



# VAREC 3600B/3650B SERIES PRESSURE OR VACUUM RELIEF VALVES

## INSTRUCTION, OPERATION AND MAINTENANCE MANUAL

Before installation, these instructions must be read carefully and understood.



FIGURE 1. 3600B AND 3650B SERIES

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### DISCLAIMER OF WARRANTIES

The contract between Emerson Automation Solutions (Emerson) and our customer states Emerson entire obligation. The contents of this instruction manual shall not become part of or modify any prior or existing agreement, commitment or relationship between Emerson and our customer. There are no express or implied warranties set out in this instruction manual. The only warranties that apply are those in the existing contract between Emerson and our customer.

The Varec 3600B and 3650B Series pressure or vacuum relief valves have not been tested by Emerson under all possible operational conditions and Emerson does not have all the data relative to your application. The information in this instruction manual is not all inclusive and does not and cannot take into account all unique situations. Consequently, you should review this product literature in view of your application. If you have any further questions, please contact Emerson for assistance.

### LIMITATIONS OF SELLER'S LIABILITY

If it is determined that this instruction manual created some new warranties, Emerson liability shall be limited to repair or replacement under the standard warranty clause. In no case shall Emerson liability exceed that stated as Limitations of Remedy in the contract between Emerson and our customer

### GENERAL INFORMATION

The 3600B and 3650B Series pressure or vacuum relief valves are designed to protect low pressure storage tanks, sludge digesters and gas holders from excessive pressure or vacuum.

The 3600B Series vacuum relief valve is a side mounted valve that relieves negative pressure by inbreathing ambient air.

The 3650B Series pressure relief valve is a top mounted valve that relieves pressure through an enclosed outlet adapter. Product vapors may be piped away rather than relieving directly to the atmosphere. This valve may also be used as a side mounted vacuum relief valve with the intake flange connectable to a dehydrator.

### SAFETY PRECAUTIONS

Read and understand this instruction manual before installing, operating or performing maintenance on 3600B and 3650B Series pressure or vacuum relief valves. Follow all precautions and warnings noted herein when installing, operating or performing maintenance on this equipment.

#### WARNING

*Relief valve must be isolated from tank pressure before servicing. All gas must be blocked and pressure safely vented.*

#### Safety precaution definitions

#### CAUTION

*Damage to equipment may result if this precaution is disregarded.*

#### WARNING

*Direct injury to personnel or damage to equipment which can cause injury to personnel may result if this precaution is not followed.*


# VAREC 3600B/3650B SERIES PRESSURE OR VACUUM RELIEF VALVES

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### PRODUCT IDENTIFICATION AND MARKING

#### Hazardous Locations

The 3600B/3650B Series Pressure and Vacuum Relief Valves (PVRVs) are available with outer housings of Carbon steel, Stainless steel or Aluminum as indicated.

 Outer Housing of Stainless Steel, Carbon Steel or Coated Aluminum

 Outer Housing of Uncoated Aluminum

#### Nameplate

The nameplate is attached to the valve and contains the following information.

1. Connection Size (Size)
2. Serial Number (S/N)
3. Model Number (P/N) per Construction Table
4. Pressure Setting and Air Flow (Not applicable for Model 3600B. Pressure and Vacuum settings are mutually exclusive.)
5. Vacuum Setting and Air Flow (Pressure and Vacuum settings are mutually exclusive.)
6. Notified Body Number

### CONSTRUCTION

Standard materials of construction include a cast body and cover. Pallets are dead weight loaded with lead or coated steel weights and include a flexible membrane sealing insert. The pallet is loosely guided through a center stem and pallet guide posts.

The 'All-weather' Models 3601B and 3651B Series include a special coating on portions of the pallet, seat ring and guides to eliminate ice accumulation.

**TABLE 1 - 3600B SERIES CONFIGURATION**

Code	Type
360	Vacuum Relief Valve (Side Mounted)
Code	Configuration
0B	Standard
1B	All Weather Type
Code	Size
2	2 inches
3	3 inches
4	4 inches
6	6 inches
8	8 inches
0	10 inches
1	12 inches
Code	Body/trim material
1	Aluminum/Aluminum
2	Aluminum/316 Stainless steel
3	Steel/316 Stainless steel
4	316 Stainless steel/316 Stainless steel
Code	Insert material
T	Fluorinated Ethylene Propylene (FEP)
B	Nitrile (NBR)
V	Fluorocarbon (FKM)
Code	Flange Drilling
F	150# ANSI Drilling (Fractional Studs)
D	PN 16 DIN Drilling (Metric Studs)
Code	Flange Face
F	Flat Face Flange
R	Raised Face Flange (Not Available with Aluminum)
Code	Gasket/o-ring material
O	Standard
B	Nitrile (NBR)
T	Polytetrafluoroethylene (PTFE)
V	Fluorocarbon (FKM)
Code	Retainer/Screen Material
P	Plastic
S	Stainless steel
Code	Vacuum Setting Ranges
02	Low
04	High

#### NOTE

Materials for the 3600B Series valves are as indicated by the full 14-character model number as shown above.

# VAREC 3600B/3650B SERIES PRESSURE OR VACUUM RELIEF VALVES

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**TABLE 2 - 3650B SERIES CONFIGURATION**

<b>Code</b>	<b>Type</b>
365	Pressure or Vacuum Relief Valve (In-Line)
<b>Code</b>	<b>Configuration</b>
0B	Standard
1B	All Weather Type
<b>Code</b>	<b>Size</b>
2	2 inches
3	3 inches
4	4 inches
6	6 inches
8	8 inches
0	10 inches
1	12 inches
<b>Code</b>	<b>Body/trim material</b>
1	Aluminum/Aluminum
2	Aluminum/316 Stainless steel
3	Steel/316 Stainless steel
4	316 Stainless steel/316 Stainless steel
<b>Code</b>	<b>Insert material</b>
T	FEP
B	Nitrile (NBR)
V	Fluorocarbon (FKM)
<b>Code</b>	<b>Flange Drilling</b>
F	150# ANSI Drilling (Fractional Studs)
D	PN 16 DIN Drilling (Metric Studs)
<b>Code</b>	<b>Flange Face</b>
F	Flat Face Flange
R	Raised Face Flange (Not Available with Aluminum)
<b>Code</b>	<b>Gasket/O-ring material</b>
O	Standard
B	Nitrile (NBR)
T	PTFE
V	Fluorocarbon (FKM)
<b>Code</b>	<b>Retainer/Screen Material</b>
P	Plastic
S	Stainless steel
<b>Code</b>	<b>Pressure or Vacuum Setting Ranges</b>
02	Low
04	High

**NOTE**

Materials for the 3650B Series valves are as indicated by the full 13-character model number as shown above.

# VAREC 3600B/3650B SERIES PRESSURE OR VACUUM RELIEF VALVES

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### OPERATION

#### Model 3650B Series pressure relief valves

When the internal tank pressure approaches the valve setting, the pallet begins to lift. As the pressure exceeds the valve setting, the pallet lifts off the seat ring. Excess product vapor is allowed to vent through the pipe away system adapter, relieving the over pressure condition. The pallet automatically re-seats as the tank pressure drops below the valve setting.

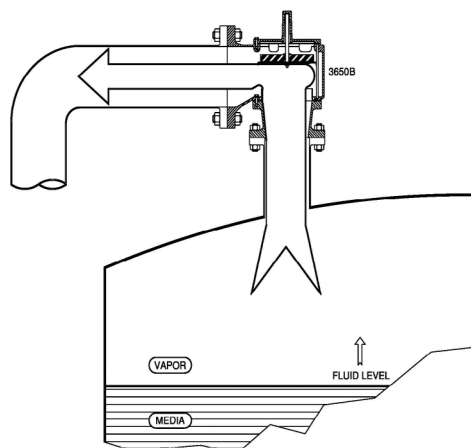


FIGURE 2. PRESSURE CONTROL OPERATION

TABLE 3 - 3650B SERIES PRESSURE SETTING

Series	Pressure Setting Low Range	Pressure Setting High Range
3650B	0.3 to 16' osig / 1.3 to 68.9* mbar	16' to 32 osig / 68.9* to 138 mbar

\*10 osig / 43.1 mbar for 2 and 3 inchec sizes.

#### Model 3600B and 3650B Series vacuum relief valves

When a vacuum within the tank approaches the valve setting, the pallet begins to lift. As the vacuum exceeds the valve setting, the pallet lifts off the seat ring. Atmospheric or dry air is allowed to flow into the tank, relieving the excess vacuum condition. The pallet automatically re-seats as the tank vacuum drops below the valve setting.

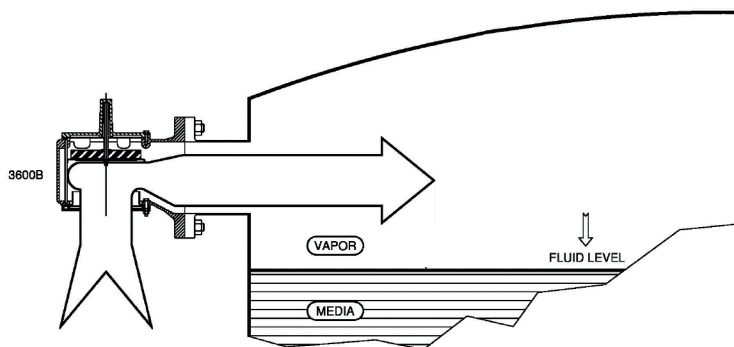


FIGURE 3. VACUUM CONTROL OPERATION

TABLE 4 - 3600B AND 3650B SERIES VACUUM SETTING

Series	Vacuum Setting Low Range	Vacuum Setting High Range
3600B	0.3 to 16 <sup>(1)</sup> osig / 1.3 to 68.9 <sup>(1)</sup> mbar	16 <sup>(1)</sup> to 32 osig / 68.9 <sup>(1)</sup> to 138 mbar
3650B	0.3 to 16 <sup>(2)</sup> osig / 1.3 to 68.9 <sup>(2)</sup> mbar	16 <sup>(2)</sup> to 32 osig / 68.9 <sup>(2)</sup> to 138 mbar

#### NOTES

1. 10 osig / 43.1 mbar for 2, 3 and 4 inches sizes
2. 10 osig / 43.1 mbar for 2 and 3 inches sizes

# VAREC 3600B/3650B SERIES PRESSURE OR VACUUM RELIEF VALVES

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### INSTALLATION (PLACING INTO SERVICE)

3600B and 3650B Series relief valves must be mated with the appropriate flange(s). The nozzle must be plumb (top mounted) or level (side mounted) and the inlet flange face level (top mounted) or plumb (side mounted) to ensure proper operation of the relief valve.

1. Remove the valve from the shipping container. Check to see if extra loading weights were bagged and packed separately.
2. Remove the cover, cover gasket and all packing material above the pallet and within the valve.

#### CAUTION

*Whenever the cover is removed and reinstalled, the end of the pallet stem must engage the stem guide chamber in the cover for proper seating and valve operation.*

3. To load pallet weights perform the following:
  - a. Remove pallet assembly from body.
  - b. Remove grip ring from pallet stem.
  - c. Non-variable setting: locate weight marked "VACUUM" and place on top of compensating weight and/or pallet. Secure with grip ring.  
**Note:** if setting is less than 2" WC, weight will be pre-loaded on the pallet.
  - d. Variable setting: each lead weight is calibrated from 1" WC increment. (Increments of ¼" WC and ½" WC may be supplied on special order). Those weights necessary for the initial specified setting will be tagged separately from any extra weight provided. Remove the packaging on the weights tagged for the initial specified setting and place the weights on top of the pallet. Secure with grip ring. Store remaining weights for future use (in case the setting needs to be increased).
  - e. Weigh entire pallet assembly (including installed weights). Using the applicable Calibration table, confirm that the assembly is the proper weight to achieve the required setting. Allowable weight tolerance is +5%, -5%.
  - f. Remove any remaining packing material from valve body. Wipe seat ring, guide posts and pallet assembly with a soft cloth to remove any material which could affect valve operation.
  - g. Place pallet assembly on valve body seat. Ensure that pallet moves freely within guide posts and rests flat on the seat ring.
  - h. Replace the cover gasket and cover. Tighten cover screws uniformly.

#### CAUTION

*The end of the pallet stem must engage the stem guide chamber in the cover for proper seating and valve operation.*

4. Place the valve in a level position. Check the pallet operation on Model 3600B by using a non-sparking tool which will pass through the center of the mesh screen. Push up on the pallet, then lower it onto the seat. Pallet should move freely and rest flat on the seat ring.
5. With valve in level position, check the pallet operation on Model 3650B. Reach up through the bottom flange opening and carefully push up on the pallet, then lower it onto the seat. Pallet should move freely and rest flat on the seat ring.
6. Mount the valve on the flanged nozzle or flame arrester using the appropriate full faced gasket.

#### CAUTION

**DO NOT MATE A FLAT FACE FLANGE TO A RAISED FACE FLANGE.**

*If it is necessary to mate a flat face flange with a raised face flange, use the proper spacer to convert the raised face to a flat face.*

7. Verify that the valve is level to permit proper operation of the pallet. Install mounting hardware and tighten uniformly.
8. For Model 3650B Series pressure relief valve, install connecting piping (if required) to outlet flange. Use a full faced gasket and tighten all mounting hardware uniformly.

#### NOTE

It is recommended that steel valves be given a coat of paint immediately after installation is completed. Apply paint to external surfaces only.

### MAINTENANCE (ASSEMBLING AND DISMANTLING)

The valve should be inspected and cleaned at periodic intervals. The first inspection should be made approximately 30 days after commissioning. Subsequent inspections should be made every 30 days. The user may adjust the schedule for his own convenience and safety, depending upon the product being stored.

#### WARNING

- Relief valve must be isolated from tank pressure before servicing. All gas must be blocked and pressure safely vented. If no isolation valve is present, carefully open vacuum cover or lift pressure pallet, allowing pressure to vent slowly.
- Wear appropriate gloves and/or breathing apparatus if hazardous vapors are present.

1. To inspect the valve proceed as follows:
  - a. Remove cover and then pallet assembly.
  - b. Inspect pallet inserts for ripples, tears, or nicks, as well as seating surfaces for debris, abrasion or pitting. Pallet edges and guide posts should be free of burrs, corrosion or other obvious damage. Clean all components, replacing any showing excess wear or damage. On the "All-Weather" versions, inspect the Teflon coating for any damage that would affect operation.
  - c. Reassemble in reverse order.

#### CAUTION

*The end of the pallet stem must engage the stem guide chamber in the cover for proper seating and valve operation.*

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### CAUTION

During periods of freezing weather, extra maintenance is required for Models 3600B and 3650B. Either remove the pallet or apply generous portions of silicone grease to the pallet, seat ring and guide posts. When using silicone grease, inspect valves at least weekly. This procedure is not required for the 'All-Weather' Models 3601B and 3651B.

2. To replace pallet insert proceed as follows:
  - a. Remove cover and then pallet assembly.
  - b. Remove nut from base of pallet stem. Remove retainer plate and insert. Clean all surfaces and threads. Install new insert, handling carefully to avoid damaging insert or pallet.
  - c. Reassemble pallet and place on seat of valve body. Ensure pallet assembly moves freely within guide posts and rests flat on seat ring.
  - d. Reinstall cover.

### CAUTION

The end of the pallet stem must engage the stem guide chamber in the cover for proper seating and valve operation.

3. To replace seat ring, proceed as follows:
  - a. For Model 3600B, remove cover, spacer (high setting), gaskets, pallet assembly, screen retainer, screen and guide posts. For Model 3650B, remove cover, spacer (high setting), gaskets, pallet assembly, guide posts and adapter outlet.
  - b. Remove seat ring and O-ring from valve body. Clean body and adapter mating surface and O-ring groove.
  - c. Install new O-ring into groove; ensure that the O-ring stays properly in groove while installing seat ring.
  - d. Install new seat ring carefully to avoid distortion. Reassemble screen and retaining ring (Model 3600B) or adapter (Model 3650B) to secure seat ring. Ensure that seat is flush and level with valve body.
  - e. Reassemble guide posts.
  - f. Place pallet assembly on valve body seat. Ensure pallet moves freely within guide posts and rests flat on seat ring.
  - g. Reassemble spacer, cover and gaskets.

### CAUTION

The end of the pallet stem must engage the stem guide chamber in the cover for proper seating and valve operation.

4. Seat ring repair:
  - a. Seat may be ground or ground and lapped (in place) to improve seal. Use a lapping plate and medium valve grinding compound, applying light pressure.
  - b. Finish lapping with a fine compound. Avoid scoring or removing excessive amounts of material.
  - c. Clean all compound from valve parts.
  - d. Hand buff seat with a medium grade 'Scotch-Brite' (#7447) pad and light oil.

### CAUTION

Whenever the cover is removed and reinstalled, the end of the pallet stem must engage the stem guide chamber in the cover for proper pallet seating and valve operation.

### CALIBRATION (ADJUSTMENT)

To verify the settings, calculate the total necessary weight using the Tables 5 and 6. Check this value against the actual weight of the pallet assembly (including loading weights). Adjust loading weights as required.

**TABLE 5 - MODEL 3600B PALLET LOADING (includes weight of pallet)**

Valve size	Ounces of weight required per ounce of setting	Ounces of weight required per inch of wc setting
2"	8.3	4.8
3"	8.3	4.8
4"	16.8	9.7
6"	22.1	12.8
8"	43.4	25.1
10"	72.7	42.0
12"	120.1	69.4

Weight tolerance: + 5%/- 5%  
Setting tolerance: + 0%/- 10%

**TABLE 6 - MODEL 3650B PALLET LOADING (includes weight of pallet)**

Valve size	Ounces of weight required per ounce of setting	Ounces of weight required per inch of wc setting
2"	8.3	4.8
3"	16.8	9.7
4"	22.1	12.8
6"	43.4	25.1
8"	72.7	42
10"	120.1	69.4
12"	179.9	104

Weight tolerance: + 5%/- 5%  
Setting tolerance: + 0%/- 10%

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**TABLE 7 - MODEL 3600B- LOW SETTING  
 SIZES AND DIMENSIONS**

Size	A in (mm)	B in (mm)	C in (mm)	D in (mm)
2"	5.50 (140)	1.62 (41)	5.94 (151)	8.62 (219)
3"	4.94 (125)	2.06 (52)	5.94 (151)	8.00 (203)
4"	6.38 (162)	2.25 (57)	7.19 (183)	10.19 (259)
6"	8.00 (203)	2.31 (59)	8.31 (211)	12.25 (311)
8"	8.75 (222)	3.62 (92)	12.50 (318)	14.19 (360)
10"	11.19 (284)	4.00 (102)	14.06 (357)	17.94 (456)
12"	13.62 (346)	5.44 (138)	16.88 (429)	22.38 (568)

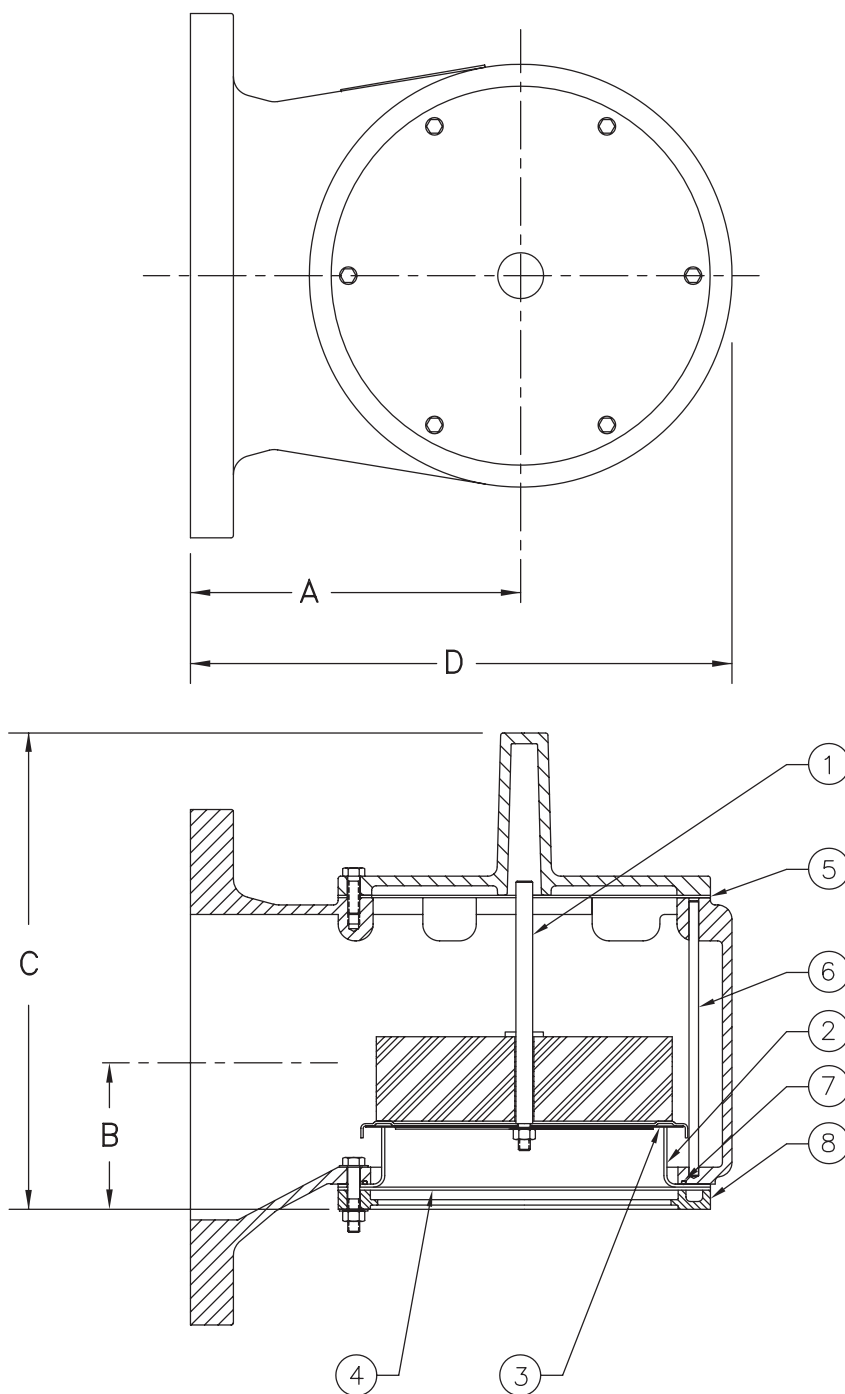


FIGURE 4. MODEL 3600B VACUUM RELIEF VALVE (LOW SETTING)  
 DRILLING PER ANSI CLASS 125 F.F.

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**TABLE 8 - MODEL 3600B HIGH SETTING  
 SIZES AND DIMENSIONS**

Size	A in (mm)	B in (mm)	C in (mm)	D in (mm)
2"	5.50 [140]	1.62 [41]	10.44 [265]	8.62 [219]
3"	4.94 [125]	2.06 [52]	10.44 [265]	8.00 [203]
4"	6.38 [162]	2.25 [57]	11.94 [303]	10.19 [259]
6"	8.00 [203]	2.31 [59]	12.38 [314]	12.25 [311]
8"	8.75 [222]	3.62 [92]	15.69 [399]	14.19 [360]
10"	11.19 [284]	4.00 [102]	16.50 [419]	17.94 [456]
12"	13.62 [346]	5.44 [138]	18.56 [471]	22.38 [568]

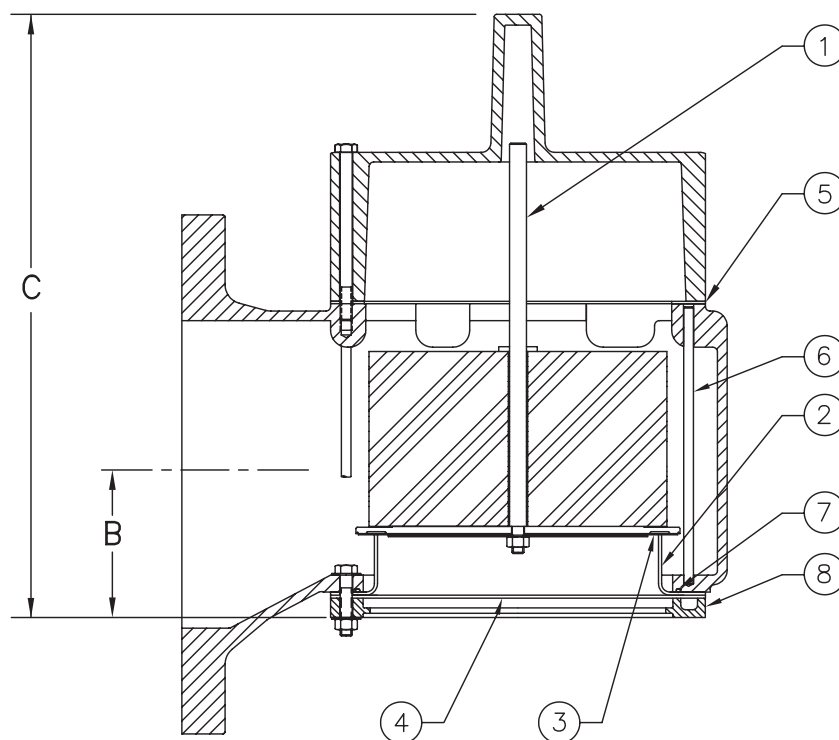
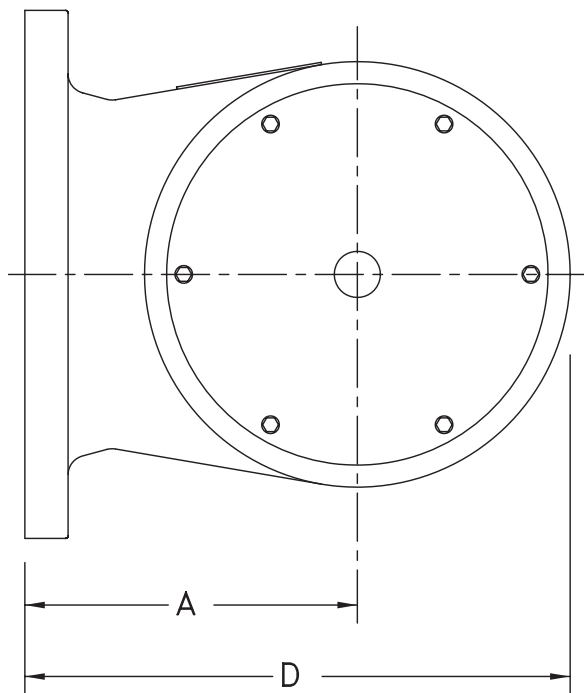


FIGURE 5. MODEL 3600B VACUUM RELIEF VALVE (HIGH SETTING)  
 DRILLING PER ANSI CLASS 125 F.F.



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**TABLE 9 - MODEL 3650B LOW SETTING SIZES AND DIMENSIONS**

Size	A in	B in	C in	D in	
E	F	(mm)	(mm)	(mm)	(mm)
2"	3"	4.94 (125)	5.81 (148)	9.62 (244)	8.00 (203)
3"	4"	6.38 (162)	6.25 (159)	11.19 (284)	10.19 (259)
4"	6"	8.00 (203)	6.31 (160)	12.31 (313)	12.25 (311)
6"	8"	8.75 (222)	8.00 (203)	16.88 (429)	14.19 (360)
8"	10"	11.19 (284)	8.62 (219)	18.69 (475)	17.94 (456)
10"	12"	13.62 (346)	12.75 (324)	24.12 (613)	22.38 (568)
12"	14"	15.38 (391)	16.69 (424)	29.88 (759)	25.38 (645)

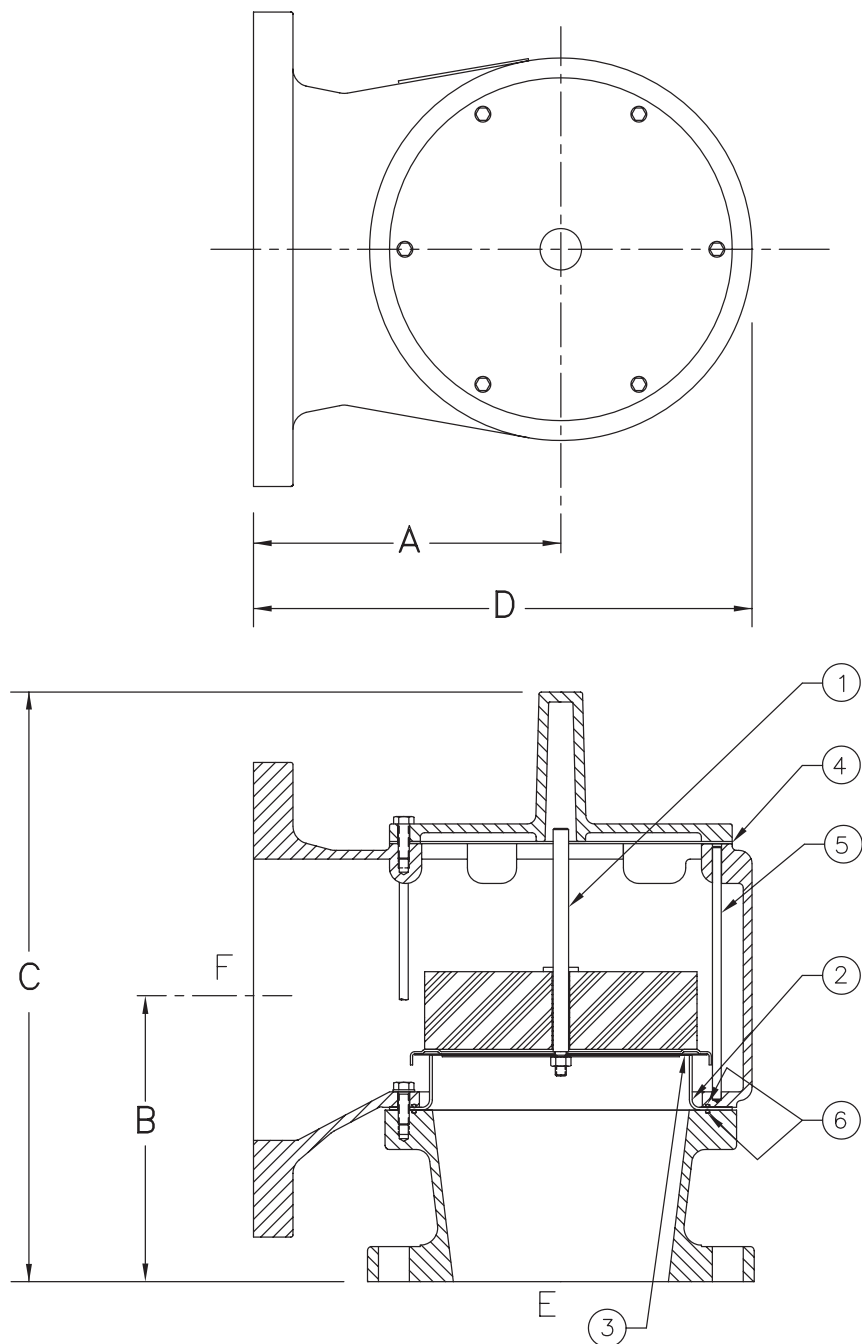


FIGURE 6. MODEL 3650B PRESSURE OR VACUUM RELIEF VALVE (LOW SETTING) DRILLING PER ANSI CLASS 125 F.F.

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**TABLE 10 - MODEL 3650B HIGH SETTING  
SIZES AND DIMENSIONS**

Size	A in	B in	C in	D in	
E	F	(mm)	(mm)	(mm)	(mm)
2"	3"	4.94 (125)	5.81 (148)	14.12 (359)	8.00 (203)
3"	4"	6.38 (162)	6.25 (159)	15.94 (405)	10.19 (259)
4"	6"	8.00 (203)	6.31 (160)	16.38 (416)	12.25 (311)
6"	8"	8.75 (222)	8.00 (203)	20.06 (510)	14.19 (360)
8"	10"	11.19 (284)	8.62 (219)	21.12 (536)	17.94 (456)
10"	12"	13.62 (346)	12.75 (324)	25.81 (656)	22.38 (568)
12"	14"	15.38 (391)	16.69 (424)	29.88 (759)	25.38 (645)

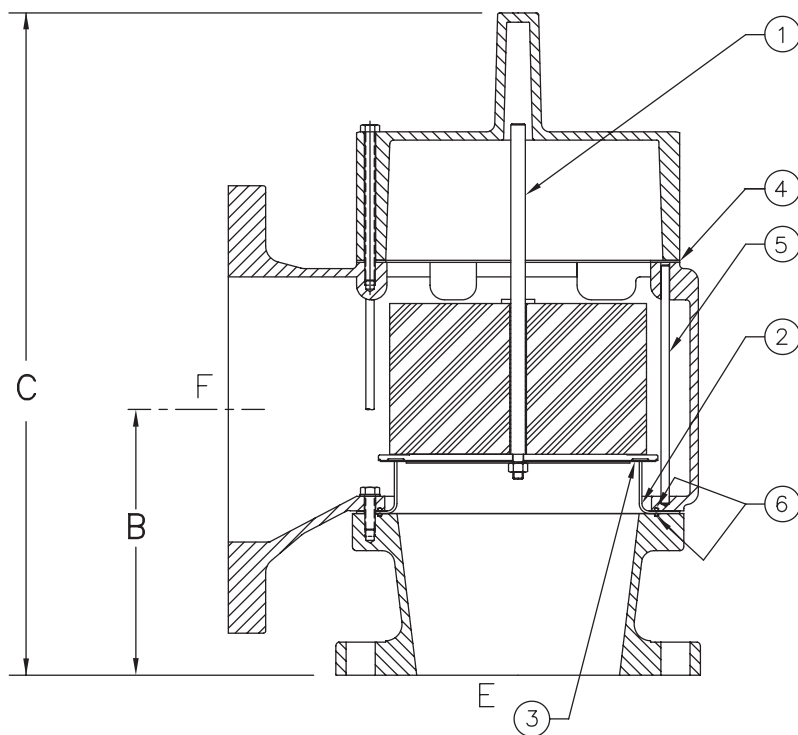
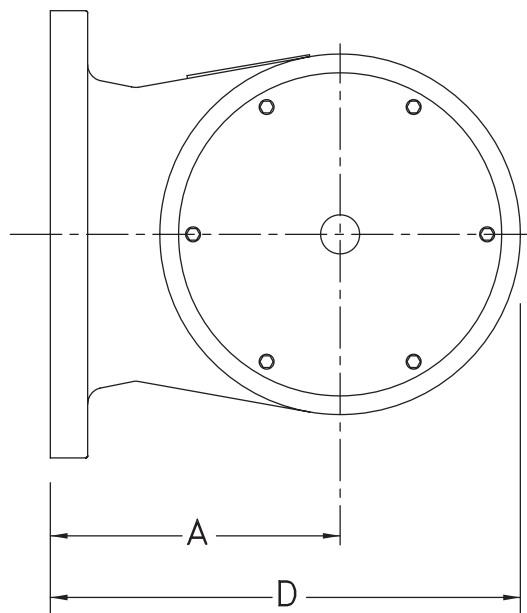


FIGURE 7 - MODEL 3650B PRESSURE OR VACUUM RELIEF VALVE (HIGH SETTING)  
DRILLING PER ANSI CLASS 125 F.F.

# VAREC 3600B/3650B SERIES PRESSURE OR VACUUM RELIEF VALVES

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### MODEL 3600B AND 3650B REPLACEMENT PARTS

When ordering replacement parts, specify relief valve by model number, pipe size and serial number. Identify replacement parts by part number, description and material where possible.

**TABLE 11 - REPLACEMENT PARTS MODEL 3600B (SEE FIG. 4 AND 5)**

Item no.	Description	Usage	Material	2"	3"	4"	6"	8"	10"	12"
1*	Pallet assembly	Low set	Aluminum	06-11485-101	06-11485-101	06-11485-201	06-11485-001	06-11485-601	06-11485-701	06-11485-801
		High set	Aluminum	06-11486-101	06-11486-101	06-11486-201	06-11486-301	06-11486-401	06-11486-501	06-11486-601
		Low set	316 SST	06-11485-106	06-11485-106	06-11485-206	06-11485-006	06-11485-606	06-11485-706	06-11485-806
		High set	316 SST	06-11486-106	06-11486-106	06-11486-206	06-11486-306	06-11486-406	06-11486-506	06-11486-606
2*	Seat ring	All	Aluminum	02-10438-001	02-10438-001	02-10251-001	02-05464-001	02-05478-001	02-05482-001	02-05487-001
		All	316 SST	02-10438-006	02-10438-006	02-10251-006	02-05464-006	02-05478-006	02-05482-006	02-05487-006
3	Pallet insert	All	PTFE	02-10361-093	02-10361-093	02-09704-093	B12741-093	B12742-093	B12743-093	B12744-093
4	Screen	All	HDPE	02-11547-051	02-11547-151	02-11547-251	02-11547-351	02-11547-451	02-11547-551	02-11547-651
5	Cover and spacer gasket	All	Nitrile (NBR)	02-11380-075	02-11380-075	02-11381-075	02-11382-075	02-11383-075	02-11384-075	02-11385-075
6*	Guide post	All	316 SST	02-11015-106	02-11015-106	02-11015-306	02-11431-306	B16553-406	B16553-206	B16553-506
7	O-ring	All	Nitrile (NBR)	P014-03-285	P014-03-285	P014-03-273	P014-03-286	P014-03-287	P014-03-288	P014-03-289
8	Retaining ring	All	Polypropylene	02-11396	02-11396	02-11397	02-11398	02-11399	02-11400	02-11401

\* For 'All-weather' parts, add -1 to end of listed part numbers.

**TABLE 12 - REPLACEMENT PARTS MODEL 3650B (SEE FIG. 6 AND 7)**

Item no.	Description	Usage	Material	Nominal pipe size (inlet x outlet)						
				2" x 3"	3" x 4"	4" x 6"	6" x 8"	8" x 10"	10" x 12"	12" x 14"
1*	Pallet assembly	Low set	Aluminum	06-11485-101	06-11485-201	06-11485-001	06-11485-601	06-11485-701	06-11485-801	06-11485-901
		High set	Aluminum	06-11486-101	06-11486-201	06-11486-301	06-11486-401	06-11486-501	06-11486-601	06-11486-701
		Low set	316 SST	06-11485-106	06-11485-206	06-11485-006	06-11485-606	06-11485-706	06-11485-806	06-11485-906
		High set	316 SST	06-11486-106	06-11486-206	06-11486-306	06-11486-406	06-11486-506	06-11486-606	06-11486-706
2*	Seat ring	All	Aluminum	02-10438-001	02-10251-001	02-05464-001	02-05478-001	02-05482-001	02-05487-001	02-05499-001
		All	316 SST	02-10438-006	02-10251-006	02-05464-006	02-05478-006	02-05482-006	02-05487-006	02-05499-006
3	Pallet insert	All	PTFE	02-10361-093	02-09704-093	B12741-093	B12742-093	B12743-093	B12744-093	B13288-093
4	Cover and spacer gasket	All	Nitrile (NBR)	02-11380-075	02-11381-075	02-11382-075	02-11383-075	02-11384-075	02-11385-075	02-11386-075
5*	Guide post	All	316 SST	02-11015-106	02-11015-306	02-11432-106	B16553-406	B16553-206	B16553-506	02-11433-106
6*	O-ring	All	Nitrile (NBR)	P014-03-285	P014-03-273	P014-03-286	P014-03-287	P014-03-288	P014-03-289	P014-03-290

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