PRS15 Pressure-Reducing Regulator
User Manual

Read the complete manual before installing and using the regulator.

Safe Product Selection

When selecting a product, the total system design must be considered to ensure safe, trouble-free performance. Function, material compatibility, adequate ratings, proper installation, operation, and maintenance are the responsibilities of the system designer and user.

WARNING

- Users must be trained and equipped for the handling, use, and servicing of pressure products and systems.
- Users must contact their gas or liquid supplier for specific safety precautions and instructions.
- Gaseous media should be free of excessive moisture to prevent icing at high flow.
- Always wear the appropriate protective clothing, including safety glasses, gloves, etc., if required.
- Follow the applicable safety and maintenance procedures.
- Obey specific local regulations.
- Do not exceed the maximum inlet and outlet pressure rating of the product or its accessories.
- Operate within the temperature limits and any other conditions specified for the product.
- Do not drop or damage the product in any other way. This may negatively affect the performance of the product which can cause the product to malfunction.
- Venting fluids and gases can be dangerous. Vent to a safe environment away from people. Ensure adequate ventilation.

Contents

Introduction

Overview

- The PRS15 series are spring-loaded pressure-reducing regulators designed for high-sensitivity regulation of gases and liquids.
- For pressure and temperature rating information refer to the *Sanitary Pressure Regulators, RHPS Series* catalog, MS-02-436.

WARNING
Check that system pressures and temperatures do not exceed those stated on the regulator as this could result in product failure.

Standard Features

- Threaded construction
- Stainless steel as standard
- Fully serviceable
- Diaphragm sensing

Additional Options

The regulator is available with the following options:

Anti-tamper

Oxygen Service

- For more information about hazards and risks of oxygen enriched systems see the *Swagelok Oxygen System Safety* technical report (MS-06-13).
- Cleaning and packaging to ensure compliance with product cleanliness requirements stated in ASTM G93 Level C is provided as standard. Refer to the *Sanitary Pressure Regulators, RHPS Series* catalog, MS-02-436, for additional information.

Installation

CAUTION
Do not use the regulator as a shutoff device. A level of leakage across the regulator seat can occur during normal operation.

Points of Attention Before Installation

Before installing the regulator you should fully understand the suitability of your particular regulator for the intended application.

- The preferred mounting position of the regulator is horizontal with the spring housing facing upwards per Fig 2. Alternative mounting positions may increase the risk of component wear.
- It may be necessary to remove the regulator from the system during maintenance or service. Ensure that this is possible.
- The regulator is suitable for gases or liquids. Ensure compatibility between the regulator's materials of construction and the system media.

Installation

- Verify that the regulator, its connections, and any accessories are undamaged.
- Verify that the regulator and any accessories are suitable for the system operating pressure and temperature and have suitable connections.
- At the time of delivery any gauge ports may be plugged with blind fittings. Remove these and connect gauges if desired.

CAUTION
Ensure all upstream tubing/pipework is clean and free from debris. Any swarf, lint, wire, etc. may damage the regulator, resulting in a seat leak.

- Verify the flow direction of the system and mount the regulator accordingly.
- Securely make the appropriate connections to the regulator in accordance with the procedures recommended by the connection manufacturer.
- Ensure that the tubing/pipework and the regulator are adequately supported and that there is no stress on the connections.
- Upstream and downstream shutoff valves should be installed in the system to facilitate servicing, maintenance, and troubleshooting of the regulator.

Operation

Required Tools for Operation

- No tools are required for changing the set pressure on a standard regulator.
- A 12 mm open-ended wrench and a 4 mm hex drive are required for anti-tamper regulators.

Points of Attention Before Operation

CAUTION
The product can be hot or cold, depending on the environmental temperature and the process media temperature. Take the necessary precautions before operating or touching the product.

- Stopping flow through the regulator by closing a downstream shutoff valve may result in a rise in outlet pressure above the set pressure. This is usually referred to as "**lock-up**". This phenomenon does not indicate a problem with the regulator.
- A decrease of the flow rate may result in a rise of the outlet pressure. An increase of the flow rate may result in a fall of the outlet pressure. This is usually referred to as "**droop**". This phenomenon does not indicate a problem with the regulator.
- A decrease of the inlet pressure may result in a rise of the outlet pressure. An increase of the inlet pressure may result in a fall of the outlet pressure. This is usually referred to as "**inlet dependency**" or "**Supply Pressure Effect (SPE)**". This phenomenon does not indicate a problem with the regulator.

Adjusting the Set Pressure

- The set pressure is the desired outlet pressure of the regulator.
- To set the regulator, ensure that the supply pressure is greater than the required set pressure but does not exceed the maximum rating of the regulator.
- The regulator must be able to flow in order for it to reduce the outlet pressure.

1. Partially open any downstream valve. This will allow minimal flow through the regulator when adjusting the set pressure, reducing media consumption during this process.
2. Fully unwind the adjustment knob counterclockwise.
3. Steadily open the supply valve to allow inlet pressure to the regulator.
4. To operate the regulator, turn the adjustment knob clockwise to increase the set pressure. Turn the knob counterclockwise to reduce the set pressure.
5. To obtain the most accurate set pressure, final adjustment must be made while **increasing** the set pressure. If the desired outlet pressure is exceeded, reduce the pressure below this value then increase up to it.
6. Fully open the downstream valve to allow full flow during operation.
7. Once under flow conditions make any final set pressure adjustments per steps 3 and 4 if required.

Maintenance

WARNING
Incorrect or improper repair or servicing of this product can cause serious personal injury and property damage.

- All repairs, servicing, and testing of this product must be performed by competent personnel.
- Following any maintenance of the regulator, it is recommended that the product be tested for operation and leakage.
- The product should be checked periodically for proper and safe operation. It is the user's sole responsibility to determine the frequency of maintenance based on the application.
- To reduce maintenance related system downtime to a minimum, either during commissioning or normal operation, Swagelok recommends having maintenance kits readily available on site. The need for maintenance kits is particularly important during the commissioning phase of a system installation due to residual assembly debris remaining in the system. Such debris can cause a seat leak in the regulator, resulting in components needing to be replaced.

Required Tools for Maintenance

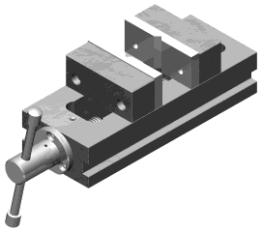
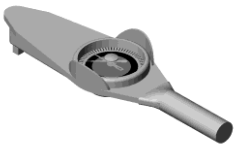
Smooth-jawed vise		Calibrated torque wrench up to 37 lbf·ft (50 N·m)	
13 mm socket		Lubricant (included in kit): Krytox® 240 AC	
36 mm socket			
24 mm open-ended wrench		Liquid leak detector	
50 mm crows foot			

Table 1

Points of Attention Before Removal from the System

- Swagelok recommends removing the regulator from the system for servicing and maintenance.
- Follow all local system safety and maintenance procedures when removing the regulator.

WARNING

Before removing a regulator from the system, to avoid personal injury, you must:

- **Depressurize the system.**
- **Purge the system to remove any residual system media left in the regulator.**
- **Always vent to a safe environment away from people and ensure there is adequate ventilation.**

CAUTION

Check if the process media is hazardous or toxic. If required, take the necessary safety precautions to ensure a safe workspace and your personal safety.

CAUTION

The product can be hot or cold, depending on the environmental temperature and the process media temperature. Take the necessary precautions before operating or touching the product.

Removal from the System

1. Isolate the regulator from all pressure sources by closing all appropriate upstream valves in the system.
2. With the regulator set, open all appropriate downstream valves to allow pressure to vent from the regulator.

WARNING

Ensure all pressure on the inlet and outlet has been fully vented. The accidental release of residual trapped pressure can cause serious personal injury.

3. Disconnect and remove the regulator from the system.

Assembly Reference Data

Item	Component Name	Kit Type(s)	Torque lbf·ft (N·m)	Recommended Lubrication (included in kit per Table 1)
1	Body plug	C1, C2	37 (50)	Lubricate threads
2	Body plug O-ring	B1, B2, C1, C2		
3	Poppet spring	C1, C5		
4	Poppet O-ring	A1, A2, B1, B2, C1		Lubricate
5	Poppet	A1, A2, B1, C1		
6	Seat	A1, B1, C1		
7	Seat O-ring	A1, B1, B2, C1		
8	Body	N/A		
9	Diaphragm screw	C1		Lubricate threads
10	Diaphragm	B1, B2, C1, C3		
11	Bottom spring guide	C1		
12	Washer	C1		
13	Hex nut	C1	11 (15)	
14	Clamp ring	C1		
15	Set spring	C1, C4		
16	Spring guide	C1		Lubricate central recess
17	Ball	C1		Lubricate
18	Spring housing	N/A	37 (50)	Lubricate threads
19	Knob assembly	D1		Lubricate threads
20	Anti-tamper set screw	D1		Lubricate threads
21	Anti-tamper cover O-ring	B1, B2, C1, D1		
22	Anti-tamper cover	D1		Lubricate threads

Table 2

For more information on RHPS series maintenance kits, refer to the *Sanitary Pressure Regulators, RHPS Series* catalog, MS-02-436.

PRS15 Series, Exploded View

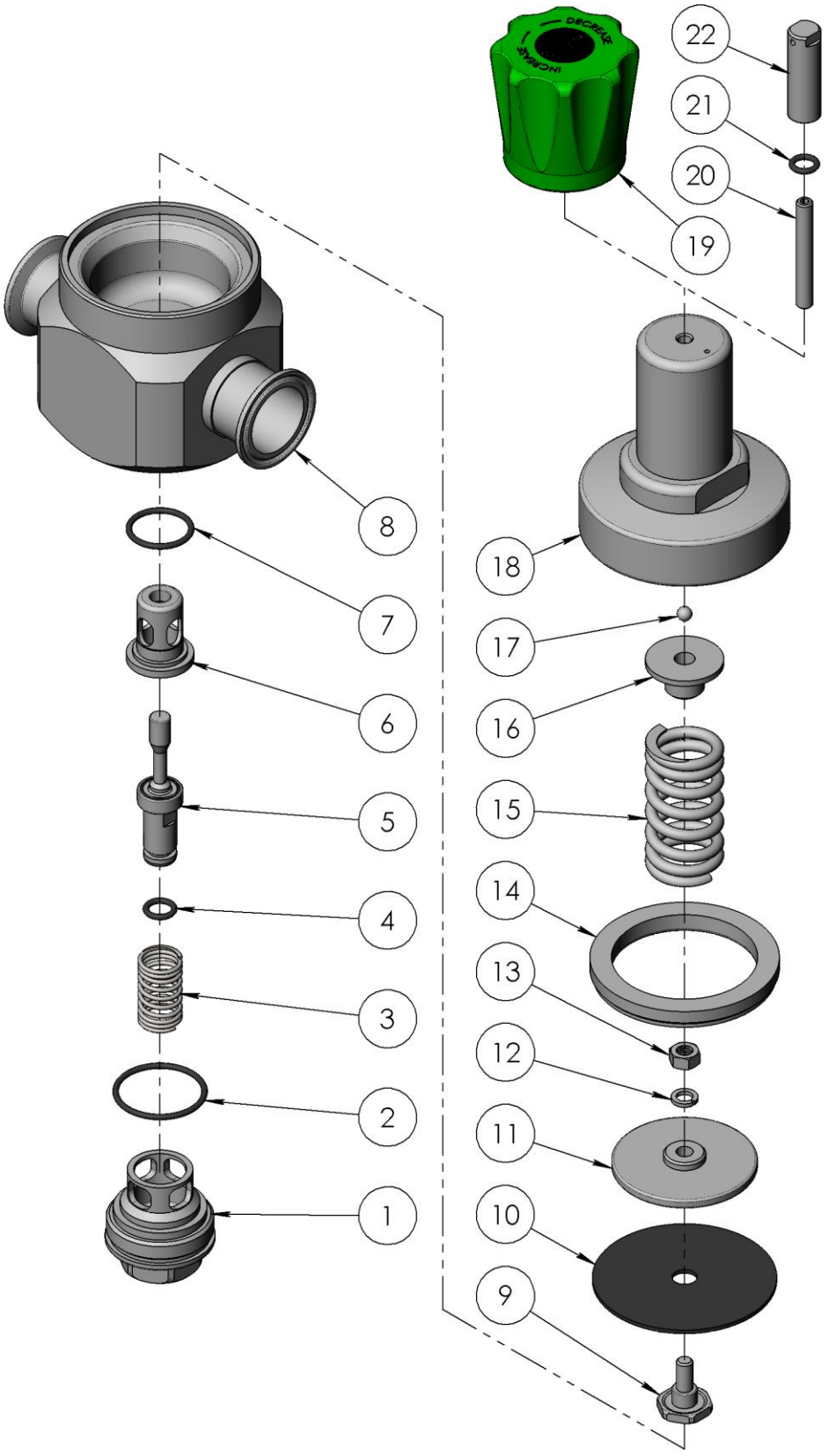


Fig 1

PRS15 Series, Section View

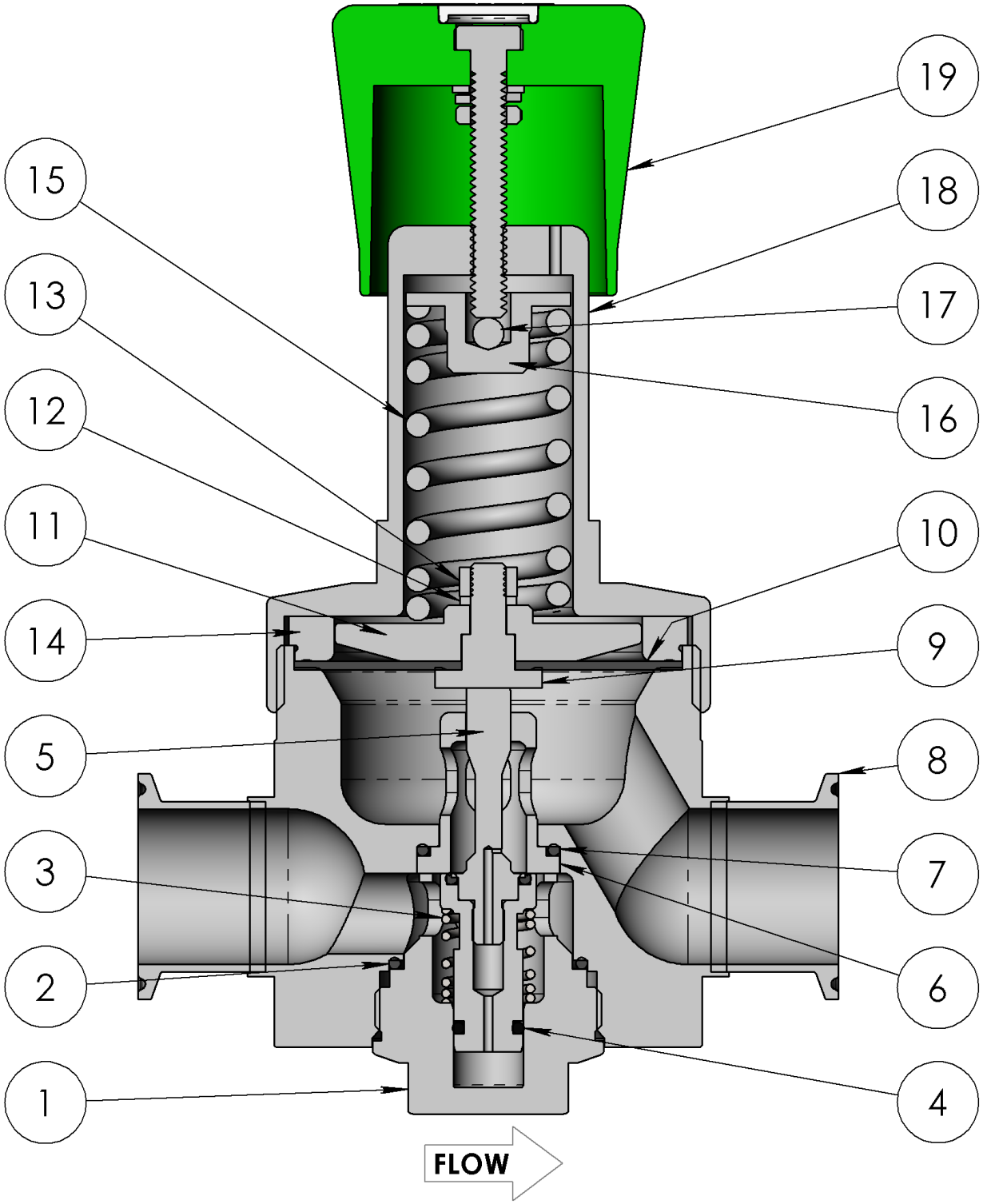


Fig 2

Disassembly

- The following instructions describe how to fully disassemble the regulator for the purposes of maintenance and repair.
- Note that not all components listed appear in all regulator configurations.
- Only disassemble the regulator as far as is required to replace the components supplied in the maintenance kit.
- Discard all components being replaced.

1. Remove the body plug (1), poppet spring (3), poppet (5), and seat (6) from the body (8).
2. Remove the O-ring (2) from the body plug (1).
3. Remove the O-ring (4) from the poppet (5).
4. Remove the O-ring (7) from the seat (6).
5. Ensure the knob assembly (19) is backed out and not acting on the set spring (15). It can be fully removed, if required, by unwinding counterclockwise until it detaches from the spring housing (18).
6. Loosen the spring housing (18).
7. Remove the spring guide (16) and set spring (15).
8. Remove the clamp ring (14) and diaphragm assembly.
9. To remove the diaphragm (10) remove the hex nut (13) and washer (12) from the diaphragm screw (9) and remove from the bottom spring guide (11).

Points of Attention Before Reassembly

- Visually inspect all components for abnormal wear or damage. Replace components in case of doubt.
- All parts must remain clean and undamaged before starting assembly.
- Maintenance kit components will be supplied preassembled where practicable to aid reassembly.
- Swagelok recommends replacing all O-rings removed during disassembly.
- Swagelok recommends that dynamic O-rings should be lightly lubricated per Table 2.

NOTICE

All threaded components must be lightly lubricated per Table 2 before reassembly to avoid galling of threads.

Reassembly

1. Secure the body (8) in a vise.
2. Fit the seat O-ring (7) onto the seat (6).
3. Insert the seat (6) into the body (8).
4. Fit the poppet O-ring (4) onto the poppet (5).
5. Lightly lubricate the poppet O-ring (4).
6. Fit the poppet spring (3) onto the poppet (5) and insert the poppet (5) through the seat (6).
7. Fit the body plug O-ring (2) into the body (8).
8. Lightly lubricate the body plug threads (1) and assemble over the poppet (5) into the body (8). Torque to 37 lbf·ft (50 N·m).
9. Fit the diaphragm (10) and bottom spring guide (11) onto the diaphragm screw (9).
10. Lightly lubricate the diaphragm screw threads (9) then fit the washer (12) and nut (13). Torque to 11 lbf·ft (15 N·m).
11. Insert the sensing assembly into the body (8).
12. Fit the clamp ring (14) into the body (8) on top of the diaphragm (10). Orient per Fig 2.
13. Fit the ball (17) into the spring guide (16) and retain in place.
14. Stack the set spring (15) and spring guide (16) onto the bottom spring guide (11).
15. Lightly lubricate the spring housing threads (18) then screw it onto the body (8). Torque to 37 lbf·ft (50 N·m).
16. Lightly lubricate the knob assembly stem (19) and thread it through the spring housing (18).

Testing

Swagelok recommends that the regulator be tested for seat and shell leakage to atmosphere. A well performing regulator will not show any indication of leaking. If any evidence of a leak is identified this must be rectified. Any damaged components must be replaced.

Seat Leak Test

1. Ensure there is sufficient supply pressure to the regulator to be able to perform the tests.
2. Ensure the handle is screwed fully counterclockwise.
3. Maintain an inlet pressure of approximately 14.5 psig (1 bar) on the regulator and close the downstream shutoff valve.
4. Monitor the outlet pressure. An increase in pressure over time indicates a seat leak.
5. Repeat the procedure with the highest inlet pressure applicable for the regulator and system.

Shell Leak Test

1. Maintain an inlet pressure of approximately 29 psig (2 bar) on the regulator and close the downstream shutoff valve.
2. Increase the outlet pressure to approximately 14.5 psig (1 bar).
3. Using liquid leak detector, check for bubbles at the spring housing to body interface, body plug to body interface and the spring housing weep hole.
4. Repeat the procedure with the highest inlet and outlet pressure applicable for the regulator and system.

Troubleshooting

Symptom	Cause	Remedy
The outlet pressure creeps up, without adjusting the spring.	A damaged poppet and/or seat.	Replace the poppet and/or seat.
Leakage around the body plug.	A damaged O-ring.	Replace the O-ring.
Leakage between the body and the spring housing or through the spring housing weep hole.	A damaged diaphragm.	Replace the diaphragm.
	Insufficient torque on the spring housing.	Tighten the spring housing per Table 2.
Controlled pressure drops off sharply even when the flow is within regulator capabilities.	The system filter element is clogged.	Replace the system filter.
The required outlet pressure cannot be reached.	The inlet pressure to the regulator is not high enough.	Ensure that the inlet pressure to the regulator is equal to or greater than the desired set pressure.
The outlet pressure rises too much when going from a dynamic to a static situation.	There is too much flow in the dynamic situation.	A larger regulator or parallel regulator is required. Review application flow capacity and contact your local authorized sales and service center.
The outlet pressure does not drop when the knob is adjusted counterclockwise.	The regulator is non-venting.	A shutoff valve in the outlet line must be opened to reduce the outlet pressure.
The outlet pressure has changed without adjusting the handle.	Changes to the inlet pressure may result in changes to the outlet pressure.	Maintain a constant inlet pressure to the regulator. See “**Points of Attention Before Operation**” about **dependency**.
	Changes to the flow may result in changes to the outlet pressure.	Maintain a constant flow through the regulator. See “**Points of Attention Before Operation**” about **droop**.

Table 3

Warranty Information

Swagelok products are backed by The Swagelok Limited Lifetime Warranty.
For a copy, visit swagelok.com or contact your authorized Swagelok representative.

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