BVAA

ISSUE THREE

VALVEuser

ANNUAL REVIEW IN CENTRE SECTION!

Revolutionary Control Valve

Sizing Safety Valves

Protective Coatings

British Valve & Actuator Association

Rotork 50th

Delivering More

Emerson ROC800

Making Waves

■ New Product Announcements ■ Application Stories ■ Company Profiles ■ Industry News

New ideas take flight

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Big issue – bigger issues!

by BVAA Director, Rob Bartlett

Welcome to Issue 3 of BVAA's Valve User magazine, which we believe to be our industry's fastest growing journal. We are providing our readers with a double publication this issue, as we have included, in the centre section, the latest copy of the very popular BVAA Annual Review. This document charts a year in the life of BVAA, and includes reports from the BVAA Chairman and Director, plus of course progress reports from all of the very active BVAA Working Groups. There are also reports upon the highlights of the past 12 months. I very much hope that you enjoy this bonus issue.

Valve User – everyone's reading it...

And while on the subject of 'issues', as I write, the UK press is alive with rather alarming stories regarding the counterfeiting of drugs, and, bigger still, the massive recall of childrens' toys which have been manufactured in the Far East. It is the sadly familiar tale of the discovery of the use of cheap, banned and very toxic lead paint, inclusion of highly dangerous magnets and – worryingly - forged test and compliance certification. The latter is a big concern in our industry too, and through VU and other journals I have urged Valve Users to be cautious, particularly when dealing with new or relatively unknown vendors of process flow equipment, which as we know are often used in critical applications. The introduction of potentially dangerous, and at best 'unproven' products, into already potentially hazardous environments, is one risk too many.

Rotork IQ90 valve actuators at Ningbo Beilun Port

These were just some of the over 200 latest generation IQ valve actuators installed at one of China's biggest ports, Ningbo Beilun. Situated on the east coast of China, Ningbo Beilun is approximately 300 kilometres from Shanghai.

The actuators are installed at a new plant at the Da Xie Tank Farm, operated by the China Sinopec Oil Storage company. Over 170 of the actuators are equipped with Pakscan 2-wire control systems to operate parallel gate valves, whilst the remainder, together with AQ actuators, are controlling butterfly valves in the water treatment plant.

Did You Know?

As well a printed copy, VALVE user magazine is also available as an email attachment, and as a download from BVAA's website, www.bvaa.org.uk

BVAA 'Mad Hatters' "How far can you go wearing a BVAA hat?"

No mysteries this time, as our young wearer is Sebastian Heap, son of Leeds Valve MD, Steven Heap, who reports later in this issue on his recent visit to OTC in Houston, Texas.

This issue's competition therefore concerns the car – there is a £50 donation to charity if you can identify the beast! There might be a bonus if you can identify the year of manufacture since this is important to enthusiasts of this particular model. Answers to rob@bvaa.org.uk.

Our congratulations to Lesley Shepherd of Wood Group Pressure Control Ltd, for correctly identifying that in Valve User 2, Alex Simmons was photographed in Antigua. £50 has been donated to the SPCA – well done Lesley!

Would you also like to participate in 'Mad Hatters'? Just send us a request for a hat and tell us where you are going.

Fisher® Certifies ESI

Emerson Process Management has certified ESI Technologies as the approved repairer of Fisher products for workshop-based repairs in Ireland. ESI Technologies has its headquarters in Dunkettle, Co. Cork, and is strategically located to service the successful and rapidly expanding pharmaceutical industry. ESI was established in the early 1900's and is now one of Ireland's leading valve repair specialists.

Only companies that meet the highest technical, quality and business standards are appointed as approved repairers of Fisher products for workshop-based repairs, and each company is subject to a stringent vetting process and quality audit. As part of the scheme, technical personnel from ESI have completed specialised Fisher valve maintenance training and all repairs will be completed to factory specifications using only genuine Fisher parts.

As an approved repairer, engineers from ESI have access to original Fisher factory specifications, maintenance instructions and service reference manuals, ensuring that repairs are completed to the highest standards. ESI is accredited to ISO 9001.

Commenting on the appointment, Roger Henbest, Emerson UK Service Operations Manager for the approved repairers said, *"ESI is a well established specialist valve repair organisation with an outstanding reputation for quality and service. With the added benefit of excellent local contacts and extensive product knowledge, ESI is the ideal organisation to be appointed as the Approved Repairer of Fisher Products for Workshop-based Repairs for Ireland."*

Declan Field, Operations Director for ESI added, *"ESI is delighted by this appointment. Our dedicated team is committed to customer satisfaction and we will continue to use our all our resources to satisfy our customer's needs in the most effective way, by applying quality products, solutions and service."*

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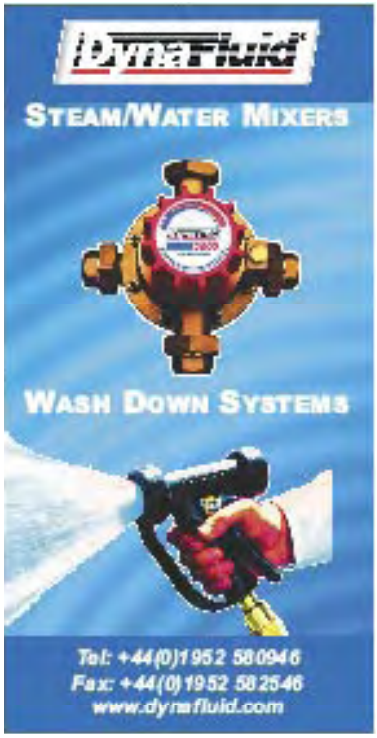
Fisher valves are repaired to original specifications by ESI using genuine Fisher parts

Emerson will continue to provide on-site valve services, including control valve diagnostic testing and data analysis. These are part of Emerson's extensive PlantWeb® services offering, enabling customers to maximise the benefits they get from their investment in process and control assets.



Valve User is your magazine, and we welcome your views on your industry and its practices. Here Mark Dowell, Business Manager of SGS United Kingdom Ltd., a BVAA member and a certification body, gives his views on validating certification.

The Importance of Checking

When you buy a piece of equipment, do you check the validity of the original certificate of compliance?

PED
ASME
NIC/EIC
CE conformity
Machinery Directive
ISO 9000
And many more.

We are all used to seeing the above names and the declarations, but if you need to use or resell the goods, or to provide original certificates, how do you know the certificate or declaration is genuine and the conformance up to specification?

The manufacturing of the goods or components should have been checked by an accredited organisation, but it is becoming obvious that in the name of a quick profit some non traditional suppliers are prepared to create a forged certificate for that compliance. Using Photoshop type software, it is possible to create a pretty good forgery.

The certification companies go to enormous lengths to prevent forgery and, when reported, the origin of fakes is hunted down and prosecutions follow. However this does not help you if you have bought and paid for a component that you then cannot legally use.

Some advice would be to keep copies of all original certification and compare any new certificates with existing, because it is the differences that will give you the clue as to if it is a fake. Also, always check out conformity when using a new supplier.

Do spot checks periodically.

The certification bodies provide hotlines, both e-mail and telephone, where you can check validity of Certificates of Conformance and they are always more than willing to help you confirm that validity. The details are always on the company websites.

There have been a lot of press articles recently about fake certification of Toys and consumer goods manufactured in China and the costs to the companies who have been duped by these unscrupulous manufacturers has been enormous. The goods are un-saleable and reputations tarnished.

Don't be caught; please contact the certification bodies with the question **"IS MY CONFORMITY CERTIFCATION FOR THIS PRODUCT GENUINE"**

Mark Dowell, Business Manager SGS United Kingdom Ltd.

Heaps supply Ball Valves to ASME III + Seismic Qualification

Heap & Partners, in partnership with fellow BVAA members LG Ball Valves, have recently completed a contract for the supply of 80 ball valves certified to ASME III Class 1 and 2. As the valves were destined for installation at two UK-based nuclear power plants, seismic qualification was an additional special requirement.

The constraints of a contract of this nature, not only in respect of product design and qualification but in the associated stringent documentation requirements would be problematic for the majority of valve manufacturers who prefer to make standard, volume product.

However, having worked closely with a number of nuclear power plants over the past 30 years, Heap & Partners has gained an extensive knowledge and awareness of the industry's supply criteria. This, coupled with their proven expertise in project management and in the preparation of complex lifetime documentation packages, complimented LG's ability to supply non-standard valves in small quantities and on short lead times, enabling Heap & Partners and LG to jointly design, qualify, manufacture, test and deliver within 20 working weeks from receipt of order, despite many delay points at critical stages in the programme.

The valves supplied were 0.5", 1.5" and 3.0" Class 600 top entry design with butt weld end connections. All incorporated a number of special features including leak detection connections, double stem sealing and double gaskets.

100% non-destructive testing and BS EN 10204 3.1 material certification was required for all components, not just pressure containing parts, with witnessed inspection at many of the manufacturing stages.

After initial build, all valves were tested to 65 bar, after which the Class 1 valves were stripped and non-destructive examination repeated. Similar specifications are available from Class 150 through to Class 2500 and in a size range from 15mm to 300mm.

Heap & Partners,
Tel: 0151 632 3393

LG Ball Valves,
Tel: 01922 459999

Metso's revolutionary new control valve

Neles® RotaryGlobe control valve

Metso Automation have launched the new Neles® RotaryGlobe control valve, which combines the best features of proven linear and rotary valve technologies in small-bore control valves capable of operating cost-effectively up to ASME 1500 pressure class. The flow characteristics of this new valve are just like those of a globe valve. By definition, the globe-style body design leads to a high pressure-recovery factor and, as in globe valves, the interchangeable trim selection includes low Cv, low noise and anti-cavitation trims to meet a wide range of applications with the same basic valve design. These factors, combined with compact size and the low emission characteristics of a rotary valve create a unique design, which offers higher standards of performance in flow-control accuracy and reliability, while reducing lifetime costs and maintenance requirements.

Neles RotaryGlobe valves are designed to control a wide range of process liquids, gases and vapours in normal, difficult and even severe service. Applications for the new valve span the petrochemical, chemical, oil and gas, refining, power generation and pulp and paper industries.

Innovative design

The Neles® RotaryGlobe valve features a compact, lightweight yet robust construction with a choice of trims. Its one-piece, globe-valve style of body minimises potential leak paths and provides enhanced anti-cavitation performance, whereas the rotary motion stem is employed to provide improved control of fugitive emissions.

The modular design offers interchangeability of parts across the size range, a choice of body materials and a range of linear, equal percentage and balanced trims to accommodate even difficult applications; for example, under high-noise conditions, the low-noise trim can reduce noise by up to –20dB.

Every aspect of the design has been carefully considered. The thrust bearing, which is isolated from the process fluid to reduce potential corrosion and erosion problems, incorporates a stem anti-blow-out device.

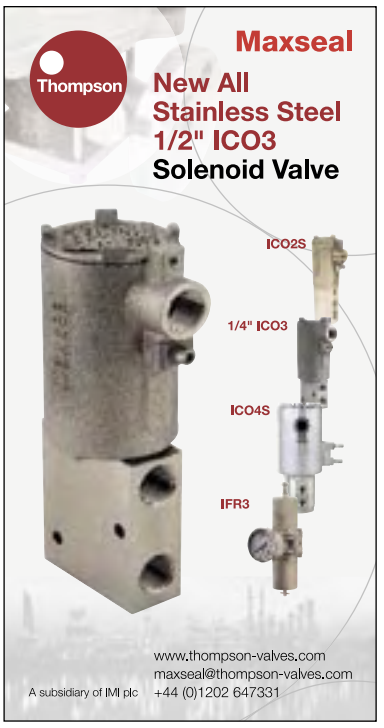
The new valve, available in the size range ½" – 2", operates in the temperature range –80 degrees C to + 425 degrees C and meets all the requirements of both ASME and EN standards. It also fulfils all the latest safety requirements and environmental standards, e.g. ISO 15848-1.

Emission control in the Neles RotaryGlobe valve

Ever-increasing emphasis on environmental issues, as well as potential product loss, has meant that closer attention is now paid to emissions from control valves. This trend has made rotary valves more attractive, because they have inherently better emission control than linear valves. In linear globe valves, the rising stem tends to move process media into the gland packing area, thereby increasing gland-packing leakage. By contrast, due to rotary stem movement, rotary valves do not draw dirt into the packing or bearing area. Hence rotary valves are less prone to gland packing leakage than linear globe valves.

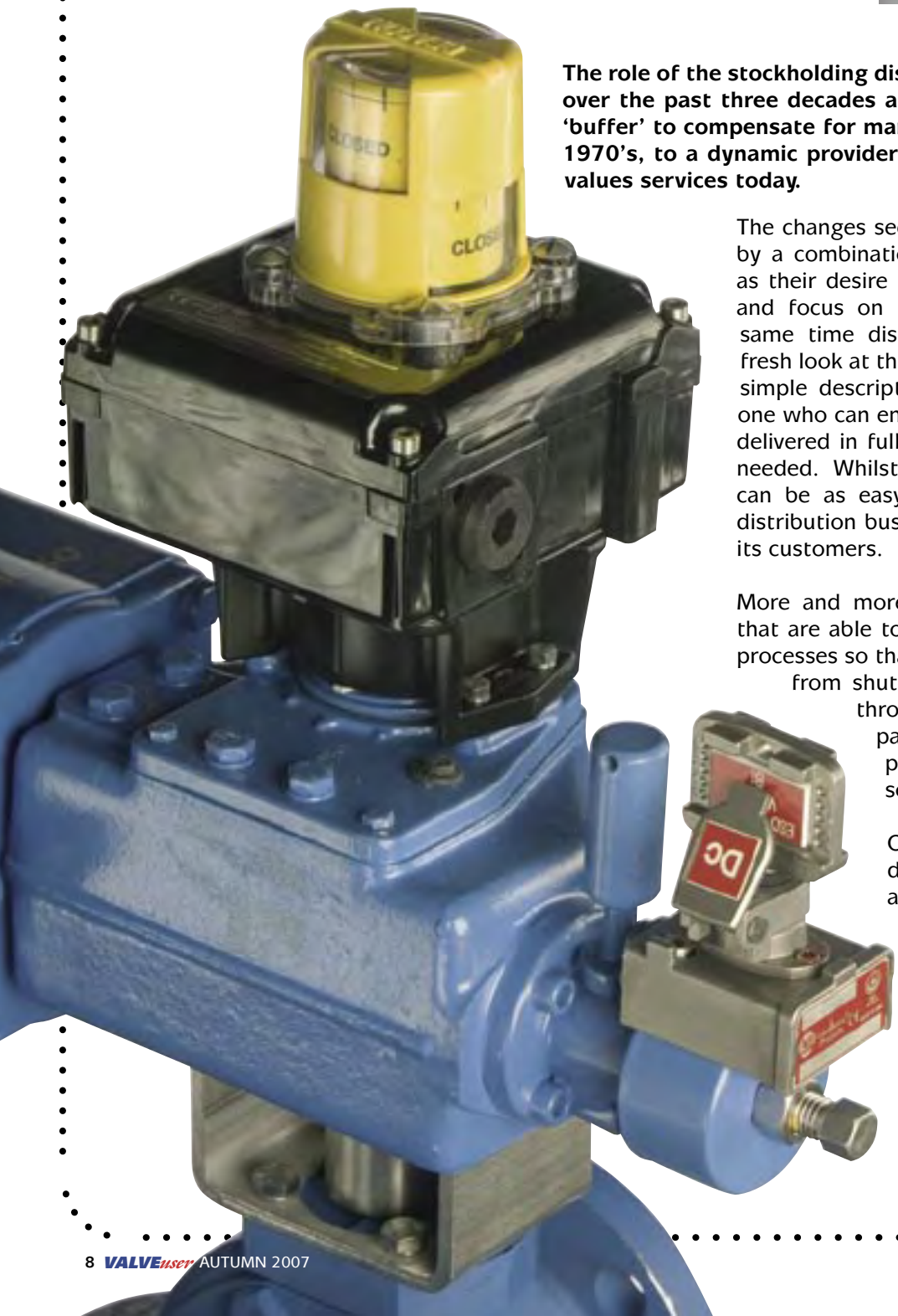
This is how the design of the Neles RotaryGlobe effectively decreases unwanted fugitive emissions but also eliminates the need for gland packing maintenance and maintenance costs. Other advantages of low fugitive emissions are that potentially costly end-product losses are reduced and, additionally, the danger of explosions, toxic atmospheres and injuries to the people are all lowered.

Metso, Tel: 0870 606 1478



Transmark Fcx
Heaton Valves

Delivering more than just valves



The role of the stockholding distributor has changed significantly over the past three decades and has transformed from being a 'buffer' to compensate for manufacturers long lead times in the 1970's, to a dynamic provider of supply chain and other added values services today.

The changes seen in the industry have been driven by a combination of customer requirements such as their desire to reduce costs, increase efficiency and focus on their core business, whilst at the same time distribution companies have taken a fresh look at their business model. The deceptively simple description of a good valve distributor is one who can ensure that the required products are delivered in full and on-time to wherever they are needed. Whilst for a standard product the process can be as easy as it sounds, a successful valve distribution business needs to offer much more to its customers.

More and more customers are seeking suppliers that are able to integrate with their own business processes so that they can add value at every stage from shutdown planning and valve selection through to delivering a complete package of products and enhancing plant efficiency through the supply of sophisticated automation systems.

Of course, providing an ex-stock delivery service is still fundamental and to achieve this the distributor must maintain a large stockholding of products which meet the majority of its customers' day-to-day requirements as well as holding stocks of slower moving products. Achieving the optimal product mix is a critical decision for supply companies and whilst modern stock control and ERP

systems are of great help, it is ultimately management that make the final stocking decision on which the success of the company can often depend. Associated with this is the stockholder's relationship with its own suppliers and whether it has access to the leading brands and also the necessary influence and support from its principles to be able to obtain special concessions when needed. One example of a valuable concession is where the manufacturer agrees to hold stocks of the components needed for long lead time items so that should the distributor have an urgent requirement the finished product can be quickly assembled.

One company that epitomises the modern distributor is Transmark Fcx who have built the largest stockholding of valves in Europe and have been very successful in securing supply agreements with major companies. Managing Director Fred McCluskey comments: *"Our approach is to be a true partner with customers and to constantly look for ways in which we can enhance the service we give them. For instance, we quite often have an imprest stock arrangement so that customers can have stocks of valves on-site but are only invoiced for the ones they actually use. Another example is that when a customer is planning for a major project we will significantly increase our own stock levels, over and above the expected demand, so that we can be sure that all of their requirements can be met ex-stock."*

The UK's valve supply base is a world leading industry and whilst it continues to innovate and focus on adding value to the sectors it serves, it looks set to have a very long and successful future.

Transmark Fcx, Tel 01274 700 000

Rotork Gears - Sub Sea Order

Rotork Gears have supplied 4 off Sub Sea gearboxes to BEL Valves Ltd in the UK. The gearboxes are for use on BEL Valves Top entry ball valves, 10" diameter, at 5,000-PSI pressure. The SSW9 gearboxes were supplied complete with ROV interface via a 1.3 metre extension spool. The gearbox and extension spools were supplied with separate pressure compensators.

Although the project operating depth is 1,200 metres, the gearboxes successfully passed a hyperbaric test at 2,400 metres.

Rotork Gears subsea gearboxes are designed for heavy-duty subsea applications at any depth with carefully chosen materials to offer the highest level of reliability required in this very harsh environment. They are suitable for manual or ROV operation and include the following main features:

* Ductile iron housing and quadrant
* Hardened steel worm
* Stainless steel external screws
* Adjustable end stops with stainless steel protection caps
* Optional ductile iron or stainless steel ROV interface receptacle

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* Optional eco-compatible oil lubrication
* Custom designs and materials are available to meet individual project specifications

Rotork Gears subsea gearboxes are not merely a modification of standard duty units as many components are specifically designed with different materials and high safety factors to guarantee the best performance and maximum reliability. The gearboxes are fully sealed with o-rings on all static joints to provide a long-term waterproof design. Gearbox housings are ductile iron and are designed to give a reliable and strong structure to withstand the most heavy-duty applications. Worms are hardened steel and the gear geometry is chosen to maximize efficiency and mechanical advantage and achieve an exceptional durability.

Rotork Gears, Tel: 0113 205 7276

Shafer Reliability 'Proven'

This Schafer RPC nitrogen gas-over-oil control system was installed approximately twenty-six years ago and has proven so reliable - and has remained undisturbed for so long - that it has become the home to a family of birds! The occupants are thought to be Cetti's Warblers, and the nest is quite large, so represents - quite literally - a lifetime's work.

Likewise a lifetime's reliability has been provided by the Schafer system, which is protecting a pipeline that crosses a river, in particularly arduous conditions. Such sustained reliability is vitally important as the system must work under all foreseeable circumstances. We think it's fair to say this product has exceeded expectations!

Many thanks to Coos van Minnen of Emerson Process Management, Netherlands, for sending in this unique picture.

Do you have a product that's been as reliable or has been installed for so long?

Send us a photograph and a background story and we will feature it in Valve User.

Sizing safety valves for supercritical steam boilers

J A Hare (HSL Buxton) & G Hawkins (HSE Bootle)
© 2007 Crown Copyright

How do you size the safety valve for a supercritical steam boiler? Steam boilers are increasingly being designed to operate under supercritical conditions i.e. pressures above 220 bar and temperatures above 374°C. Sizing equations for safety valves on steam boilers are often given in codes and standards for saturated and superheated steam assuming 'choked' flow, with the safety valve acting as the choke point in the system. For supercritical steam conditions other methods must be used to obtain the required discharge capacity. Choked flow occurs with gas flow and two-phase flow. How do you determine the Choke? You determine the maximum flow along an isentropic path. Choke conditions can occur in either the superheated vapour or sub-cooled liquid regions. Use of the isentropic coefficient (k) is valid when the choke is in the superheated vapour region. Figure 1 helps to explain some of the above terms.

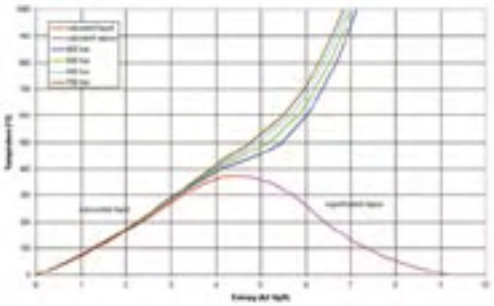

Figure 1: Entropy Temperature Diagram

To calculate the choked flow condition for supercritical steam the Homogeneous Equilibrium Model is the reference method (Fisher 1992). It involves an isentropic expansion from an initial supercritical pressure and supercritical temperature. The mass flux (G) is calculated at each reduced pressure. The calculated mass flux G goes through a maximum at the choke pressure. This mass flux is the choke mass flux G_{choke}. The vent area is then calculated. HEM can be evaluated using the Omega method developed by Leung (Leung 1996). The method involves a single isentropic expansion generally to 0.9 or 0.7 of the original pressure P_o. The value of Omega is then calculated. There are also equations to calculate the choke pressure ratio, the choke pressure, the dimensionless mass flux and the choke mass flux. For gas flow one can define a dimensionless mass flux G_{choke}^* similar to that used in the Omega method, but calculated using the isentropic coefficient. Values of k which were evaluated were k = 1.135 for saturated steam and k = 1.3 for superheated steam. Equations for choke pressure ratio and choke temperature ratio are also available.

Example calculations were performed at four relieving pressures (400, 500, 600 & 700 bara) and four relieving temperatures (400, 500, 600 & 700°C). The required mass flow rate (Q_m) was 20 000 kg/h. Isentropic expansion involves reducing the temperature (and pressure) whilst maintaining the same entropy - i.e. a vertical line downwards on the entropy – temperature diagram.

Figures 2 shows the dimensionless mass flux (G_{choke}^*), obtained using the rigorous HEM, versus relieving pressure for a range of relieving temperatures. The figure also shows the dimensionless mass flux calculated using gas flow equations with two values of the isentropic coefficient (k) and calculated using a liquid flow equation. Figure 3 shows the critical pressure ratio (η_c), obtained using the rigorous HEM, versus relieving pressure for a range of relieving temperatures. The figure also shows the critical pressure ratio calculated using gas flow equations with two values of the isentropic coefficient (k)

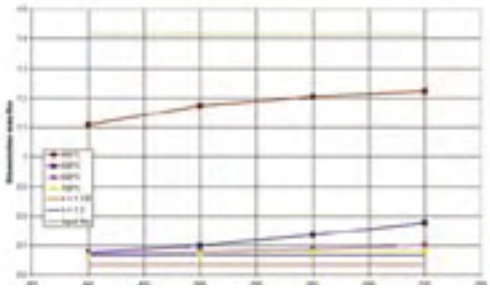

Figure 2: Dimensionless Mass Flux

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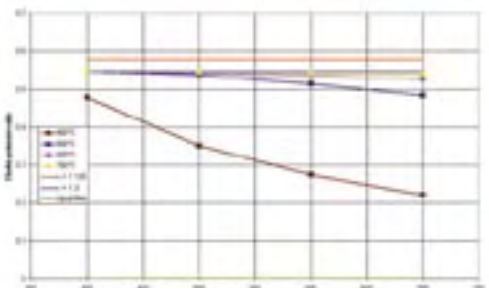

Figure 3: Choke pressure ratio

The results using HEM / Omega were:

For relieving temperatures of 500°C and above:
- The chokes were in the superheated vapour region.
- There was excellent agreement between HEM and Omega methods.
- The value of Omega remains relatively constant during the isentropic expansion.

For relieving temperatures of 400°C:
- The chokes were in the sub-cooled liquid region.
- There was less agreement between HEM and Omega methods.
- The value of Omega varies considerably during the isentropic expansion.

If the chokes are in the superheated vapour region then the standard methods could also be evaluated. Accurate specific volume (v) was obtained from steam tables and was in good agreement with PPDS (PPDS 2004). There was excellent agreement between all gas flow methods using a particular k value in terms of calculated vent area. With k=1.3, the calculated flow areas were slightly higher than the reference methods.

The correct sizing of Safety Valves can be critical (photo Comid)

With k = 1.135, the calculated flow areas were higher than reference methods but not unduly conservative.

The recommended approach is to examine the relieving pressure and relieving temperature:
- If it lies above saturated vapour line, the choke is in the superheated vapour region. The rigorous HEM or Omega method can be used to determine the mass flux.
- Reasonable predictions can be made for mass flux using the gas flow equations with k=1.3 and accurate specific volume data.
- If it lies above the saturated liquid line, the choke is in the sub-cooled liquid region. The rigorous HEM is generally the only method able to predict mass flux. Use of a liquid flow equation may over-predict the mass flux and therefore under-predict the vent size needed.
- If it lies directly above the critical point, or above the saturated vapour line but at a temperature below 500°C, it would be prudent to use the rigorous HEM. Further work is in progress to better define the applicability of different methods in the region.

Fisher HG et al "Emergency Relief System Design using DIERS technology" Chapter II, DIERS / AIChE, 1992.

Leung "Easily Size Relief Devices and Piping for Two-Phase Flow" Chemical Engineering Progress, p28 December 1996.

Physical Property Data Service (PPDS) for Windows, v3.1.4 TUV NEL Ltd, 2004.

The full text of this paper appears in the 12th International Symposium, Loss Prevention in the Process Industries, Edinburgh, May 2007, IChemE Symposium Series No 153, Poster 08. Email contact: john.hare@hsl.gov.uk

Flow Group makes waves

Leading valve manufacturers, the Sheffield-based Flow Group, is making waves with sponsorship of British and European Women's Surf Kayak Champion, and world number two, Tamsin Green.

The Group – a key player on the international stage with a sales turnover of $50million – has a knack for backing winners, and has given Tamsin its support as she prepares for the World Surf Kayak Championships in October.

Tamsin Green

Flow Group Chief Executive Mark Ansell said: *"Many of our Shipham valves are used to control seawater in the coastal and offshore oil and gas industry, as well as on naval submarines and ships. We also supply our range of Bestobell LNG cryogenic valves to LNG cargo ships, so our business is heavily focused on the sea and we know how tough it can be out on the water. So when Tamsin approached us to be her sponsors, as top performers in our field, we felt it was highly appropriate that we should help in her quest to reach the top of hers. Her ambitions to be world number one match ours and, as a successful team, we know the value of working in partnership. We wish Tamsin every success when she competes for gold this autumn."*

Flow Group is a privately owned British valve manufacturing group, recognised internationally for its engineering excellence. The Group – which has purpose built manufacturing facilities in Sheffield, Hull, and Newcastle and a distribution centre near Pittsburgh in the USA – has 50 years' experience supplying the global energy industry.

It now consists of five major specialist valve manufacturing brands – Shipham Valves, Conflow, Bestobell Valves, Bestobell LNG and John Mills Valves – each supplying its own niche global energy market.

Tamsin Green said she was *"delighted"* to have won the backing of such prestigious sponsors. She said: *"I'm really grateful to Flow Group for their support. It will be a big help in providing some of the logistics for my training programme and I hope I can justify their faith in me."*

Tamsin has had a meteoric rise to the crest of her wave. She became British Women's Surf Kayak Champion at her first attempt in West Donegal last September, and a month later took a silver medal in the World Surf Kayak Championships in Portugal. This was the first time the 32-year-old from Northumberland had competed in the event, which was only her second open competition. This year Tamsin has maintained her form, retaining her place as the world number two at the Santa Cruz Surf Festival in California, in March.

BVAA

ANNUAL review

2007

British Valve & Actuator Association

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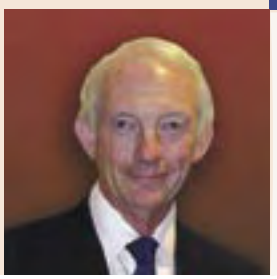
UL CSA CE Ex ATEX INMETRO (GOST R) IECEx



David Caines, BVAA Chairman

Chairman's Report

This is my fifth, and last, annual report as Chairman of the BVAA, as I will be standing down at the association's AGM in November 2007. I must say the time has passed incredibly quickly, and it seems like only yesterday that I took over the post from my predecessor, Brian Varley!

Traditionally my report covers what has happened in the previous twelve months, but our Director has adequately summarised this in his own report, and I feel it might be useful to summarise instead some of the major developments that occurred 'on my watch'.

Firstly, I had the unenviable task of immediately finding a replacement Director, following David Pangbourne's retirement. I am pleased to say we were fortunate to find a very enthusiastic and energetic replacement in Rob Bartlett, who has very quickly become the embodiment of the BVAA, and added a much-needed professional touch to all of our work.

Secondly, the association bravely moved forward and put aside the 'manufacturers only' tag that had been the mainstay of our representation for so many years. With it went the BVAMA name and logo, and the new-look BVAA emerged. When an organisation has a 70 year pedigree, changing its name and raison d'être is not done lightly. The decision to re-organise to represent a much wider sector, incorporating distributors, repairers and suppliers, obviously seems the right one now, but it came only after much soul-searching and debate. I am gratified that this proved to be the right decision, and I am sure that this has greatly contributed to our sustained growth.

"…60% increase in membership…"

I would also congratulate our Director on his enthusiastic pursuance of new members, from all sections of the industry. We must be the only trade association in the engineering sector to have enjoyed a 60% increase in membership in just a few short years.

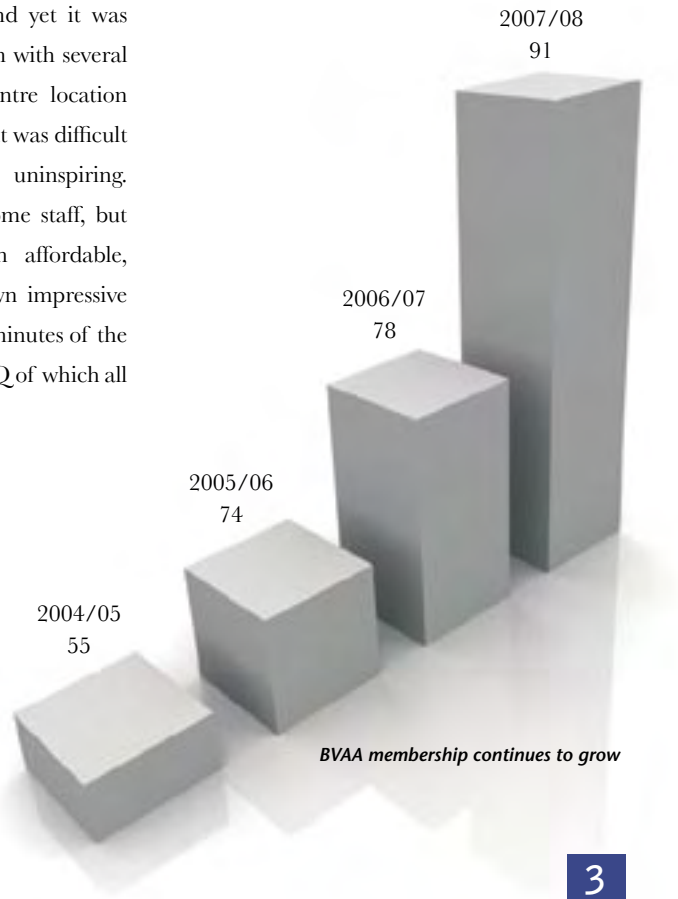
BVAA also took another momentous decision, to relocate its headquarters to Banbury in Oxfordshire. The BVAA had resided in Birmingham for many years, and yet it was not 'home' due to our co-location with several other associations. The city-centre location was unpopular with members as it was difficult to reach, and the offices were uninspiring. Sadly we did have to change some staff, but happily, BVAA now resides in affordable, purpose built offices, with its own impressive meeting facilities, and all within minutes of the UK motorway network. It is a HQ of which all members can be rightly proud.

With regard to finances, I am very pleased to report that the situation has dramatically changed for the better. In 2003 we were struggling, being reliant almost solely on subs in a consolidating and contracting sector of engineering.

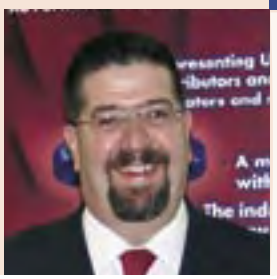
Last year our non-subs income had grown to record levels, as had our membership. We also posted our best-ever results, resulting in a healthy surplus, which will be reinvested in yet more new services and products.

Members of the BVAA still face many challenges in the marketplace, but I am happy to report that their association is now perfectly placed to fully support them in all aspects of their work.

BVAA's Executive Committee.



BVAA membership continues to grow



Rob Bartlett, BVAA Director

Director's Report

In what has been yet another exciting year, the only difficulty I have is in knowing where to commence my report, which selection of the many activities I should mention, and where to end!

I will, as usual, commence by expressing sincere and heartfelt thanks to the BVAA Steering Group and Executive Committees - I am delighted to recognise the support and guidance these important groups to provide to the BVAA secretariat team on behalf of the whole membership.

I am also very pleased to report that we have once again, by many measures, had a very successful year. We 'bedded in' at the new headquarters in Banbury, and the new meeting facilities proved particularly useful, with several committees making the most of the 'home' venue. We were also pleased to be able to host some meetings for our members' customers. Our flexibility also meant we could host all our own training courses, and it was no coincidence that we delivered more courses than ever before this year.

In November, we had a very successful week at Valve World in Maastricht. The week after, I was delighted to help orchestrate another success - one of our best ever AGM / Dinner Dances at Wood Hall in Wetherby. It represented a 'step-change' in quality and was certainly one of our most memorable gatherings!

BVAA's Marketing Committee continued to excel, achieving remarkable success with modest funding. The future looks particularly encouraging, as this year we have a generous budget with which to further promote the association and its members. March saw the launch of 'Valve User' magazine, BVAA's new flagship publication, which is already making a significant impact in the industry. Work has also been completed on the second issue of the BVAA Members' Literature DVD.

Under the guidance of our excellent and hard-working Working Group Chairmen, our technical groups have also continued to flourish. Guest speakers and factory tours have added an extra element to this important aspect of our work. The importance of the contribution made by Peter Churm, BVAA's Technical Consultant, cannot be overstated, and his commentary and guidance on all technical issues affecting the industry continue to remain very popular and much appreciated by all.

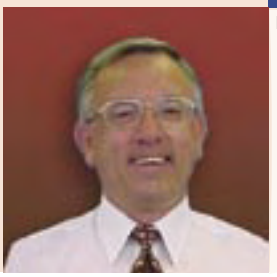
As to membership, BVAA continues to rapidly expand. Currently we have over ninety members, who collectively represent the vast majority of the total UK industry. On studying the Trade Association Forum's benchmarking report, I was delighted to find that BVAA was categorised as *'lean and efficient, with greater than average member-retention and membership growth'*.

We are justly proud, especially as amid all the recent developments and improvements, BVAA has also moved to its strongest ever financial position. Our work is not done however, but we do now have a strong bridgehead from which we can develop further.

The UK is rightly recognised as a centre of excellence in our industry, and activity levels in member companies generally remain high. Turnover for most members has increased, but I would quickly add that increased turnover does not necessarily lead to improved profitability. Many members still face stiff competition from overseas, soaring material costs and the occasional piece of skulduggery by fraudsters!

Finally, it is with great pleasure that thank my colleagues, Sarah Edginton and Peter Churm, for their continued hard work. I would also take this opportunity to formally acknowledge the huge contribution made by our outgoing Chairman, Mr David Caines. David was Chairman when I joined BVAA, and has stoically remained at his post far longer than any of his predecessors. I will miss his patient and sage-like guidance, which has contributed greatly to BVAA's successes in recent years.

One of the many meetings at BVAA HQ



Peter Churm, BVAA Technical Consultant

Technical Report

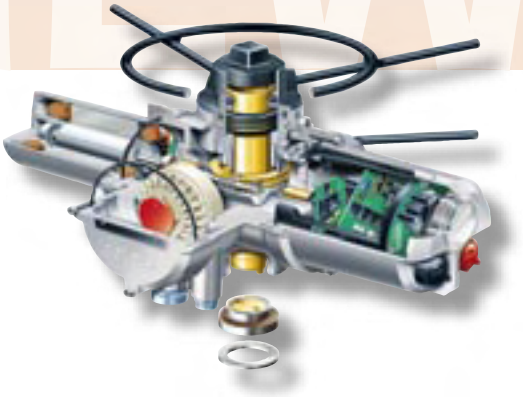
During the course of the past year my activities have included continued work on International, European and British standards committees, the issues surrounding the latest revision of the European ATEX Guidelines and managing the continuing changes in the support and services provided by BSI. I have also provided support and guidance to DTI and HSE on valve technical issues, attended and supported the various BVAA Working Groups, and provided technical support to member companies, plus of course written regular technical articles for the Valve World magazine. Additionally I have attended CEN valve meetings and workshops as the UK expert representative and have, on behalf of the BVAA, presented a paper at the Institution of Mechanical Engineers conference on 'CEN Standards for Business Benefit.'

A considerable amount of time has been dedicated to the attendance of standards meetings at BSI and CEN. The necessary work on International, European and British standards has continued and the new or revised standards are published upon completion. CENTC/69 has now published 73 standards (five during the past year, see list) with four draft standards registered at preliminary stage and seventeen remaining under preparation. There are currently eight draft standards for comment due by end November 2007. There is however a need for diligence, as previously published standards are now being identified for their 5 year systematic review. The difficulties encountered in recruiting standards committee members in our industry is reflected in other industries and is a worrying trend that we must address.

This has not been helped by the 'Resource re-alignment' initiative introduced by BSI which is effectively reducing the support being given to standards committees in the traditional industries such as Industrial Valves. The PSE/7 Industrial Valves committee has now had five BSI secretarial changes in 18 months, rendering continuity very difficult to manage.

To ensure that member companies are aware of the preparation and revision of industrial valve standards, BVAA regularly and routinely announce and distribute draft standards to members, to ensure the input of a wider cross-section of views.

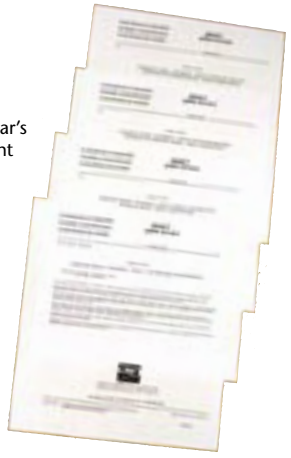
I continue to be involved in the BVAA Working Groups, whose continuing high levels of activity are encouraging to report, with meetings of most groups being well attended. Useful issues addressed include European directives, valve standards, statistics, Valve World opportunities, desktop exhibitions, strategic review and BVAA publications. Recently some of these Working Group meetings have been held at member company premises. It has been most impressive to see members of a traditional manufacturing industry including modern technology/techniques in their processes and manufacturing facilities.



The EN 15714 series of European Standards will cover most types of Actuators

Several 'desktop' exhibitions have been undertaken at major contractors' offices and many members have benefited from contacts made at these events. A service included at these exhibitions is a Technical Help Desk, at which I have provided technical advice and support on Standards, European directives and related issues to the host contractor's engineers.

BVAA's decision to market its own valve training courses has proven to be most successful with regular courses being held at BVAA offices in Banbury. A significant and most popular addition has been the introduction of a one day course on a technical issue that has become increasingly prominent in recent years, that of Safety Integrity Levels (SILs) for valves.

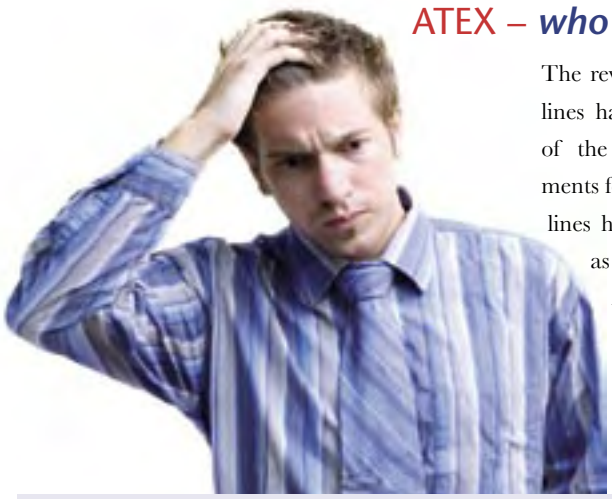


Some of this year's most important standards

Imparting knowledge through standards (photo: Shipham Valves)

Technical Report

BVAA's own ATEX Guide



ATEX – *who's right?*

The revision of the European ATEX Guidelines has contradicted BVAA's interpretation of the ATEX Directive 94/9/EC requirements for valves. These new European guidelines have been challenged as being unsafe, as valves would not be submitted to an ATEX ignition risk assessment when some valve-types are known to have ignition risks. Meetings and discussions continue with DTI, to convince them of our concerns.

Finally I would remind you all that my provision of technical information, advice and support to member companies continues, and assure you of my continuing support during the coming year. In addition, the provision of technical support advice and guidance for specific member company needs, conducted at member company premises, has been found to be most useful and this facility will be more widely broadcast to all members in future.

Standards published during the past year are:

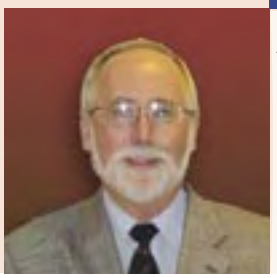
BS EN ISO 4126-1: 2006	Industrial valves - Safety devices for protection against excessive pressure - Part 1: Safety valves.
BS EN ISO 4126-2: 2006	Industrial valves - Safety devices for protection against excessive pressure - Part 2: Bursting disc safety devices.
BS EN ISO 15848-2: 2006	Industrial valves – Measurement, test and qualification procedures for fugitive emissions - Part 2: Production acceptance test of valves
BS EN ISO 7121: 2006	Industrial Valves – Steel ball valves for general purpose industrial applications
CEN/TS 13547: 2006	Industrial Valves – Copper alloy ball valves

CEN/TC69 standards currently in preparation/revision

prEN 15081	Industrial valves – Mounting kits for part-turn valve actuator attachment
prEN 12516-4	Industrial valves - Shell design strength – Part 4: Calculation method for valve shells in metallic materials other than steel
EN 12982 rev	Industrial valves - End-to-end and centre-to-end dimensions for butt welding end valves
prEN 558 rev	Industrial valves – Face-to-face and centre-to-face dimensions of metal valves for use in flanged pipe systems – PN and Class designated valves
prEN 736-3 rev	Industrial Valves – Terminology - Part 3: Definition of terms
prEN 1267 rev	Industrial Valves - Test of flow resistance using water as test fluid
prEN 12266-1 rev	Industrial valves – Testing of valves – Part 1: Pressure tests, test procedures and acceptance criteria – Mandatory requirements
prEN 15714-1	Industrial valves – Actuators – Part 1: Terminology and definitions of actuators for industrial valves
prEN 15714-2	Industrial valves – Actuators – Part 2: Electric actuators for industrial valves – Basic requirements
prEN 15714-3	Industrial valves – Actuators – Part 3: Pneumatic part-turn actuators for industrial valves – Basic requirements
prEN 15714-4	Industrial valves – Actuators – Part 4: Hydraulic part-turn actuators for Industrial valves – Basic requirements
prEN ISO 10434 rev	Industrial Valves - Bolted bonnet steel gate valves for petroleum and natural gas industries
prEN 1074-6 rev	Valves for water supply - Fitness for purpose requirements and appropriate verification tests – Part 6: Hydrants
prEN 13774 rev	Valves for gas distribution systems with maximum operating pressure 16 bar - Performance requirements
prEN 1349 rev	Industrial process control valves
prEN 12569 rev	Industrial valves - Valves for chemical and petrochemical process industry - Requirements and tests
prEN 15389	Industrial valves - Performance characteristics of thermoplastic valves when used as construction products

ISO/TC153/SC1 standards in preparation/revision

ISO/DIS 5208 rev	Industrial valves - Pressure testing of metallic valves
ISO/CD 15761 rev	Steel gate, globe and check valves for sizes DN 100 and smaller for the petroleum and natural gas industries
ISO/CD 10434 rev	Bolted bonnet steel gate valves for petroleum and. natural gas industries
ISO/CD 10497 rev	Testing of valves – Fire type testing requirements
ISO 28922 preliminary	Pressure testing of valves for temps lower than -50°C
ISO 28921 preliminary	Industrial valves – Isolating valves for low temperatures application



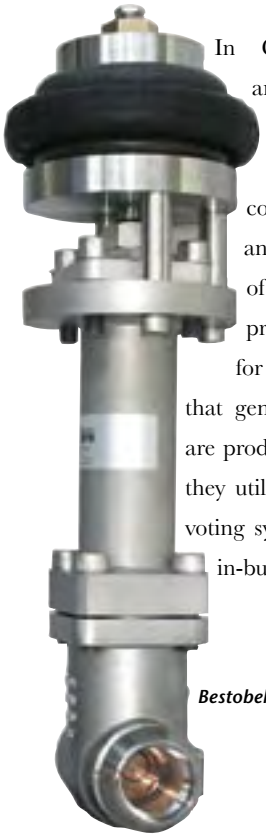
Chairman: Geoff Newman,
Anderson Greenwood Crosby

Valve Working Group

At our last BVAA Valve Working Group meeting, we advised the assembled members that, since our last meeting, over two hundred documents had been circulated to the BSI committees concerning Industrial Valves (PSE/7) and Safety Devices (PVE/12).

This is a huge number of documents! Included are draft standards, committee voting reports, meeting minutes, etc., and the sheer quantity emphasises just how many valve-related standards there are out there in development or revision. These encompass not only British Standards, but in the main international standards; prepared either by CEN for Europe or ISO (the International Organisation for Standards) for the wider world.

We also know that many of the important standards completed in recent years will soon be coming up for their periodic reviews too, and we anticipate that many more standards will soon start their revision process.



Bestobell Valves

In CEN, new standards are developed via a voting system that positively encourages consensus building, and while the longevity of the development process often comes in for criticism, it does mean that generally 'good' standards are produced. In ISO however, they utilise a different majority-voting system, which carries an in-built positive bias. Once an ISO standard is to be revised, it is generally considered 'open season' on the entire text and some of the carefully drafted wording can soon be substantially altered. Several 'safety device' standards are soon to move from CEN stewardship to that of ISO, and we do have some concerns that the same arguments, that were once resolved, will commence all over again.

Several of the most recent standards in development cover subjects such as fire testing, pressure testing, actuator-interfaces and face-to-face dimensions, and they ought to be of significant interest to all manufacturers, as they no doubt will have to use these standards in the coming months and years. It is therefore imperative that the UK begins to take standards as seriously as some of our European colleagues seem to do.

No report for the Annual Review is complete without formal thank-yous to the 'Three Peters': -

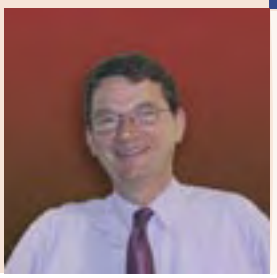
Peter Taylor has been the Chairman of BSI PVE/12 for many years, and it was only last year that he handed over the CEN chair for Safety Devices to myself. He has continued to chair our BSI meetings however, and we all owe him a huge debt of gratitude for his consistent hard work on behalf of the European safety device industry.

Peter Hirst chairs the BVAA and BSI Actuator working groups, and is a regular attendee at our Valve WG meetings, always ready and able to keep the Valve WG appraised of developments with important standards that affect us all.

Finally, a special thank-you to the BVAA Technical Consultant, ***Peter Churm***. Peter keeps a watchful eye on all developments with standards, Directives, legislation etc., and keeps all the BVAA WGs appraised via his excellent monthly Technical Reports and attendances at our meetings. We are all indeed very fortunate to benefit from such a comprehensive and well informed technical service.

Blackhall

Anderson Greenwood Crosby (Tyco) Safety Selector Valve with Tandem linked Snap Acting Pilot Operated safety valves.



Chairman: Peter Hirst,
Rotork Controls

Actuator Working Group

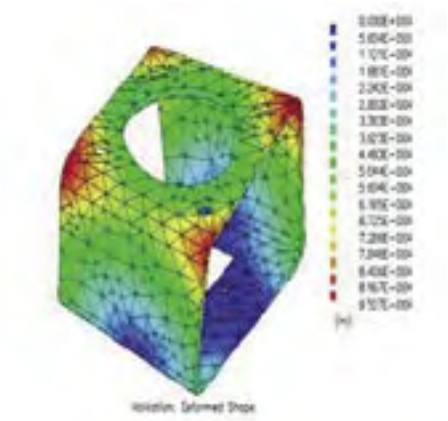
The Actuator Working Group has had something of a mixed year, with some continued, very patient waiting for some important CEN standards, steady progress with a standard on interfaces, and a possible new work item. The BVAA WG also continues to meet in conjunction with its BSI counterpart, PSE/7/1/10, simplifying matters considerably for everyone involved.

Rotork E250E Nuclear actuators

The long awaited CEN prEN 15714 'Basic Requirements' standard for actuators, covering terminology, electric, pneumatic and hydraulic models, has at last progressed. Following a series of cancellations and reinstatements to the work programme, parts 1, 2, 3 and 4 were recently issued by CEN central secretariat for comment. The BVAA WG will no doubt need to meet several times in order to discuss our response to these important standards. It is likely however, that as the standards have been in development so long, we may find it necessary to update the content significantly in order that the standards are representative of modern practices.

prEN15081, the draft standard for 'Industrial Valves – Mounting kits for part-turn valve actuator attachment' moved through its voting stages and was recently issued again as a 'final draft' for voting. I am pleased to report that the UK's comments on Annex B, the proposed stem details for ball and butterfly valves, were accepted and incorporated into this last draft. This was essentially a 'Yes or No' vote in Europe, and as it was accepted unanimously, we assume the standard will soon be formally published.

The international standard for part turn actuator interfaces, ISO 5211, is up for periodic review this year and the UK has again voted for a revision, in order that 5211 and 15081 can be consistent with regard to the Annex B dimensions. Although it seems an obvious and necessary revision to those of us who initiated the changes, we are mindful that the last year's opportunity to revise the CEN version - EN 5211 - resulted in insufficient support, but it is thought that this was perhaps as a result of the wider ignorance of the issues rather than a conscious decision to perpetuate the inconsistencies.

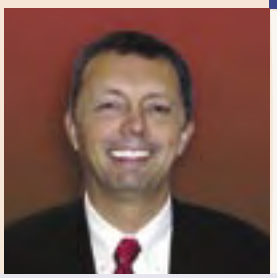


Mounting kits are engineered solutions (CAD graphic: Heap & Partners)

A sea of actuators – Emerson Process Management

The proposed BVAA guide for manual actuators (gearboxes) was circulated for comment again this year, and will be discussed at our next meeting. It is anticipated that this will be a 'Combined WG' meeting with out Valve WG colleagues. The subject of 'valve repair' has also been a recent topic of discussion with our Valve colleagues, and as the current BVAA repair guide also covers actuators, we will no doubt be working together on any future revision.

Rotork Fluid Systems



Chairman: Laurence Kettle,
Rotork Controls

Marketing Committee

I am pleased to report that BVAA's Marketing Committee has had another very busy year. Like all good marketing departments, our work never stops, as we constantly seek to improve on the services we provide and oversee, and also to evaluate and implement new initiatives.

We are also continuing, whenever possible, with our tour of members' facilities, as with such a diverse industry it is vital that we keep up to speed with the needs of all our members, large and small.

This year we again revitalised the BVAA website – the third such overhaul in as many years. Keeping the website aesthetically pleasing is just one motivation; the most important aspect is of course ensuring that the site continues to deliver a useful service to members and non-members alike. We are very grateful to BVAA's Membership Secretary, Sarah Edginton, for her continued mastery of the website, which allows us to make changes immediately that they are agreed.

The Committee, mainly via the Director and Peter Churm, has also ensured that BVAA remains in the industry's eye, and a constant presence in Valve World magazine has been a core of this activity, supplemented by appearances in other trade journals and presentations.

The whole BVAA team were also present at the Valve World exhibition and conference in Maastricht in November 2006. Valve World continues to be a key event for BVAA, which not only facilitates promotion and dialogue with members and non-members, it also allows us to meet informally with suppliers, users and customers, from which we all derive benefits.

Sarah Edginton distributing members' literature at Valve World

VALVEuser

This year also saw the introduction of Valve User, BVAA's own quarterly magazine. The development of such a magazine was first proposed a couple of years ago, but before BVAA News had attained the necessary momentum to facilitate such a change. In March 2007 that goal was achieved however, and Valve User was re-modelled out of the rapidly expanding 'News'. This involved a radical overhaul in terms of format, content and length. The new name was also intended to be a reflection of the new magazine's focus and its aim of appealing to the industry's customer base.

I am delighted to report that Valve User has already exceeded our expectations, and has rapidly grown in stature and reputation. Indeed the recent record attendance at the BVAA Training Courses owes much to the power of Valve User, as we did not need to advertise the courses in any other trade magazines. We are justly proud of this important new industry journal.

Advertising

The pros and cons of mainstream exhibitions can, and are, debated endlessly, as indeed they have been at BVAA. The decision by the Association's Executive Committee not to expand our participation in overseas exhibitions led to a proposal for us to engage in more targeted advertising. With the usual aplomb, the BVAA Director has already masterminded a striking new series of advertisements, which readers will find within this publication and will no doubt be seeing in others in the very near future.

Desktops

A full report on the continuing series of BVAA mini exhibitions, staged inside major contractors' premises, is given in the News section of this Review. However the Marketing Committee continues to play a role in the management of this important promotional activity. Times have changed, and finding hosts with sufficient space has become a challenge in today's 'leaner' office environments. Once again the BVAA staff have rapidly adapted and this year we saw the series continue, but with modern, smaller back-stands and pared down representation. The result – two very successful, very professional events at KBR and AMEC, with more to come.

Marketing Committee's spring 2007 meeting.

www.bvaa.org.uk

News

DVD

We believe that our Committee has played a part in the impressive expansion of the BVAA membership in recent years. It is partly because of this influx of new members, and partly because stocks have been depleted, that we have decided to prepare a second, updated edition of the very successful BVAA DVD. This literature library has proven to be very popular and literally thousands of individuals across the globe now have a copy. They are constantly in demand.

The new version, which includes product data from over 90 companies, will be launched in the autumn.

EIF Report

The Office of National Statistics (ONS) used to carry out quarterly reporting on our industry's products, but the move last year to annual reporting means the reports are now so late as to be regarded as unusable. They are also purely historical, with no forecast element at all. The Marketing Committee is therefore delighted to announce that BVAA will once again be commissioning, this autumn, a new 'Global Markets Report' from European Industrial Forecasting and all members will be able to access this extensive, and updated, 5-year forecast.

To close, I would like to thank my committee members for their continued support, encouragement and non-stop flow of ideas, and of course our BVAA secretariat team who so rapidly and enthusiastically convert these ideas into reality.

BVAA AGM Dinner Dance

The BVAA AGM cluster of meetings and Dinner Dance was held on Friday 17th November 2006 at Wood Hall, near Wetherby, West Yorkshire. The meeting cluster included the usual Combined Working Group meeting, plus the Executive Committee, which also included the Association's 67th AGM.

Highlight of the day however was the evening Dinner Dance, which has already been described as 'unforgettable' by some and must surely be one of our most popular events ever. The cabaret was provided by 'Louise', who delivered the most amazing Kylie tribute – just simply superb entertainment.

The 2007 AGM has been scheduled for Friday 23rd November, and will, by popular demand, once again be held at Wood Hall.

Are you a significant buyer/user of valves and actuators?

Call BVAA on 01295 221270 for a no obligation discussion on how a BVAA desktop event could help your business.

Desktop Exhibitions

BVAA's famous series of in-house exhibitions continued this year, and these very simple events increase in popularity with members and hosts alike. The key is their convenience. BVAA will bring a number of potential suppliers to a major customer/user's own premises, and quickly and without fuss assemble a very professional-looking mini exhibition in any spare office, room or space. 'Pop-up' banner-stands add to the atmosphere, and of course competent technical staff are on hand to demonstrate products. These events are ideal for updating staff with new products from known providers, or seeking out new suppliers.

KBR Leatherhead

SMC's Thom Shannon engaged with several KBR staff

BVAA were delighted to return to KBR's facility in Leatherhead to hold another desktop exhibition on 23rd January 2007. Twenty BVAA members participated and received over forty visitors from the various departments within KBR, which is part of the Halliburton group. BVAA Director Rob Bartlett commented *'It was particularly rewarding to see such a diverse range of engineers and specialists from across all disciplines.'*

AMEC Oil & Gas

On 22nd May 2006, BVAA visited AMEC Oil and Gas in London. Although we have held previous events at their Aberdeen offices, this was our first visit to AMEC at their Old Street

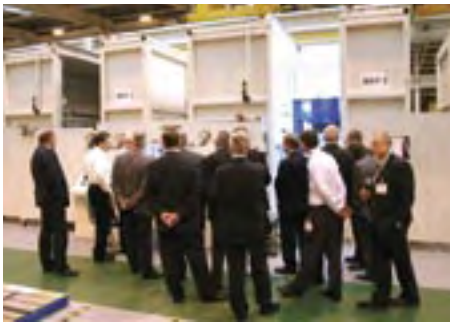
address. Again over 40 visitors attended, and the event was deemed so successful, BVAA have been invited to return again in October.

REV Kick-Off Meeting

On 27th June, BVAA hosted, on behalf of Score, Amec and their valve suppliers, the 'kick-off' meeting for the British Gas 'REV' project. Over twenty representatives from all over the UK attended. The new BVAA facilities are intended to be utilised as widely as possible by the whole valve industry and its supply chain, and BVAA were delighted to be able to offer a central meeting point.

Valve WG at Weir Valves

On 31st May, BVAA's Valve Working Group held their meeting at Weir's impressive new manufacturing facility in Elland, Yorkshire. Part of the visit comprised a tour of the workshops, which have to be some of the smartest and most well designed in the industry.



What's UVDB?

That was the question answered by Andy Aldington of Achilles when he attended the BVAA Marketing Committee meeting on 29th March. Some BVAA members are already participants in the Utility Vendor Database, and its partner FPAL, but it was felt that members might benefit from knowing more about the scheme. After the presentation it was suggested that BVAA might usefully help with the standardisation of the UVDB valve and actuator classifications/categories across both the UVDB and FPAL databases.

The UVDB presentation

Valve World 2006

November saw the bi-annual gathering of Valve World in Maastricht once again. This year BVAA fielded a strong team, with BVAA Director Rob Bartlett and Membership Secretary Sarah Edginton covering stand duty, while Technical Consultant Peter Churm attended the important aspects of the Conference. More members exhibited at Valve World than ever before this year, and the increase in numbers of exhibitors and attendees was quite noticeable. For some, the jury is still out on the usefulness of such exhibitions for sales-related success, but as a trade association there is no better way of meeting the members we serve and the customers they supply.

BVAA's Rob Bartlett and Sarah Edginton at Valve World

REVIEW

Training Courses

BVAA remains totally committed to training, and addressing the future needs of our industry is a subject that is not only growing in importance, it is often a topic of discussion at BVAA meetings. Indeed, the summer 2007 Executive meeting was dedicated to this subject, having been held at the UK's National Fluid Power Centre in Worksop. NFPC is an inspiring example of training excellence which underlines what is possible with the right application of funding and industrial support.

BVAA Executive Committee visiting the National Fluid Power Centre

BVAA's SILs Training caused lively debate

Following on from last year's impressive series of courses, BVAA again ran a 'Training Week' in April 2007. The courses covered introductions to Valves - delivered, as ever, by Derek Smith, and to Valve Actuators, by Chris Wareing and Howard Mutters. BVAA also ran more in-depth courses on Safety Valves with Geoff Newman, and Control Valves with Dave Barnes and Dave Martin. The lecturers' in-depth knowledge is a constant source of complimentary feedback from delegates.

There was strong demand again this year for our relatively new course on Safety Integrity Levels (SILs), which is delivered by Roger Stillman of ARC-Sil and Bob Smith of PRfSS. SILs are clearly becoming a big issue in the industry, and a further course was delivered in June, with more planned for the autumn. All our Training Course announcements are posted on the BVAA website, see ww.bvaa.org.uk

Rotork Gears IW gearbox in section

Anderson Greenwood Crosby

Geoff Newman lecturing on Safety Valves

Blackhall

ITT Corporation to Acquire International Motion Control

Acquisition to enhance ITT's global motion and flow control capabilities

ITT Corporation has announced it has executed an agreement to acquire privately held International Motion Control (IMC) for $395 million. IMC is a global developer of motion control products with 2006 revenues of approximately $200 million. The transaction, which is subject to normal closing conditions, is expected to be completed in the third quarter.

"The IMC acquisition aligns exceedingly well with our strategy to grow the ITT Motion and Flow Control business globally. IMC adds a complementary mix of highly engineered, mission-critical products to expand our core capabilities in specialty energy absorption, energy management and actuation, and industrial and aerospace controls," said Steve Loranger, chairman, president and chief executive officer of ITT. *"We look forward to welcoming IMC's talented workforce and strong customer base to the ITT family."*

IMC is a market leader in the manufacture of specialty energy absorption, industrial and aviation control and automation technology under the brand names of Burny, Enidine, Compact Automation, CMC, and Midland-ACS, among others. Under brand names including Koni, Jabsco, Neodyne, Rule and Flojet, ITT's Motion and Flow Control group produces leading products for the marine and leisure, transportation, aerospace, telecommunications, and industrial markets. Nick Hill, president of the ITT Motion and Flow Control group, will continue to lead the integrated organization.

MIDLAND-ACS An IMC Company

alcon SOLENOID VALVES An IMC Company

"For more than four decades, our customers have known IMC for its technological expertise, problem-solving approach and exemplary customer service," said Patrick Lee, chairman and chief executive officer of IMC. *"We found ITT to share these core values and together expect to continue this tradition as we enter this exciting new chapter in our history."*

ERRATUM - In IMC's remote actuated valves article in Valve User Issue 2, we inadvertently reported an operating temperature range of -290C to +400C, when it should be –29°C to +40°C. We apologise for this error.

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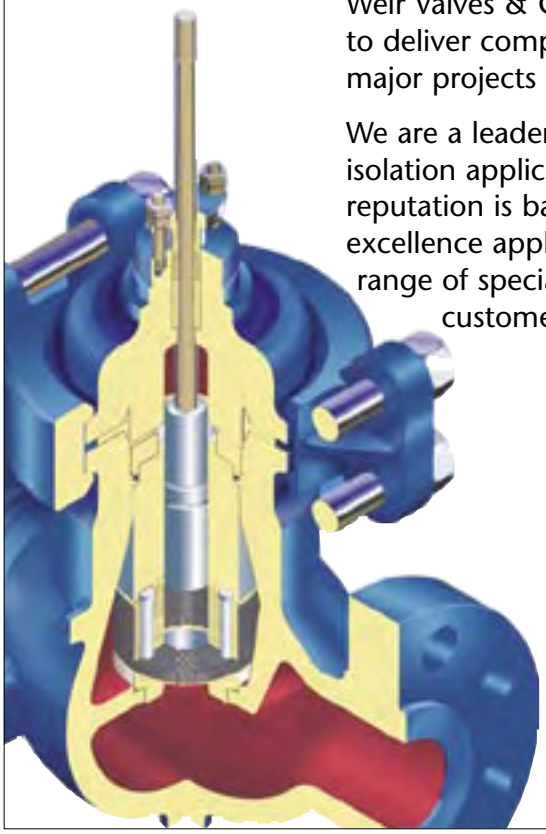

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Rotork's Golden Celebration

50 YEARS 1957 - 2007

rotork®

Rotork celebrated fifty years of international valve actuation success with a spectacular birthday party, held in a vast marquee in the grounds of Longleat House, close to the city of Bath where Jeremy Fry first started the company.

Over 800 guests, including present and former employees, suppliers and local businessmen enjoyed a glamorous evening of food, drink and entertainment which even the appalling English summer weather could do nothing to tarnish!

Entertainment was supplied by wandering opera singers The Three Waiters, a team of gymnasts and jugglers who had made a name for themselves at the Millennium Dome, Japanese inspired drummers from Scotland and The Bootleg Beatles.

Preparations for the party started over a year ago, explained Rotork Sales Support and Marketing Manager Tony Scott: *"The whole point was to create something special for those people who have done the most to make Rotork the world leader that it is today. Many met up with people who they hadn't seen in years. I lost count of the number of people who came up to me and said they had a great time."*

Among the many guests, Rotork's Laurence Kettle (left) and BVAA Director Rob Bartlett

Just some of Rotork's superb entertainment

Rotork were also the outright winner of the 2007 West of England Business of the Year Award, a prestigious annual event now in its twentieth year, organised by the international accounting and consulting firm Price Waterhouse Coopers.

The award recognises a company's achievements and performance across a broad range of aspects including innovation, business management, future outlook, employee development and training, health and safety, commitment to the community and environmental responsibility.

The rigorous selection procedure, performed by a judging panel comprised of leading figures from industrial, financial and business sectors, embraces the submission of an extensive written review of the business including performance figures for the past five years, followed by a detailed and penetrative visit to the company's premises.

Competition for the award was fierce. In addition to Rotork the six finalists consisted of eminent companies in the construction, property maintenance and business management sectors and the National Trust.

In the final analysis, however, the Rotork package of business achievement and innovation won through, proving once again that at the age of 50 the company can still outperform the toughest challengers.

Research and Development Director Graham Ogden led Rotork's award winning campaign, which follows closely on last year's success in winning a 2006 Innovation and Design Excellence Award.

Rotork: 01225 733 200

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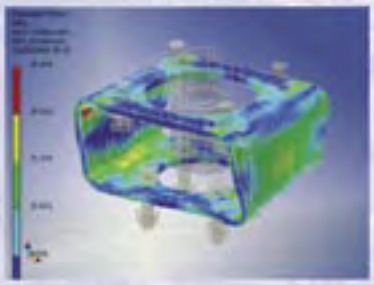

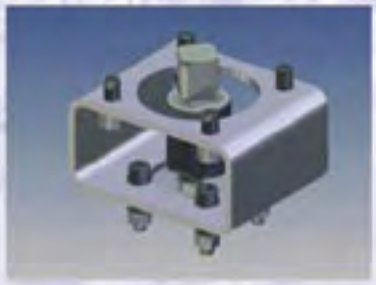

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The only source of knowledge is experience

Unique New Ribbed Disc Design from Tomoe

- Improves Flow Rates of 700 series valves

Tomoe, a world leader in the development of butterfly valves and associated actuation and control systems, has launched its revolutionary new 316SS stainless steel disc, developed for use in the 700 series valves. With its unique ribbed disc design, the 316SS offers significantly improved flow rates and optimises processing performance within plants.

The design of the new stainless steel disc is based on a disc pattern incorporating a series of ribs on opposite and opposing faces of the disk. This enables a thinner disc section to be used in the valve, providing higher CV characteristics over a conventional flat faced disc. It also leads to a noticeable reduction in the effects of cavitation by breaking up the flow into thinner 'jet streams', which dissipates energy over a greater number of 'jet streams'.

The discs incorporate all the other features and benefits of the flat faced disc design which is available for applications that require polished discs.

The 316SS stainless steel disc has been specifically developed for the 700 series, offers a broad choice of valves for most processes including water treatment, power generation and HVAC duties. In addition to the new ribbed design disk, valves in this range also offer abrasion resistance, chemical resistance and high temperature and high pressure suitability.

Tomoe, Tel: 01633 636800

Leeds Valve at OTC, Houston

An overview by Leeds Valve MD Steven Heap.

Steven Heap, MD Leeds Valve, and some OTC visitors

More than 67,000 people visited OTC in May 2007. This represented a twenty-five year high and an increase of thirteen per cent over 2006. OTC expanded for the first time into the adjacent Reliant Stadium, the home of "The Texans", Houston's American football team (formerly known as the "Houston Oilers").

Almost 2400 companies from thirty different countries participated in this showcase exhibition.

The offshore technology conference was founded in 1969 and is the world's foremost event for the development of offshore resources in the fields of drilling, exploration, production and environmental protection.

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Leeds, Tel: 0113 252 5081

A COATING FOR OPTIMUM VALVE PERFORMANCE

Do you have problems with excessive wear, corrosion or galling in your valve applications? Are traditional coating methods not achieving the results you would like? Or are lead times an issue? If so, then Hardide, a new and innovative hard facing coating, might just be the answer.

Hardide is a unique ultra-hard, tough and chemical resistant tungsten-carbide based component coating which has proven highly successful in valve applications. It has been developed by Hardide Coatings Limited which has manufacturing plants in Bicester, Oxfordshire, UK and Houston, Texas, USA. The nano-structured binder-free coating, which doesn't require grinding, can also coat out-of-sight surfaces and internal diameters e.g. valve bodies, connectors, and female threads on slabs for gate valves.

Hardide has proven to be extremely successful in ½" to 8" bore ball valve, as well as needle and gate valve applications. It is also proven for valve components including stems, balls, seats, bodies (internals), connectors (internals). As Hardide is a batch process and no post grinding is required on ball valves (only polishing), lead-times from uncoated to finished product are short; on average three weeks for ball valves. A lapping service is also available to ball valve customers, and balls and seats can be lapped as a matched set.

Hardide's unique properties include:

- 1300 – 1600 Hv
- accurately controlled thickness ranging from 5 to 100 microns, with a typical valve coating of 40 – 50 microns
- resists 3000 microstrain deformation without damage to the coating
- superior bond strength due to chemical bond
- low coefficient of friction making valve operation easier
- can be used against itself without galling concerns
- can be used in conjunction with HVOF

Robin Gillham, Business Development Manager for Valves at Hardide Coatings said: *"Hardide offers unique advantages for valve applications. In particular, our one stage in-house finishing means we can offer very quick turnaround times with no risk of particle pullout and no grinding stresses. The smoothness and uniformity of the coating also facilitates polishing. The coating has been consistently proven to outperform traditional hard coatings in industry standard tests including NACE TM0177, ASTM G65 and ASTM G75,"* added Mr Gillham.

Hardide is in commercial use around the world with valves operating in oil & gas facilities (downhole and topside), petrochemical refineries, food manufacturing, cryogenic equipment and power generation.

Hardide Coatings

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The Bestobell cryogenic gate valve – unique design, worldwide success

Bestobell Stainless Steel Gate Valves DN40-DN80

Five years after its launch, the Bestobell cryogenic gate valve is now widely accepted as the first choice of the cryogenic trailer manufacturing industry.

Its unique design – offering full bore flow rates with globe valve sealing performance – has led to a quiet revolution in the industry leading to lower fill times and significant financial savings.

Traditionally globe valves have been favoured by cryogenic storage tank builders and industrial gas companies in applications where tight shut off is critical. Conversely, the gate valve – despite its greater flow capabilities – has only been popular in applications where maximum flow rates are important due to the unreliable sealing capabilities of available products, as well as installation and maintenance issues.

However, the unique lapped finish on the Bestobell Gate Valve's seat means excellent sealing performance comparable to that of a globe valve.

Kevin Fretwell, Bestobell Valves' Technical Director, said: *"The design has been refined over the last few years so that, in recent tests, the Bestobell Gate Valve actually has better sealing capabilities than the Globe Valve. And, if we take the DN50 Bestobell Gate Valve as an example, it offers around five times the flow characteristics of the equivalent DN50 Globe Valve. The implications for cost saving as a result of shorter fill times are clear."*

Globe valve sealing performance from a Gate Valve

Two factors contribute to the unprecedented sealing performance of the Bestobell gate valve;

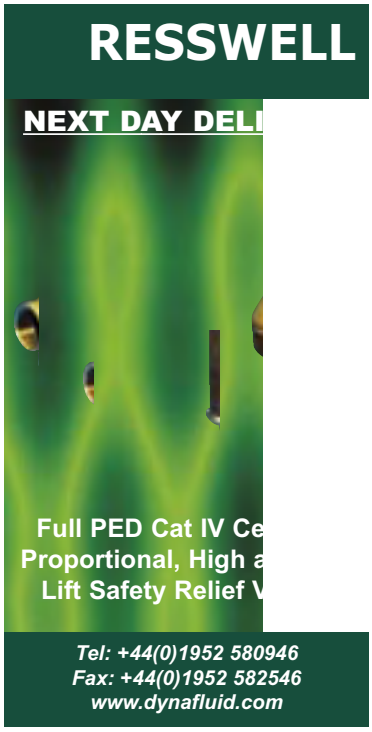
1. The Bestobell Lapped Seat

All Bestobell gate valves feature a lapped seat. On the DN40, this is threaded and seal-welded into the body, whereas on the DN50-DN80 this seat is mounted in a carrier attached to the headworks. No other cryogenic gate valve features such a lapped seat.

2. The Bestobell 'flexi wedge' Design (DN40–DN80)

The Bestobell Gate Valve wedge seat is unlike other gate valves in that it is designed to be removed from the valve wedge itself. The PTFE seat forms part of the bronze insert that sits inside the wedge. This bronze insert can be replaced easily and without the need to replace the actual stainless steel wedge.

- After 2000 cycle type tests, DN40 Bestobell Gate Valves had leakage rates on Helium of 50 cm^3/min.



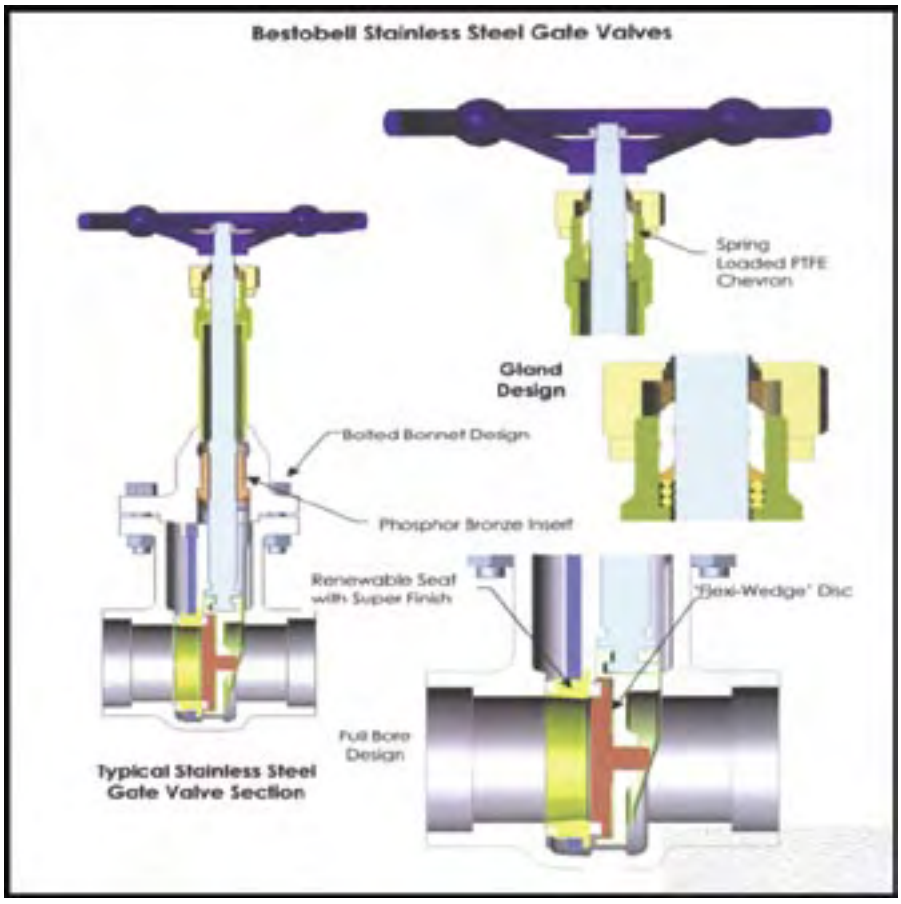
- Comparable figure for the DN40 soft seated Globe Valve 130 cm^3/min
- The standard EN1626 for Soft-Seated Valve DN40 allows 2400 cm^3/min

Conclusion: It is the combination of these two features that mean, on all sizes, the Bestobell Gate Valve has comparable, if not better, sealing characteristics to that of the Globe Valve.

Full bore flow characteristics

Unlike other available gate valves, the Bestobell Gate Valve offers full bore flow characteristics on all sizes, and therefore offers CV values that are considerably higher than for other valves.

Gate valve headworks showing replaceable seat and seal assembly



CAD sectioned view of the Bestobell stainless steel cryogenic gate valve

For example:
Bestobell Gate Valve: 50mm sized valve CV value 204 GPM
Globe Valve: 50mm sized valve CV value 43 GPM
Ball Valve: 50mm sized valve CV 138 GPM

In comparison:
Globe Valve: 100mm sized valve CV value 174 GPM

Conclusion: Looking specifically at the DN50 Bestobell Gate Valve, as above, it offers around five times the flow characteristics of traditional Globe Valve for fill duties, which will contribute to lower fill times.

More efficient installation and maintenance

Bestobell has also resolved important maintenance issues associated with conventional gate valves. Included in the design of the Gate Valve DN50-DN80 is a body seat that is removed from the valve body with the headworks.

Kevin Fretwell explained: *"With conventional gate valves, if the critical valve seat-face is damaged, the only solution is to cut the valve body from the pipework. But with the Bestobell Gate Valve you simply remove the headworks, replace the seat and re-install – simple, fast and cost effective."*

Bestobell Valves is the world leader in the design and manufacture of cryogenic valves, recognised globally for product quality and innovation. Bestobell valves are used with numerous cryogenic liquefied gases including oxygen, carbon dioxide, nitrogen, liquefied natural gas (LNG) and argon.

Bestobell, Tel: 0114 224 0000

Tomoe Appoints Distributor in Sweden

Tomoe, a world-leading manufacturer of butterfly valves and actuators, has recently appointed Processteknik GH AB as its distributor in Sweden. Tomoe supplies an extensive range of performance butterfly valves and actuators that combine the latest in both valve design and materials technology to meet the varied and demanding applications found in the chemical processing, power generation, water treatment, marine, automotive and food processing industries.

Commenting on the appointment, Willie Duncan, Tomoe Group sales and marketing director said, *"We are delighted to appoint Processteknik GH AB as our partner in Sweden and extend our reach within the European market. Tomoe places great emphasis on customer service, valve range optimisation, first-class technology and reliability. Processteknik operates to the same exacting business standards making us great partners for the future."*

Processteknik GH AB, founded in 1996, has a great deal of experience of working in the process industry with customers in pulp and paper, powerplants, chemicals, oil refineries, shipping, food and pharmaceutical sectors. The company offers an extensive range of valves suitable for a wide range of applications and industries.

"We specialise in steam and condensate applications and work closely with our customers to provide process solutions. We have a good relationship with Tomoe and, backed by their excellent range of butterfly valves and associated products, we can grow our business in Sweden," commented Goran Hilding, managing director, Processteknik GH AB.

Tomoe supplies an extensive range of performance valves and actuators that combine the latest in both valve design and materials technology to meet varied and demands and applications.

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Flowserve First Valve Manufacturer To Achieve Testing Laboratory Accreditation

Flowserve Flow Control UK has become the first valve company to achieve formal accreditation to ISO 17025 as a testing laboratory by the United Kingdom Accreditation Service (UKAS).

The UKAS award, which encompasses Flowserve's plants in Haywards Heath and Burgess Hill, was in direct response to customer requirements and covers hydrostatic, pneumatic, torque and anti-static testing and visual examination to a range of internationally-recognised standards and follows an intensive, three-month evaluation process. In addition, Flowserve's testing and inspection personnel are qualified and certificated to BS EN 473.

Integrating with Flowserve's ISO 9001 Quality Management System (which the company has held for over 20 years), principal QMS enhancements relate to calibration inspection records, which are now traceable back to UKAS accredited calibration laboratories, fully traceable test equipment and more detailed final certification. These enhancements now allow Flowserve Flow Control to offer certification comparable to any other similar accredited testing laboratory's.

Commenting Nick Green, General Manager, said: *"This recognition of our investment in quality management means that we are able to reduce the certification costs associated with using external laboratories. In addition eliminating transportation delays will enable us to upgrade our customer delivery performance."*

Initially, Flowserve will focus its certification activity on the valves produced at its Sussex manufacturing facilities and will evaluate future expansion to encompass other valve types produced by sister companies in its Flow Control Division, as well as external manufacturers.

United Kingdom Accreditation Service

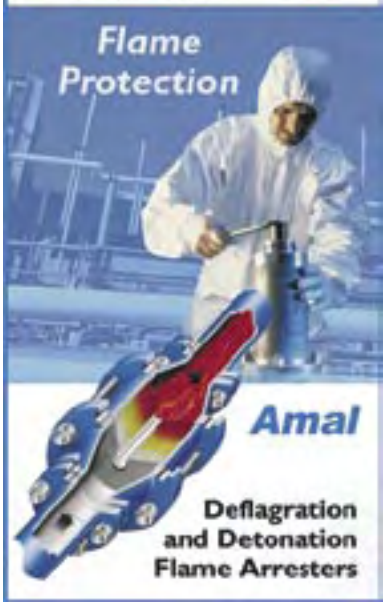
ACCREDITATION CERTIFICATE

UKAS

TESTING LABORATORY

Flowserve Flow Control (UK) Ltd

Safety Systems UK Ltd.
www.safetysystemsuk.com



Rotork Gears manufacture a wide range of Gearboxes, as well as Valve mounting kits, Switchboxes, valve position monitors, extensions, locking devices and other adaptation accessories for customised valve configuration.

The Gearboxes and accessories are designed to withstand the harsh challenges of various environments, to include Sub Sea and Nuclear.

Rotork Gears provide a complete solution for all valve gearbox and manual override requirements, flexible products to suit the needs of the valve and actuator industry, Cost effective partnerships with the international valve and actuator industry, full support and back up worldwide.

rotork gears your single source for valve gear technology

For further information visit our website www.rotork.com or e-mail info@rotorkgears.co.uk

Smart Wireless Communication

Emerson Adds ROC800-Series Remote Operations Controller to Smart Wireless Solutions

New Smart Wireless Communication capability in the ROC800-Series enables PlantWeb® to improve predictability of remote oil and gas assets.

Emerson Process Management has expanded its Smart Wireless solutions family, with the addition of native communications capability for the integration of wireless field networks to the ROC800-Series Remote Operations Controller. Extending the ROC800-Series to include wireless field networks enables oil and gas operators to improve asset predictability, manage remote assets more profitably, improve maintenance efficiency and effectiveness, and deliver cost reductions in asset construction time.

Wireless technology has long been used in the oil and gas industry where production and distribution systems can span hundreds of kilometres. In this industry, Emerson's remote operations controllers communicate with instrumentation at wellheads, pipelines, and other remote sites. Secure and robust wireless technology centralises access, helping users improve safety and minimise risk of dangerous environments. Furthering these benefits, Emerson's enhancement of the ROC800 adds wireless functionality to the company's Smart Remote Automation Solutions, which further extends the predictive intelligence of PlantWeb digital architecture into remote oil and gas locations.

The new Smart Wireless Communication capability allows the ROC800-Series Remote Operations Controller to communicate directly with any mix of up to 30 wireless temperature transmitters or wireless pressure transmitters over the self organising mesh field network. This has significant cost benefits when used for monitoring process variables that may be located up to 200 metres away from the RTU. Wiring of instrumentation has significant costs in these environments since land is often leased and surfaces may be rocky and difficult for wiring. The remoteness of such locations also makes manual monitoring very expensive.

Since Smart Wireless monitoring points enable up to 90 per cent installed cost reduction as compared with wired installations, the technology opens significant opportunities for operations improvement. Field instruments that use the wireless self-organising network approach can be installed to bring in diagnostic information from points that could not be monitored earlier because of cost constraints. There are a number of applications in these locations that can benefit from low cost incremental monitoring.

The predictive intelligence provided by the ROC800 with Smart Wireless Communication increases process availability and eliminates unnecessary field trips for data retrieval, configuration changes, and asset profiling. Through enabling online monitoring with detailed diagnostics and notification of potential problems, Smart Wireless helps users prevent unplanned downtime. Furthermore, it extends asset lifecycles through proactive asset management. Scheduled maintenance is now linked to actual asset performance to target the highest value equipment.

Learn more about the ROC800 and other Remote Automation Solutions from Emerson Process Management at: **www.EmersonProcess.com/Remote**

Bruce Logan of Hobbs Valve

HOBBS SUCCESS CONTINUES

It has long been argued that it is not easy to continually be at the forefront of innovation. It is even more difficult today, with commercial demand hugely outweighing global capacity – who needs to be innovative?

This lack of product innovation is a factor in keeping oil & gas production costs high and allows established manufacturers to avoid R&D costs, further reducing customer choice.

Hobbs Valve sees innovation as the driving force behind its success and has made the commitment to overcome these obstacles by ensuring the TVT range of Triple Offset Butterfly Valves are more than just competitively priced with short lead times.

With the launch of the TVT Double Block & Bleed earlier this year already illustrating a huge success and the current developments of Control and Cryogenic Valves due for release 2007/2008, Hobbs firmly stamps its commitment on providing solutions to age old problems.

Sales and Marketing Director Rhys Jones recently stated *'I am extremely proud to be associated with a product and a team of people that have a passion rather than a duty in ensuring Global Customers return to purchase more product time and time again.'* The current success has been echoed by the continual increase in Global approvals helped along by the appointment of Bruce Logan as Regional Sales Manager for Scotland, Scandinavia and London placing Hobbs Valve as one of the key suppliers of Today's Triple Offset Butterfly Valves.

The looming Offshore Europe Event held in Aberdeen will be an ideal opportunity to take the time and visit members of the team and find out more about the exciting times ahead.

Hobbs Valve will be present along side H.S. Pipequipment (stand 1519) supporting one of the many organisations who believe in their product and philosophy.

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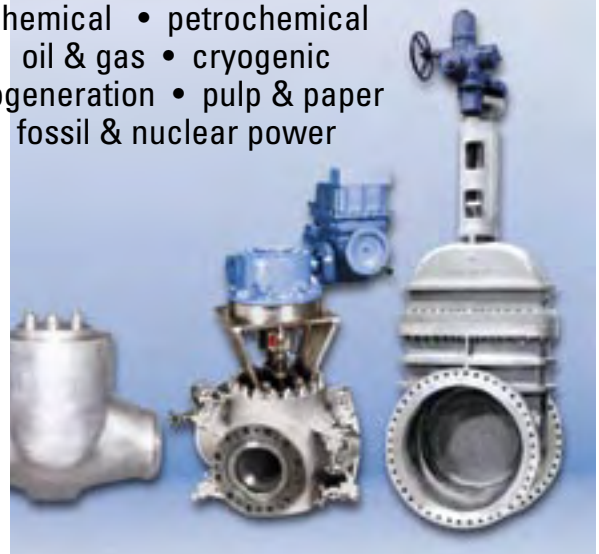

GENERAL INFORMATION

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Training Dates

Valve training from professionals

BVAA will again be running their very successful series of Training Courses in the Autumn.

Dates are:

Introduction to Valves – Mon 15th Oct 2007
Introduction to Actuators – Tues 16th Oct 2007
Control Valves – Wed 17th Oct 2007
Safety Valves – Thurs 18th Oct 2007
Introduction to SILs – Fri 19th Oct 2007

All product courses are £295+VAT.
BVAA members receive a 30% discount on fees.

The 'introduction' courses are ideal for newcomers to the industry or for admin staff. The Control and Safety Valves courses assume a basic familiarity of valves.

Full details are available from the BVAA website, http://www.bvaa.org.uk/H1.asp

Alternatively contact BVAA to register or for further details.

Would you prefer a training course at your own plant or premises?

BVAA also offer courses 'In House' at your convenience.
Call: 01295 221270.

Hobbs VALVE

Tomorrow's Valve Today

Hobbs Valve | Summer 07 | Vol.1 Bulletin

Our Future Is Your Future

Being the leading light in the supply of a 100% British Manufactured product established **Hobbs Valve** as a proven supplier of **Triple Offset Butterfly Valves.**

With continued market growth in the Oil & Gas, Petrochemical, Power & Marine Industry we aim to deliver your product within 14 Weeks when the demand of the Global Market is seeing lead times of up to 52 Weeks.

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Flow Control Valve (TVTFC)
Due for launch 2007

Double Block & Bleed Valve (TVTDB&B)
Launched

Cryogenic Service Valve (TVTCS)
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