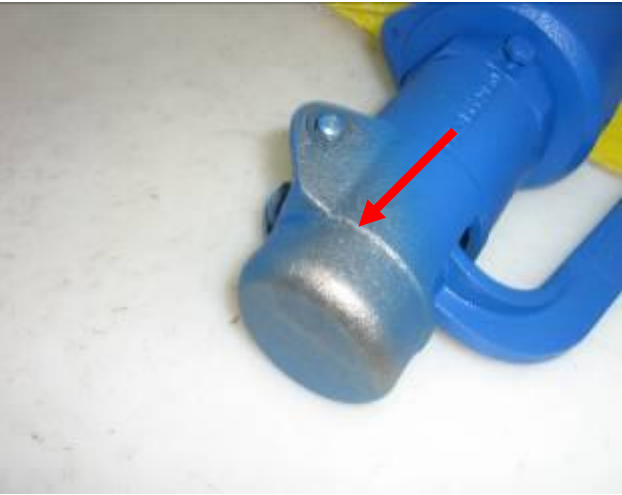
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## 7.2 Visual inspection of other items

### 7.2.1 Inspection of the paintwork

#### a) Valve is not completely painted

OK specimen:	Rejected specimen:
 <p data-bbox="188 1137 359 1171">Figure 7.2.1-1</p>	 <p data-bbox="817 1167 989 1200">Figure 7.2.1-2</p>



#### b) Paint coat is cracked (too much paint)

OK specimen:	Rejected specimen:
 <p data-bbox="188 1747 359 1780">Figure 7.2.1-3</p>	 <p data-bbox="817 1780 989 1814">Figure 7.2.1-4</p>



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c) Paint coat is not complete due to oil / grease

OK specimen:	Rejected specimen:
	
<p>Figure 7.2.1-5</p>	<p>Figure 7.2.1-6</p>

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OK specimen:	Rejected specimen:
	
<p>Figure 7.2.1-7</p>	


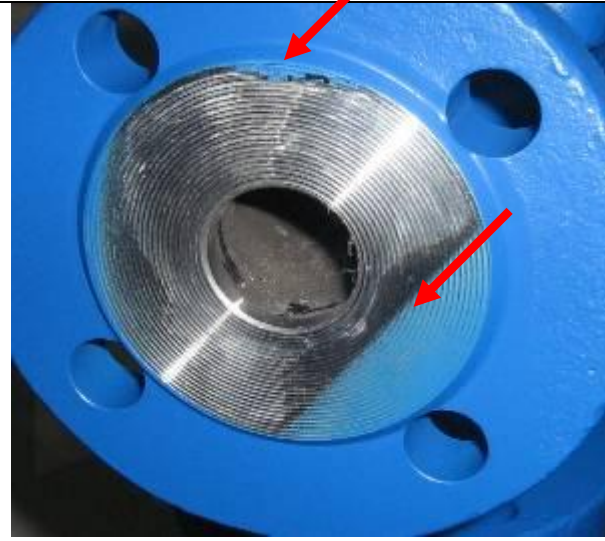
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Figure 7.2.1-8

d) Paint on masked off areas

<p><b>OK specimen:</b></p>  <p>Figure 7.2.1-9</p>	<p><b>Rejected specimen:</b></p>  <p>Figure 7.2.1-10</p>
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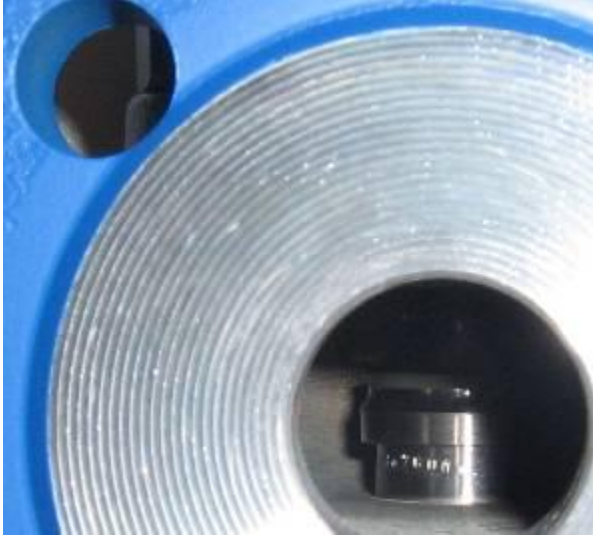
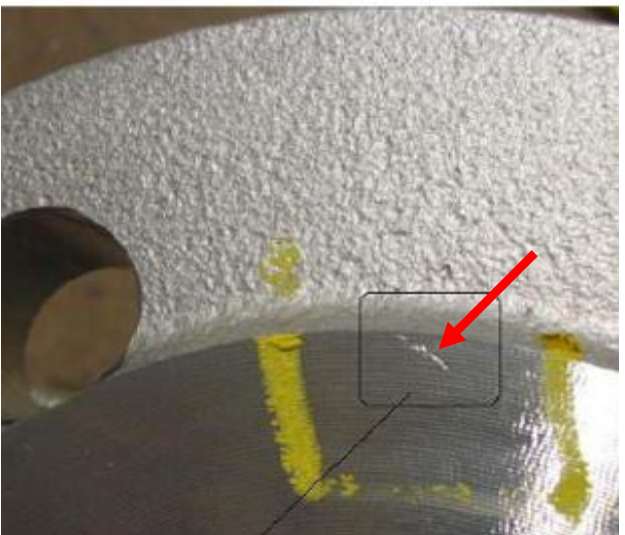
<p><b>OK specimen:</b></p>  <p>Figure 7.2.1-11</p>	<p><b>Rejected specimen:</b></p>  <p>Figure 7.2.1-12</p>
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Reason: The legibility of the plate is not guaranteed.

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## 7.2.2 Inspection of the sealing surfaces

<b>OK specimen:</b>	<b>Rejected specimen:</b>
	
<p><b>Figure 7.2.2-1</b></p>	<p><b>Figure 7.2.2-2</b></p>

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## 7.2.3 Inspection of the seal

<b>OK specimen:</b>	<b>Rejected specimen:</b>
	<p>Seal is missing for sealed valves, or it is not crimped.</p>
<p><b>Figure 7.2.3-1</b></p>	

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If the result of the inspection is okay, then the safety valve is sent for packaging and shipment.

### 7.3 Fault notification process

- If the result of the inspection is not okay, then the fitting is sent to the fault notification process that is to be determined.
- The final inspection is performed again after completion of the fault notification process.

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