

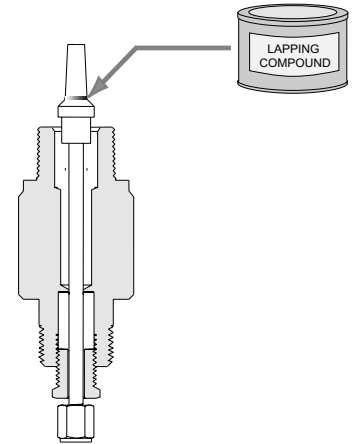
# RESEARCH CONTROL<sup>®</sup> VALVES

## Replacement Trim Instructions (Lapping Procedure)

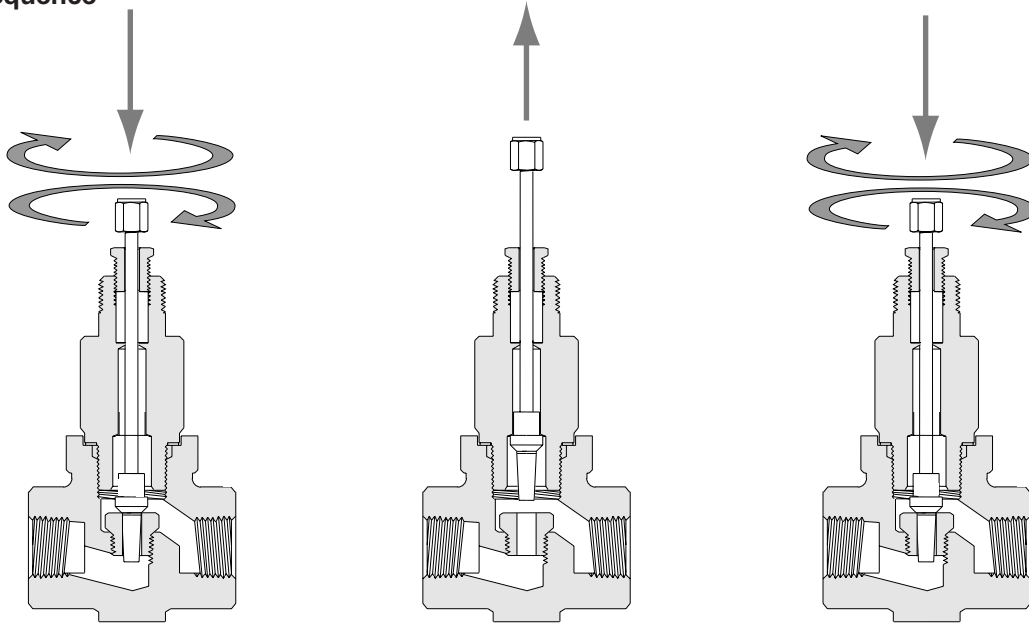
All replacement trim sets have been pre-lapped at the factory. When installed per factory instructions, the trim should not leak greater than an ANSI Class III shutoff. If better shutoff is required, please follow the instructions below. Before performing this procedure, please refer to the IOM for disassembly and reassembly instructions.

**Note: Soft seated trims should not be lapped.**

1. Install seat into body. Do not over torque (see manual). Install innervalve plug into bonnet after removing the packing. Lapping can be done with the packing removed and the packing gland acting as an upper guide. An optional lapping bushing may be used for better alignment; install it where the packing normally goes. Using a pipe cleaner or toothpick, apply a small amount of lapping compound (white aluminum oxide 38-1000 grit) uniformly around the seating surface of the innervalve plug.
2. Attach the bonnet to the body with body/bonnet gasket installed.



### Lapping Sequence



3. Begin lapping the trim by using a clockwise, counterclockwise motion between the thumb and forefinger, lifting the innervalve periodically off the seat and repositioning to achieve a uniform lap ring. If at first the plug sticks in the seat, lap lightly until the stick is gone. Do not over lap. After each lapping operation, remove the bonnet and clean both the seat and plug. Clean seat by submerging the body in solvent and swabbing the seat orifice with a wetted pipe cleaner or small brush. Blow dry parts with air.
4. Reassemble valve and check leak rate. Repeat lapping sequences three or four times until desired shutoff is achieved. If leakage still occurs, check both the seating surfaces of the innervalve plug and seat for nicks or scratches.

**Note: Do not lap any "Flow Trims" (K,L,M,N,O) or "P-Trims" for shutoff.**

