

Trumbull Manufacturing is an outgrowth of Trumbull Industries which was founded in 1922 in Warren, Ohio (Trumbull County). Manufacturing operations started in 1981 to offer specialty products for the Municipal and Industrial markets. We stand behind our products with experienced Engineering, Quality Control and Field Service personnel. Our products are designed for long life, and are rigorously tested in-house and at independent labs.

Trumbull Mud Valves are manufactured in cast iron and cast stainless steel. Stem designs include Non-Rising Stem (NRS), Rising Stem (RS), as well as sliding stem. A full line of accessories are offered to operate our Mud Valves, including Valve Position Indicators, Extension Stems, Stem Guides, Floorstands and Floor Boxes.

**Premium Stainless Mud Valves** use only cast stainless components & have additional advantages:

- Heavy-duty CAST stainless steel, Type 316
  - 1. No welded components
  - 2. Cast design eliminates problem of carbide precipitation from welding
  - 3. Stainless castings passivated per ASTM A-967
- · Resilient seats are field-replaceable and mechanically retained; available in a variety of elastomers
- One-piece heavy-duty stem, 3rd party torque tested to over 500 ft-lb
- Permanently bonded coating on stainless stem prevents galling, 3rd party tested to over 15,000 cycles
- Rising stem, non-rising stem and sliding stem styles

Extend useful life of critical valves and components

"All stainless" installation available with stainless Extension Stem, Stem Guide and Floorstand

Trumbull Mud Valves have been thoughtfully designed to meet the highest expectations of Engineers and Operators.



3850 Hendricks Road, Youngstown, Ohio 44515

Phone: | Toll Free: | Fax: 330.270.7888 | 877.504.1507 | 330.392.0756

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Cast Iron Mud Valves

Certified to NSF-61 & NSF-372 in U.S.A. & Canada

TRUMBULL MUD VALVES are designed primarily for use in settling tanks of water and wastewater treatment plants. They are for low pressure applications only; consult Trumbull for special requirements. Their intended use is to drain tanks for maintenance or cleaning.

Mud valves are furnished with a 2" square operating nut; however, they can be supplied with optional extension stem or handwheel (see our Catalog page G-4).

This valve series uses bronze seats in the body and gate (also available with resilient seat). The cast iron body assembly features manganese bronze stems and guides for use in submerged installations. The fasteners are furnished in stainless steel to prevent corrosion from years of submerged service.

Nuts, bolts and gaskets for mounting to floor pipe are NOT furnished but can be ordered separately. Cast iron components are coated with Tnemec N140-1211 epoxy, per NSF 61. See pages 4 and 5 for drawings.

#### NOTE

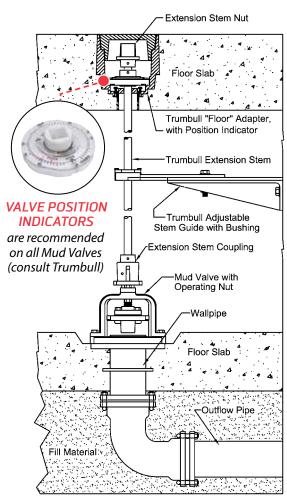
The flange drilling is according to ANSI 125# STD. on all sizes; however, one hole under each leg of the yoke is not available for fastening to the mating flange.

	Non-Ris	sing Stem	Rising Stem			
Size	Trumbull Item No.	Weight	Trumbull Item No.	Weight		
3″	367-1309	26.00 lbs.	367-1329	25.00 lbs.		
4"	367-1310	31.00 lbs.	367-1330	30.00 lbs.		
6"	367-1311	47.00 lbs.	367-1331	46.00 lbs.		
8″	367-1312	76.00 lbs.	367-1332	73.00 lbs.		
10"	367-1313	95.00 lbs.	367-1333	90.00 lbs.		
12"	367-1314	130.00 lbs.	367-1334	130.00 lbs.		
14"	367-1315	142.00 lbs.				
16"	367-1316	169.00 lbs.		<b>-</b>		
18"	367-1317	256.00 lbs.	Consult Trumbull for availability.			
20"	367-1318	281.00 lbs.				
24"	367-1319	450.00 lbs.				

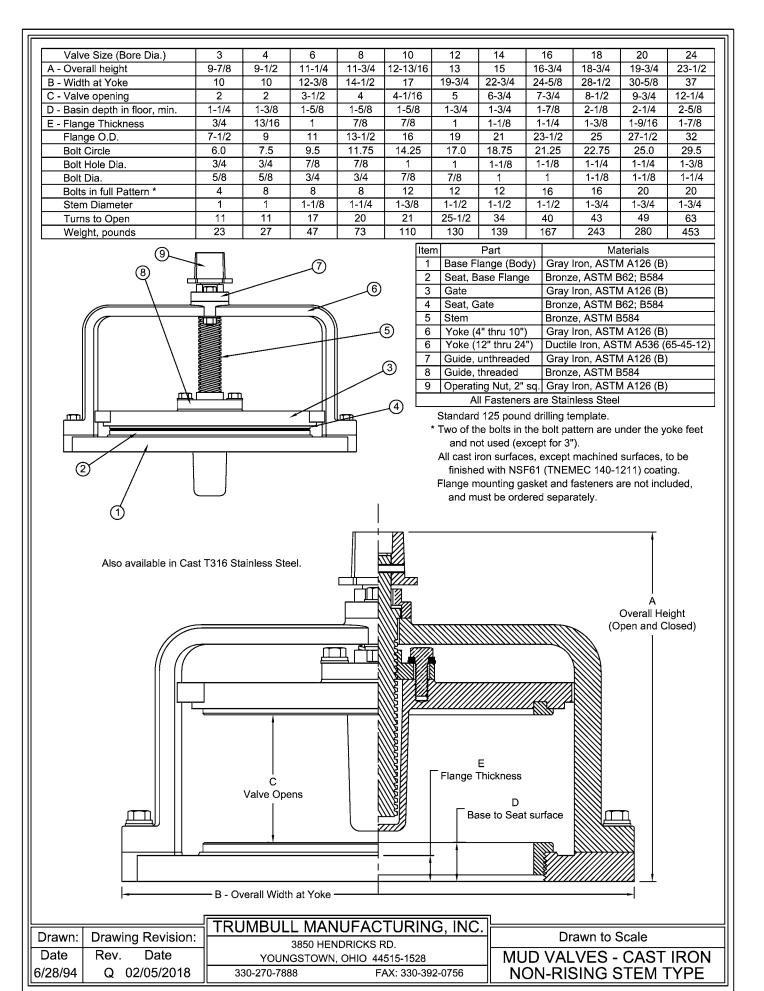
See page 10 for installation options.



Rising Stem Style



Typical Mud Valve Installation



A. Overall height, closed 9-3/4 11 11-3/4 12-3/4 13 14-1/2 16-3/4 19-3/4 27-3/4 29-3/4 38-1/2 17-3/4 18-3/4 18-3/4 25-1/2 (24-3/4 27-3/4 29-3/4 38-1/2 39-5/8 37-3/4 25-1/2 17-3/4 18-3/4 18-3/4 25-1/2 (24-3/4 27-3/4 29-3/4 38-1/2 39-5/8 37-3/4 18-3	Value Gine (Dama Din )	1	1 6	0	10	40	1 44	40**	40**	20**	24**
A. Overall Height, Open  11-1/76  14-3/8  15/34  15-3/4  15-3/4  15-3/4  15-3/2  15-3/2  15-3/4  15-3/4  15-3/4  15-3/2  15-3/2  15-3/4  15-3/	Valve Size (Bore Dia.)	9 2/4	6	8	10	12	14 1/2	16**	18**	20**	24**
B- Width at Yoke    10											
C Valve opening					+						
D- Beain depth in floor, min. 1-3/8   1-5/8   1-5/8   1-5/8   1-5/4   1-17/8   1-17/8   2-1/8   2-1/4   2-5/8   E Flange Thickness   13/16   1   7/8   7/8   1   1-17/8   1-17/8   1-17/8   1-17/8   E Flange O.D. 9   11   13-1/2   16   19   21   23-1/2   25   27-1/2   32   Bol Crote   7-5   9.5   11/75   14/2   17.0   16/75   21/25   22/5   25-5   Bol Crote   7-5   9.5   11/5   14/2   17.0   16/75   21/25   22/5   25-5   Bol Crote   7-5   9.5   3/4   3/4   7/8   1   1   1-1/8   1-1/4   1-1/4   1-1/4   Bots in full Pattern*   8   8   8   12   12   12   16   16   20   20   Sitem Diameter   1   1-1/8   1-1/4   1-3/4   1-3/4   1-3/4   1-3/4   Turns to Open   11   17   20-1/2   20   25   35   40   45   50   60   Sitem Diameter   10   11/7   20-1/2   20   25   35   40   45   50   60   Meight pounds   30   48   7/3   110   130   140   165   240   238   450    Slandard 125 pound drilling template.  **Consult Trumbial on the availability of to* and larger sizes in the Bot pattern are under the ycke feet and not used.  All cast from surfaces, except machined surfaces, to be finished with NSF81 (TNEMEC 140-1211) coating.  Flange mountain on the availability of to* and larger sizes in the Rising Stem configuration.  **Consult Trumbial on the availability of to* and larger sizes in the Rising Stem configuration.  **Consult Trumbial on the availability of to* and larger sizes in the Rising Stem configuration.  **TRUMBULL MANUFACTURING**  Drawn: Drawn: Drawn Drawn Drawn: Drawn Dra											
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Plange O.D.	·										
Bott Circle 7, 5 9.5 11,75 14,25 17,0 18,75 21,25 22,75 25,0 28,5 28,5 28,5 28,5 28,5 28,5 28,5 28,5	<u> </u>										
Bolt Dia	-										
Bott Dia											
Botts in full Pattern*   8   8   8   12   12   12   16   16   20   20   20   25   35   40   45   50   60   60   60   60   60   60   6								ļ		-	
Stem Diameter											
Turns to Open											
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Standard 125 pound drilling template.  *Two of the bots in the bot pattern are under the yoke feet and not used.  *All cast fron surfaces, except machined surfaces, to be finished with NSF61 (TNBMEC 140-1211) coating.  Flange mounting gasket and fasteners are not included, and must be ordered separately.  **Consult Trumbull on the availability of 16" and larger sizes in the Rising Stem configuration.  **Also available in Cast T316 Stainless Steel  **Overall Height  Open  **Drawin: Drawing Revision:  Date  Rev. Date    TRUMBULL MANUFACTURING   Drawn to Scale   MUD VALVES - CAST IRON   Mude from the value of the bot pattern and value in the part of the bot pattern and value in the part of the bot pattern and value in the part of the p	•										
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Drawn: Drawing Revision: TRUMBULL MANUFACTURING Drawn to Scale  3850 Hendricks Road MUD VALVES - CAST IRON	Times to Open 11 17 20-1/2 20 25 35 40 45 50 60 Weight, pounds 30 46 73 110 130 140 150 240 280 450 Standard 125 pound drilling template.  *Two of the bolts in the both pattern are under the yoke feet and not used.  All cast iron surfaces, except machined surfaces, to be finished with NSF61 (TNEMEC 140-1211) coating. Flange mounting gasket and fasteners are not included, and must be ordered separately.  *Consult Trumbull on the variability of 16" and larger sizes in the Rising Stern configuration.  **Indeed of the surface of										
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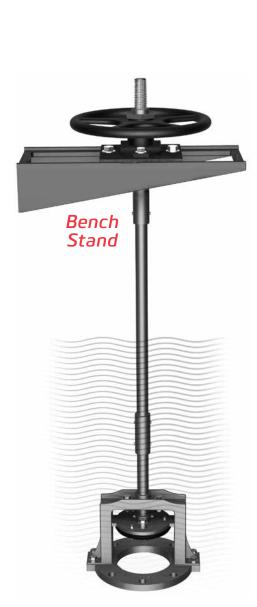


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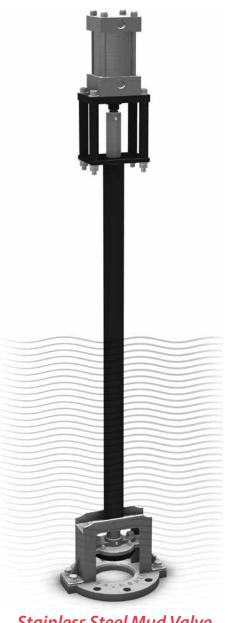
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## Other Adaptations for Mud Valves



Sliding Stem Mud Valve

Available when desirable to keep operating threads out of the water.



Stainless Steel Mud Valve Extended Bonnet with Pneumatic Cylinder

For remote operation.



Floorstand with Limit Switches

For remote indication of valve position.



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### Cast 316 Stainless Steel Mud Valves

Heavy-Duty Design - Certified to NSF-61 & NSF-372 in U.S.A. & Canada

TRUMBULL MUD VALVES are

designed primarily for use in settling tanks of water and wastewater treatment plants. They are for low pressure applications only; consult Trumbull for special requirements. Their intended use is to drain tanks for maintenance or cleaning.

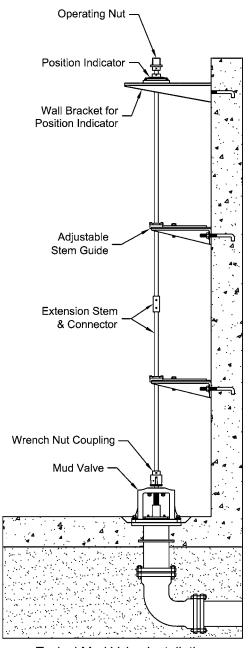
Due to the corrosive applications in which Mud Valves are used, the yoke, flange, guides and gate are cast from Type 316 stainless steel. The one-piece,

Type 316 stem has a permanently bonded coating to protect against galling for a lifetime of maintenance-free operation. Cast components eliminate corrosion problems frequently caused when stainless steel is welded. Castings are passivated after machining, per ASTM A-967. Heavy-duty design incorporates generous wall thicknesses and stem diameters for maximum strength and corrosion protection. Seat is SBR rubber for positive shutoff. Mechanically retained seat is field-replaceable. Fasteners are Type 316 stainless. See pages 8 and 9 for drawings.

Nuts, bolts and gaskets for mounting to floor pipe are NOT furnished but can be ordered separately.

	Non-Ris	ing Stem	Rising Stem				
Size	Domestic	Non- Domestic	Domestic	Non- Domestic			
3"	1367-1349		1367-1369*				
4"	1367-1350	367-1350*	1367-1370*	367-1370			
6"	1367-1351	367-1351*	1367-1371*	367-1371			
8"	1367-1352	367-1352*	1367-1372*	367-1372			
10"	1367-1353	367-1353*	1367-1373*	367-1373			
12"	1367-1354	367-1354*	1367-1374*	367-1374			
14"	spec/ord	367-1355					
16"	spec/ord	367-1356					
18"	spec/ord	367-1357	* Consult Trumbull for availability.				
20"	spec/ord	367-1358					
24"	spec/ord	367-1359					

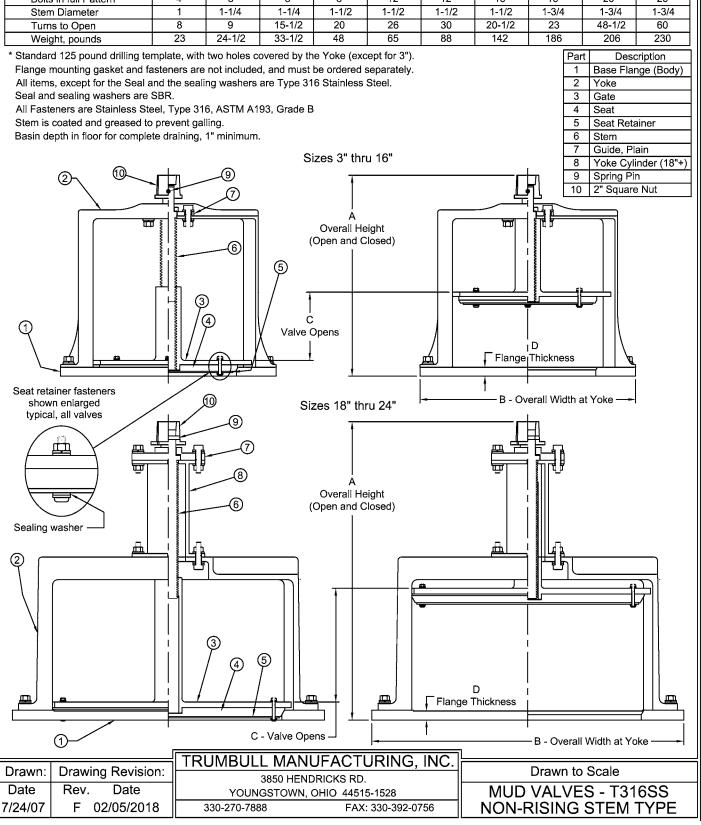
See pages 8 & 9 for weights; page 10 for installation options.



Typical Mud Valve Installation



Valve Size (Bore Dia.)	3	4	6	8	10	12	16	18	20	24
A - Overall height	8-3/8	8	10-1/2	12-1/2	14-1/2	17	21-1/4	23	25-3/4	34-5/8
B - Width at Yoke	7-1/2	10-1/4	12-5/8	15-1/8	17-3/8	19	25-3/4	27-3/4	27-1/2	32
C - Valve opening	1-1/2	1-3/4	2-3/4	3-1/2	4-3/4	6	7-1/2	8-1/4	9-1/4	12
D - Flange thickness	3/4	3/4	3/4	3/4	3/4	3/4	3/4	3/4	3/4	3/4
Flange O.D.	7-1/2	9	11	13-1/2	16	19	23-1/2	25	27-1/2	32
Bolt Circle Diameter	6.00	7.50	9.50	11.75	14.25	17.00	21.25	22.75	25.00	29.5
Bolt Hole Dia.	3/4	3/4	7/8	7/8	1	1	1-1/8	1-1/4	1-1/4	1-3/8
Bolt / Stud Size	5/8	5/8	3/4	3/4	7/8	7/8	1	1-1/8	1-1/8	1-1/4
Bolts in full Pattern*	4	8	8	8	12	12	16	16	20	20
Stem Diameter	1	1-1/4	1-1/4	1-1/2	1-1/2	1-1/2	1-1/2	1-3/4	1-3/4	1-3/4
Turns to Open	8	9	15-1/2	20	26	30	20-1/2	23	48-1/2	60
Weight, pounds	23	24-1/2	33-1/2	48	65	88	142	186	206	230



Valve Size (Bore Dia.)	4	6	8	10	12	16**	18**	20**	Part Description			
A - Overall height, closed	8-3/4	10-1/2	12-1/2	14	17	23	18	18	1 Base Flange (Body)			
A - Overall height, open	11-1/2	16	19-1/4	22-3/4	28-1/2	38-1/4	27	28	2 Yoke			
B - Width at Yoke	10-1/4	12-5/8	15-1/8	17-3/8	19	25-3/4	27-3/4	27-1/2	3 Gate			
C - Valve opening	2-1/4	5	7	8-1/4	11-1/2	15-1/8	9	10	4 Seat			
D - Flange thickness	3/4	3/4	3/4	3/4	3/4	3/4	3/4	3/4	5 Seat Retainer			
Flange O.D.	9 7.50	9.50	13-1/2 11.75	16 14.25	19 17.00	23-1/2 21.25	25 22.75	27-1/2 25.00	6 Stem 7 Guide, Plain			
Bolt Circle Diameter Bolt Hole Dia.	3/4	7/8	7/8	14.25	17.00	1-1/8	1-1/4	1-1/4	7 Guide, Plain 8 Yoke Cylinder (18"+)			
Bolt / Stud Size	5/8	3/4	3/4	7/8	7/8	1	1-1/8	1-1/8	9 Gate Cap (18"+)			
Bolts in full Pattern*	8	8	8	12	12	16	16	20	10 Spring Pin			
Stem Diameter	1-1/4	1-1/4	1-1/2	1-1/2	1-1/2	1-1/2	1-3/4	1-3/4	11 2" Square Nut			
Turns to Open	13-1/2	26-1/2	30-1/2	36-1/2	50-1/2	75-1/2	45	50				
Weight, pounds	25	34	48	59	78	XX	XX	XX				
* Standard 125 pound drilling t	emplate, wit	h two holes	covered by	the Yoke.								
Flange mounting gasket and					ed separate	y.			Seat retainer fasteners			
All items, except for the Seal and the sealing washers are Type 316 Stainless Steel.												
Seal and sealing washers are	SBR.							<b>(1)</b>	typical, all valves			
All Fasteners are Stainless S	teel, Type 3	16, ASTM	A193, Grad	e B	Size	s 18" thru	20"					
Stem is coated and greased		_						/ ~				
Basin depth in floor for compl	_				1				<del></del>			
** Consult Trumbull on the avail	•	" and larger	sizes				<u> </u>					
in the Rising Stem configura	ation.								/			
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### Optional Mud Valve Installations

Standard options are shown on right

Mud Valve: Cast iron or cast 316 stainless steel
Stem Guide: Ductile iron or cast 316 stainless steel
Floorstand: Ductile iron (30" or 36") or cast 316 SS (36")

Pedestal: Ductile iron or cast 316 SS Extension Stem: Carbon steel or stainless steel

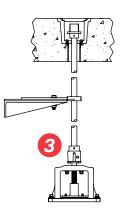
Wall Bracket: Ductile iron or cast 316 stainless steel Floor Box: Sealed or unsealed, cast iron or cast SS



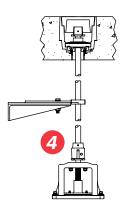
Stem Guide with Handwheel or 2" square nut



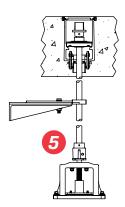
Wall Bracket with Position Indicator



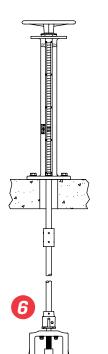
Floor Box w/out Position Indicator



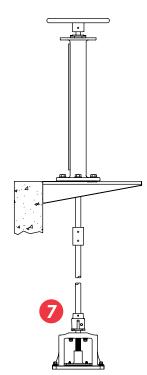
Floor Box with Position Indicator



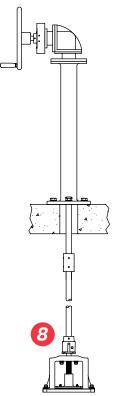
Cast Sealed Floor Box with Position Indicator



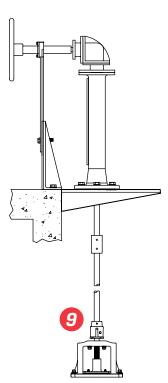
Indicating Floorstand



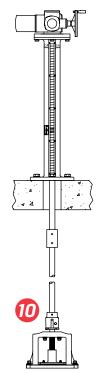
Indicating Floorstand with Wall Bracket\*



Pedestal with Miter Gear, Crank Handwheel & Position Indicator (57T or 275T only)



Indicating Floorstand with Wall Bracket, Miter Gear & Horizontal Extension Stem\*



Indicating Floorstand with Actuator\*

<sup>\*</sup> Indicating slot faces operator and is not visible in installations 7 & 9.



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## Stainless Mud Valve Design & Test Results

Independent Testing of Stainless Mud Valves



### Stork Herron Testing Laboratories

8/13/2008

F Craig Newmeyer Trumbull Industries 1040 N Meridian Rd PO Box 1556 Youngstown, OH 44501-1556

Date Received: 1/30/2008 Test Report No.: TRU040-08-01-53169-1

P.O. No.: EXPIRED

Material Testing and Non-Destructive Testing

5405 E. Schaaf Road Cleveland, OH 44131 USA

Telephone: (216) 524-1450 (216) 524-1459

TEST REPORT

Three (3) T316 Stainless Steel 6" Mud Valves were assembled and tested as shown in Figure 1.



FIGURE 1

The above services were performed in accordance with Herron Testing Laboratories' Quality Assurance Program Edition 1, Revision 2 dated 1/2007, Information and statements in this report are derived from material, information that the specifications burstline by the client and exclude any expressed or implied warrantees as to the fitness of the analors specifications burstline graphs of our particular purpose or use. This report is the confidential property of our client and may not be used for advertising purpose. This report shall not be reproduced except in full, without written approval or this baboratory. The recording of fasts, Scittious or traudulent statements or entries on this document may be of this laboratory. The recording of fasts, Scittious or traudulent statements or entries on this document may be strong to the statements are held for a minimum of 30 days following issuance of test results, at which point they will be Sample remnents are held for a minimum of 30 days following issuance of test results, at which point they will be Sample of the statements are held for a minimum of 30 days following issuance of test results, at which point they will be Sample remnents are held for a minimum of 30 days following issuance of test results, at which point they will be Sample remnents are held for an information of the statement of the

EST REPORT & VIDEO OF INDEPENDENT TESTING **AVAILABLE UPON** 

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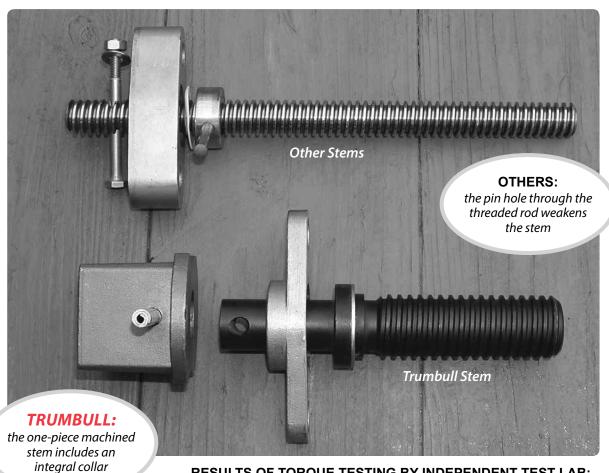
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### Stem Diameters



### Stem Designs

Trumbull Stem is Machined One-Piece, vs. All-Thread Rod with a Pinned Collar



#### **RESULTS OF TORQUE TESTING BY INDEPENDENT TEST LAB:**

Stem with drilled holes =165 ft-lb (fastener and stem failed) Trumbull one-piece stem = 625 ft-lb (connecting pin sheared, stem intact)



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### Seat Design

Stainless Mud Valves

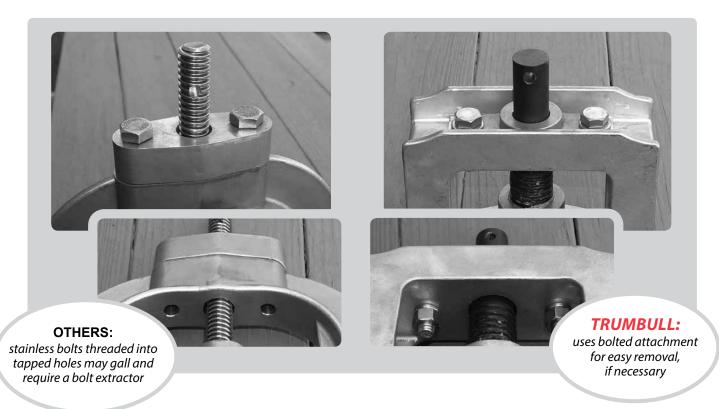




Trumbull's standard seating material is SBR rubber; optional seat materials available, including BUNA, EPDM & Viton.

### Yoke Bolt Design

Stainless Mud Valves





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### Cycle Tests

Independent Testing of Stainless Mud Valves



#### # of Cycles Results of Other Models

500 Nylon sleeve damage

700 Nylon sleeve completely shredded

1,000 Build-up of fine metal shavings

1,308 Required increased torque to continue rotation

5.000 Deformation of threads

#### **OTHERS BY 7,500 CYCLES:**

stem threads that engaged the internal threads during cycling showed deformation when compared to non-engaged threads





Non-Engaged

Engaged

#### **TESTING OF** TRUMBULL'S MUD VALVE:

Stem has anti-galling coating with anti-seize lubricant

#### **AFTER 7,500 CYCLES:**

- no damage
- slight wear

#### **AFTER 15,000 CYCLES:**

- no damage
- slight wear



BY 500 CYCLES:

little wear and no damage to stem or internal thread



### **BY 7,500 CYCLES:**

stem threads that engaged the internal threads during cycling showed some wear and no damage when compared to non-engaged threads



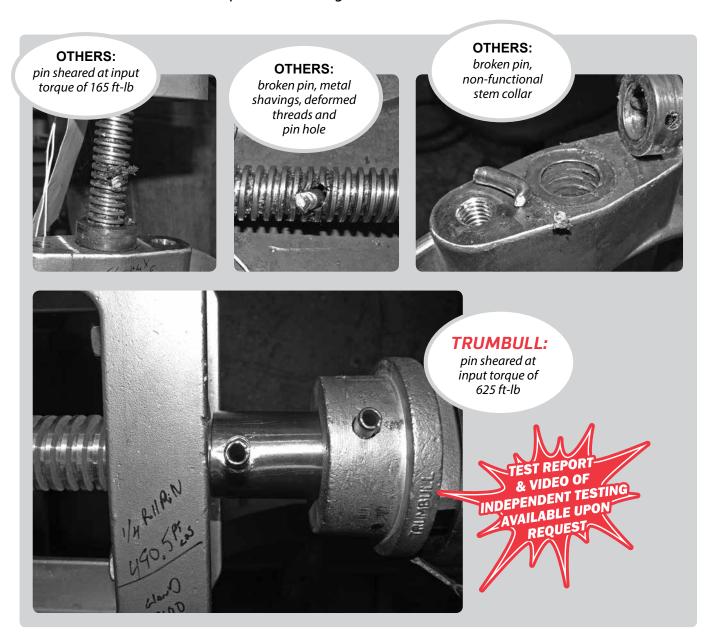
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### **Torque Tests**

Independent Testing of Stainless Mud Valves



Thank you for your interest in **Trumbull Mud Valves!** 

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We stand behind our product with experienced Engineering, Quality Control and Field Service personnel. Our products are designed for long life, and are rigorously tested, in-house and at independent labs. Our inside Sales staff is passionate about customer satisfaction, contact them today.









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