



TOP ENTRY BALL VALVE



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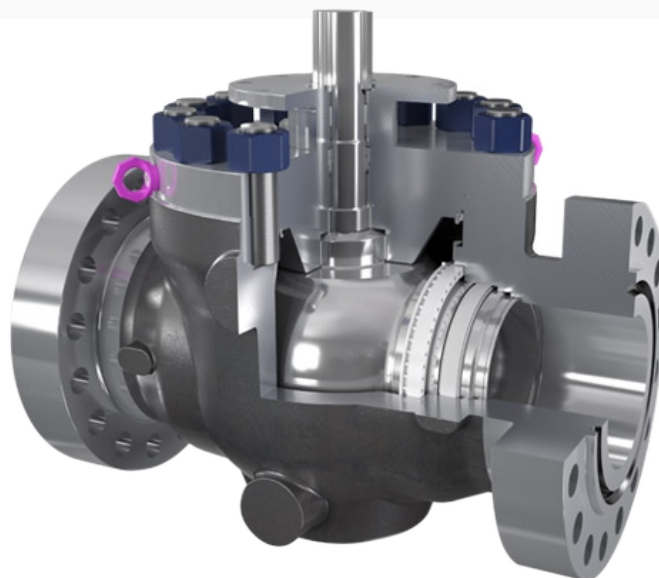
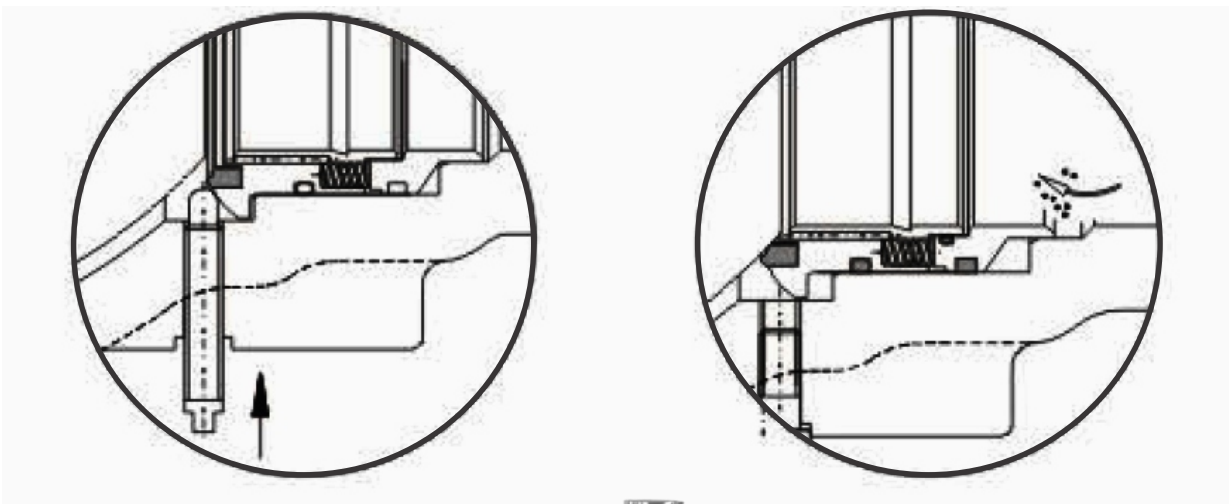
Introduction :-

The Top Entry Ball Valve is mainly used on pipeline and industrial systems. It has such advantages as top online maintenance functions, small fluid resistance, simple structure, reliable sealing, convenient operation & maintenance, rapid on - off operation, flexible opening and closing. The driving modes includes manual operation worm & worm gear transmission, pneumatics operations and electric operation. The connection end can flange or butt welding

The body adopt the integral structure, so as to ensure that it has enough strength and rigidity under the maximum rated working pressure. The valve trims have been carefully designed and selected to ensure reliability under various working conditions. The sufficient wall thickness and the connection bolt of high strength are very helpful to the maintenance and services of valve and are able to endure pipeline stress.

Top Entry Structure:

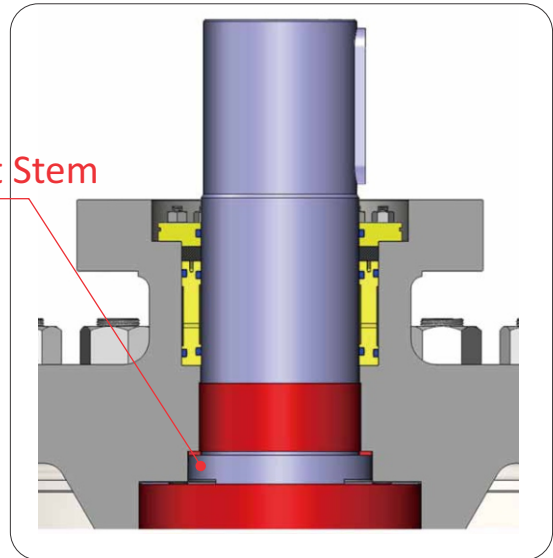
The valve adopt the TOPENTRY structure. The most distinctive differences between this kind of valve and others is that the online maintenance function can be realized without need of removing valve from the pipeline. The seat adopt the connections type seat structure, and rear the end of the seat retainer set as oblique angle to prevent impurities accumulated on the seat from influencing the connections of seat.



Anti Blow-out Stem

The valve stem is designed with a Collor which makes it blow out proof under pressure conditions.

Anti Blow-out Stem

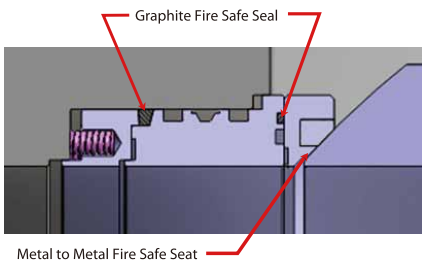


Anti-static Device

A spring loaded ball makes positive electrical continuity between ball, stem and body. This is a standard feature on all Dembla ball valves.

Fire Safe Design

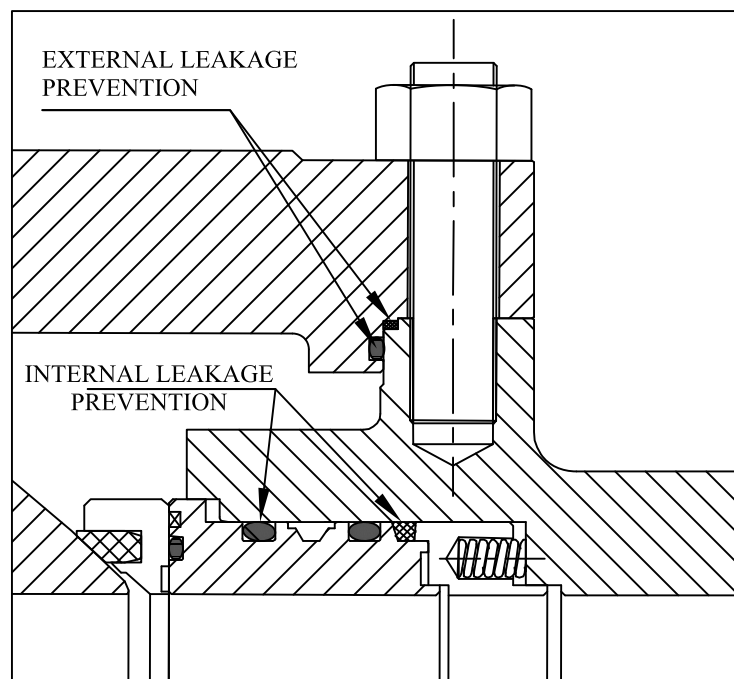
Valves when supplied with fire safe design the external and internal process fluid leakage is restricted as follows so that the valve meet API607 / API 6FA requirements.



Internal Leakage Prevention External Leakage Prevention

The seat design is such that in case of fire the polymer soft seat gets decomposed or deteriorated, the adjacent metallic edge of seat retainer comes in contact with the ball as the seat retainer is energized with multiple seat springs. This minimizes the leakage in the valve bore. Also an additional graphite ring is provided on the outer diameter of seat retainer. This graphite ring prevents internal leakage through the periphery of seat retainer.

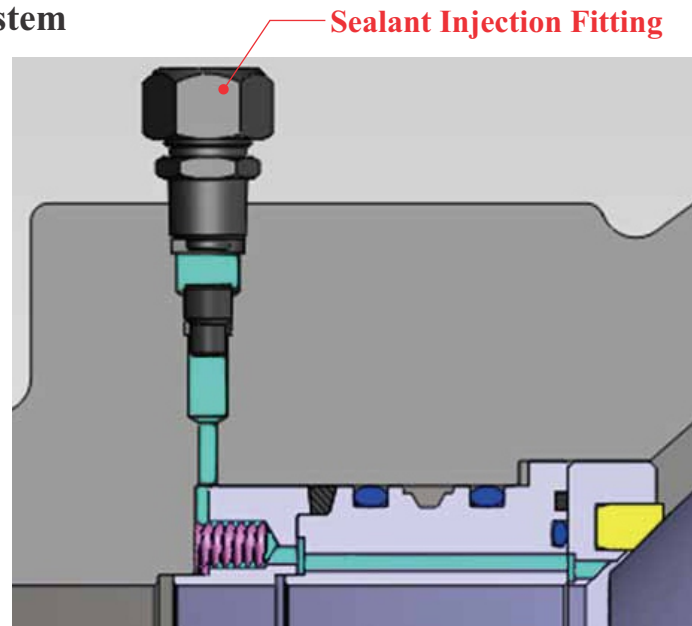
The gland arrangement has two nos 'o' rings and a graphite gasket. The gland packing is of graphite material. The leakage from body to side connection is designed with graphite gasket in addition to 'o' ring. In case of fire the graphite gland packings and graphite gasket prevent external leakage.



Design Features

Emergency Sealant Injection System

The sealant injection fittings are provided on ball valves for the seat and valve stem. In case the soft seat or gland seals are damaged due to some accidental cases the liquid sealants can be injected through these fittings at seat ring and gland area to prevent leakage. These fitting contain internal check valves. These fittings are provided on all Dembla Trunnion Ball Valves sizes 6' and above.



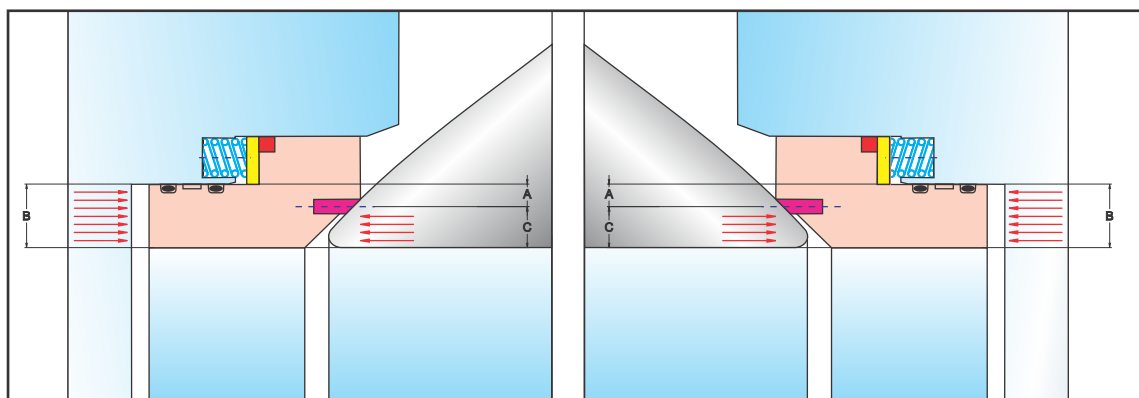
Double Block and Bleed

Both up stream and down stream seats are capable of sealing fluid pressure independently when valve is in fully closed / open position. If pressure is applied simultaneously from up stream and down stream the cavity is isolated and the pressure in the body cavity can be released through drain plug.

The seat assembly is provided with multiple helical springs on its back

face. With the ball and seat assembly these springs are compressed and push the seat towards the ball ensuring ball and seat contact even at zero line pressure.

When the line pressure increases the seat differential area $A=(B-C)$ that creates a piston effect facing the seat against ball. This additional load increases seal effectiveness.

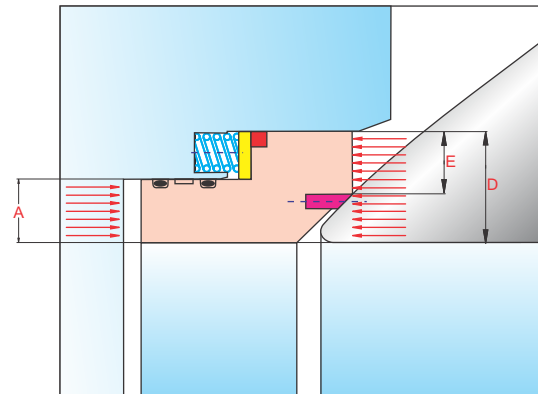


Double Block and Bleed

Design Features

Automatic Cavity Relief

If the valve cavity pressure increases beyond the line pressure the differential area at the inner face of seat creates a differential area $E = (D - A)$ that pushes the seat away from the ball thus releasing the excess cavity pressure back to line pressure at up stream / down stream.



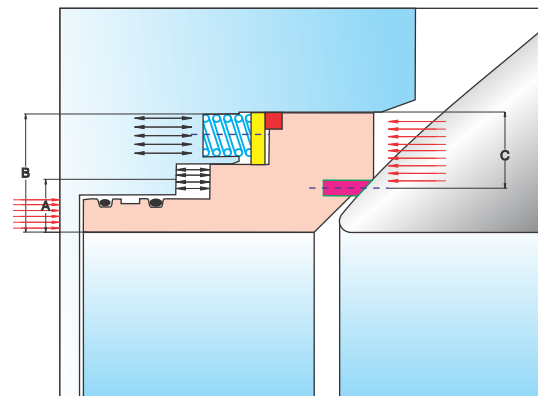
Double Piston effect Seats

With standard cavity relief seats create single seal on the seat exposed to line pressure. The opposite seat relieves the cavity pressure.

If the up stream seat fails it may be appropriate to use down stream seat as a secondary sealing arrangement.

This arrangement can be given using double piston effect with modified seats.

The seats are designed with a double piston profile exploring more surface area to cavity pressure than a normal floating seat. The fluid pressure upstream / downstream as well as in the body cavity creates a resultant thrust that pushes the seat towards ball. The differential area $A = B - C$ creates a piston effect forcing the

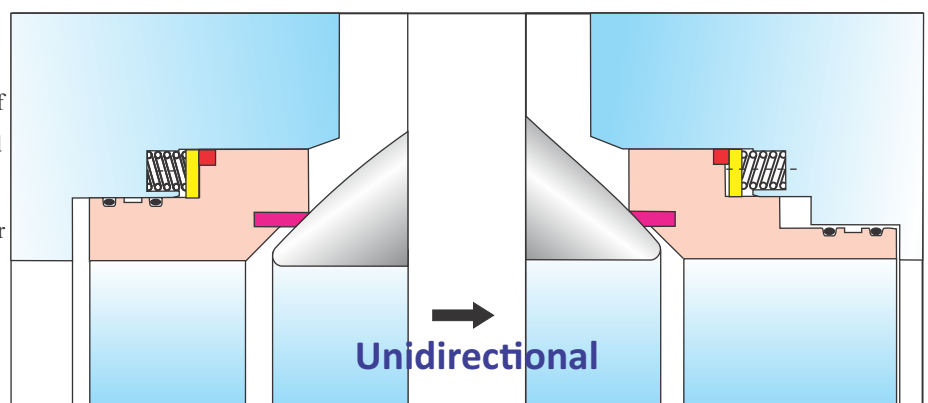


seat against the ball. Valve with double piston effect seat rings require a relief valve to be provided in the body cavity in order to reduce the build up of over pressure in the body cavity.

Self Relieving Upstream and Double Piston Effect Down-stream Seat

As an option it is possible to adapt the self relieving seat at upstream side and double piston effect seat on the downstream side. In this case the need for cavity pressure relief valve is eliminated.

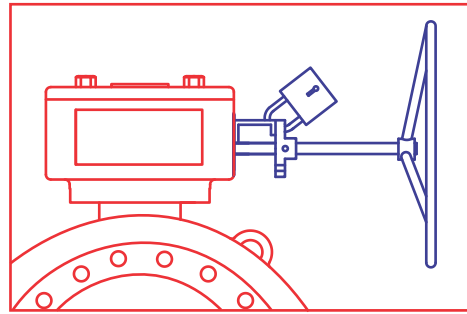
With this combination of seats the valve becomes unidirectional. This arrangement is available on request.



Design Features

Locking Devices

Locking facility is available as standard on all Dembla Gear Operators. This facility is also available on Lever Operators.



Actuation

Dembla ball valves are designed with ISO 5211 top flanges to accept pneumatic, electric and hydraulic actuators. The valve components are engineered so that the breakaway torques are minimum that allow for economical actuator packages.

The automated ball valves are fully mounted, tested and calibrated with actuators and accessories before shipment.

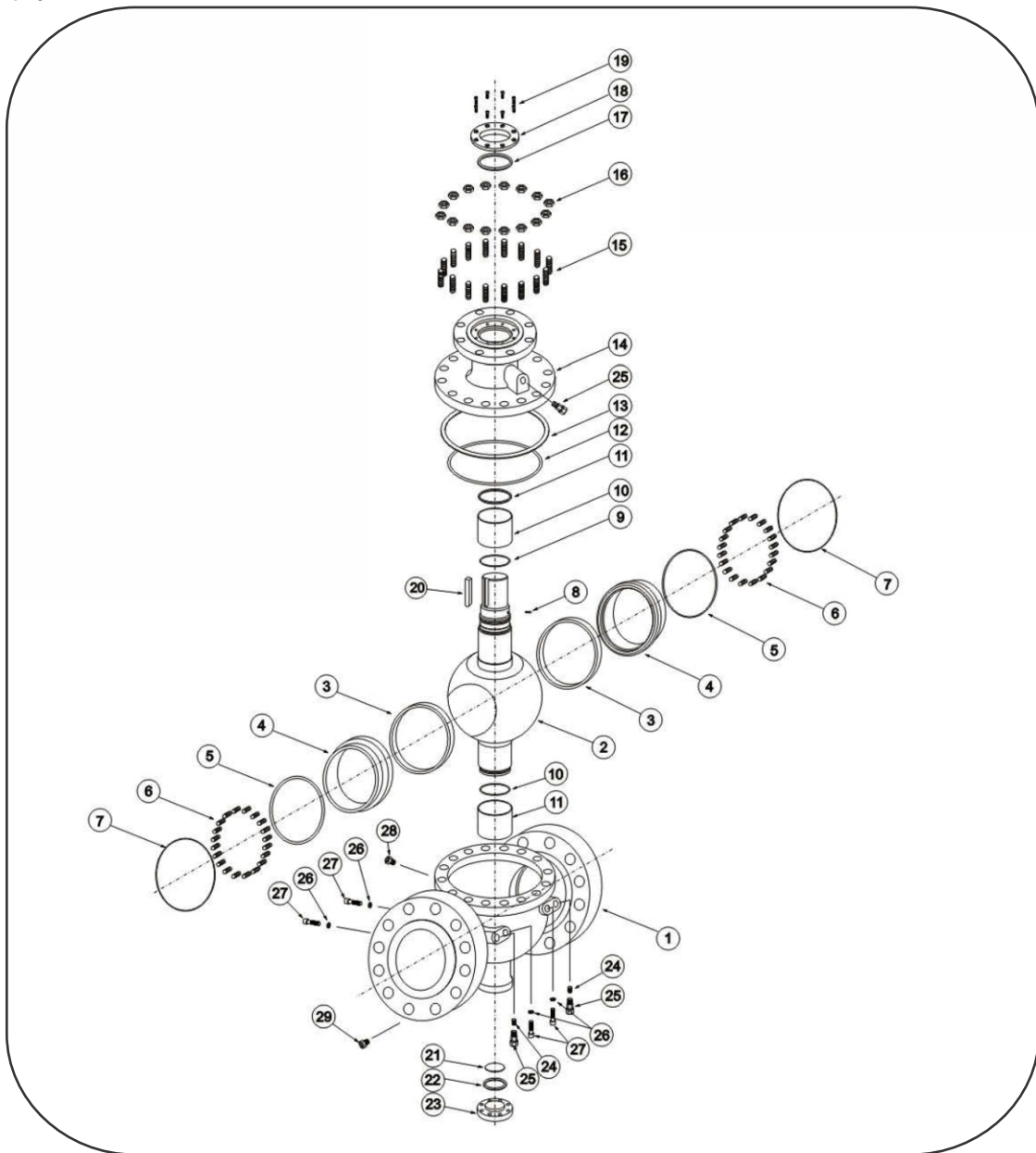


Coatings / Weld Overlay Technology

A wide variety of coatings like hard chrome, electro less nickel coatings and weld overlay of Stellite, Tungsten carbide, Inconel 625 can be provided on ball seat and other components to provide a cost affective solutions for corrosive and erosive applications. Using these technologies could result in considerable savings without affecting the performance of the valve and service life.



Part :



Sr. No.	Part	Sr. No.	Part	Sr. No.	Part
1	Body	11	Thrust Bearing	21	Thrust bearing
2	Ball	12	O rings	22	Anti Fire Gasket
3	Seat	13	Anti Fire Gasket	23	Lower Cover
4	Seat Ring	14	Bonnet	24	Check Valve
5	O rings	15	Stud	25	Sealant Injection
6	Spring	16	Hexagon nut	26	Sealing gasket
7	Anti Fire Packing	17	Packing	27	Socked Head Screw
8	Anti- Static Device	18	Gland Packing	28	Air release valve
9	O ring	19	Socked Head Screw	29	Drainage valve
10	Sliding Bearing	20	Flat Key		

Material Specifications

Part No.	Part	Carbon Steel	Stainless Steel	Low Temperature Service	Nace Service
1	Body	ASTMA216-WCB	ASTMA351-CF8M	ASTMA352-LCB	ASTMA216-WCB
2	Side Connection	ASTMA216-WCB	ASTMA351-CF8M	ASTMA352-LCB	ASTMA216-WCB
3	Ball	ASTMA105N/ENP	ASTMA182-F316	ASTMA350-LF2/ENP	ASTMA105N/ENP
4	Soft Seat	RPTFE/NYLON/PEEK DEVLON	RPTFE/NYLON/PEEK DEVLON	RPTFE/NYLON/PEEK DEVLON	RPTFE/NYLON/PEEK DEVLON
5	Seat Retainer	ASTMA105N/ENP	ASTMA182-F316	ASTMA350-LF2/ENP	ASTMA105/ENP
6	Valve Shaft	ASTMA105N/ENP	ASTMA182-F316	ASTMA350-LF2/ENP	ASTMA105/ENP
7	Thrust Washer (Trunnion to Ball)	PTFE COATED- CARBON STEEL	PTFE COATED- CARBON STEEL	PTFE COATED- CARBON STEEL	PTFE COATED- CARBON STEEL
8	Trunnion	ASTMA216-WCB-ENP	ASTMA351-CF8M	ASTMA352-LCB/ENP	ASTMA216-WCB/ENP
9	Gasket (Bonnet to Body)	316SS+Graphite	316SS + Graphite	316SS+Graphite	316SS+Graphite
10	Gasket (Body to Side Conn)	316SS+Graphite	316SS + Graphite	316SS + Graphite	316SS+Graphite
11	Backup Gasket	Graphite	Graphite	Graphite	Graphite
12	Bonnet	ASTMA105N	ASTMA182-F316	ASTMA350-LF2	ASTMA105N
13	Mounting Flange	ASTM105N	ASTMA182-F316	ASTMA350-LF2	ASTMA105N
14	Thrust Washer (Shaft to Bonnet)	25% Glass Fiber+ PTFE/BRONZE	25% Glass Fiber+ PTFE/BRONZE	25% Glass Fiber + PTFE/BRONZE	25% Glass Fiber + PTFE/BRONZE
15	Bearing Bush (Ball to Trunnion)	PTFE+COATED+ CARBON STEEL	PTFE COATED+ SS316	PTFE COATED+ CARBON STEEL	PTFE COATED+ CARBON STEEL
16	Vent	Stainless Steel	Stainless Steel	Stainless Steel	Stainless Steel
17	Drain	Stainless Steel	Stainless Steel	Stainless Steel	Stainless Steel
18	Seat Spring	Inconel X-750	Inconel X-750	Inconel X-750	Inconel X-750
19	'O'-Ring (Shaft to Bonnet)	VITON/NBR/EPDM	VITON/NBR/EPDM	VITON/NBR/EPDM	VITON/NBR/EPDM
20	O-Ring (Bonnet to Body)	VITON/NBR/EPDM	VITON/NBR/EPDM	VITON/NBR/EPDM	VITON/NBR/EPDM
21	O-Ring (Seat Retainer to Side Conn.)	VITON/NBR/EPDM	VITON/NBR/EPDM	VITON/NBR/EPDM	VITON/NBR/EPDM
22					
23	O-Ring (Side Connection to Body)	VITON/NBR/EPDM	VITON/NBR/EPDM	VITON/NBR/EPDM	VITON/NBR/EPDM
24	Stud with one nut (Body to Side Conn.)	ASTMA193-B7	ASTMA193-B8	ASTMA320-L7M	ASTMA193-B7M
25	Allen Bolt (Bonnet to Body)	ASTMA194-2H	ASTMA194-8	ASTMA194-7M	ASTMA194-2HM
26	Allen Bolt (Mounting Flange to Bonnet)	Stainless Steel	Stainless Steel	Stainless Steel	Stainless Steel
27	Lock Pin (Mounting Flange to Bonnet)	Carbon Steel	Stainless Steel	ASTMA320-L7M	Carbon Steel
29	Seat Injection	Carbon Steel	Stainless Steel	Stainless Steel	Carbon Steel
30	Stem Injection	Carbon Steel	Stainless Steel	Stainless Steel	Carbon Steel

1] Please contact factory for materials supplied.

Quality Control

Dembla has extensive Quality control Department. Experienced engineers are trained and qualified to level II for testings requirements like radiography, Ultrasonic test, Dye penetrate test, Magnetic, Particle Test etc. Additional testing requirements like fire test, Low Fugitive Emission test,

and Vacuum are under quality control department. Valves are offered with 3.1 certificate whenever required. Extensive quality documentation are produced and submitted to customer for every project. Third party / Customers inspections

are carried out on routine basis. The factory has independent testing equipments and separate inspection cell who offers final inspection to customers.

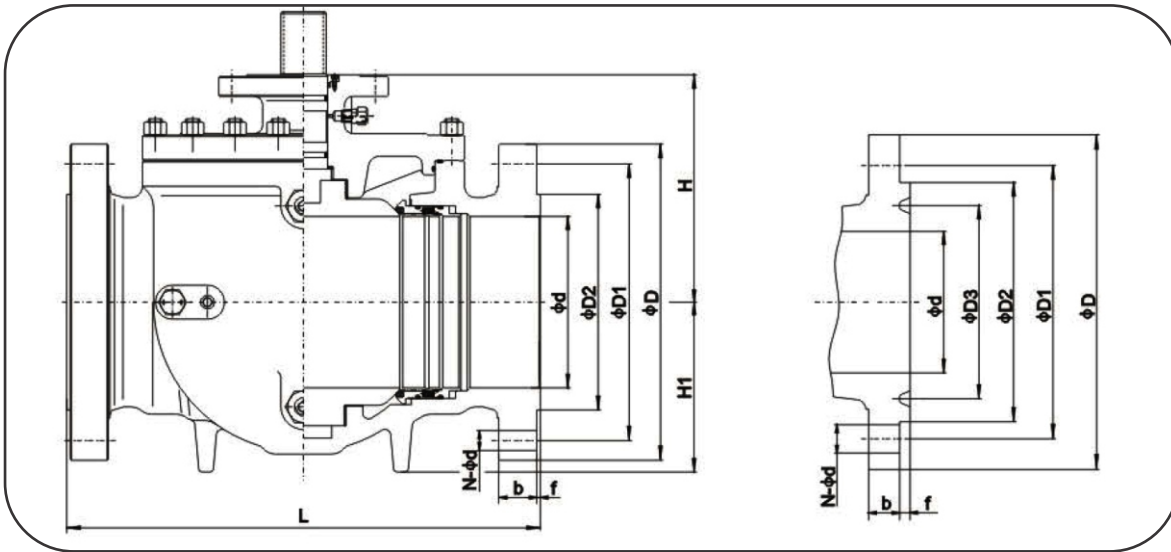
Dembla Quality Processes

- Chemical Composition (PMI)
- Mechanical Property Testing
- NDT Tests (UT, RT, PT, MT)
- Dimensional Inspection
- Degreasing & Cleaning for Oxygen Service
- Pressure Testing
- Fire Safe Testing
- Low fugitive Emission Testing
- Vacuum Testing
- Painting Inspection like
- Surface Preparation Inspection

Design and Testing Standards

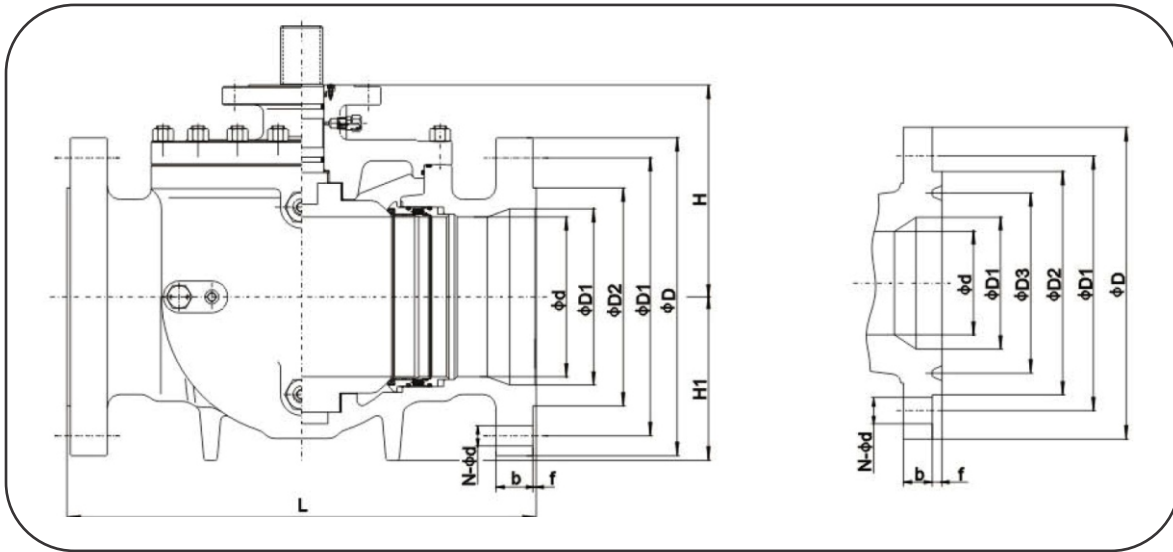
- Design Standards : ASME B16.34, API 6D, BS 5351, BS/EN 17292
- Flange Drilling : ANSI B16.5, ANSI B16.47 Series A & B, MSS SP 44, EN 1092
- Face-to-Face : ANSI B16.10, API 6D
- Buttweld Ends : ASME B16.25, ASME B31.3
- Actuator Mounting Pad : ISO 5211
- Drain / By Pass : API 6D
- Materials : ASME SEC.II
- Nace Compliance : NACE MR 01-75
- Valve Testing : API 598, API 6D, EN 12266-1 & 2, ISO 5208
- Fire Safe Design : API 607, API 6FA
- Casting Inspection : MSS SP -55
- Fugitive Emission Test : ISO 15848

Dimension:



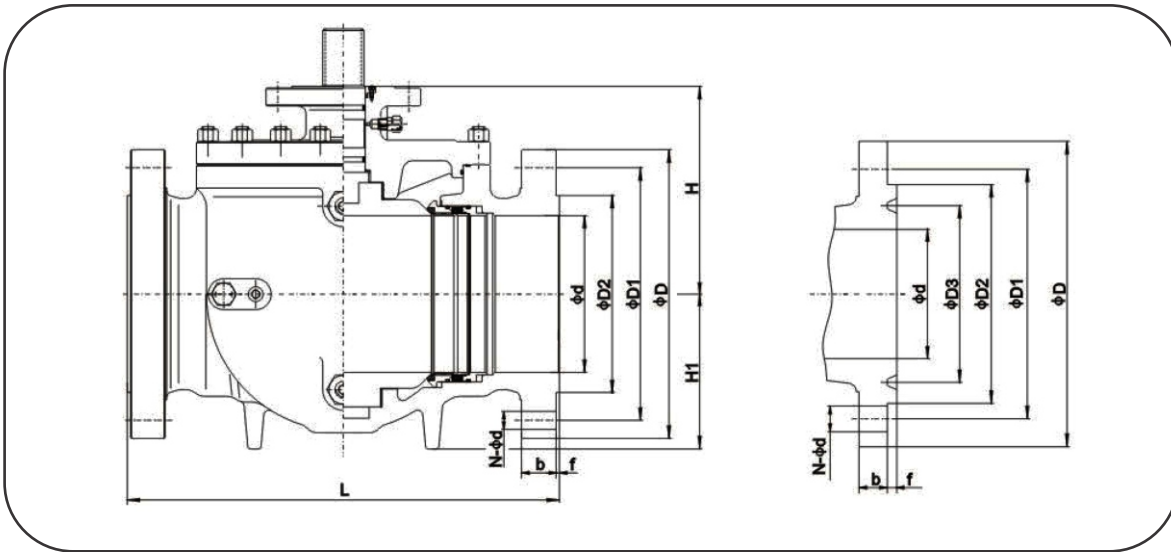
Pressure rating	Nominal Diameter		d	Flanged		Butt welding	Flanged						H	H1	Weight(kg)	
	Class	NPS		DN	L(RF)		L(RTJ)	L(BW)	D	D1	D2	D3				f
150	2"	50	50	292	295	292	150	120.5	92	-	2	14.5	4-φ19	130	102	△
	3"	80	75	283	298	283	190	152.5	127	-	2	17.5	4-φ19	163	150	△
	4"	100	100	432	435	432	230	190.5	157	-	2	22.5	8-φ19	177	175	△
	6"	150	150	559	562	559	280	241.5	216	-	2	24	8-φ22	240	231	△
	8"	200	201	660	664	660	345	298.5	270	-	2	27	8-φ22	266	256	△
	10"	250	252	787	791	787	405	362	324	-	2	29	12-φ25	324	303.5	△
	12"	300	303	838	841	838	485	432	381	-	2	30.5	12-φ25	383	310	△
	14"	350	334	889	892	889	535	476	413	-	2	33.5	12-φ29	390	300	△
	16"	400	385	991	994	991	595	540	470	-	2	35	16-φ29	435	340	△
	18"	450	436	1092	1095	1092	635	578	533	-	2	38.5	16-φ32	522	410	△
	20"	500	487	1194	1200	1194	700	635	584	-	2	41.5	20-φ32	565	445	△
	24"	600	589	1397	1407	1397	815	749.5	692	-	2	46.5	20-φ35	618	480	△
	26"	650	633	1448	-	1448	870	806.5	749	-	2	68	24-φ35	660	540	△
	28"	700	684	1549	-	1549	927	864	800	-	2	71	28-φ35	690	596	△
	30"	750	735	1651	-	1651	984	914.5	857	-	2	75	28-φ35	770	620	△
	32"	800	779	1778	-	1778	1060	978	914	-	2	81	28-φ41	838	680	△
36"	900	874	2083	-	2083	1168	1086	1022	-	2	90	32-φ41	910	710	△	
300	2"	50	50	292	295	292	165	127	92	-	2	21	8-φ19	130	102	△
	3"	80	75	283	298	283	210	168.5	127	-	2	27	8-φ22	163	150	△
	4"	100	100	432	435	432	255	200	157	-	2	30.5	8-φ22	177	175	△
	6"	150	150	559	562	559	320	270	216	-	2	35	12-φ22	240	231	△
	8"	200	201	660	664	660	380	330	270	-	2	40	12-φ25	266	276	△
	10"	250	252	787	791	787	445	387.5	324	-	2	46.5	16-φ29	324	303.5	△
	12"	300	303	838	841	838	520	451	381	-	2	49.5	16-φ32	383	362	△
	14"	350	334	889	892	889	585	514.5	413	-	2	52.5	20-φ32	390	300	△
	16"	400	385	991	994	991	650	571.5	470	-	2	56	20-φ35	440	365	△
	18"	450	436	1092	1095	1092	710	628.5	533	-	2	59	24-φ35	535	420	△
	20"	500	487	1194	1200	1194	775	686	584	-	2	62	24-φ35	575	450	△
	24"	600	589	1397	1407	1397	915	813	692	-	2	68.5	24-φ41	640	490	△
	26"	650	633	1448	-	1448	972	876.5	749	-	2	79	28-φ45	680	560	△
	28"	700	684	1549	-	1549	1035	940	800	-	2	86	28-φ45	720	610	△
	30"	750	735	1651	-	1651	1092	997	857	-	2	92	28-φ48	808	640	△
	32"	800	779	1778	-	1778	1149	1054	914	-	2	98	28-φ51	860	700	△
36"	900	874	2083	-	2083	1270	1168	1022	-	2	105	32-φ54	935	730	△	

Dimension:



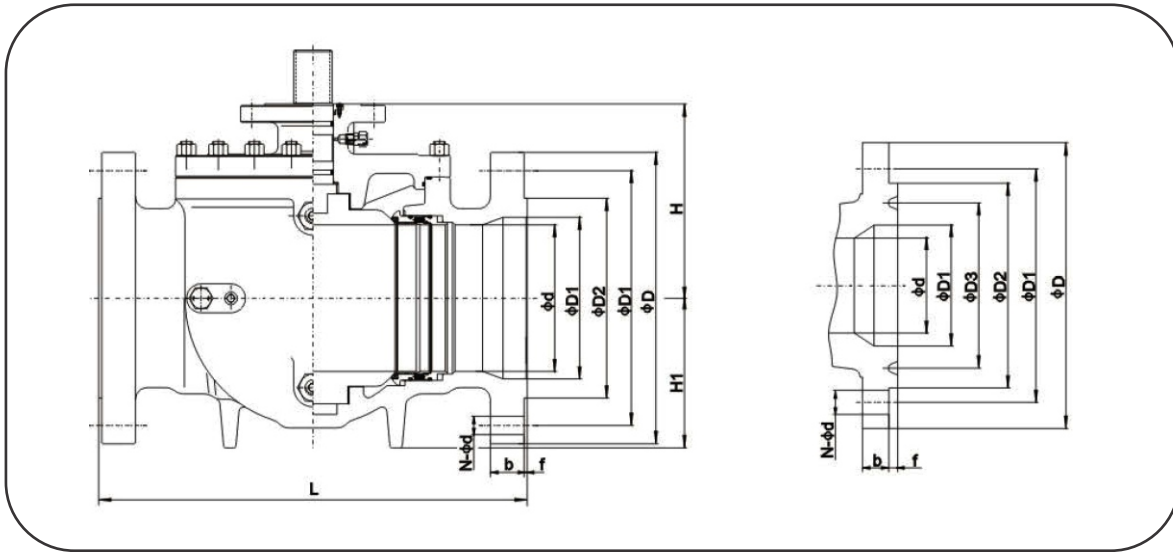
Pressure rating	Nominal Diameter		d	d1	Flanged		Butt welding	Flanged					H	H1	Weight(kg)		
	Class	NPS			DN	L(RF)		L(RTJ)	L(BW)	D	D1	D2				D3	f
150	3"×2"	80	50	75	283	298	283	190	152.5	127	-	2	17.5	4-φ19	130	102	△
	4"×3"	100	75	100	432	435	432	230	190.5	157	-	2	22.5	8-φ19	163	150	△
	6"×4"	150	100	150	559	562	559	280	241.5	216	-	2	24	8-φ22	177	175	△
	8"×6"	200	150	201	660	664	660	345	298.5	270	-	2	27	8-φ22	240	231	△
	10"×8"	250	201	252	787	791	787	405	362	324	-	2	29	12-φ25	266	256	△
	12"×10"	300	252	303	838	841	838	485	432	381	-	2	30.5	12-φ25	324	303.5	△
	14"×10"	350	252	334	889	892	889	535	476	413	-	2	33.5	12-φ29	324	303.5	△
	14"×12"	350	303	334	889	892	889	535	476	413	-	2	33.5	12-φ29	383	310	△
	16"×12"	400	303	385	991	994	991	595	540	470	-	2	35	16-φ29	383	310	△
	16"×14"	400	334	385	991	994	991	595	540	470	-	2	35	16-φ29	390	300	△
	18"×16"	450	385	436	1092	1095	1092	635	578	533	-	2	38.5	16-φ32	435	340	△
	20"×16"	500	385	487	1194	1200	1194	700	635	584	-	2	41.5	20-φ32	435	340	△
	20"×18"	500	436	487	1194	1200	1194	700	635	584	-	2	41.5	20-φ32	522	410	△
	24"×20"	600	487	589	1397	1407	1397	815	749.5	692	-	2	46.5	20-φ35	565	445	△
30"×24"	750	589	735	1651	-	1651	984	914.5	857	-	2	75	28-φ35	618	480	△	
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300	3"×2"	80	50	75	283	298	283	210	168.5	127	-	2	27	8-φ22	130	102	△
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	6"×4"	150	100	150	559	562	559	320	270	216	-	2	35	12-φ22	177	175	△
	8"×6"	200	150	201	660	664	660	380	330	270	-	2	40	12-φ25	240	231	△
	10"×8"	250	201	252	787	791	787	445	387.5	324	-	2	46.5	16-φ29	266	276	△
	12"×10"	300	252	303	838	841	838	520	451	381	-	2	49.5	16-φ32	324	303.5	△
	14"×10"	350	252	334	889	892	889	585	514.5	413	-	2	52.5	20-φ32	324	303.5	△
	14"×12"	350	303	334	889	892	889	585	514.5	413	-	2	52.5	20-φ32	383	362	△
	16"×12"	400	303	385	991	994	991	650	571.5	470	-	2	56	20-φ35	383	362	△
	16"×14"	400	334	385	991	994	991	650	571.5	470	-	2	56	20-φ35	390	300	△
	18"×16"	450	385	436	1092	1095	1092	710	628.5	533	-	2	59	24-φ35	440	365	△
	20"×16"	500	385	487	1194	1200	1194	775	686	584	-	2	62	24-φ35	440	365	△
	20"×18"	500	436	487	1194	1200	1194	775	686	584	-	2	62	24-φ35	535	420	△
	24"×20"	600	487	589	1397	1407	1397	915	813	692	-	2	68.5	24-φ41	575	450	△
30"×24"	750	589	735	1651	-	1651	1092	997	857	-	2	92	28-φ48	640	490	△	
36"×30"	900	735	874	2083	-	2083	1270	1168	1022	-	2	105	32-φ54	808	640	△	

Dimension:



Pressure rating	Nominal Diameter		d	Flanged		Butt welding	Flanged						H	H1	Weight(kg)		
	Class	NPS		DN	L(RF)		L(RTJ)	L(BW)	D	D1	D2	D3				f	b
600		2"	50	50	292	295	292	165	127	92	-	7	26	8-Φ19	142	110	△
		3"	80	75	356	359	356	210	168.5	127	-	7	32	8-Φ22	188	165	△
		4"	100	100	432	435	432	275	216	157	-	7	38.5	8-Φ25	205	193	△
		6"	150	150	559	562	559	355	292	216	-	7	48	12-Φ29	255	242	△
		8"	200	201	660	664	660	420	349	270	-	7	56	12-Φ32	282	268	△
		10"	250	252	787	791	787	510	432	324	-	7	64	16-Φ35	369	339	△
		12"	300	303	838	841	838	560	489	381	-	7	67	20-Φ35	402	300	△
		14"	350	334	889	892	889	605	527	413	-	7	70	20-Φ39	410	320	△
		16"	400	385	991	994	991	685	603	470	-	7	77	20-Φ41	467	360	△
		18"	450	436	1092	1095	1092	745	654	533	-	7	83	20-Φ44	560	430	△
		20"	500	487	1194	1200	1194	815	724	584	-	7	89	24-Φ44	633	490	△
	24"	600	589	1397	1407	1397	940	838	692	-	7	102	24-Φ51	692	536	△	
900		2"	50	50	368	371	368	215	165	124	95.25	7.92	38.5	8-Φ25	160	112	△
		3"	80	75	381	384	381	240	190.5	156	123.83	7.92	38.5	8-Φ25	213	168	△
		4"	100	100	457	460	457	290	235	181	149.23	7.92	45	8-Φ32	232	197.5	△
		6"	150	150	610	613	610	380	317.5	241	211.12	7.92	56	12-Φ32	289	258	△
		8"	200	201	737	740	737	470	393.5	308	269.88	7.92	64	12-Φ39	319	294	△
		10"	250	252	838	841	838	545	470	362	323.85	7.92	70	16-Φ39	407	372	△
		12"	300	303	965	968	965	610	533.5	419	381	7.92	79.5	20-Φ39	443	329	△
		14"	350	322	1029	1038	1029	640	559	467	419.1	11.13	86	20-Φ42	467	345	△
		16"	400	373	1130	1140	1130	705	616	524	469.9	11.13	89	20-Φ45	527	388	△
		18"	450	423	1219	1232	1219	785	686	594	533.4	12.7	102	20-Φ51	632	463	△
		20"	500	471	1321	1334	1321	855	749.5	648	584.2	12.7	108	20-Φ54	715	527	△
	24"	600	570	1549	1568	1549	1040	901.5	772	692.15	15.88	140	20-Φ67	782	573	△	

Dimension:



Pressure rating	Nominal Diameter		d	d1	Flanged			Butt welding						H	H1	Weight(kg)		
	Class	NPS			DN	L(RF)	L(RTJ)	L(BW)	D	D1	D2	D3	f				b	N-φd
600		3"×2"	80	50	75	356	359	356	210	168.5	127	-	7	32	8-φ22	142	110	△
		4"×3"	100	75	100	432	435	432	275	216	157	-	7	38.5	8-φ25	188	165	△
		6"×4"	150	100	150	559	562	559	355	292	216	-	7	48	12-φ29	205	193	△
		8"×6"	200	150	201	660	664	660	420	349	270	-	7	56	12-φ32	255	242	△
		10"×8"	250	201	252	787	791	787	510	432	324	-	7	64	16-φ35	282	268	△
		12"×10"	300	252	303	838	841	838	560	489	381	-	7	67	20-φ35	369	339	△
		14"×10"	350	252	334	889	892	889	605	527	413	-	7	70	20-φ39	369	339	△
		14"×12"	350	303	334	889	892	889	605	527	413	-	7	70	20-φ39	402	300	△
		16"×12"	400	303	385	991	994	991	685	603	470	-	7	77	20-φ41	402	300	△
		16"×14"	400	334	385	991	994	991	685	603	470	-	7	77	20-φ41	410	320	△
		18"×16"	450	385	436	1092	1095	1092	745	654	533	-	7	83	20-φ44	467	360	△
		20"×16"	500	385	487	1194	1200	1194	815	724	584	-	7	89	24-φ44	467	360	△
		20"×18"	500	436	487	1194	1200	1194	815	724	584	-	7	89	24-φ44	560	430	△
	24"×20"	600	487	589	1397	1407	1397	940	838	692	-	7	102	24-φ51	633	490	△	
900		3"×2"	80	50	75	381	384	381	240	190.5	156	123.83	7.92	38.5	8-φ25	160	112	△
		4"×3"	100	75	100	457	460	457	290	235	181	149.23	7.92	45	8-φ32	213	168	△
		6"×4"	150	100	150	610	613	610	380	317.5	241	211.12	7.92	56	12-φ32	232	197.5	△
		8"×6"	200	150	201	737	740	737	470	393.5	308	269.88	7.92	64	12-φ39	289	258	△
		10"×8"	250	201	252	838	841	838	545	470	362	323.85	7.92	70	16-φ39	319	294	△
		12"×10"	300	252	303	965	968	965	610	533.5	419	381	7.92	79.5	20-φ39	407	372	△
		14"×10"	350	252	322	1029	1038	1029	640	559	467	419.1	11.13	86	20-φ42	407	372	△
		14"×12"	350	303	334	1029	1038	1029	640	559	467	419.1	11.13	86	20-φ42	443	329	△
		16"×12"	400	303	373	1130	1140	1130	705	616	524	469.9	11.13	89	20-φ45	443	329	△
		16"×14"	400	334	385	1130	1140	1130	705	616	524	469.9	11.13	89	20-φ45	467	345	△
		18"×16"	450	373	423	1219	1232	1219	785	686	594	533.4	12.7	102	20-φ51	527	388	△
		20"×16"	500	373	471	1321	1334	1321	855	749.5	648	584.2	12.7	108	20-φ54	527	388	△
		20"×18"	500	423	471	1321	1334	1321	855	749.5	648	584.2	12.7	108	20-φ54	632	463	△
	24"×20"	600	471	570	1549	1568	1549	1040	901.5	772	692.2	15.88	140	20-φ67	715	527	△	



Dembla

Sales Office:

M/S. Dembla Valves Ltd.
C-30, Jai Matadi Compound, Kalher
Village, Thane-Bhiwandi-Agra Raod -
421302,
Maharashtra, India.
Tel - +91-9292234790 - 97
E-mail - expo@dembla.com
[More info - www.dembla.com](http://www.dembla.com)

Works:

M/S. Dembla Valves Ltd.
A/8, Arahm Logistic, Valshind Village,
Mumbai -Nashik Highway
(NH3), Bhiwandi
Thane - 421302. Maharashtra (India)

