

Tool List:

1. Socket set.
2. Spanner set.
3. Allen key set.
4. Screw driver set
5. Brass punch set.
6. Circlip pliers.
7. O-ring pick.
8. Plastic hammer.
9. 12" adjustable spanner.
10. Vice.
11. Grease.
12. Hydraulic oil.
13. Anti-seize protective compound.
14. PTFE thread tape.
15. Clean rags.
16. Wireline valve control panel, hoses and bridals (if hydraulically operated).
17. Wireline valve schematics for the valve being worked on.
18. Maintenance file for valve being worked on.
19. Complete Brace supplied redress kit suited for the well conditions and equipment specification.

DISASSEMBLY: Reference Bill of Materials for Part Identification

1. Remove adapter plugs from the body.
2. Remove the hexagon socket button head cap screw from the by pass plug.
3. Remove the bleed off plug from the bypass plug.
4. Remove the by pass plug from the body.
5. Remove the adapter plugs and/or hydraulic fittings from the cylinder and drain any excess fluid.
6. Unscrew valve nut, this will back out the hydraulic cylinder from the valve.
7. Have two people for this task so you can guide out the cylinder and prevent the ram from dropping once the ram is visible.
8. Once the ram and the cylinder are free from the body use a bench vise to handle the part removal from the cylinder.
9. Remove the spiraloc ring from the cylinder and slide off the nut.
10. Remove the end cap.
11. Remove the retaining ring (interior) from the end cap.
12. Remove the lock out bolt from the end cap.
13. Remove the piston from the piston shaft (This can be accomplished by using the piston wrench.)
14. Remove the piston shaft through front of cylinder.
15. Remove the bushing from piston shaft.
16. Remove the indicator rod from the piston.
17. Remove the internal retaining ring (snap ring pliers required).
18. Remove all V-packing, back up rings, and O-rings from cylinder, piston, and end cap.
19. Clean and inspect all parts for wear or damage.
20. Remove inner and outer seals from rams.
21. Remove the lock out pins and bronze bushings from the hydraulic cylinder.
22. Remove the V-packing, O-rings, and anti rotation pin from the hydraulic cylinder.
23. Remove the lock out bolt from the end cap.
24. Repeat steps 5 thru 23 for the remaining cylinder assemblies.
25. Remove set screws on the top and bottom subs of the wireline valve.
26. Remove the top sub.
27. Remove the bottom sub and union nut.
28. Clean and inspect all parts for wear or damage.
 - a. If any significant damage or wear; replace or repair as per original OEM spec.

ASSEMBLY: Reference Bill of Materials for Part Identification

1. Install two #249 O-rings and #249 back-up rings in the top and bottom of the wireline valve body.
2. Install the top sub into the body of the wireline valve with the wellhead arrow facing down to the bottom sub. ***RECOMMENDED TORQUE –600 FT/LBS***.
3. Install two set screws in the wireline valve body located at the top sub and tighten.
4. Install the bottom sub and hand nut into the body of the wireline valve (the wellhead direction arrow will be pointing towards the bottom sub and hand nut.) ***RECOMMENDED TORQUE -600 FT/LBS***.
5. Install two set screws in the wireline valve body located at the bottom sub and tighten.
6. Install one #111 O-ring onto the four adapter plugs.
7. Install the adapter plugs into the body of the wireline valve.
8. Install the #009 O-rings and #009 back up rings on the two bleed off plugs and install into the by-pass plugs.
9. Install two #114 O-rings and two #114 back-up rings onto by-pass plugs.
10. Install two by-pass plugs into the body of the wireline valve.
11. Install two hexagon socket button head cap screws into the by-pass plug.
12. Install the #248 O-ring and #248 back-up ring into the hydraulic cylinder.
13. Install the #222 O-ring and #222 back-up ring into the inside of the cylinder and end cap.
14. Install the “T” seal and back-up rings on the piston.
15. Install the #244 O-ring and #244 back up ring onto the end cap.
16. Install the #131 O-ring on the outside of the male back-up ring and the #128 O-ring on the inside of the male back-up ring.
17. Install the female back-up ring into the packing bore of the cylinder with the V-groove exposed.
18. Install the V-packing into the packing bore of the cylinder so that it fits into the female back-up ring.
19. Install the male back-up ring into the packing bore (take care to ensure that the external #131 O-ring is not scored).
20. Install the internal retaining ring (snap ring pliers required).
21. Install the piston onto the indicator rod and tighten.
22. Install the bronze bushing onto the piston shaft and install into the cylinder through the packing and back-up rings. (Take care not to score the O-rings when sliding the threads of the piston shaft through.)
23. Install the piston into the cylinder and thread onto the piston shaft (This can be accomplished by using the piston wrench.)
24. Install the end cap onto the cylinder (Care should be taken to ensure that the O-rings and back-up rings are not damaged.)
25. Install the lock out bolt into the end cap.
26. Install the stop ring against the lock out bolt.
27. Install the internal snap ring into the end cap.
28. Install the nut onto the cylinder.
29. Install the spiroloc retaining ring onto the cylinder to the first groove closest to the end cap.
30. With piston in the closed position, fill the cylinder with hydraulic fluid via the NPT port in the end cap.
31. Install the desired hydraulic fittings.
32. Install the desired inner and outer seals onto the rams using the key retainer to retain the inner seals.
33. Install the lock out pin and bushing into the “T” slot of the ram. The bushing is to act as a bearing between the “T” slot and the lock out pin.
34. Install the anti rotation pin into the cylinder. (This is accomplished by dropping the pin through the alignment slot on the ram, aligning with the threaded hole in the cylinder and tightening with a wrench.)
35. Install the ram and hydraulic cylinder assembly into the body of the wireline valve by pushing the ram into the body far enough that the nut can engage the threads. (Ensure that the outer seal is facing up and the locating pin is lined up with the locating pin hole on the cylinder.)

ASSEMBLY: Reference Bill of Materials for Part Identification

36. Move the spiraloc retaining ring to the grove closest to the nut, which allows you to remove the cylinder via the nut at the disassembly stage.
37. Repeat steps to 12-36 for additional hydraulic cylinder assemblies.
38. It is recommended that a function test is performed after assembly before being put into service.
39. It is recommended that a pressure test be performed at this point to verify wireline valve integrity, as per your local regulations.

Pressure Testing Guidelines for a Slickline Wireline Valve:

- Confirm that all personnel are deemed competent to perform the task.
- Document all changes, configurations and repairs made to the equipment and keep copies in your company maintenance files.
- Sign off completed pre-job inspection checklist.
- Place signs and barriers warning all personnel of the defined test area.
- Ensure clear radio communication between the controller of the pressure test unit (PTU) and the supervisor in charge of the test.
- Ensure all personnel without radio communication are in a clear line of visibility.
- Ensure constant communication between the PTU operator and the supervisor.
- Pressure test as per local regulations or manufacture guidelines.

Pressure Testing Guidelines for Slickline Wireline Valve dressed with Blind Ram Seals:

- Install the wireline valve and connect bridals and hoses to wireline valve panel/hand pump.
- Make an announcement for pressure testing, so everyone in the area is aware of the danger.
- Open the equalizing port.
- Partially close blind rams, leaving enough gap to allow test fluid overflow above the rams to expel any air in the system.
- Fill with test fluid.
- Cease pumping fluid when the fluid is level with the blind rams.
- Close the blind rams.
- Instruct the pressure pump operator to pump slowly and wait for fluid to overflow over the blind ram via equalization port or manifold if the test is being done with the lubricator in position.
- Stop pump operator and close equalization ports.
- Perform initial low-pressure test. The test is a 5-minute, 300 psi test to ensure the integrity of the pressure test lines etc.
- Perform the high-pressure test as per company's pressure test procedure, typically working pressure rating.
- Pressure up slowly in stages to the required test pressure. Ensure this figure does not exceed the working pressure.
- On completion of a successful blind ram test, bleed pressure back to zero via PTU.
- Open equalization ports (slowly) on the wireline valve to dispel any residual low pressure.
- Open the wireline valve blind ram.
- Close the equalization ports and continue pressure test procedure.

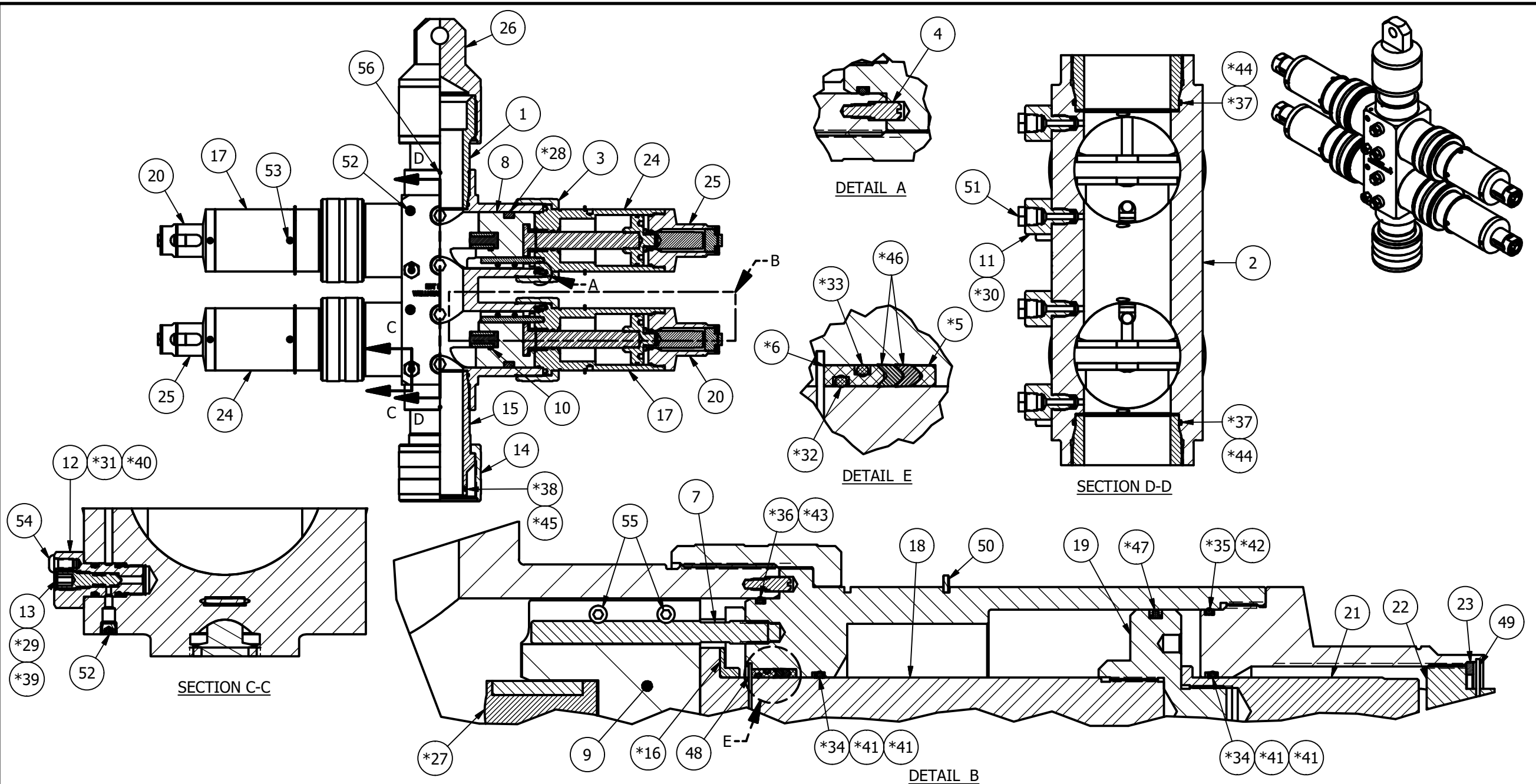
Pressure Testing Guidelines for Braided Line Wireline Valve:

- Confirm that all personnel are deemed competent to perform the task.
- Document all changes, configurations and repairs made to the equipment and keep copies in the maintenance files.
- Sign off completed pre-job inspection checklist.
- Place signs and barriers warning all personnel of the defined test area.
- Ensure clear radio communication between the controller of the pressure test unit (PTU) and the supervisor in charge of the test.
- Ensure all personnel without radio communication are in a clear line of visibility.
- Ensure constant communication between the PTU operator and the supervisor.
- Ensure all grease lines and sufficient injection grease is available for the operation duration.
- For hydraulic wireline valves connect bridals and hoses to control panel and grease injection ports.
- Make an announcement for pressure testing, so everyone in the area is aware of the danger.
- Install the correctly sized test rod and close lower ram and apply ram pressure, ensuring the rod is tied off correctly with certified strop and shackles.
- Inject grease and close upper and lower rams on the test rod applying equal pressure on both top and bottom rams.
- Apply injection grease pressure between the rams.
- Open the equalizing port to remove air pocket.
- Instruct the pressure pump operator to pump slowly and wait for test fluid to overflow over the wireline valve ram via equalization port.
- Stop the pump operator and close equalization ports.
- Perform initial low-pressure test. This is a 5-minute test, 300 psi test to ensure the integrity of the pressure test lines etc.
- Perform the high-pressure test as per company's pressure test procedure, typically working pressure rating.
- Pressure up slowly in stages to the required test pressure. Ensure this figure does not exceed the working pressure.
- On completion of a successful ram test, bleed pressure back to zero via PTU..
- Open the equalization ports on the wireline valve to dispel any residual low pressure.
- Open the wireline valve rams.
- Close equalization ports and continue pressure test procedure.

Inspection & Testing

- Brace Tool recommends a complete tear down inspection after any procedure that may expose the wireline valve to sand, salt, KCL water, or like fluid, extended periods of H₂S service, or any other corrosive or oxidizing fluids or materials.
- Brace Tool recommends a complete tear down inspection at least quarterly based on operational exposure; this may increase at the user's discretion.
- All Pressure Control Equipment must be maintained at regular intervals and re-certified at least once per year with an accurate record of all essential and non-essential maintenance.
- The yearly maintenance procedure should be implemented after any job that exposes the Pressure Control Equipment to conditions, such as accidental drops, corrosive fluids, long durations in position on H₂S or CO₂ or any major maintenance.
- An annual pressure test should be performed when any service requirements are performed.
- After any integral part is removed or replaced that may compromise the integrity of the wireline valve.
- After servicing of the wireline valve.
- After any inspection or repair.
- After any seals are changed out.
- Prior to any pressure test remove any NPT plugs, clean, oil and thread depth check.

AT ANY POINT THAT WELLBORE PRESSURE OR FLUIDS ARE ALLOWED TO ESCAPE UNEXPECTEDLY TO ATMOSPHERE DUE TO FAILURE OF THE WIRELINE VALVE. IT IS RECOMMENDED THAT THE EQUIPMENT BE IMMEDIATELY REMOVED FROM SERVICE AND QUARANTINED UNTIL A COMPLETE INSPECTION, REPAIR, AND PRESSURE TEST CAN BE DONE.



REV	DATE	DESCRIPTION	BY	ECR

THIS DOCUMENT IS THE SOLE PROPERTY OF BRACE TOOL INC. IT CONTAINS CONFIDENTIAL AND PROPRIETARY INFORMATION; IT IS DISTRIBUTED WITH THE UNDERSTANDING THAT IT WILL NOT BE REPRODUCED OR USED FOR ANY PURPOSE EXCEPT THE CONFINED FUNCTION OF WHICH IT IS DISTRIBUTED. UPON DEMAND, THIS DOCUMENT SHALL BE RETURNED TO BRACE TOOL INC.

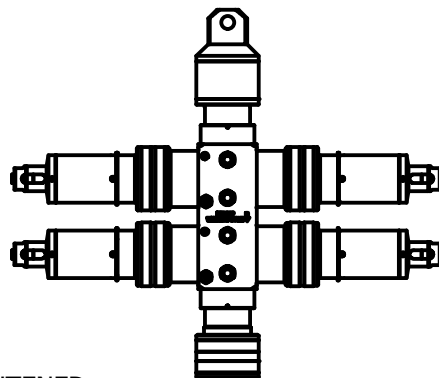
TOLERANCES		MATERIAL AS REQ		TITLE	
.X = +/- 0.030	.XX = +/- 0.015	.XXX = +/- 0.005	SCALE NTS	SHEET 1 of 2	4 1/16" WIRELINE VALVE
∠ = +/- 0.5 DEG	© = .005 TIR		DWN L.M.B.	DATE 8/15/2018	6.500-4 ACME BOX x PIN
			CHK CB	DATE 8/18/2018	5K HYDRAULIC ACTIVATED
					DWG # 13-01-DWL-400-A0
					REV 0

BRACE TOOL
 TEL (780) 438 - 0441 1-800-438-0061

ITEM	QTY	DESCRIPTION	PART NUMBER	MATERIAL	ITEM	QTY	DESCRIPTION	PART NUMBER	MATERIAL
1	1	TOP SUB	13-01-WLV-400-01	AISI 4140 - L80	*29	4	O-RING	2-009	HSN OR AS REQUIRED
2	1	BODY	13-01-DWL-400-02	AISI 4140 - L80	*30	4	O-RING	2-111	HSN OR AS REQUIRED
3	4	NUT	13-01-WLV-400-03	4140 HTSR (28-32 HRC)	*31	4	O-RING	2-114	HSN OR AS REQUIRED
4	4	LOCATING PIN	13-01-WLV-300-04	AISI 1018	*32	4	O-RING	2-128	HSN OR AS REQUIRED
*5	4	FEMALE BACKUP RING	13-01-WLV-400-12	BRASS (UNS C36000)	*33	4	O-RING	2-131	HSN OR AS REQUIRED
*6	4	MALE BACKUP RING	13-01-WLV-400-13	BRASS (UNS C36000)	*34	8	O-RING	2-222	HSN OR AS REQUIRED
7	4	ANTI-ROTATION PIN	13-01-WLV-400-15	AISI 1018	*35	4	O-RING	2-244	HSN OR AS REQUIRED
8	2	RAM BLOCK (RIGHT HAND)	13-01-WLV-400-18	AISI 4140 - L80	*36	4	O-RING	2-248	HSN OR AS REQUIRED
9	2	RAM BLOCK (LEFT HAND)	13-01-WLV-400-19	AISI 4140 - L80	*37	2	O-RING	2-249	HSN OR AS REQUIRED
10	4	KEY RETAINER	13-01-WLV-300-23	AISI 1018	*38	1	O-RING	2-348	HSN OR AS REQUIRED
11	4	ADAPTER PLUG	13-01-WLV-300-24	AISI 4140 - L80	*39	4	BACKUP RING	8-009	HSN OR AS REQUIRED
12	2	BY-PASS PLUG	13-01-WLV-300-27	AISI 4140 - L80	*40	4	BACKUP RING	8-114	HSN OR AS REQUIRED
13	2	BLEED-OFF PLUG	13-01-WLV-300-28	316 STAINLESS STEEL	*41	16	BACKUP RING	8-222	HSN OR AS REQUIRED
14	1	NUT	13-02-HUN-650-02	AISI 4140 - P110	*42	4	BACKUP RING	8-244	HSN OR AS REQUIRED
15	1	BOTTOM SUB	13-01-WLV-400-30	AISI 4140 - L80	*43	4	BACKUP RING	8-248	HSN OR AS REQUIRED
*16	4	BUSHING	13-01-WLV-400-31	BRASS (UNS C36000)	*44	2	BACKUP RING	8-249	HSN OR AS REQUIRED
17	2	LEFT CYLINDER	13-01-WVH-400-01	AISI 4140 - L80	*45	1	BACKUP RING	8-348	HSN OR AS REQUIRED
18	4	PISTON SHAFT	13-01-WVH-400-06	AISI 4140 - L80	*46	8	'V' PACKING	08-02-VP-187-01	AS REQUIRED
19	4	PISTON	13-01-WVH-400-07	17-4 H1150 SS	*47	4	T-SEAL	TP043	AS REQUIRED
20	2	LEFT END CAP	13-01-WVH-400-08	AISI 4140 - L80	48	4	INTERNAL RETAINING RING	HO-200	STAINLESS STEEL
21	4	INDICATOR ROD	13-01-WVH-400-09	17-4 H1150 SS	49	4	INTERNAL RETAINING RING	HO-218	STAINLESS STEEL
22	4	LOCK-OUT BOLT	13-01-WVH-400-10	17-4 H1150 SS	50	4	RETAINING RING - EXT.	RST-550	STAINLESS STEEL
23	4	STOP RING	13-01-WVH-400-11	17-4 H1150 SS	51	4	HEX HEAD PLUG	1/2-14 NPT	AS REQUIRED
24	2	RIGHT CYLINDER	13-01-WVH-400-12	AISI 4140 - L80	52	4	SOCKET HEAD PLUG	1/8-27 NPT x .25 LG	AS REQUIRED
25	2	RIGHT END CAP	13-01-WVH-400-13	AISI 4140 - L80	53	8	SOCKET HEAD PLUG	1/4-18 NPT	AS REQUIRED
26	1	LIFT CAP	13-01-LS-400-01	AISI 4140 - L80	54	2	HEX SOCKET BUTTON CAP SCREW	.250-20 UNC x .50 LG	AS REQUIRED
*27	4	INNER RAM SEAL	Inner Ram Seal 4.063	NITRILE OR HSN	55	8	HEX SOCKET HEAD CAP SCREW	.250-20 UNC x 1.25 LG	AS REQUIRED
*28	4	OUTER RAM SEAL	Outer Ram Seal 4.063	NITRILE OR HSN	56	4	SET SCREW	.250-20 UNC x .38 LG	AS REQUIRED

*IDENTIFIER INDICATES PARTS THAT ARE COMMONLY REPLACED ON ASSEMBLY

DESCRIPTION	DATA
MINIMUM ID (FULLY OPEN)	Ø4.063
TOP CONNECTION	6.500-4 ACME PIN
BOTTOM CONNECTION	6.500-4 ACME BOX
MAXIMUM WORKING PRESSURE	5,000 PSI
TYPE OF SERVICE	H2S
SHIPPING DIMENSIONS	50" x 43" x 9"
APPROXIMATE WEIGHT	749 lb



WEIGHT = 748.58 lb

NOTE:

1. INSURE THAT ALL PLUGS AND VALVES ARE PROPERLY SEALED AND TIGHTENED.

<p>THIS DOCUMENT IS THE SOLE PROPERTY OF BRACE TOOL INC. IT CONTAINS CONFIDENTIAL AND PROPRIETARY INFORMATION; IT IS DISTRIBUTED WITH THE UNDERSTANDING THAT IT WILL NOT BE REPRODUCED OR USED FOR ANY PURPOSE EXCEPT THE CONFINED FUNCTION OF WHICH IT IS DISTRIBUTED. UPON DEMAND, THIS DOCUMENT SHALL BE RETURNED TO BRACE TOOL INC.</p>			
<p>TOLERANCES .X = +/- 0.030 .XX = +/- 0.015 .XXX = +/- 0.005 < = +/- 0.5 DEG © = .005 TIR</p>	<p>TEL (780) 438 - 0441 1-800-438-0061</p>	<p>MATERIAL AS REQ</p> <p>SCALE NTS SHEET 2 of 2</p> <p>DWN DATE 8/15/2018</p> <p>L.M.B.</p> <p>CHK DATE 8/18/2018</p> <p>CB</p>	<p>TITLE</p> <p>4 1/16" WIRELINE VALVE 6.500-4 ACME BOX x PIN 5K HYDRAULIC ACTIVATED</p> <p>DWG # 13-01-DWL-400-A0</p> <p>REV 0</p>