

Gas Pressure Regulator RMG 402



**Operation and Maintenance,
Spare Parts**

402.20
edition 01/2000

Serving the Gas Industry - WORLDWIDE



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1. General

In addition to this leaflet 402.20 concerning "Operation and Maintenance, Spare Parts" of the regulator RMG 402, the brochure 402.00 gives full information about all relevant technical data, description of function, the available different versions, and the dimensions.

Due to the special design and operation of the RMG 402, we recommend to study and observe the special instructions within these leaflets as well:

Pilot:	RMG 630/640	General Description	630.00
		Operation and Maintenance, Spare Parts	630.20
SAV:	RMG 720 / 721	General Description	402.00
		Operation and Maintenance, Spare Parts	
		Control Devices K1a, K2a	673.20
		Control Devices K4, K5, K6	674.20
		Control Devices K10a, K12, K13, K16, K17	672.20
Filter:	RMG 905	General Description	905.00
		Operation and Maintenance, Spare Parts	905.20

The RMG brochure "General operating instructions for gas pressure regulators and safety devices" will be useful to fit the regulator into the line, put it into service and find faults that might disturb its operation. Please also check if the construction, set-up, supervision and maintenance of gas pressure regulating stations may be subject to special national regulations. These technical rules should be observed strictly (Within Germany observe the DVGW worksheets G 490, G 491, G 495).

The frequency of periodical maintenance of gas pressure regulators and other components of the regulating line is strongly dependant on the prevailing service conditions, the type and composition of the gaseous medium, the ambient temperature and on dust and dirt withing the pipe system. We therefore abstain from imposing any fixed intervals and would rather advise testing out the necessary maintenance intervals, starting with short gaps (i.e. quarter of a year) for maintenance disassembly, and then increasing the intervals to a maximum of 2 years, if no defects within the spare parts show up.

For maintenance all parts are to be cleaned and subjected to a thorough visual inspection. Complete dismantling together with visual inspection should not be omitted when the course of operation or performance tests have shown lack of accuracy. Particular care should be given to the checking of sealings and diaphragms, as well as the closing spring and all movable parts. Damaged parts should be replaced by new ones.

The item numbers referred to in the maintenance instructions are identical with those of the spare parts drawings and spare parts lists.

Note! We recommend to keep all parts marked "EV" in stock for maintenance availability.

1.1 Appointed workmen

Experts

Thanks to his technical training, his practical work and his experience, the expert has sufficient knowledge in the field of maintaining complete gas facilities as well as the single devices with their constructional elements and sub-groups. He must be acquainted with the purpose and the tasks of gas pressure regulating facilities, with the relevant laws, guidelines and general technical rules, and must also be capable of deciding and acting on his own.

Qualified employee

The qualified employee must possess special, proven knowledge for the certain task he is about to perform. He is acquainted with the general rules and regulations, and it is guaranteed that he can carry out tasks correctly when ordered to do so.

Instructed person



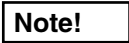
A person trained to accomplish simple tasks.

Tasks and workmen	instructed person	qualified employee	expert
Visual checks			
Inspection			
Functional tests			
Maintenance / repairs			additional 2nd person required
Putting into operation / re-starting			
Operation using by-pass lines			

1.2 Security Instructions

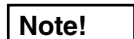
1.2.1 Risk characteristics, general

Security instructions are marked in the operating instructions by the following **signal words** or **symbols** :

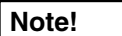
Designation	Used by:
	Risk of injury to personnel
	Risk of damaging equipment and environment
	Additional information or requirements

2. Special Operating Instructions

2.1 Start-up:

 **Note!**

 **Caution!**

 **Note!**

 **Caution!**

- Close the outlet gate valve
- Release completely the setpoint springs of the pilots RMG 620, 630, 640 of the load limiting stage and of the auxiliary pressure stage (only valid for the RMG pilot 630) by turning the setpoint adjusting screw (218) counter-clockwise.
(The complete releasing of the setpoint screws is at least recommendable for start-up)
- Open the start-up valve. The existing start-up valve assures a pressure compensation on the expansion diaphragm (6, 107)
- Pressurize slowly.
- The start-up valve (107, 125, 135) must be absolutely re-closed.
- Adjust the setpoint of the load limiting unit of pilot RMG 630 to approximately 5 bar above the outlet pressure (p_a).
- Open the outlet gate valve slowly.
- Increase slowly the setpoint value with the adjusting screw (218) until the device takes over the gas supply and the outlet pressure p_{as} wanted is adjusted.

2.2 Shut-down:

- Close the outlet gate valve
or
- Turn the setpoint screw slowly counter-clockwise (release)

3. Special Maintenance Operations

3.1 Main Valve

- Expansion diaphragm (6, 107)

The expansion diaphragm must be put into the corresponding seat of the main valve (11, 52, 113) without distortions. A diaphragm having a too big outer diameter must be replaced.

- Noise reduction (180)

When mounting the metal foam ring (180), please see that the working surface on the ring shows downwards (showing to the outlet surface of the seat of the main valve)

- Foamed disc / foamed ring (102, 105) from the pipe size DN 80

The damping elements (102, 105) must be replaced for each maintenance.
The damping disc situated on the diaphragm plate must be fixed to the part (104) with bounding agent (Loctite 454).

3.2 Pilot RMG 620

3.2.1

- **Double diaphragm system**

By releasing the screw connection (207) between the parts (208) and (209) the double diaphragm system can be dismantled and visually controlled.

Diaphragms (210) must be inspected on porous places or on the detachment of the rubber coating. For the dismantlement of the screws (212) are released from the stay bolts (216).

If damages are noticed on the piston sealing (241), the bolts must be replaced.
Unscrew the pistons (241 premounted part) of the amplifying valve out of the piston guide (240) by releasing the hexagonal nut (241).

Note!

The sealing edge of the orifice (239) of the amplifying valve should not show any mechanical damages.

To mount each part of the double diaphragm system, please care about the following remarks:

Note!

- **Premounted piston (241)**

The piston is mounted with a suspension spring and provided with a corresponding distance dimension for the amplifying valve.

If the pilot was maintained, the piston must be replaced (higher closing pressure).



Warning

- **Diaphragm fixing (211, 214)**

The rounded-off side on the diaphragm plates (211, 214) must show to the diaphragm (210).

3.2.2

- **Pressure compensating element (303) from DN 80**

Control the easy-running of the pressure compensating pin or grease it with silicone grease.

3.2.3

- **Lubricants**

All parts must be greased according to the lubricants lists (see lubricants charts on the next page).

3.3

• Torques

screw pos. no.	torque M _A in Nm			
	DN 25 [Nm]	DN 50 [Nm]	DN 80 [Nm]	DN 100 [Nm]
1	10	10	-	-
5	50	50	-	-
13	12	12	-	-
15	12	12	-	-
56	-	50		
103	-	-	20	20
106	-	-	50	50
110	-	-	12	12
120	-	-	50	50
188	-	-	50	50
204	25	25	25	25
207	30	30	30	30
212	6	6	6	6

3.4

• Lubricants

element (grease slightly)	lubricant	RMG-part no.
all o-rings mounting swelling of expansion diaphragm (6, 107) switching balls (510) ball bearing intermediary spaces (529)	silicone grease	can 1,0 kg 00 027 079 tube 0,1 kg 00 027 081
all fixing screws and all pipe connections	high pressure grease	00 027 058

3.5

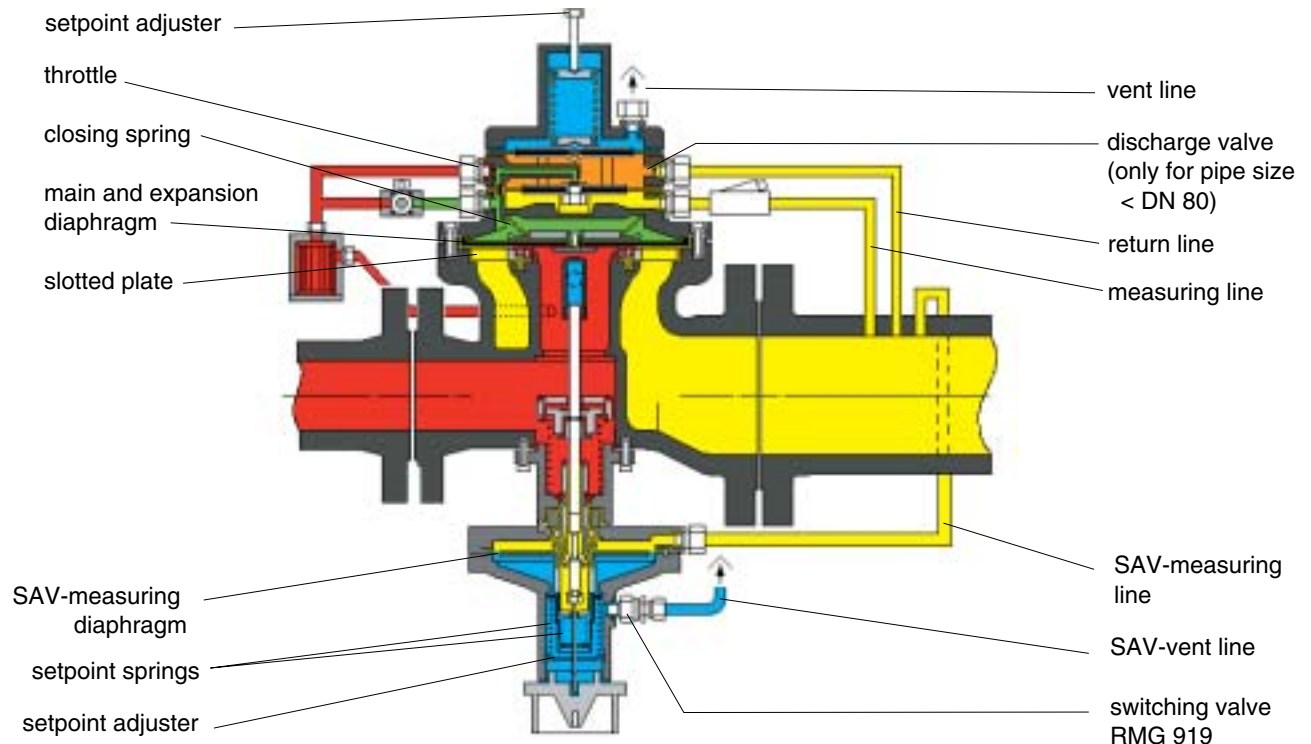
• Screw seals

element	means	
cylinder screw (1, 103)	LOCTITE**) Type 221	

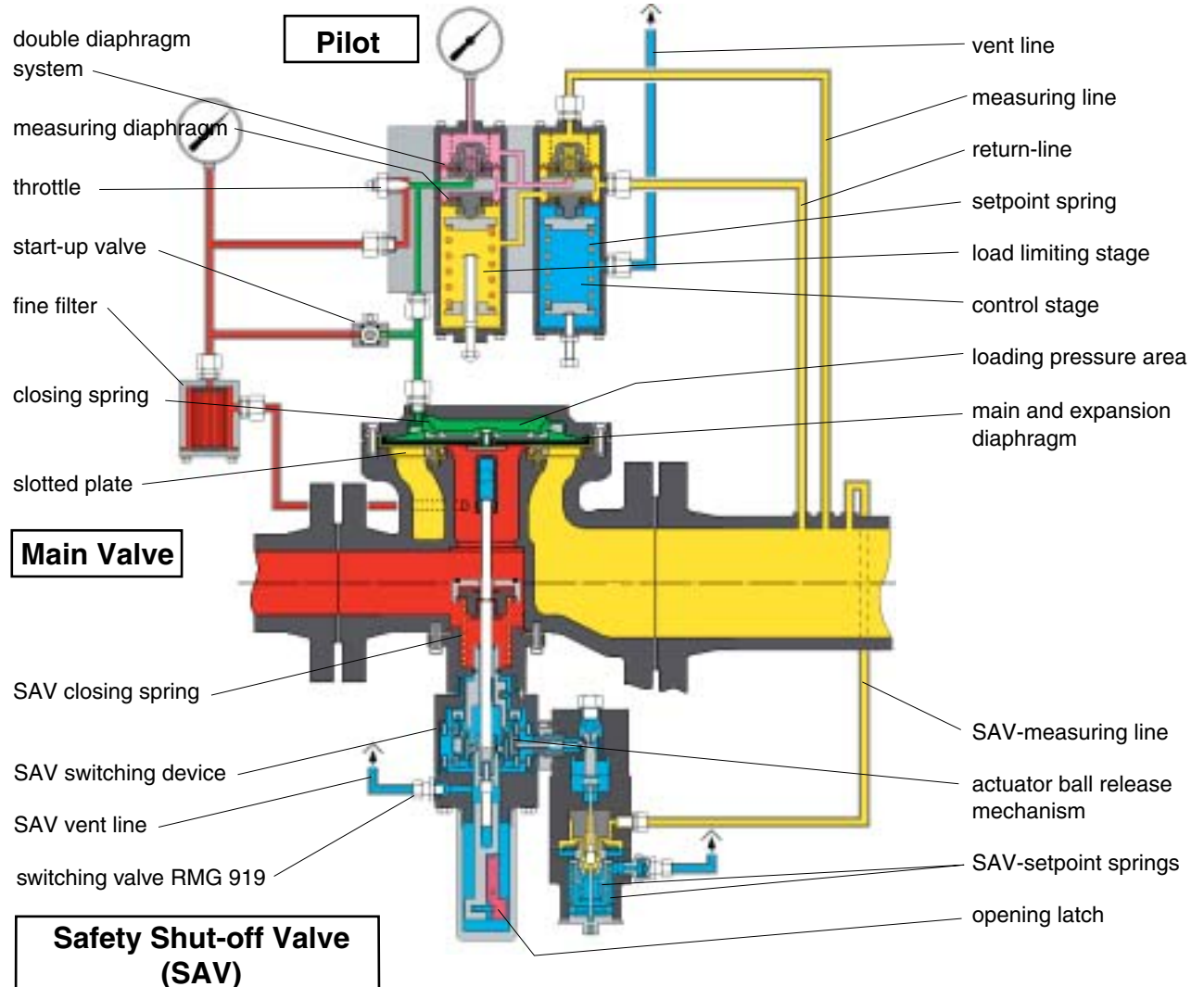
**) is to be found in specialized stores

3.6 Examples of different pilot combinations without or with outlet expansion

a) RMG 402 without outlet expansion, f.i. with pilot RMG 620 and SAV-unit RMG 720 / K4



b) RMG 402 with outlet expansion, f.i. with pilot RMG 630a and SAV-unit RMG 721 / K12

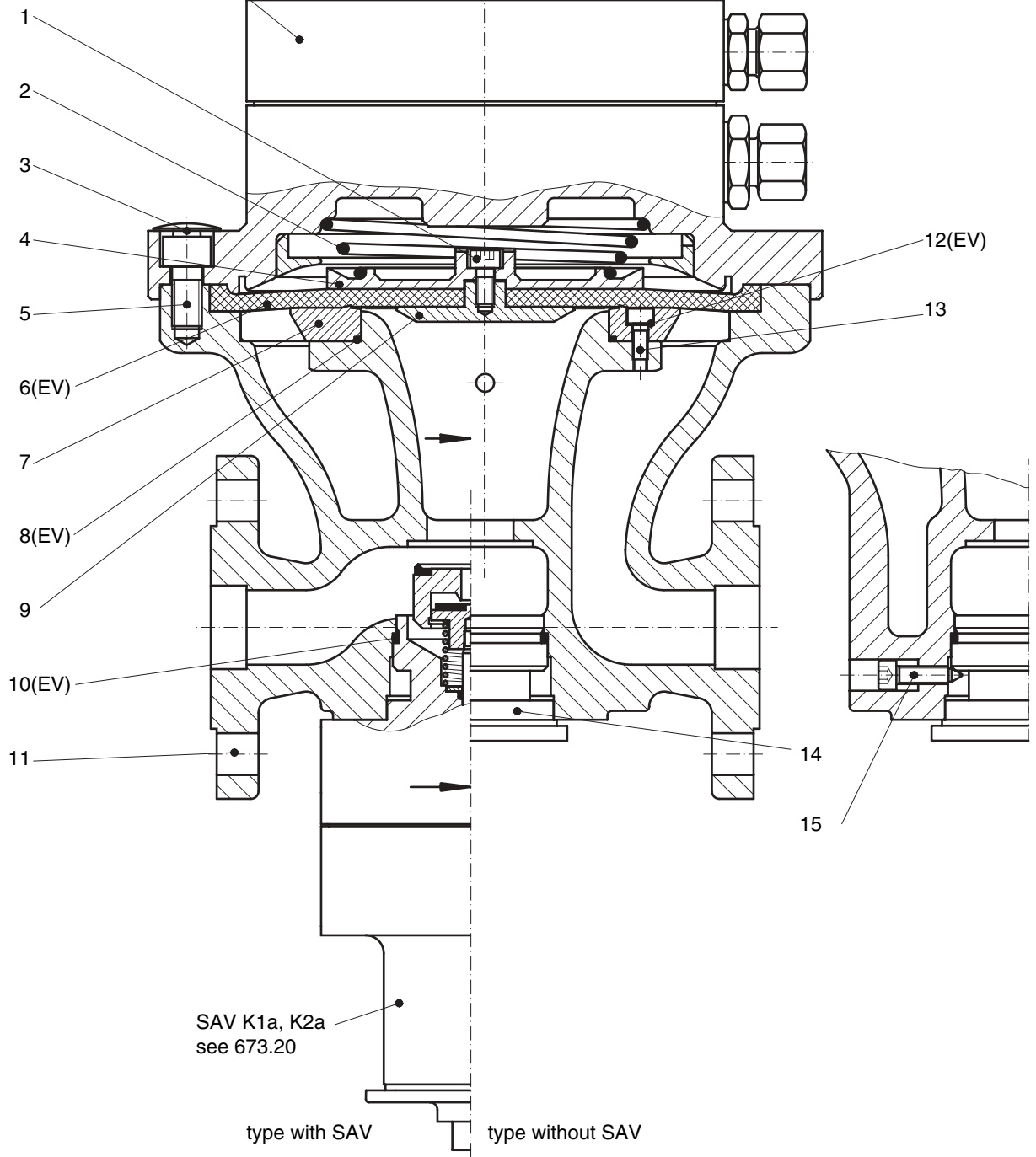


4. Spare Parts Drawings

4.1 Spare Parts Drawing RMG 402 DN 25

from serial number 95 10 157 88
see spare parts list p. 21

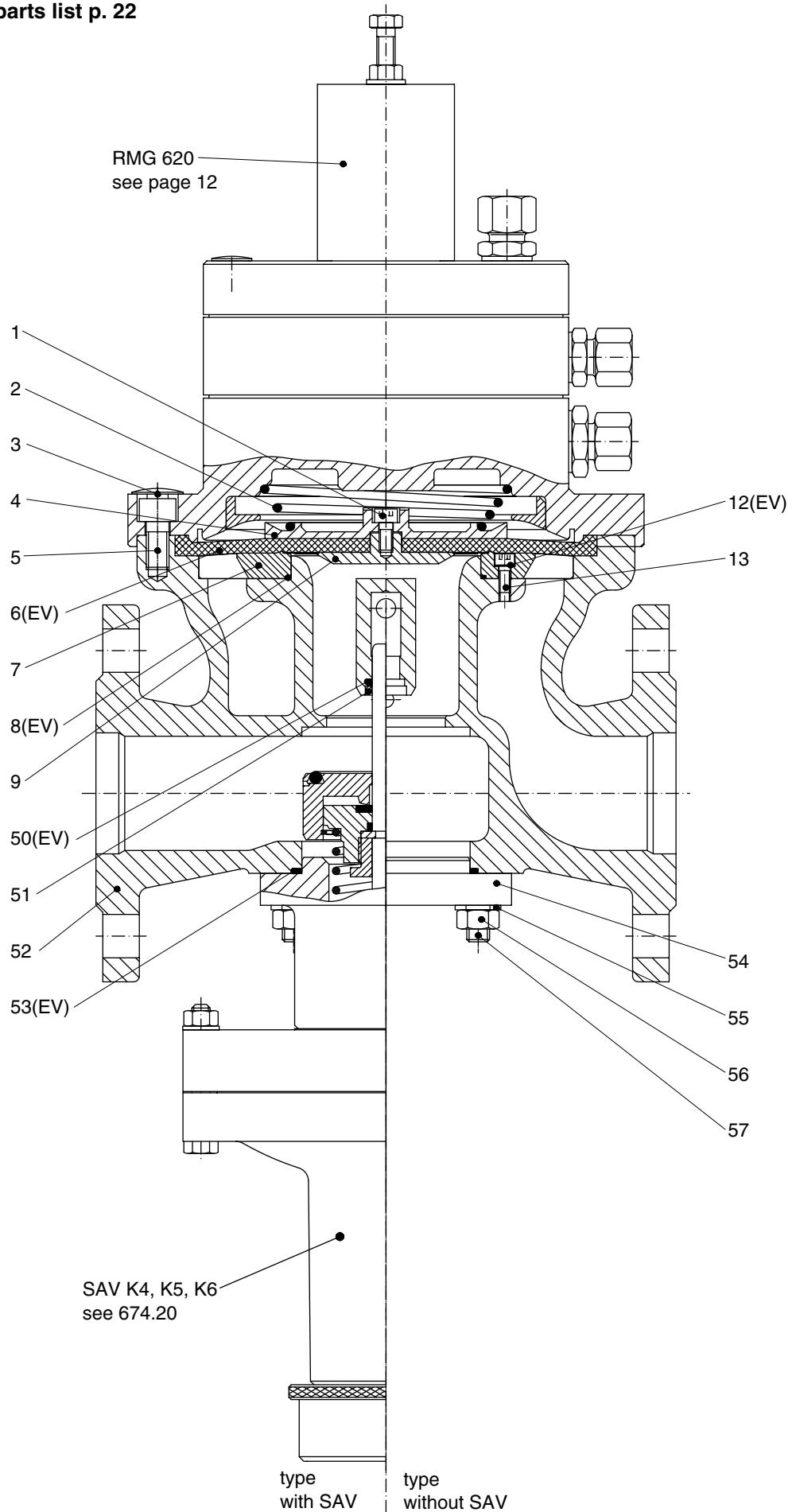
RMG 620 see page 12



Note! Parts marked by EV are to be kept in stock for maintenance

4.2 Spare Parts Drawing RMG 402 DN_E 50

Type from serial number.: 95 10 157 88
 see spare parts list p. 22



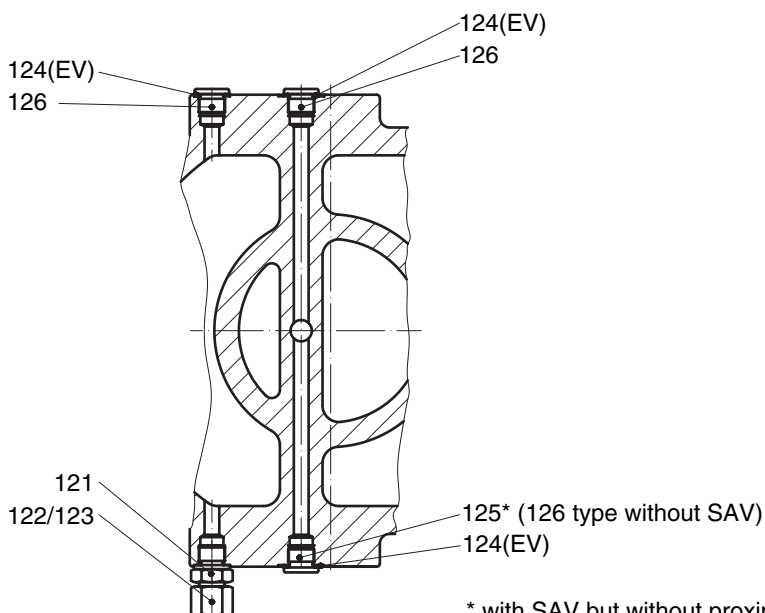
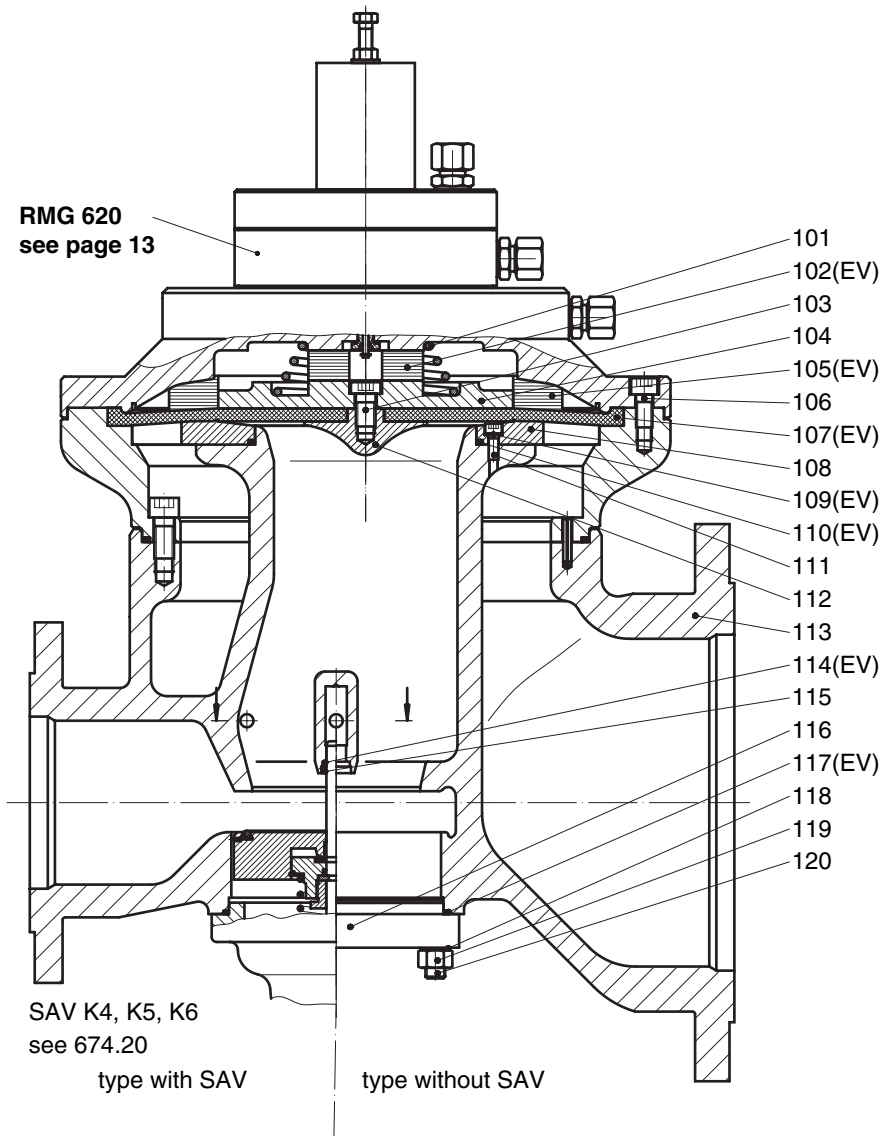
Note! Parts marked by EV are to be kept in stock for maintenance

4.3 Spare Parts Drawing RMG 402 DN_E 80 to DN_E 100

(type marked DN 100/200)

from serial number 95 041 4600

see spare parts list p. 21, 22



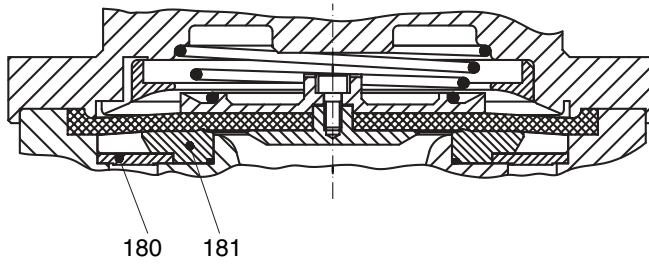
* with SAV but without proximity switching device

Note! Parts marked by EV are to be kept in stock for maintenance

Spare Parts Drawing RMG 402 Sectional view

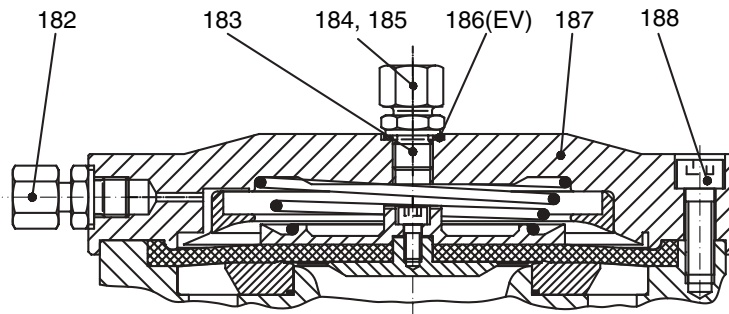
4.4

Type with noise reduction
see spare parts list p. 27



4.5

Type with pilot RMG 630/640
see spare parts list p. 27

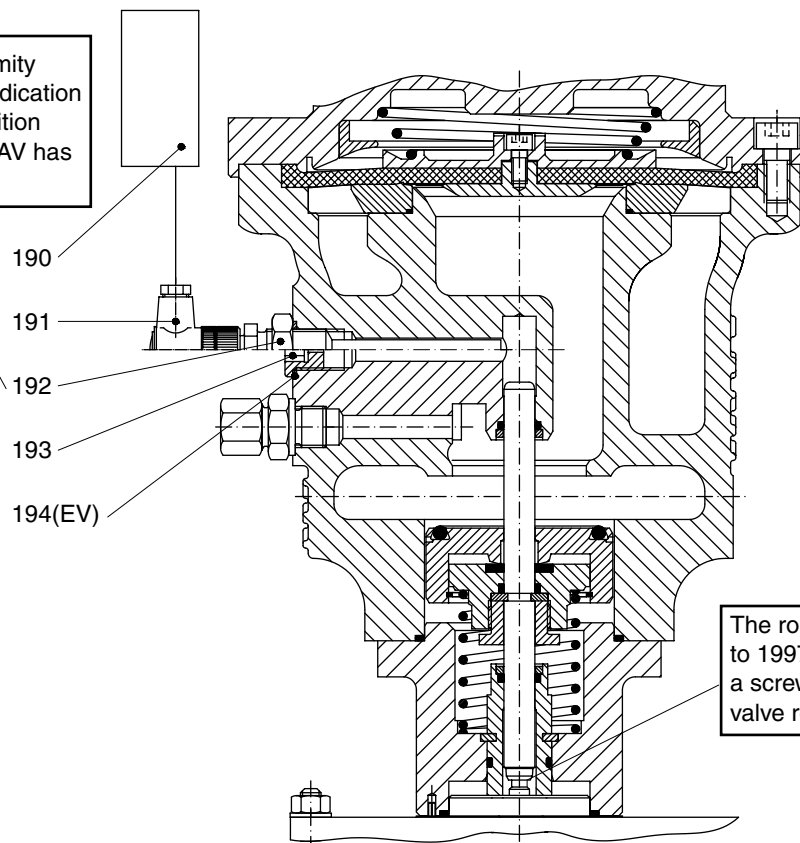


4.6



Type with SAV RMG 720 and RMG 721
see spare parts list p. 28

The assembly of the proximity initiator (192) for remote indication of the SAV valve plate position **may only** be done if the SAV has been closed completely

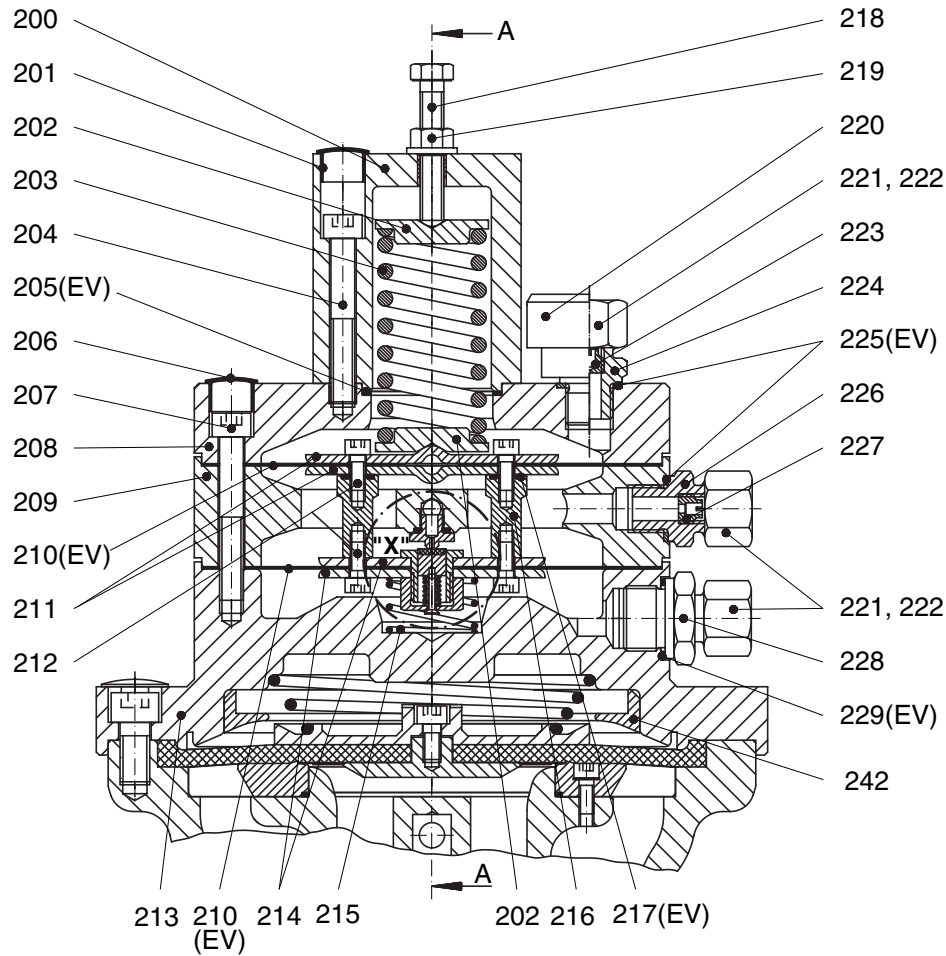


The rolling connection used up to 1997 has been replaced by a screw connection on the valve rod of the SAV RMG 720

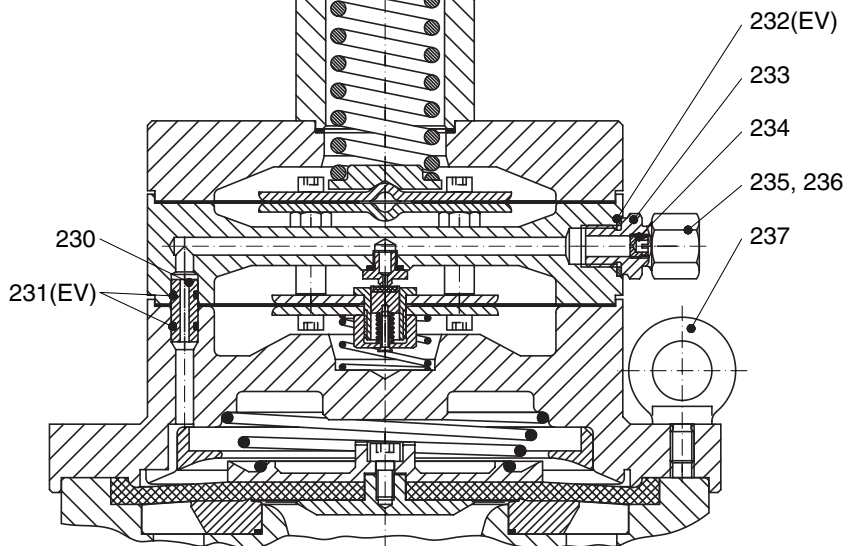
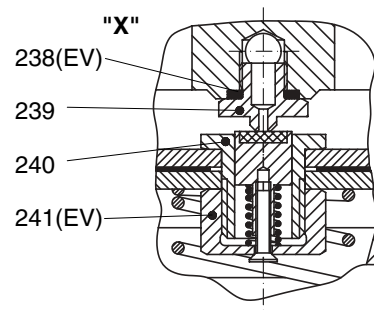
Note! Parts marked by EV are to be kept in stock for maintenance

4.7 Spare Parts Drawing RMG 402 DN 25 to DN_E 50 with pilot RMG 620

see spare parts list p. 23, 24

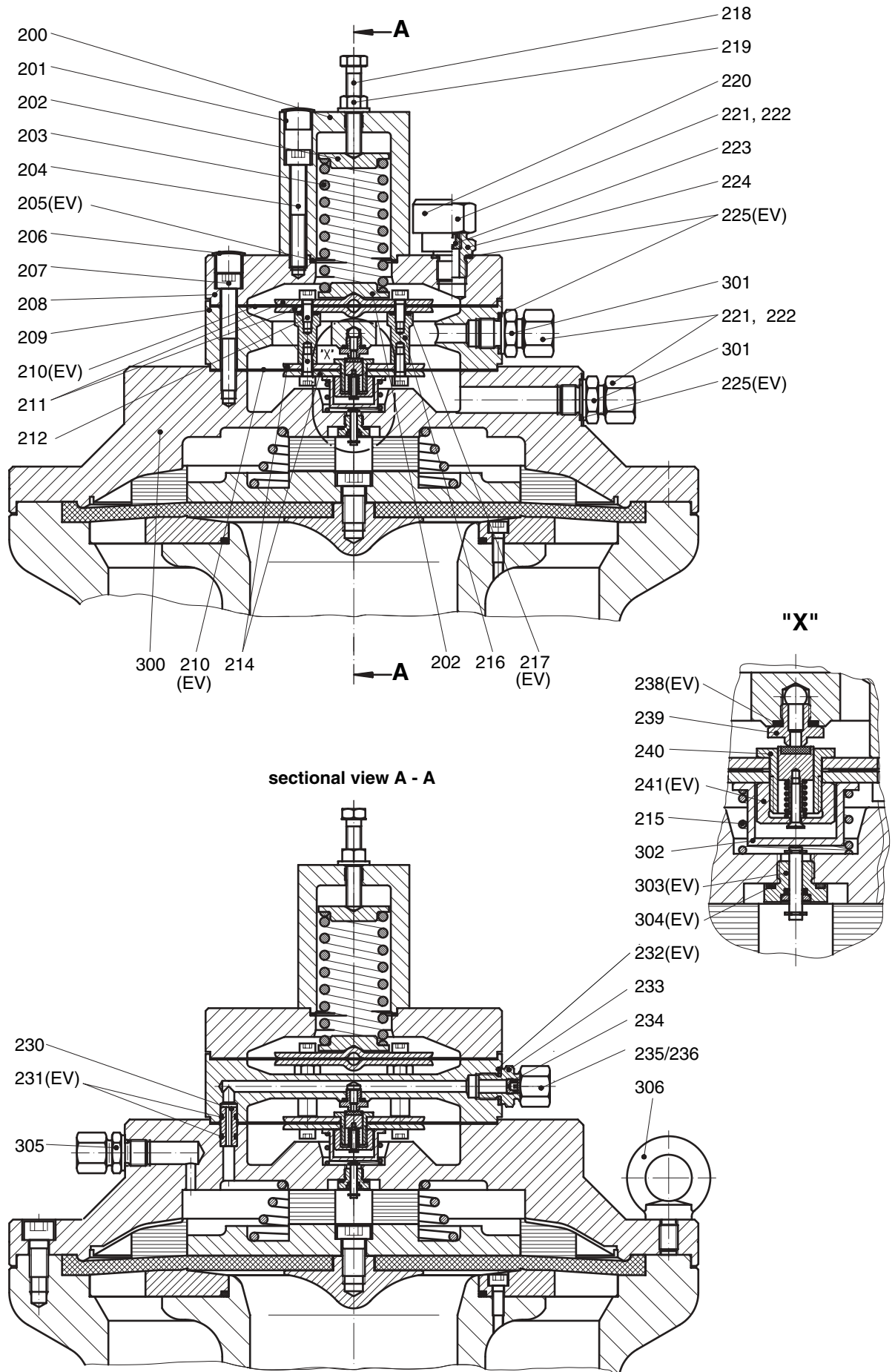


sectional view A - A



Note! Parts marked by EV are to be kept in stock for maintenance

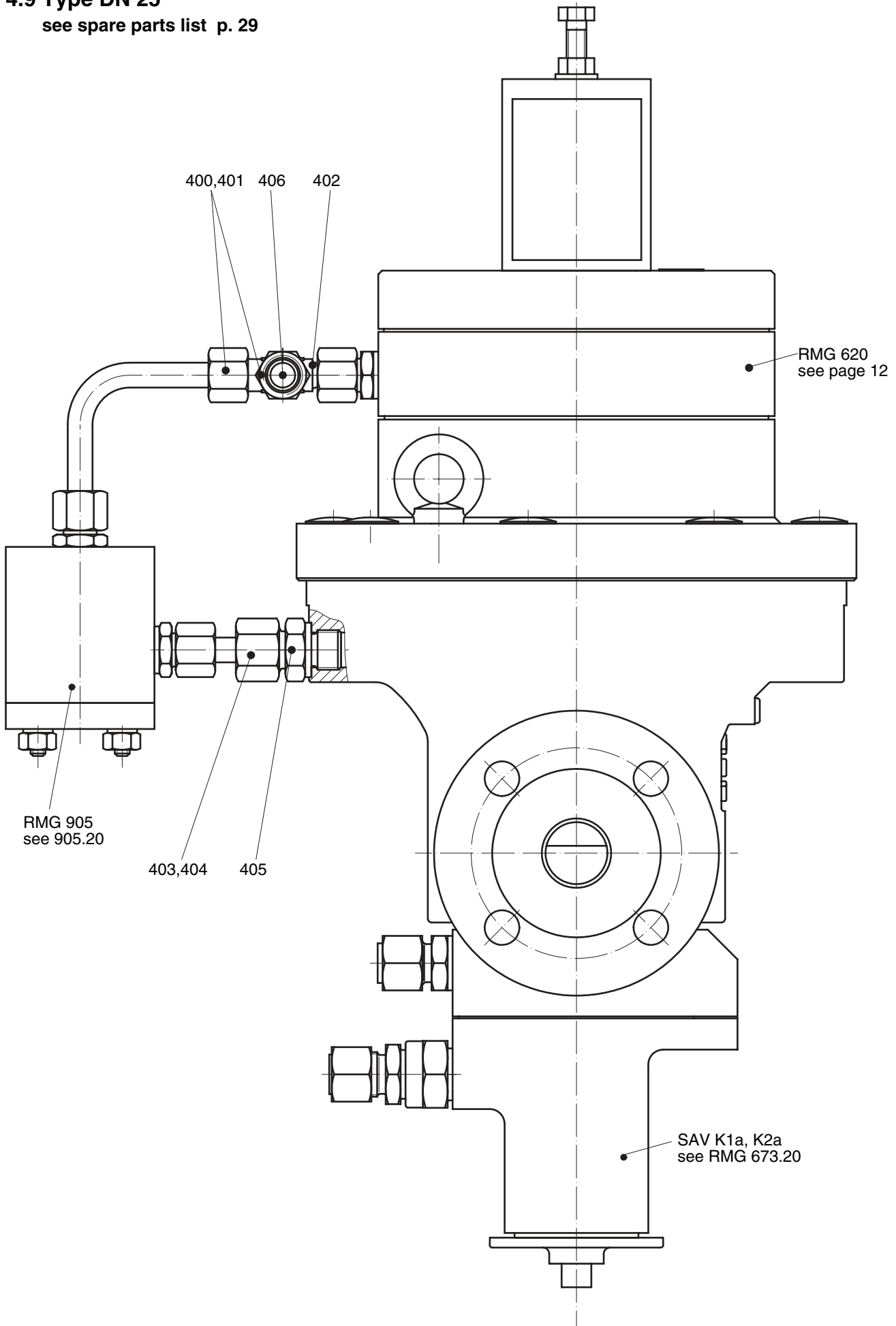
4.8 Spare Parts Drawing RMG 402 DN_E 80 to DN_E 100 with pilot RMG 620
 see spare parts list p. 25, 26



Note! Parts marked by EV are to be kept in stock for maintenance

4.9 Type DN 25

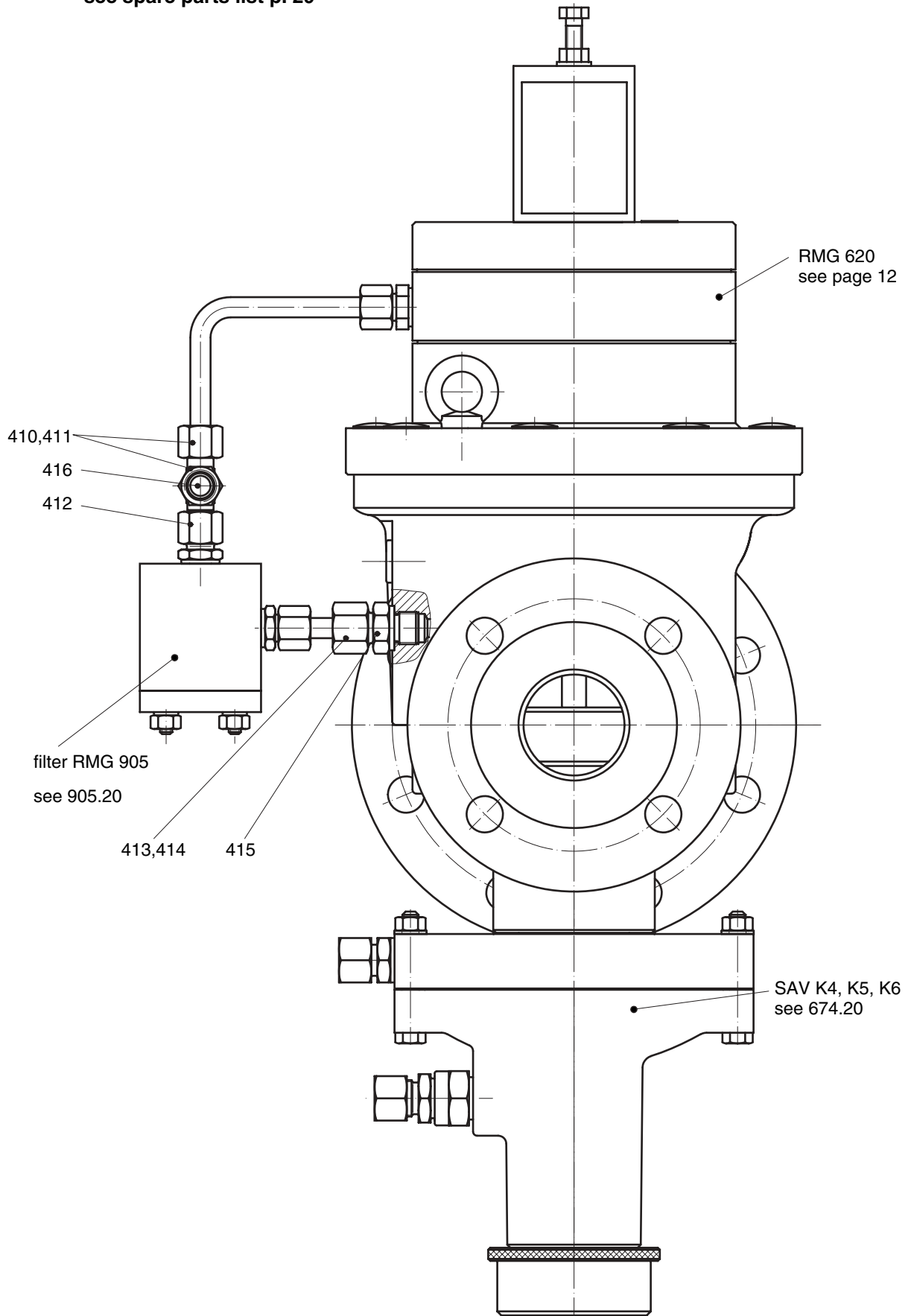
see spare parts list p. 29



Note!

Parts marked by EV are to be kept in stock for maintenance

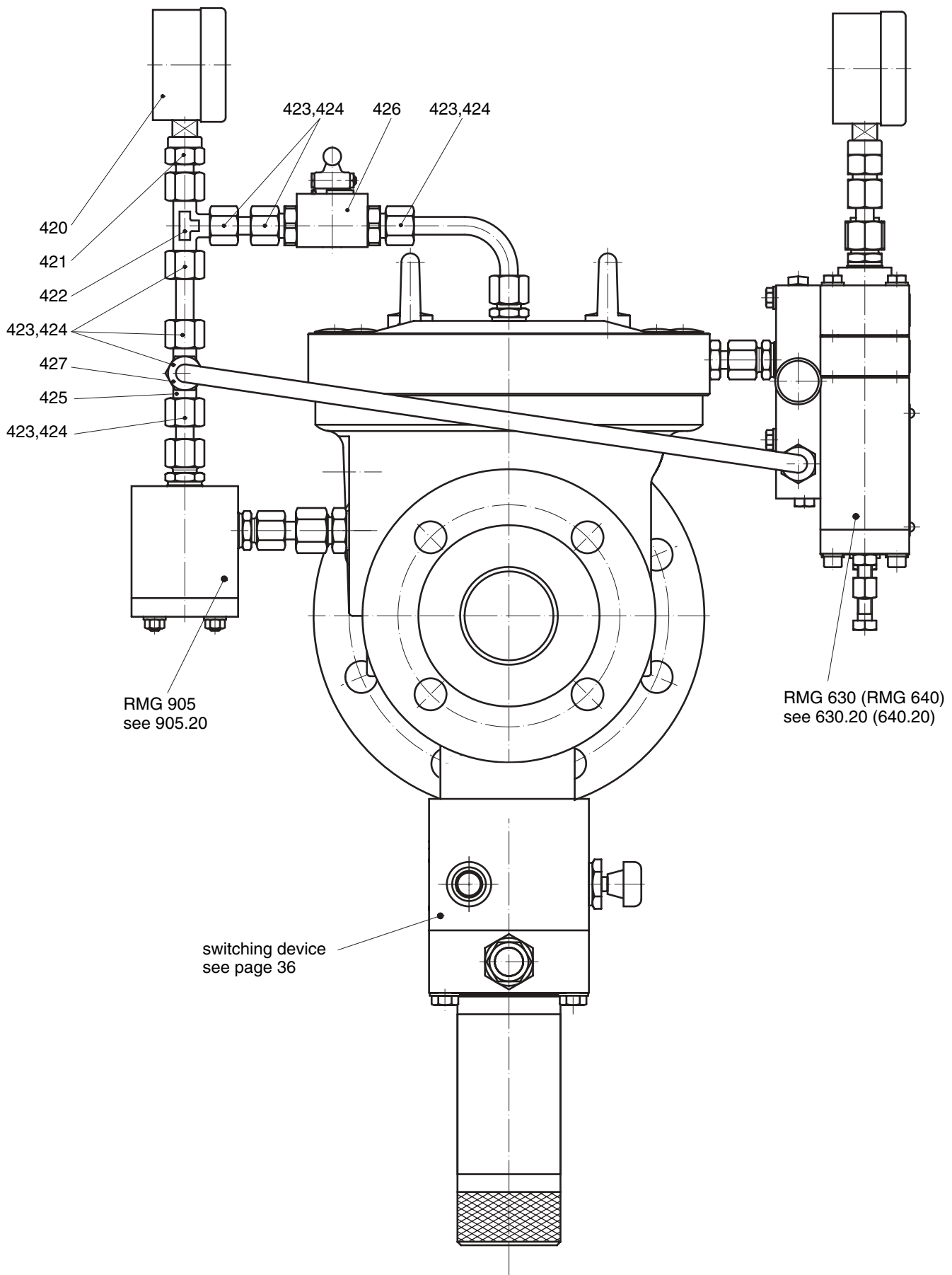
4.10 Type DN_E 50
see spare parts list p. 29



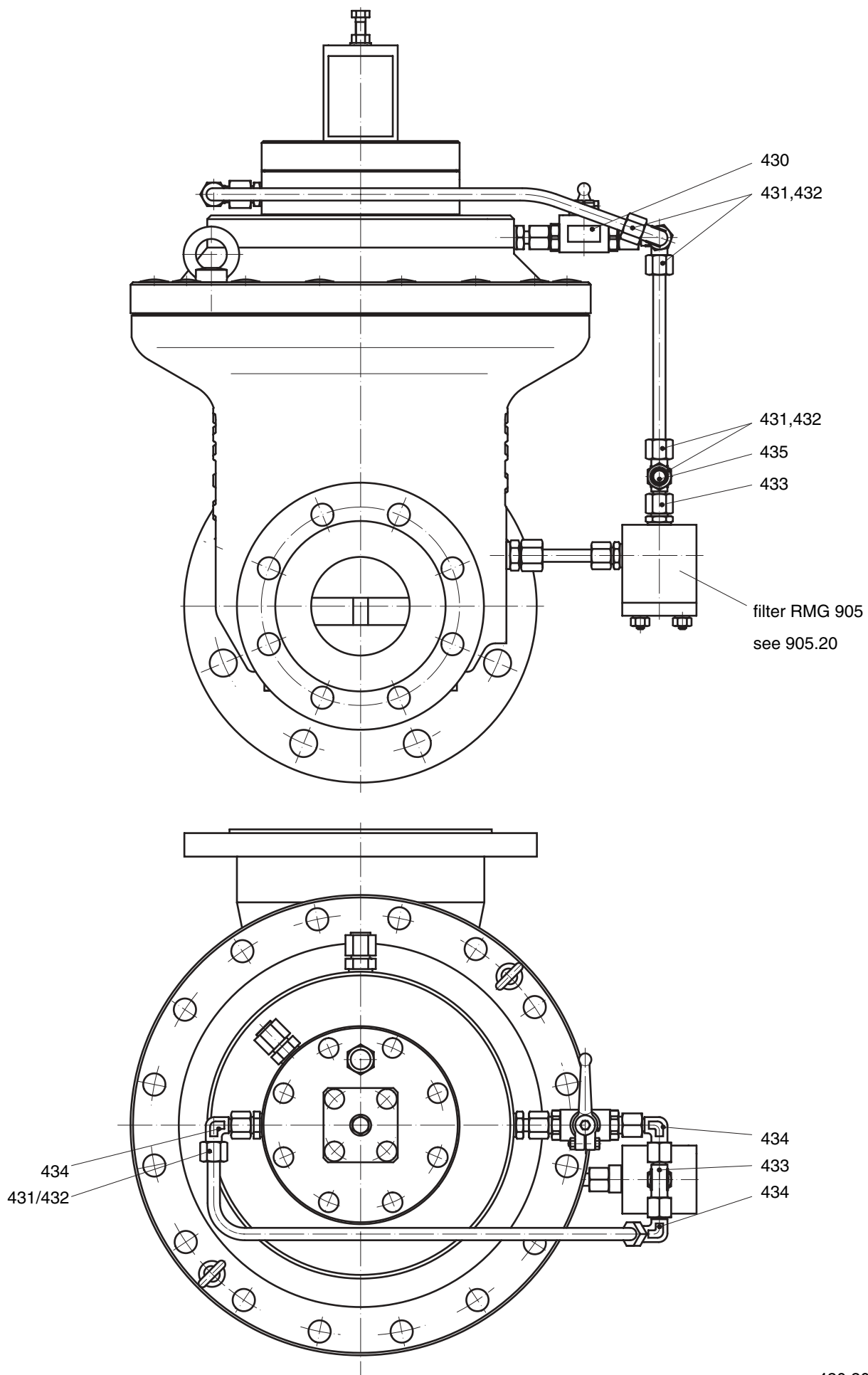
4.11 Type for DN 25 and DN_E 50 with pilot RMG 630/640

(marked DN 50/100)

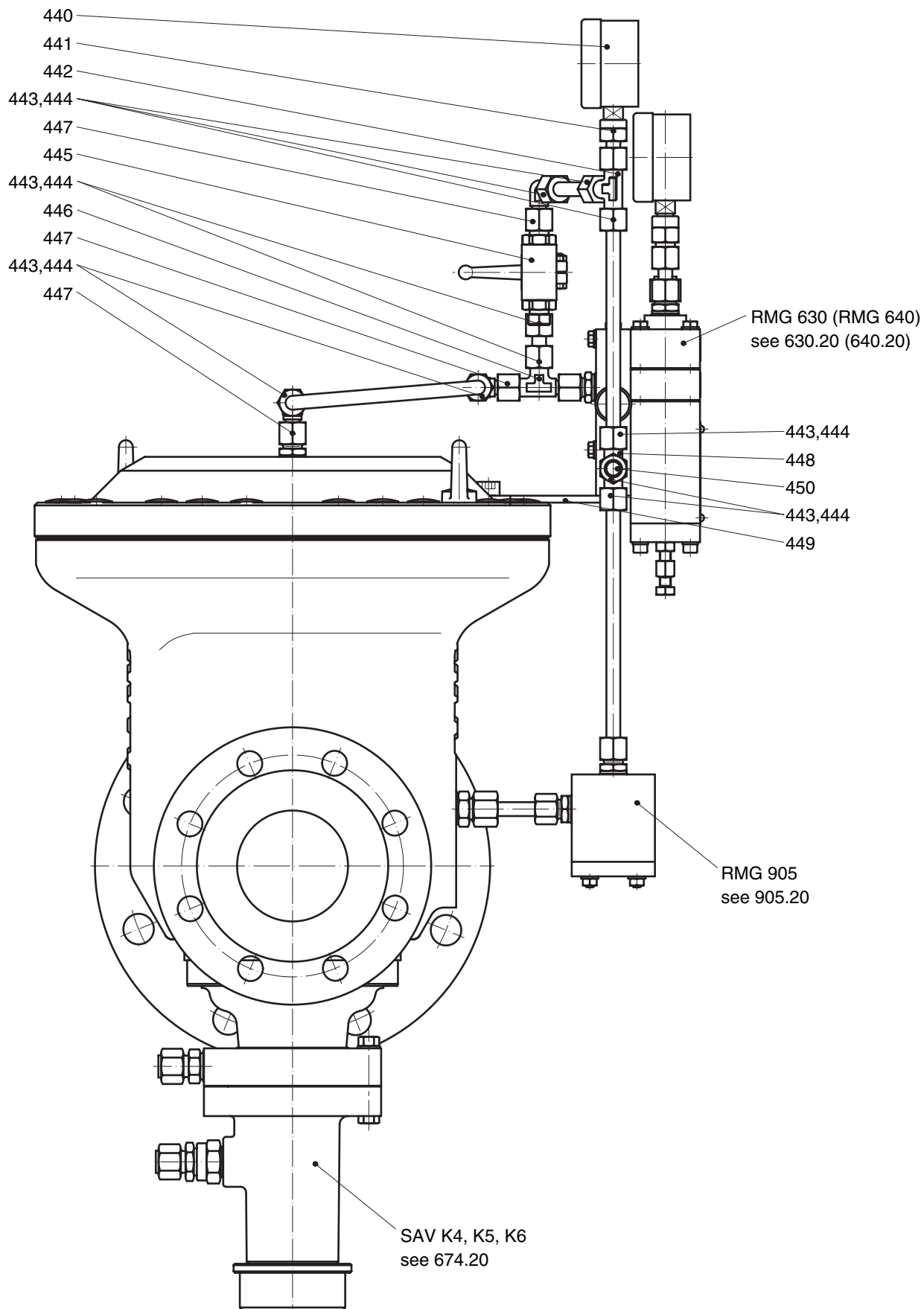
see spare parts list p. 29



4.12 Start-up valve DN_E 80 and DN_E 100 with pilot RMG 620 see spare parts p. 30



4.13 Start-up valve for DN_E 80 and DN_E 100 with pilot RMG 630/640 see spare parts list p. 30



5. Spare Parts Lists

5.1 Spare Parts List RMG 402 DN 25 from serial no. 951015788

pos. no.	description	Qty.	EV	material	stock no.		
1	cylinder screw	1		St	00 008 177		
2	closing spring	1		NFSt	10 024 055		
3	cap	8		K	00 027 786		
4	diaphragm plate	1		LM	10 021 489		
5	cylinder screw	8		St	00 008 174		
6	diaphragm	1	EV	KG	10 011 304		
7	expansion piece:	1		LM	10 021 488		
8	o-ring	1	EV	KG	00 021 074		
9	flow separator	1		LM	10 021 493		
10	o-ring	1	EV	KG	00 020 243		
11	casing :						
	pressure stage PN 16/25	1		GGG	10 021 484		
	pressure stage ANSI 150	1		GGG	10 021 485		
12	sealing ring	3	EV	LM	00 018 807		
13	cylinder screw	3		St	00 010 318		
14	locking plate	1		LM	10 021 533		
15	cylinder screw	4		St	10 004 895		

see drawing p. 8

Note Parts marked EV are to be kept in stock for maintenance

St..... steel	GLM... light metal cast	Cu.... copper
NSt.... stainless steel	GZn... zinc cast	K..... plastic material general
FSt.... spring steel	MS.... brass	KG.... rubber-like plastic material
NFSt.. stainless spring steel	GMs... brass cast	KGT.. plastic material sprayed with Teflon
GS..... cast steel	Bz..... bronze	KV.... Viton
GGG.. cast with nodular cast	GBz.. bronze cast	KT.... Teflon
LM.... light metal	AlBz. aluminium bronze	PGI.... plexiglass

5.2 Spare Parts List RMG 402 DNE 50 from serial no. 951015788

pos. no.	description	Qty.	EV	material	stock no.		
1	cylinder screw	1		St	00 008 177		
2	closing spring	1		NFSt	10 024 055		
3	cap	8		K	00 027 786		
4	diaphragm plate	1		LM	10 021 489		
5	cylinder screw	8		St	00 008 174		
6	diaphragm	1	EV	KG	10 011 304		
7	expansion piece	1		LM	10 021 488		
8	o-ring	1	EV	KG	00 021 074		
9	current separator	1		LM	10 021 493		
12	sealing ring	3	EV	LM	00 018 807		
13	cylinder screw	3		St	00 010 318		
50	o-ring	1	EV	KV	00 020 752		
51	disc	1		St	10 008 559		
52	casing: DN 50/50						
	pressure stage PN16/25	1		GGG	10 021 498		
	pressure stage ANSI 150	1		GGG	10 021 499		
	casing: DN 50/50						
	pressure stage PN 16/25/40	1		GS	10 023 235		
	pressure stage ANSI 150	1		GS	10 023 237		
	pressure stage ANSI 300	1		GS	10 023 239		
	casing : DN 50/100						
	pressure stage PN 16	1		GS	10 021 856		
	pressure stage PN 25/40	1		GS	10 021 857		
	pressure stage ANSI 150	1		GS	10 021 858		
	pressure stage ANSI 300	1		GS	10 021 859		
53	o-ring	1	EV	KG	00 020 246		
54	locking plate	1		LM	10 007 475		
55	disc	4	EV	St	00 014 113		
56	hexagon nut	4		St	00 005 692		
57	locking screw	4		St	00 012 376		

see drawing p. 9

Note Parts marked by EV are to be kept in stock for maintenance

St..... steel	GLM... light metal cast	Cu.... copper
NSt.... stainless steel	GZn... zinc cast	K..... plastic material general
FSt.... spring steel	MS.... brass	KG.... rubber-like plastic material
NFSt.. stainless spring steel	GMs...brass cast	KGt.. plastic material sprayed with Teflon
GS..... cast steel	Bz..... bronze	KV.... Viton
GGG.. cast with nodular cast	GBz.. bronze cast	KT.... Teflon
LM.... light metal	AIBz. aluminium bronze	PGI.... plexiglass

5.3 Spare Parts List RMG 402 DN 80, DN 80/150 from serial no. 950414600

pos. no.	description	Qty.	EV	material	stock no.		
101	closing spring	1		NFSt	10 023 245		
102	ring	1	EV	K	10 024 056		
103	cylinder screw	1		St	00 010 620		
104	diaphragm plate	1		LM	10 024 111		
105	ring	1	EV	K	10 024 057		
106	cylinder screw	16		St	00 008 174		
107	diaphragm	1	EV	KG	10 011 305		
108	expansion piece	1		LM	10 021 812		
109	sealing ring	4	EV	LM	00 018 818		
110	o-ring	1	EV	KG	00 021 075		
111	cylinder screw	4		St	00 010 320		
112	current separator	1		LM	10 011 237		
113	casing: DN 80						
	pressure stage PN 16/25	1		GGG	10 021 776		
	pressure stage ANSI 150	1		GGG	10 021 777		
	pressure stage PN 16	1		GS	10 023 271		
	pressure stage PN 25/40	1		GS	10 023 273		
	pressure stage ANSI 150	1		GS	10 023 275		
	pressure stage ANSI 300	1		GS	10 023 277		
	casing: DN 80/150						
	pressure stage PN 16	1		GS	10 023 255		
	pressure stage PN 25/40	1		GS	10 023 254		
	pressure stage ANSI 150	1		GS	10 023 256		
	pressure stage ANSI 300	1		GS	10 023 257		
114	o-ring	1	EV	KV	00 020 752		
115	disc	1		St	10 008 559		
116	closing plate	1		LM	10 007 675		
117	o-ring	1	EV	KG	00 020 427		
118	disc	4		St	00 014 114		
119	hexagon nut	4		St	00 013 120		
120	locking screw	4		St	00 012 212		
121	nozzle	1		St	00 030 154		
122	compression joint	1		St	00 030 903		
123	cap nut	1		St	00 030 802		
124	sealing ring	3	EV	LM	00 018 694		
125	locking screw (with bore)	1		St	10 021 474		
126	locking screw (without bore)	2		St	00 010 381		

see drawing p. 10

Note Parts marked by EV are to be kept in stock for maintenance

St..... steel	GLM... light metal cast	Cu.... copper
NSt.... stainless steel	GZn... zinc cast	K..... plastic material general
FSt.... spring steel	MS.... brass	KG.... rubber-like plastic material
NFSt.. stainless spring steel	GMs...brass cast	KGT.. plastic material sprayed with Teflon
GS..... cast steel	Bz..... bronze	KV.... Viton
GGG.. cast with nodular cast	GBz.. bronze cast	KT.... Teflon
LM.... light metal	AIBz. aluminium bronze	PGI.... plexiglass

5.4 Spare Parts List RMG 402 DN100, DN100/200 from serial number 950414600

pos. no.	description	Qty.	EV	material	stock no.
101	closing spring	1		NFSt	10 023 245
102	ring	1	EV	K	10 024 044
103	cylinder screw	1		St	00 010 620
104	diaphragm plate	1		LM	10 024 111
105	ring	1	EV	K	10 023 632
106	cylinder screw	16		St	00 008 174
107	diaphragm	1	EV	KG	10 011 305
108	expansion piece	1		LM	10 021 812
109	sealing ring	4	EV	LM	00 018 818
110	o-ring	1	EV	KG	00 021 075
111	cylinder screw	4		St	00 010 320
112	current separator	1		LM	10 011 237
113	casing: DN 100				
	pressure stage PN 16	1		GGG	10 021 778
	pressure stage PN 25	1		GGG	10 021 933
	pressure stage ANSI 150	1		GGG	10 021 779
	pressure stage PN 16	1		GS	10 023 780
	pressure stage PN 25/40	1		GS	10 023 782
	pressure stage ANSI 150	1		GS	10 023 784
	pressure stage ANSI 300	1		GS	10 023 786
	casing: DN 100/200 premoun.				
	pressure stage PN 16	1		St/GS	10 021 901
	pressure stage PN 25	1		St/GS	10 021 903
	pressure stage PN 40	1		St/GS	10 021 902
	pressure stage ANSI 150	1		St/GS	10 021 904
	pressure stage ANSI 300	1		St/GS	10 021 905
114	o-ring	1	EV	KV	00 020 752
115	disc	1		St	10 008 559
116	locking plate	1		LM	10 007 675
117	o-ring	1	EV	KG	00 020 427
118	disc	4		St	00 014 114
119	hexagonal nut	4		St	00 013 120
120	locking screw	4		St	00 012 212
121	nozzle	1		St	00 030 154
122	compression joint	1		St	00 030 903
123	cap nut	1		St	00 030 802
124	sealing ring	3	EV	LM	00 018 694
125	locking screw (with bore)	1		St	10 021 474
126	locking screw (without bore)	2		St	00 010 381

see drawing p.10

Note Parts marked by EV are to be kept in stock for maintenance

St..... steel	GLM... light metal cast	Cu.... copper
NSt.... stainless steel	GZn... zinc cast	K..... plastic material general
FSt... spring steel	MS.... brass	KG.... rubber-like plastic material
NFSt.. stainless spring steel	GMs...brass cast	KGT.. plastic material sprayed with Teflon
GS..... cast steel	Bz..... bronze	KV.... Viton
GGG.. cast with nodular cast	GBz.. bronze cast	KT.... Teflon
LM.... light metal	AlBz. aluminium bronze	PGL... plexiglass

5.5 Spare Parts List RMG 402 / 620, DN 25, DN 50, DN 50/100

pos. no.	description	Qty.	EV	material	stock no.		
200	spring housing	1		St/LM	10 021 433		
201	cap	4		K	00 026 067		
202	spring plate						
	for spring 10000139	2		LM	10 000 114		
	for spring 10000063	2		LM	10 000 114		
	for spring 10000115	2		LM	10 000 114		
	for spring 10000064	2		LM	10 000 148		
	for spring 10000149	2		LM	10 000 148		
203	setpoint spring :						
	pressure range						
	0020 - 0200 mbar	1		FSt	10 000 139		
	0100 - 0500 mbar	1		FSt	10 000 063		
	0200 - 1000 mbar	1		FSt	10 000 115		
	0500 - 2000 mbar	1		FSt	10 000 064		
	1000 - 4000 mbar	1		FSt	10 000 149		
204	cylinder screw	4		St	00 010 542		
205	o-ring	1	EV	KG	00 020 293		
206	cap	8		K	00 026 067		
207	cylinder screw	8		St	00 010 542		
208	diaphragm cap	1		St/LM	10 021 432		
209	diaphragm casing	1		LM	10 021 431		
210	diaphragm	2	EV	KG	10 021 437		
211	diaphragm plate	2		LM	10 021 435		
212	cylinder screw	8		St	00 010 318		
213	diaphragm cap	1		St	10 023 240		
214	diaphragm plate	2		LM	10 021 436		
215	pressure spring	1		NFSt	10 012 616		
216	bolt	4		NSt	10 021 434		
217	o-ring	4	EV	KG	00 020 226		
218	setpoint spring	1		NSt	10 002 795		
219	hexagon nut	1		St	00 013 136		
220	RMG 915	1		-	10 010 570		
221	cap nut	3		St	00 030 804		
222	compression joint	3		St	00 030 904		
223	throttle ø 2,0	1		Ms	10 005 095		
224	nozzle	1		St	10 007 642		
225	sealing ring	2	EV	LM	00 018 694		

see drawing p. 12

Note Parts marked by EV are to be kept in stock for maintenance

St..... steel	GLM... light metal cast	Cu.... copper
NSt.... stainless steel	GZn... zinc cast	K..... plastic material general
FSt.... spring steel	MS.... brass	KG.... rubber-like plastic material
NFSt.. stainless spring steel	GMs...brass cast	KGT.. plastic material sprayed with Teflon
GS..... cast steel	Bz..... bronze	KV.... Viton
GGG.. cast with nodular cast	GBz.. bronze cast	KT.... Teflon
LM.... light metal	AlBz. aluminium bronze	PGI.... plexiglass

pos. no.	description	Qty.	EV	material	stock no.		
226	nozzle	1		St	10 007 642		
227	throttle ø 3,0	1		NSt	10 005 098		
228	nozzle	1		St	00 030 169		
229	sealing ring	1	EV	LM	00 018 787		
230	small connecting tube ø 1,5	1		NSt	10 021 442		
231	o-ring	2	EV	KG	00 020 226		
232	sealing ring	1	EV	LM	00 018 842		
233	nozzle	1		St	10 000 714		
234	throttle ø 0,8	1		Ms	10 020 474		
235	cap nut	1		St	00 030 803		
236	compression ring	1		St	00 030 903		
237	ring screw	2		St	00 010 597		
238	o-ring	1		KG	00 020 341		
239	orifice ø 1,5	1		Ms	10 021 438		
240	piston guide	1		NSt	10 021 441		
241	piston, premounted	1	EV		10 021 426		
242	ring	1		LM	18 356 283		

see drawing p. 12

Note Parts marked by EV are to be kept in stock for maintenance

St..... steel	GLM... light metal cast	Cu.... copper
NSt.... stainless steel	GZn... zinc cast	K..... plastic material general
FSt.... spring steel	MS.... brass	KG.... rubber-like plastic material
NFSt.. stainless spring steel	GMs...brass cast	KGT.. plastic material sprayed with Teflon
GS..... cast steel	Bz..... bronze	KV.... Viton
GGG.. cast with nodular cast	GBz.. bronze cast	KT.... Teflon
LM.... light metal	AIBz. aluminium bronze	PGI.... plexiglass

5.6 Spare Parts List RMG 402/620 DN80, DN80/150; DN100, DN100/200

pos. no.	description	Qty.	EV	material	stock no.		
200	spring housing	1		St/LM	10 021 433		
201	cap	4		K	00 026 067		
202	spring plate						
	for spring 10000139	2		LM	10 000 114		
	for spring 10000063	2		LM	10 000 114		
	for spring 10000115	2		LM	10 000 114		
	for spring 10000064	2		LM	10 000 148		
	for spring 10000149	2		LM	10 000 148		
203	setpoint spring:						
	pressure range						
	0020 - 0200 mbar	1		FSt	10 000 139		
	0100 - 0500 mbar	1		FSt	10 000 063		
	0200 - 1000 mbar	1		FSt	10 000 115		
	0500 - 2000 mbar	1		FSt	10 000 064		
	1000 - 4000 mbar	1		FSt	10 000 149		
204	cylinder screw	4		St	00 010 542		
205	o-ring	1	EV	KG	00 020 293		
206	cap	8		K	00 026 067		
207	cylinder screw	8		St	00 010 542		
208	diaphragm cap	1		St/LM	10 021 432		
209	diaphragm casing	1		LM	10 021 431		
210	diaphragm	2	EV	KG	10 021 437		
211	diaphragm plate	2		LM	10 021 435		
212	cylinder screw	8		St	00 010 318		
214	diaphragm plate	2		LM	10 021 436		
215	pressure spring	1		NFSt	10 012 616		
216	bolt	4		NSt	10 021 434		
217	o-ring	4	EV	KG	00 020 226		
218	setpoint screw	1		NSt	10 002 795		
219	hexagon nut	1		St	00 013 136		
220	RMG 915	1		-	10 010 570		
221	cap nut	3		St	00 030 804		
222	compression joint	3		St	00 030 904		
223	throttle ø 2,0	1		Ms	10 005 095		
224	nozzle	1		St	10 007 642		
225	sealing ring	3	EV	LM	00 018 694		

see drawing p. 13

Note Parts marked by EV are to be kept in stock for maintenance

St..... steel	GLM... light metal cast	Cu.... copper
NSt.... stainless steel	GZn... zinc cast	K..... plastic material general
FSt.... spring steel	MS.... brass	KG.... rubber-like plastic material
NFSt.. stainless spring steel	GMS...brass cast	KGT.. plastic material sprayed with Teflon
GS..... cast steel	Bz..... bronze	KV.... Viton
GGG.. cast with nodular cast	GBz.. bronze cast	KT.... Teflon
LM.... light metal	AIBz. aluminium bronze	PGI.... plexiglass

pos. no.	description	Qty.	EV	material	stock no.		
230	small connecting tube ø 3,0	1		NSt	10 021 871		
231	o-ring	2	EV	KG	00 020 226		
232	sealing ring	1	EV	LM	00 018 842		
233	nozzle	1		St	10 000 714		
234	throttle ø1,5	1		NSt	10 019 340		
235	cap nut	1		St	00 030 803		
236	compression joint	1		St	00 030 903		
238	o-ring	1	EV	KG	00 020 341		
239	orifice ø 3,0	1		Ms	10 021 852		
240	piston guide	1		NSt	10 021 441		
241	piston, premounted	1	EV		10 021 426		
300	diaphragm cap	1		St	10 024 112		
301	nozzle	2		St	10 007 642		
302	suspension bush	1		Ms	10 021 850		
303	compensating element	1	EV		10 021 899		
304	o-ring	1	EV	KG	00 021 047		
305	nozzle	1		St	00 030 023		
306	ring screw	2		St	00 010 487		

Note Parts marked by EV are to be kept in stock for maintenance

St..... steel	GLM... light metal cast	Cu.... copper
NSt.... stainless steel	GZn... zinc cast	K..... plastic material general
FSt.... spring steel	MS.... brass	KG.... rubber-like plastic material
NFSt.. stainless spring steel	GMs...brass cast	KGT.. plastic material sprayed with Teflon
GS..... cast steel	Bz..... bronze	KV.... Viton
GGG.. cast with nodular cast	GBz.. bronze cast	KT.... Teflon
LM.... light metal	AlBz. aluminium bronze	PGI.... plexiglass

5.7 Type with RMG 630 / 640

pos. no.	description	Qty.	EV	material	stock no.		
182	nozzle (only DN 25 and DNE 50)	1		St	00 030 023		
183	nozzle	1		St	00 030 111		
184	cap nut (only DN 25, DNE 50)	1		St	00 030 803		
185	compression joint	1		St	00 030 903		
186	sealing ring	1	EV	LM	00 018 842		
187	diaphragm cap DN 25 and DNE 50	1		St	10 021 889		
	diaphragm cap DNE 80 and DNE 100	1		St	10 024 113		
188	cylinder screw DN 25 u.DNE 50	14		St	00 010 400		
	cylinder screw DNE 80 and DNE 100	24		St	00 008 174		

see drawing p.11

5.8 Type with noise reduction

5.8.1 DN_E 25 and DN_E 50

pos. no.	description	Qty.	EV	material	stock no.		
180	noise reduction/ring	1			10 024 014		
181	expansion	1		LM	10 024 010		

see drawing p.11

5.8.2 DN_E 80 and DN_E 100 :

pos. no.	description	Qty.	EV	material	stock no.		
180	noise reduction /ring	1			10 024 015		
181	expansion piece	1		LM	10 024 011		

see drawing p.11

Note

Parts marked by EV are to be kept in stock for maintenance

St..... steel	GLM... light metal cast	Cu.... copper
NSt.... stainless steel	GZn... zinc cast	K..... plastic material general
FSt.... spring steel	MS.... brass	KG.... rubber-like plastic material
NFSt.. stainless spring steel	GMs...brass cast	KGt... plastic material sprayed with Teflon
GS..... cast steel	Bz..... bronze	KV.... Viton
GGG.. cast with nodular cast	GBz.. bronze cast	KT.... Teflon
LM.... light metal	AlBz. aluminium bronze	PGl.... plexiglass

5.9 Type with SAV RMG 720/721 from DNE 50

SAV-remote indication (673.20 is valid for SAV RMG 673 K 1a, K 2a)

pos. no.	description	Qty.	EV	material	stock no.		
190	section amplifier	1		-	00 024 402		
191	cable socket 90°	1		K	00 024 099		
192	SAV-remote indication consist. of final control element: (see pos. 52 , 113)						
	for DN 50/50 GGG	1		-	10 021 832		
	for DN 50/50 GS	1		-	10 021 838		
	for DN 50/100 GS	1		-	10 021 838		
	for DN 80/80 GGG	1		-	10 021 832		
	for DN 80/80 GS	1		-	10 021 832		
	for DN 80/150 GS	1		-	10 021 837		
	for DN 100/100 GGG	1		-	10 021 832		
	for DN 100/100 GS	1		-	10 021 837		
	for DN 100/200 GS	1		-	10 021 839		

see drawing p.11

5.9.1 Type without SAV RMG 720 and SAV RMG 721 from DNE 50

193	locking screw	1		St	00 010 381		
194	sealing ring	1	EV	LM	00 018 694		

see drawing p.11

5.9.2 Type without SAV-remote indication from DNE 50 with SAV RMG 720/721

193	locking screw	1		St	10 021 474		
194	sealing ring	1	EV	LM	00 018 694		

see drawing p.11

Note Parts marked by EV are to be kept in stock for maintenance

St..... steel	GLM... light metal cast	Cu.... copper
NSt.... stainless steel	GZn... zinc cast	K..... plastic material general
FSt.... spring steel	MS.... brass	KG.... rubber-like plastic material
NFSt.. stainless spring steel	GMs..Messing-Guß	KGT.. plastic material sprayed with Teflon
GS..... cast steel	Bz..... bronze	KV.... Viton
GGG.. cast with nodular cast	GBz.. bronze cast	KT.... Teflon
LM.... light metal	AlBz. aluminium bronze	PGI.... plexiglass

5.10 Piping RMG 402 DN 25 - Type with pilot RMG 620

(see page 14)

pos. no.	description	Qty.	EV	material	stock no.		
400	cap nut	2		St	00 030 803		
401	compression joint	1		St	00 030 903		
402	screw connection	1		St	00 030 622		
403	cap nut	1		St	00 030 802		
404	compression joint	1		St	00 030 903		
405	nozzle	1		St	00 030 154		
406	locking body	1		St	00 032 004		

5.11 Piping RMG 402 DN 50 - Type with pilot RMG 620

(see page 15)

pos. no.	description	Qty.	EV	material	stock no.		
410	cap nut	2		St	00 030 803		
411	compression joint	1		St	00 030 903		
412	screw connection	1		St	00 030 622		
413	cap nut	1		St	00 030 802		
414	compression joint	1		St	00 030 903		
415	nozzle	1		St	00 030 154		
416	locking body	1		St	00 032 004		

5.12 Start-up valve RMG 402 DN 25 and DN 50 Type with pilot RMG 630/640

(see page 16)

pos. no.	description	Qty.	EV	material	stock no.		
420	manometer :						
	type PN 16	1		-	00 026 314		
	type PN 25 / ANSI 150	1		-	00 026 284		
	type PN 40	1		-	00 026 282		
	type ANSI 300	1		-	00 026 283		
	(pe max = 40 bar)						
421	manometer screw connection	1		St	00 031 810		
422	screw connection	1		St	00 031 439		
423	cap nut	8		St	00 030 803		
424	compression joint	7		St	00 030 902		
425	screw connection	1		St	00 031 609		
426	ball valve	1		St	00 026 457		
427	locking body	1		St	00 032 004		

see drawing p. 14, 15, 16

Note Parts marked by EV are to be kept in stock for maintenance

St..... steel	GLM... light metal cast	Cu..... copper
NSt.... stainless steel	GZn... zinc cast	K..... plastic material general
FSt.... spring steel	MS.... brass	KG.... rubber-like plastic material
NFSt.. stainless spring steel	GMS...brass cast	KGt.. plastic material sprayed with Teflon
GS..... cast steel	Bz..... bronze	KV.... Viton
GGG.. cast with nodular cast	GBz.. bronze cast	KT.... Teflon
LM.... light metal	AIBz. aluminium bronze	PGI.... plexiglass

5.13 Piping RMG 402 DNE 80 and DNE 100 Type: with pilot RMG 620

(see page 17)

pos. no.	description	Qty.	EV	material	stock no.
430	ball valve	1		St	00 026 457
431	cap nut	4		St	00 030 803
432	compression joint	3		St	00 030 903
433	screw connection	2		St	00 030 622
434	screw connection	3		St	00 031 207
435	locking body	1		St	00 032 004

5.14 Piping RMG 402 DNE 80 and DNE 100 Type: with pilot RMG 630/640

(see page 18)

pos. no.	description	Qty.	EV	material	stock no.
440	manometer:				
	type PN 16	1		-	00 026 314
	type PN 25 / ANSI 150	1		-	00 026 284
	type PN 40	1		-	00 026 282
	type ANSI 300	1		-	00 026 283
	(pe max = 40 bar)			-	
441	manometer screw connection	1		St	00 031 810
442	screw connection	1		St	00 031 439
443	cap nut	11		St	00 030 803
444	compression joint	10		St	00 030 903
445	ball valve	1		St	00 026 457
446	screw connection	1		St	00 030 622
447	screw connection	3		St	00 031 207
448	screw connection	1		St	00 031 609
449	plate (only for RMG 630)	1		St	10 024 043
450	locking body	1		St	00 032 004

see drawing p. 17, 18

Note Parts marked by EV are to be kept in stock for maintenance

St..... steel	GLM... light metal cast	Cu..... copper
NSt.... stainless steel	GZn... zinc cast	K..... plastic material general
FSt.... spring steel	MS.... brass	KG.... rubber-like plastic material
NFSt.. stainless spring steel	GMs..Messing-Guß	KGT.. plastic material sprayed with Teflon
GS..... cast steel	Bz..... bronze	KV.... Viton
GGG.. cast with nodular cast	GBz.. bronze cast	KT.... Teflon
LM.... light metal	AlBz.. aluminium bronze	PGL.... plexiglass

6. Special Operation and Maintenance Instructions - SAV RMG System 721

6.1 Switch gear RMG 721

6.1.2 Opening of the safety shut-off valve SAV with lever opening mechanism

(type from year of construction 1997, see spare parts drawing on page 36)

- Screw off the cap (548).
- Screw the handle (549) out of the cover casing by turning to the left until the jack lever can be pushed outwards.
- Keep the jack lever pressed while turning clockwise, until it rests on the cover casing. When turning further clockwise the pressure compensating valve is automatically opened. Allow some time (several seconds) for pressure compensation at the SAV-valve plate.
- Pull the SAV open.

6.1.3 Dismantling of the switch bearing (511) and of the ball bearing (529) in the switching device

- The SAV must be brought into a closing position on the control device by manual triggering
- Manual release device (542) and all control devices situated on the switching device must be dismantled.

• Type from 01/97

Unscrew the cap (548) and the handle (549).

The valve rod (514) of the switching device must be clamped with a protection stock. Release the threaded bolts (547) with an Allan key SW 6 out of the SAV-valve rod.

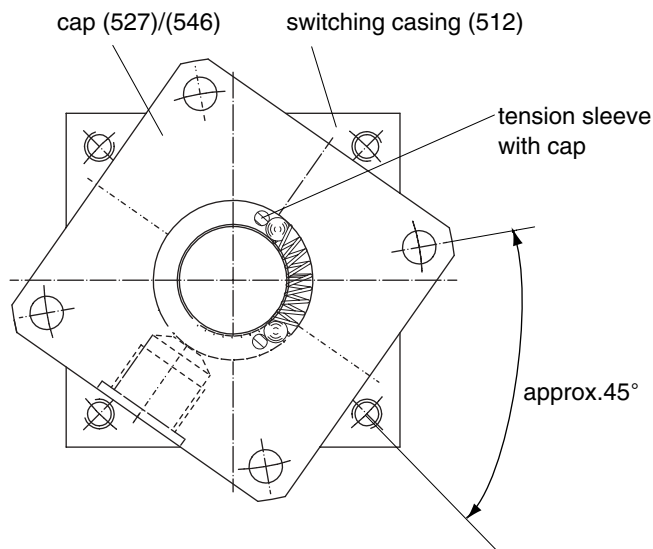
Note!

- Before lifting the cap (527)/(546) the reset-spring (544) must be released. In order to this, the cap (527)/(546) on the switching device (512) must be anti-clockwise rotated approx. of 45° (see drawing 1).

Note!

- To dismantle the switch bearing (511) from the switching casing (512), the tool (part no. 10000716) is screwed into the threaded bores which are situated in the switch bearing (511).

Drawing 1: Switching device - Release of the reset-spring



- Engaging socket (530)
The switching edge of the engaging socket should not be damaged.

Note!

- Switching balls (510)
The switching balls must be damaged and should not be slightly greased with silicone grease (see lubricant charts on page 6).

Note!

- Switch bearing (511)
The switch bearing must function easily and should not be corroded.
By the ball bearings (529) the rooms between the internal and external rings must be filled with silicone grease (see lubricant charts on page 6)

The parts must be mounted in a contrary order. The tensile rod (525)/ threaded bolt (547) must be fastened together with valve rod (514) with Loctite 241**.

** to be found in specialized stores

6.1.4 Priming adjustment of manual release device (542) onto the switch gear

- The priming adjustment of the switching device is only determined by the adjustment of the manual release device.
- Control of the priming adjustment:
all release and control devices as well as electrical magnetic releases must be taken away from the switching device.
- The SAV must be brought into an opening position.
- Mount the control device (part no. 10 001 935) with a distance screw connection (part no. 10 001 942) at any place on the switching device. (Example see drawing 2). The device is impinged with pressure, to detect with which control pressure the release mechanism is disengaged.

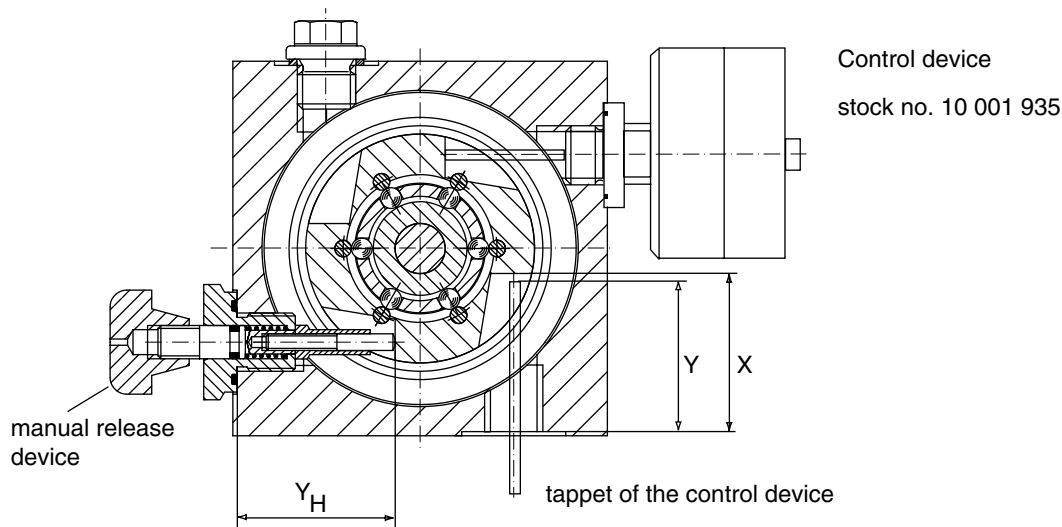
The switching pressure for the releasing must be between 0,35 and 0,4 bar.

In case of variations of those values a correction of the adjustment of the manual release device must be operated.

Switching pressure too low: Reduce the adjusting dimension Y_H on the manual release device (542)

Switching pressure too high: Increase the adjusting dimension Y_H on the manual release device (542)

Drawing 2 : Adjustment of the switching device



Modification of the adjusting dimension Y_H on the manual release device are to be carried out as follows:

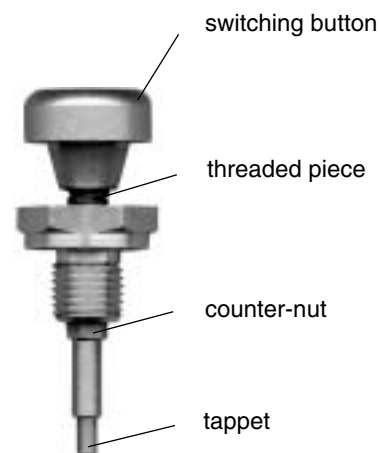
- Clamp the tappet in the vice and release the counter-nut.
- Rotate the switching button to the right -the adjusting dimension Y_H is reduced.
rotate to the left -the adjusting dimension Y_H is increased
- Assure the last adjustment with a counter-nut.

Note!

- The Y_H dimension plant-sided is marked within the switching casing (512) over the manual release device (542). For new adjustments, this dimension data must be corrected.

Caution!

- To replace the manual release device on another side of the switch device always needs controls of the priming adjustment.
- If this dimension is corrected, adjustments of all existing release devices must be controlled.



6.2 Adjustment of the switching device

All release devices (control devices, pressure converter and e-magnets) must be adjusted so that in an opening position of the SAV they have **no direct contacts with the switching surface of the switch bearing**.



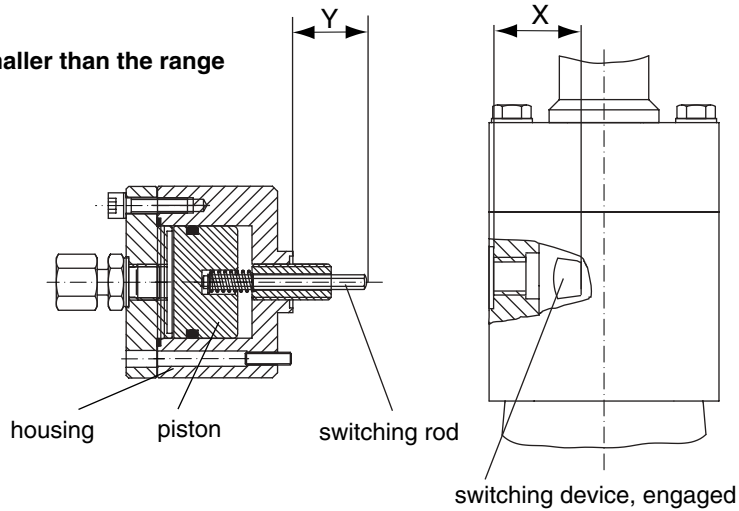
All measurement checks refer to an engaged switching device.

6.2.1 Pneumatic release for control devices with RMG 670/671 (K16 /K17 pilot-operated) and pressure converter

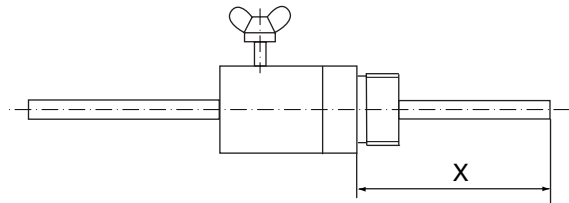
Adjusting dimension Y is smaller than the range

dimension X

$$Y = X - 2 \text{ mm}$$



To determine the range dimension X a jig (RMG stock no. 10 001 943) can be helpful!



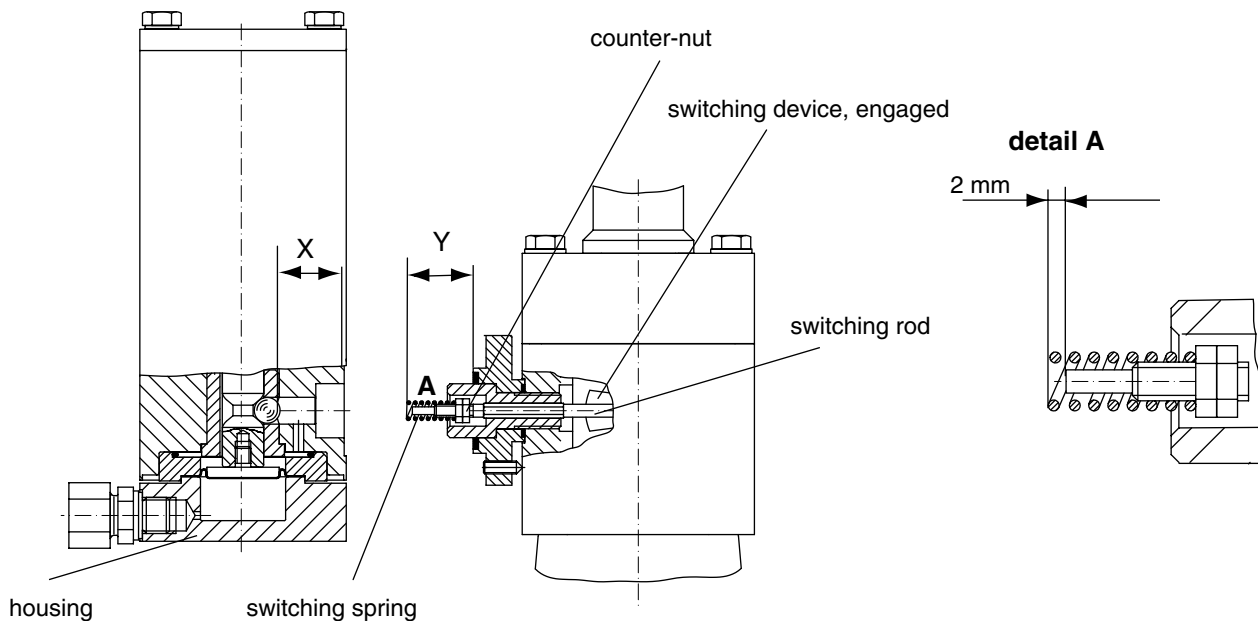
6.2.2 Pneumatic direct release with control devices RMG 672 (K10a, K12 and K13)

Adjusting dimension Y = range dimension X

$$Y = X$$

Note!

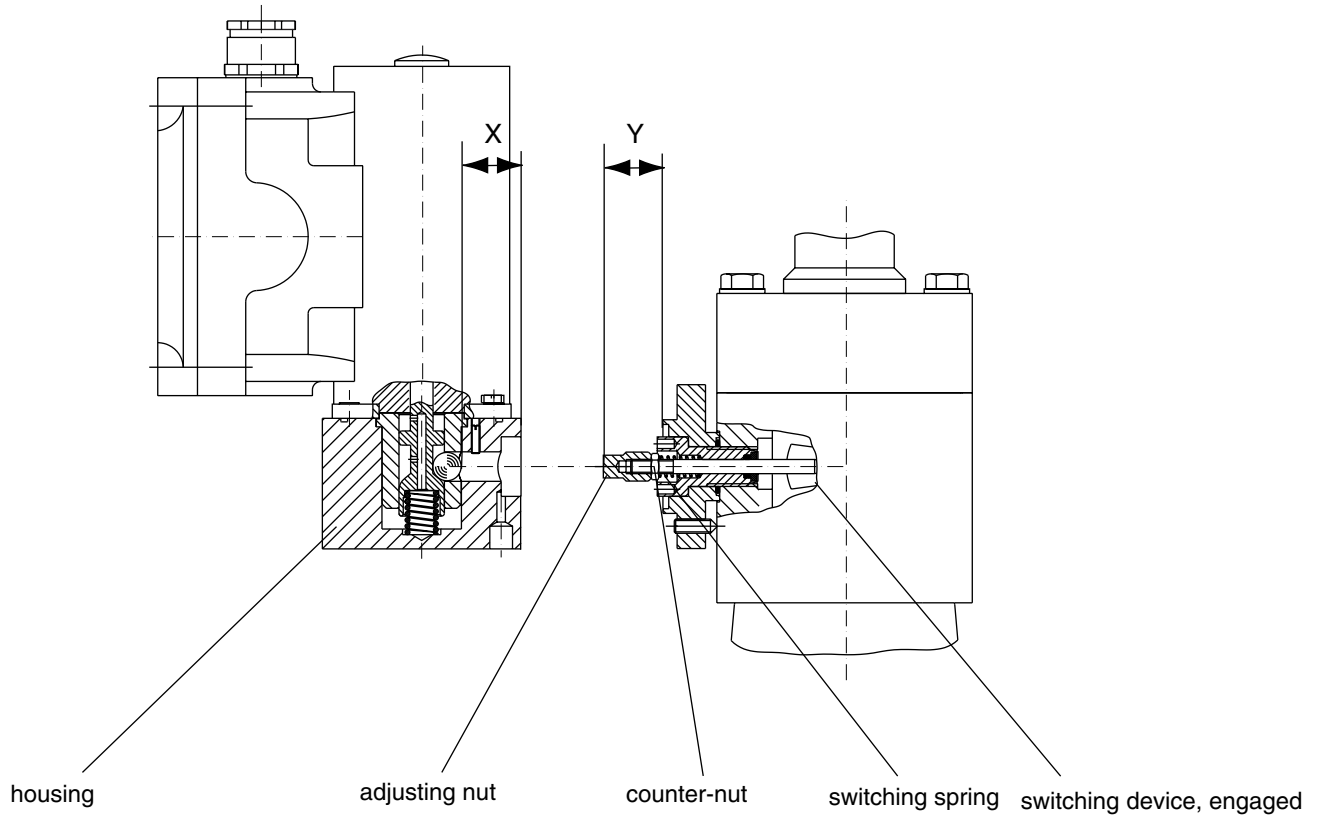
The leading edge of the switching rod must be situated at approx. 2 mm back from the spring (see detail "A").



6.2.3 Electromagnetic release by current failure

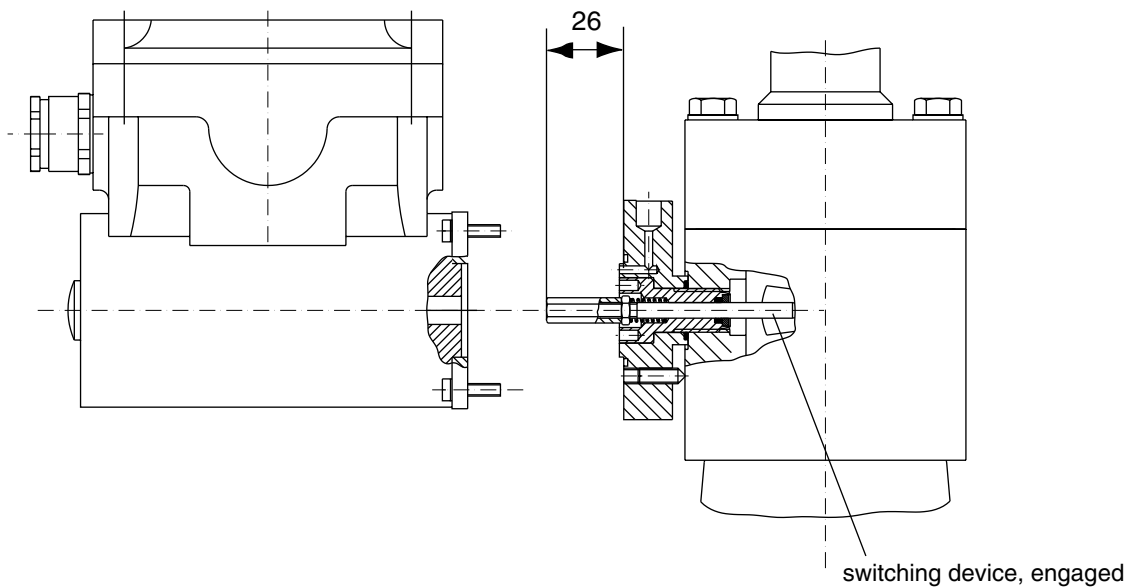
Adjusting dimension Y is smaller than the range dimension X

$$Y = X - 0,2 \text{ mm}$$

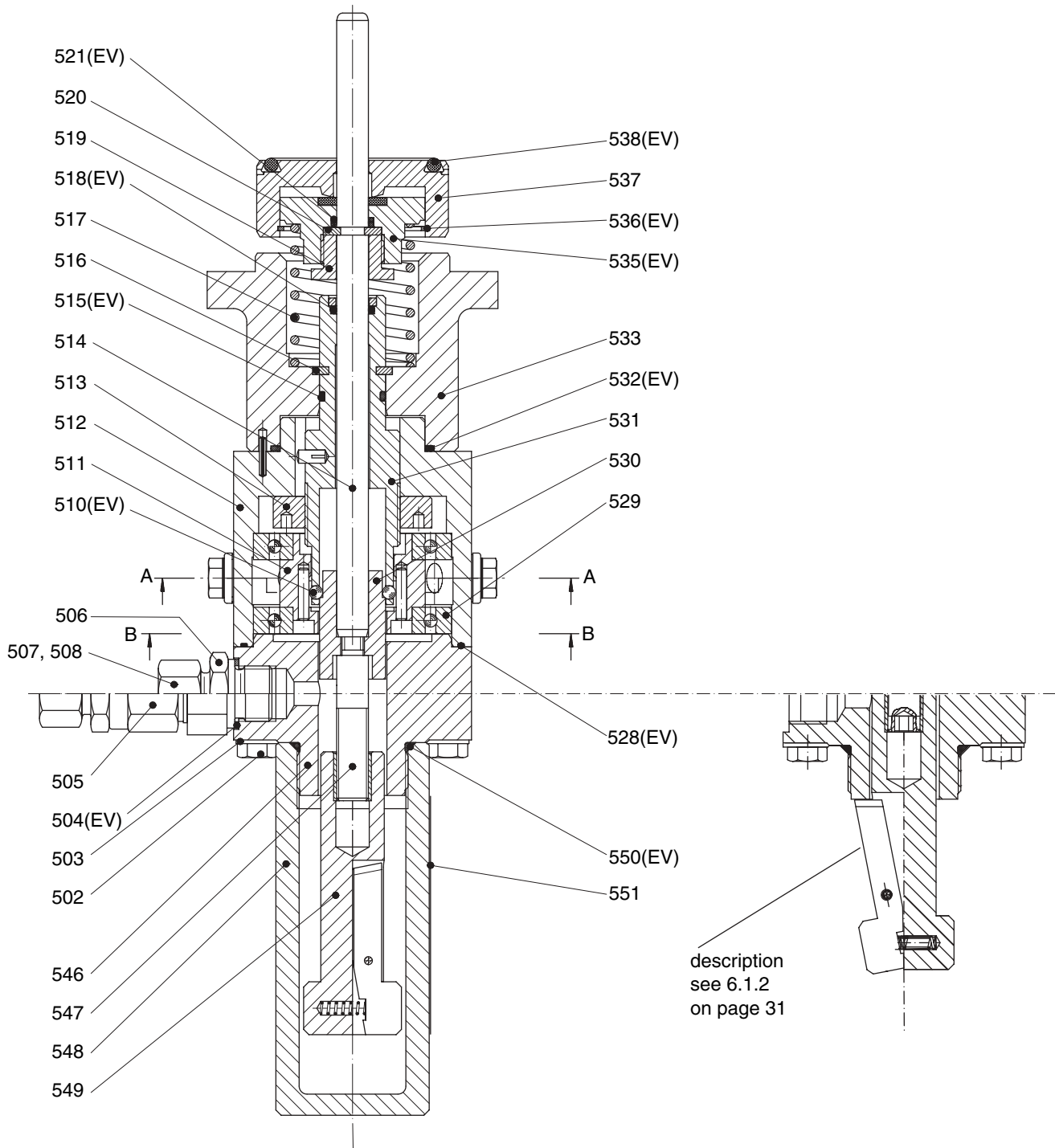


6.2.4 Electromagnetic release by current supply

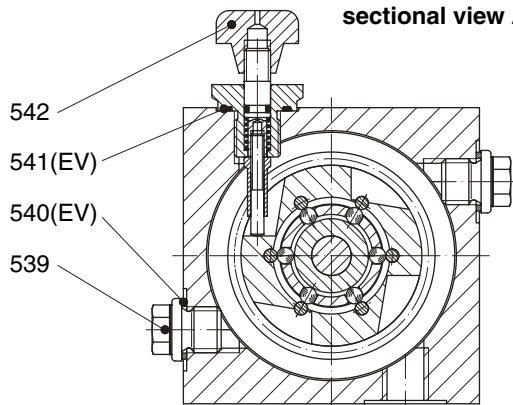
Adjusting dimension Y = 26 mm



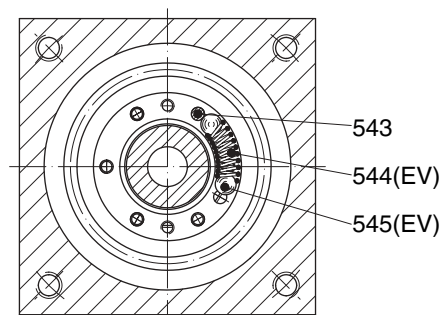
7.2 Spare Parts Drawing RMG 721 switching device with lever opening mechanism



sectional view A - A



sectional view B - B



Note!

Parts marked by EV be kept in stock for maintenance

8. Spare Parts Lists SAV-system RMG 721

8.1 Spare Parts List RMG system 721, DNE 50, 80, 100 (type from 01/1997)

pos. no.	description	Qty.	EV E	material	stock no.		
502	hexagon screw	4	E	St	00 010 398		
503	disc	4	E	St	00 008 281		
504	sealing ring	1	EV	LM	00 018 684		
505*	pilot valve RMG 919-1 (for type with RMG 672 K 10 a)	1	E		89 190 000		
	(for type with RMG 672 K 12, K 13)	1	E		89 190 100		
506*	nozzle	1	E	St	00 030 142		
507	cap nut	1	E	St	00 030 804		
508	compression joint	1	E	St	00 030 904		
510	switch ball ø 5	6	E	NSt	00 005 108		
511	switch bearing, premounted	1	E	St	10 008 771		
512	switch casing, premounted	1	E	LM/St	10 008 749		
513	two-hole nut	1	E	St	10 008 761		
514	valve rod	1	E	NSt	10 021 926		
515	o-ring	1	EV	KG	00 020 383		
516	ring segment	2	E	St	10 007 589		
517	pressure spring	1	E	NFSt	10 008 577		
518	o-ring	1	EV	KV	00 020 752		
519	nut	1	E	NSt	10 008 614		
520	ring segment	2	E	St	10 008 612		
521	o-ring	1	EV	KG	00 020 412		
528	o-ring	1	EV	KG	00 020 320		
529	ball bearing	1	E	St	00 026 236		
530	engaging socket	1	E	St	10 008 765		
531	guide cylinder, premounted	1	E		10 008 756		
532	o-ring	1	EV	KG	00 020 413		
533	SAV connecting flange for DNE 50	1	E	St	10 008 500		
	for DNE 80	1	E	St	10 008 502		
	for DNE 100	1	E	St	10 008 502		
535	valve plate, vulkanized	1	EV	LM/KG	10 008 606		
536	holding ring	1	E	FSt	00 019 127		

Note Parts marked EV to be kept in stock for maintenance

*) according to the type of the control device

St.... steel	GZn... zink cast	K.... plastic material general
FSt.... spring steel	MS.... brass	KG.... rubber-like plastic material
NFSt.. stainless spring steel	GMS..brass cast	KGT.. rubber-like plastic material sprayed with Teflon
NSt.... stainless steel	Bz.... bronze	KV.... Viton
GGG.. spheroidal graphite cast iron	GBz.. bronze cast	KT.... Teflon
LM.... light metal	AIBz. aluminium bronze	PGI.... plexiglass

pos. no.	description	amt.	EV E	material	stock no.
537	valve plate bleed		E	LM	
	for DNE 50	1			10 008 599
	for DNE 80	1			10 008 600
	for DNE 100	1			10 008 601
538	o-ring, DN _E 50	1	EV	KG	00 020 596
	o-ring, DN _E 80	1	EV	KG	00 020 266
	o-ring, DN _E 100	1	EV	KG	00 020 268
539	locking screw	2	E	St	00 026 175
540	sealing ring	2	EV	LM	00 018 689
541	o-ring	1	EV	KG	00 020 310
542	manual release, complete	1	E		10 001 179
543	tension sleeve (pos. 527, 511)		E	St	00 017 186
544	spring	1	EV	NFSt	10 001 187
545	ball dia. 6,35	2	EV	NSt	00 003 055
546	lid, complete	1	E	LM/St	10 025 111
547	threaded bolt	1	E	NSt	10 025 109
548	cap M 42 x 1,5	1	E	LM	10 025 110
549	handle, complete	1	E		10 025 106
550	o-ring	1	EV	KG	00 020 434
551	plate	1	E	K	10 025 112

Notice Parts marked by EV to be kept in stock for maintenance

St..... steel	GZn... zink cast	K..... plastic material general
FSt.... spring steel	MS.... brass	KG.... rubber-like plastic material
NFSt.. stainless spring steel	GMs..brass cast	KGt.. rubber-like plastic material sprayed with Teflon
NSt.... stainless steel	Bz..... bronze	KV.... Viton
GGG.. spheroidal graphite cast iron	GBz.. bronze cast	KT.... Teflon
LM.... light metal	AIBz. aluminium bronze	PGI.... plexiglass

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