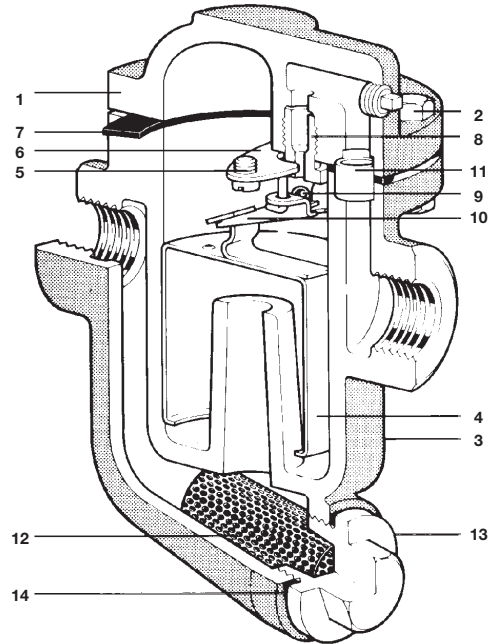


spirax sarco

Steel Inverted Bucket Steam Trap Series HM 34

The trap contains an inverted bucket mechanism which responds to the difference in density between steam and condensate. The discharge action is cyclic. Condensate and non-condensibles are discharged close to steam temperature. The HM 34 has an integral stainless steel strainer.

Model	HM 34
PMO	464 psig
Sizes	1/2", 3/4", 1"
Connections	NPT
Construction	Carbon Steel Body, Stainless Steel Internals
Options	SW Connections



Limiting Operating Conditions

Max. Operating Pressure (PMO)

	Model #	psig	barg
1/2"	HM34/4	464	32
	HM34/5	290	20
	HM34/6	170	12
	HM34/7	120	8.5
	HM34/8	60	4
3/4"	HM34/5	464	32
	HM34/6	290	20
	HM34/7	170	12
	HM34/8	120	8.5
	HM34/10	60	4
1"	HM34/5	464	32
	HM34/6	290	20
	HM34/8	170	12
	HM34/10	120	8.5
	HM34/12	60	4

Max. Operating Temperature *

482°F at 464 psig (250°C at 32 barg)

572°F (300°C) at operating pressures below

406 psig (28 barg)

* For superheated steam applications, a check valve should be installed at the trap inlet.

Pressure Shell Design Conditions

PMA	580 psig/up to 248°F	40 barg/up to 120°C
Maximum Allowable Pressure	472 psig/464°F	33 barg/240°C
	406 psig/572°F	28 barg/300°C

TMA	572°F/0-406 psig	300°C/0-28 barg
Maximum Allowable Temperature		

Capacities: See TIS 2.406

Construction Materials

No.	Part	Material	
1	Cover 1/2", 3/4" 1"	Forged Steel	1.0460 (C22.8)
		Cast Steel	DIN 17245 GS C25
2	Cover Bolts Cover Nuts	Steel	BS 4168 Gr.8.8
		Steel	BS3692 Gr.8
3	Body	Cast Steel	DIN 17245 GS C25
4	Bucket	Stainless Steel	AISI Type 321
5	Valve Guide Plate Screw	Stainless Steel	BS4183 (18/8)
		Stainless Steel	AISI Type 321
6	Valve Guide Plate	Nickel Reinforced Exfoliated Graphite	
7	Cover Gasket	Stainless Steel	AISI 440 B
8	Valve Seat	Stainless Steel	AISI 440 B
9	Valve	Stainless Steel	AISI Type 321
10	Valve Lever	Stainless Steel	AISI Type 304
11	Ferrule 1/2", 3/4" 1"	Stainless Steel	AISI Type 321H
		Stainless Steel	AISI Type 304
12	Strainer Screen	Stainless Steel	AISI Type 304
13	Strainer Cap	Steel	1.0460 (C22.8)
14	Strainer Gasket	Stainless Steel	AISI Type 304

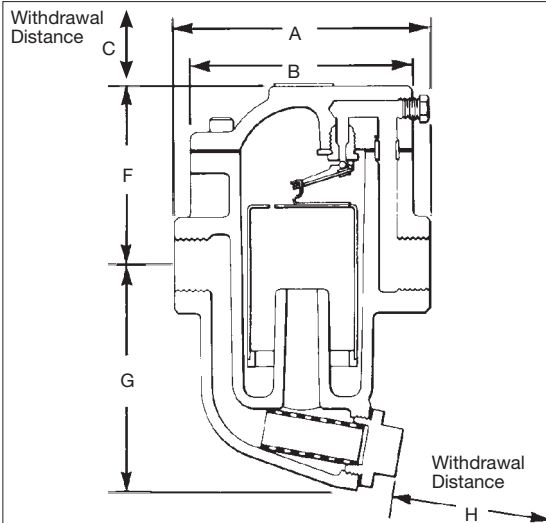
Typical Applications

Steam main drip stations, laundry equipment, industrial dryers and storage tanks.

Local regulation may restrict the use of this product below the conditions quoted. Limiting conditions refer to standard connections only. In the interests of development and improvement of the product, we reserve the right to change the specification.

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Steel Inverted Bucket Steam Trap Series HM 34



Dimensions (nominal) in inches and millimeters							
Size	A	B	C	F	G	H	Weight Scr./SW
1/2"	4.7 120	4.1 105	4.0 100	2.6 67	3.5 89	2.6 65	5.8 lb 2.6kg
3/4"	4.7 120	4.1 105	4.0 100	3.5 88	4.2 107	2.6 65	8.9 lb 4.0 kg
1"	7.1 180	6.3 160	6.3 160	5.7 145	4.7 120	3.4 85	22.9lb 10.4 kg

Sample Specification

Steam traps shall be of the mechanical inverted bucket type with steel bodies with screwed NPT horizontal connections, stainless steel internals, and an integral stainless steel strainer.

Installation

Suitable full-port isolation valves should be placed around trap to permit servicing. The trap should be installed below the equipment drainage connection in a horizontal position so that the bucket will rise and fall vertically.

Maintenance

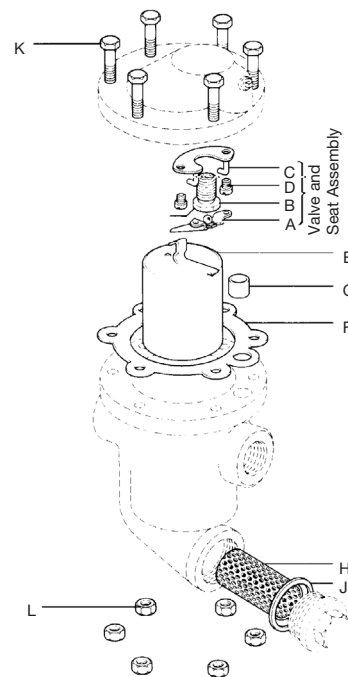
This product can be maintained without disturbing the piping connections. Complete isolation of the trap from both supply and return line is required before any servicing is performed.

The trap should be disassembled periodically for inspection and cleaning of the valve head and seat, and operating mechanism. The bucket vent hole must be clear. The strainer screen should be removed and cleaned.

Worn or damaged parts should be replaced using a complete valve and seat assembly.

Complete installation and maintenance instructions are given in IMI 2.400, which accompanies the product.

Spare Parts



Valve & Seat Assembly	A, B, C, (2 of D)
Bucket	E
Cover Gasket & Ferrule (pkt of 3)	F, G
Strainer Screen	H
Strainer Cap Gasket (pkt of 3)	J
Set of Cover Bolts & Nuts (set of 6)	K, L

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