GET THE **POWER** OF THE PIN

Advanced Pressure Relief & Isolation Valves
Rupture Pin Technology
Advanced Pressure Relief Valves

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Get the POWER of the PIN!

For over 27 years, many of
the world's top companies
have experienced the
performance advantages of our
advanced relief valve technology.

These companies have come to trust
our technology because they understand
what uniquely sets us apart and gives us
the edge over other relief valves and rupture
discs on the market.

So, what sets us apart from the rest? It's something we
call "The Power of the Pin".

The pin is the heart of each advanced pressure relief valve
and is vital to the function, accuracy and consistency of
the valve.

By modifying the pin, we are able to control the valve’s
performance – from small changes to more dramatic
changes. It is for this reason that each pin is carefully
crafted using a precise manufacturing process.

This process ensures that each valve will perform its
function accurately, consistently and within an extremely
tight tolerance – something other products on the market
simply can’t achieve.

We invite you to find out more about our exciting
technology by reading this information, visiting our
website at www.rupturepin.com and calling our reps.

GET THE POWER OF THE PIN for the best overall value on
the market and keep people, systems, products and the
environment safe!
**History of Rupture Pin**

In 1986, Shell and Exxon came to Mr. Julian Taylor of Taylor Tools and asked him to solve a serious problem with pilot operated valves that were failing to operate 5% of the time. The set pressure was 83 bar (1220 psi) and the tolerance was +/-1.5%. This tolerance was not possible with conventional methods.

Mr. Taylor developed the Rupture Pin™ pressure relief valve. This Rupture Pin valve was used as back-up dome relief for the existing pilot operated valves. He used Euler’s Law of Compressed Columns to meet the stringent requirements handed to him.

After meeting the challenge presented and obtaining approval of ASME Section VIII, paragraph UG 127(c), Code Case #2091-3, for Buckling Pins, volume sales of the Rupture Pin Valve started in 1990. With the need for high pressure relief of slurries and more viscous fluids requiring full flow orifices, high pressure valves were developed using ball valves and pistons for pressures to 20,000 PSI.

Today Rupture Pin Technology is located in Oklahoma City, Oklahoma. They are still owned and operated by Mr. Taylor and enjoy an honored and excellent reputation in the pressure relief business. Our customers come to us for solutions to problems with any pressurized system, whether it is relief or shutoff. Over 30,000 valves have been sold through trained independent representatives around the world and have a remarkable 99.99% customer satisfaction rate.

**Valve Operation**

It opens in milliseconds to relieve pressure.

**Valve Operation**

It closes in milliseconds for pressure isolation.
Advantages Over the Competition

1. We have over 30,000 valves operating worldwide with a satisfaction rate of 99.9% in over 27 years!
2. Pins buckle at set pressure
3. No worker safety concerns
4. No product loss
5. No environmental pollution
6. No fragmentation
7. Extremely accurate
8. Low maintenance costs
9. Low pin replacement costs
10. Full bore relief in milliseconds
11. Pin can be replaced by one person in only one minute
12. Minimal downtime
13. Works close to set point
14. Does not require vacuum support
15. Can sense upstream pressure only or differential pressure only
16. Pins are rugged and can be stored at the valve
17. No costly handling
18. It is easy to tell when a pin is buckled visually or remotely when using a proximity sensor
19. You don’t break the line to change the pin
20. Buckling stress is lower than yield stress
21. Few inspections
22. Replacement pins can be produced quickly
23. Replacement pins can be shipped immediately
24. We make custom valves to your specifications
25. We take on “mission impossible” projects
26. Settings can be changed in minutes without breaking the line by changing the pin (with POCO option)
27. Reliability can be checked in the field under pressure
28. It is safe for your system providing emergency relief
29. There is no size limit large or small (within reason)
Pin Lots

The Rupture Pin raw material is ordered in large lots with certification that the entire lot came from the same batch of material with the same heat number. The Rupture Pins then are centerless ground to four or five decimal places, depending on pin diameter, to meet our stringent specifications and tolerances.

Rupture Pin diameters vary from 0.010” to 1.250” in small increments. There are three proprietary alloys – each is highly corrosion resistant and selected for the ambient conditions at the application. With alloy #3, the Rupture Pin’s ambient temperature can vary from -100°F to +400°F and the modulus of elasticity will vary no more than 0.3%.

Pin Calculations

When our team knows the effective piston diameter and set pressure to protect the user’s system, we can calculate the axial force on the Rupture Pin for a specific application.

The Rupture Pin alloy, diameter, and length are then selected by utilizing Euler’s Law with the optimum slenderness ratio.

These initial calculations are used for a starting point in the testing and setting of the valve. This method of determining the Rupture Pin’s dimension nails down the pin length and diameter in about three trial openings.

The Pin Buckling Process

The Rupture Pin ends are supported in the valve by close tolerance bushings. This causes the pin to buckle accurately at three places, assuring that the force to buckle the pin is much greater in comparison to the seal friction within the valve.

Another key feature is the slight bowing of the Pin before buckling. Pressure increases allow the piston to move up slightly prior to buckling.

In a test of 2” valves, it was found that the bowing of the Rupture Pin allowed the piston to move up 0.012” prior to buckling. Because the elastic limit of the Rupture Pin material is not reached until full buckling, the set point is held.

This Rupture Pin bowing is critically important for the valve’s proper functioning. Over long periods of use, there may be some seal cold vulcanization to the adjacent cylindrical surface. Due to the bowing which allows a slight movement of the piston, the seal stiction is removed prior to the buckling of the Rupture Pin at set pressure. This prevents the seal friction from building up over time. The set pressure is held.

Pin Preparation

In order to meet customer specifications, Rupture Pins are cut and tuned in the valve. This cutting process is performed using proprietary machines which give the Rupture Pin a burr free, perfectly flat end, with an overall length accurate to 0.0005”.

The seal friction and piston weight modify the calculated Rupture Pin’s length to a slight degree. This difference is overcome by performing a series of tests on each valve and slightly varying the Rupture Pin’s length until the proper set pressure is reached. During these tests, the valve is oriented as it will be in the actual application.

This process may take as many as 3 to 5 test Rupture Pins to get the exact pin length. Once these tests are complete, the Rupture Pin’s parameters are then fixed and recorded.

The Rupture Pins are then cut and buckled in the valve three times. The test results and all pertinent information is sent with the valve order. The peak force at buckling is measured with an accuracy of 0.01% using calibrated vaetrix electronic gauges. This locks in the valve accuracy, on average at set point between +/-1% to +/-3%. Additional Rupture Pins are now cut for customer requirements and three tests in the Tinius Olsen compression test instrument. The results are then archived for correct settings of replacement pins.
Pin Labeling
Once the Rupture Pin specifications are determined, each pin is then labeled. The label contains the Rupture Pin code, the valve serial number, and the set pressure of the valve.

Each valve is assigned a unique serial number to which all design calculations, sizing information, and production drawings are associated. This information, along with the valve’s set pressure, simplifies the re-ordering process by giving the customer all the information we need to reproduce replacement Rupture Pins.

In addition to the label, a name plate with serial number and all relevant information is attached to the valve bonnet. We also stamp the serial number on the valve bonnet should the name plate be accidentally removed. These steps make future orders of pins or valve parts very easy. Pins ordered before noon on business days are shipped the same day.

Pin Archiving
Our Tinius Olsen instrument is capable of slowly adding a force load to a Rupture Pin while recording and providing real time feedback of the applied force, the distance compressed, and the buckling point of the Rupture Pin once it is reached.

Three Rupture Pins are tested in this manner for archive results.

This test is used because it is free of valve friction. These results assure that Rupture Pins from a new material batch can be tested in an identical manner to conform to the original archived results. Proprietary methods are used to bring the latest material batch to conformity.

Pin Diameter Variations
To show you how the pin diameter affects performance, we conducted the Diameter Variations test. (see below) We took 4 different diameters (0.12063", 0.12571", 0.15618", 0.18741") all cut to the same length of 6.9951". We then took 5 samples of each diameter and determined the ultimate load at the buckling point with our Tinius Olsen Machine.

In the Diameter Variations table, we have listed the average ultimate buckling force for each diameter. As the diameter slowly increases, the capacity of the pin increases dramatically. This illustrates that even a diameter change of 0.00508" can effect the load capacity of the pin and why we are so meticulous in getting the Rupture Pin measurements right.

### Diameter Variations

<table>
<thead>
<tr>
<th>Diameter (in)</th>
<th>% Difference</th>
<th>Ultimate Load (lbf)</th>
<th>% Increase</th>
</tr>
</thead>
<tbody>
<tr>
<td>0.12063&quot;</td>
<td>-</td>
<td>249.008312</td>
<td>-</td>
</tr>
<tr>
<td>0.12571&quot;</td>
<td>4.17%</td>
<td>294.253781</td>
<td>18.17%</td>
</tr>
<tr>
<td>0.15618&quot;</td>
<td>30.0%</td>
<td>564.913319</td>
<td>126.87%</td>
</tr>
<tr>
<td>0.18741&quot;</td>
<td>55.8%</td>
<td>1225.693782</td>
<td>392.23%</td>
</tr>
</tbody>
</table>
Pin Length Variations

In this test, we took the same diameter material (0.09005”) and cut it to varying lengths (3.9945”, 4.0932”, 4.1936”, and 4.2910”). We tested 5 samples of each length to determine the ultimate force required to make the Rupture Pin buckle.

In the table below, we have listed the average values for each length.

<table>
<thead>
<tr>
<th>Length (in)</th>
<th>% Length Difference</th>
<th>Ultimate Load (lbf)</th>
<th>% Decrease</th>
</tr>
</thead>
<tbody>
<tr>
<td>3.9945”</td>
<td>-</td>
<td>243.511804</td>
<td>-</td>
</tr>
<tr>
<td>4.0932”</td>
<td>2.49%</td>
<td>239.834812</td>
<td>1.53%</td>
</tr>
<tr>
<td>4.1936”</td>
<td>4.98%</td>
<td>232.151709</td>
<td>4.89%</td>
</tr>
<tr>
<td>4.2910”</td>
<td>7.43%</td>
<td>212.647204</td>
<td>14.51%</td>
</tr>
</tbody>
</table>

“POCO” Pin Design Variation

This intelligent design allows the user to change the set pressure of the valve by simply changing pins. This is done by affixing pin spacers on each end of the Rupture Pin while keeping the overall length of the pin assembly constant.

The changes in set pressure are accomplished by varying the diameter and length between the spacers of the actual Rupture Pin. We’re able to meet customer requirements for multiple settings.
**Euler’s Law**

Axial Force on the Pin Causing the Pin to Buckle

(Piston/Plunger Area x System Pressure) \( \sim \) \( \frac{\text{Pin Diameter}^4 \times \text{Pin Material Modulus of Elasticity}}{\text{Pin Length}^2} \)

**Tinius-Olson Test**

1.7 milliseconds for full pin buckling (for actual 1” Model C @ 900 psig valve event)

Ability to work close to set point .75%

**Rupture Pin vs. Rupture Disc**

**Why Rupture Discs Fail**

The main weaknesses of the disc is the fact that the disc’s stress at the burst point is much greater than the yield stress. The stress-strain curve of the forward acting/tension loaded rupture disc is shown. Once the disc is pressured beyond its yield point, the disc is irreversibly damaged. Unless the pressure continues to increase to the burst pressure, the disc will fail far below set point, usually at the next pressure increase over yield point. Yes, when the disc breaks early, it “fails safe”, but consider the needless pollution, loss of product, downtime, disc replacement cost and labor to replace the disc.

With the Rupture Pin, the stress is always below the elastic limit. Because its mechanism of buckling is Euler’s Law, the pin can’t fatigue.

**STRESS-STRAIN CURVE**

Rupture/Buckling PIN vs. Tension Loaded Rupture DISC

Showing why a Rupture PIN is more accurate, reliable and does not buckle early.
**Stress Tests**

In these pin tests, we load the pin to 98% of set point 9 consecutive times and then buckle the pin on the 10th compression. Each test showcases the ability of our design to operate just below set point without fatigue of the pin or risk of an early rupture. The tests also show the accuracy of the set point.
How We Test Our Valves

Every valve manufactured by Rupture Pin Technology is shipped with a Valve Certification Document unique to each individual valve. These “Valve Testing Certifications” are prepared to the Customer’s exact specifications set forth by the Sales Order. Each valve undergoes Quality Control checks at various stages of production. The production process is controlled from the inspections of raw materials received, to in-progress tolerance checks, and welding quality inspections. The final and most critical inspection is done by personnel that do final assembly and testing of each valve. If any deficiencies show up here, Quality Control will be notified and any parts not meeting the requirements will be reworked and scrapped. When Assembly and Quality Control have approved all components, the valve may be assembled and tested.

All valves are given a “Bubble Test” to verify the integrity of the valve body, a “Seat Test” to verify the pistons Class VI seal, and a “Shell Test” to verify the sustained pressure integrity over time. When these three tests have been documented, the assembly personnel will begin testing to determine the exact pin material, length and diameter to achieve the Customer’s required pressure setting. Once the setting is determined, we will run a series of at least three additional tests to verify consistent operation under air pressure. Valves with set requirements over 3,000 PSIG will be tested with water “Hydro” or other materials specified by the Customer. Each valve tested is given a “Test Certificate” with this information documented and signed by our Quality Control Inspector.

Special Testing such as X-Ray, Dye Penetration, and Extended Shell Testing can be provided at the Customer’s request.

In testing for a valve’s set point with an electronic pressure or vacuum gauge, it is important to know the incremental event sample time. Usually the time is one second. During this second, four readings are taken and the average of the four is displayed. It is obvious that the average display is 500 milliseconds behind if the pressure increase is uniform. To reduce the delay error, we use the following maximum test times:

- 0% to 50% of set point 1/2 minute
- 51% to 90% of set point 2 minutes
- 91% to the buckling point 2 minutes

Pin Testing: Before each valve is shipped to the Customer, Engineering performs a final test on our Tinius Olsen instrument. This machine measures and documents the force to buckle the pin material used in each valve. A test set of at least three pins from each job are tested to record the buckling pounds of force. These test results give us an archive benchmark, free of seal friction. If the Customer needs a replacement pin or an o-ring, the original test information will be available. In addition to that, all the Customer’s job prints and information are kept.

Each valve has a “Serial Information Tag” that includes: Valve Type – Size – Set Pressure PSI – Capacity in SCFM or GPM – Serial Number – Pin Data – and Date. This Tag is attached to the valve bonnet. The valve bonnet is also stamped with the serial number. All Pins are tagged with the Pin Code, Valve Serial Number and the specified Set Pressure.

TEST CERTIFICATE
**Quality Assurance, Product Testing and Research**

<table>
<thead>
<tr>
<th><strong>TYPICAL TEST SETUP</strong></th>
<th><strong>PIN LENGTH MEASUREMENT</strong></th>
</tr>
</thead>
<tbody>
<tr>
<td>Gives the hydro test and required pin length and diameter for the exact set pressure and a Class VI seal.</td>
<td>We measure pin length to four decimal places.</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th><strong>AIR TESTING</strong></th>
<th><strong>TINIUS-OLSEN PIN TEST</strong></th>
</tr>
</thead>
<tbody>
<tr>
<td>We test a Model I-A slurry relief valve at 6,000 PSI to assure proper function and repeatability at maximum stress.</td>
<td>Gives precise pin buckling force for archive information on each valve to assure exact replacement pins.</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th><strong>AIR TEST STAND</strong></th>
<th><strong>DATA ACQUISITION</strong></th>
</tr>
</thead>
<tbody>
<tr>
<td>We test valve set pressures to 21,000 PSI.</td>
<td>Tinius Olsen test results are kept on record.</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th><strong>WATER TEST STAND</strong></th>
<th><strong>HEAT TREATING</strong></th>
</tr>
</thead>
<tbody>
<tr>
<td>We test valve set pressures to 50,000 PSI and are now working on a stand to 100,000 PSI.</td>
<td>We heat treat valve parts and tweak the pin modulus as required.</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th><strong>AIR TEST VESSEL</strong></th>
<th><strong>RESEARCH TEST</strong></th>
</tr>
</thead>
<tbody>
<tr>
<td>Used to test large valves to 21,000 PSI.</td>
<td>Determines how close our valve can operate to set point. This valve shows 2% max.</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th><strong>PIN MATERIALS</strong></th>
<th><strong>HIGH SPEED VIDEO</strong></th>
</tr>
</thead>
<tbody>
<tr>
<td>We carry a large stock of pin materials to meet immediate pin orders. One bin is shown.</td>
<td>Piston speed when the pin buckles is determined by the distance between frames at up to 5,000 frames/sec.</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th><strong>DIAMOND SAW</strong></th>
<th><strong>TINIUS OLSEN SEAL TEST</strong></th>
</tr>
</thead>
<tbody>
<tr>
<td>Cuts our pins to the exact length with polished square ends.</td>
<td>We research our seal tensile strength.</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th><strong>LASER MIKE</strong></th>
<th><strong>SEAL TESTING</strong></th>
</tr>
</thead>
<tbody>
<tr>
<td>Determines pin diameter to five decimal places</td>
<td>We do careful research and test our seals up to 6,000 PSI with air.</td>
</tr>
</tbody>
</table>
Client List

3M
Air Products
Alabama Gas Corp
Alabama Pine Pulp
Allied Signal
Amalgamated Sugar
American Azide
American Cyanimid
Amoco
Aramco
Arco
Arizona Chemical
BASF
Bauer, Inc.
Belize Natural Energy
Bohai Oil
Boom Drilling
British Petroleum American
British Petroleum United Kingdom
Brunswick Cellulose
Cactus Drilling
Calidra de Occidente
Carbon Fuels
Chalmette Refining LLC
CIBUS Inc.
Conoco
Columbia Natural Gas
Cytec Engineered Materials
Day & Zimmerman
Dow Chemical
DuPont
Durez Corporation
Eastman Chemical
El Paso Natural Gas
Encore
Energy Transfer
Englobal Engineering
Exxon
Fermilab
Fluor Daniel
Foster Wheeler
General Dynamics
Georgia Pacific
Goodyear
Hanover LTD
Hazen Research
Kerr-McGee Oil & Gas
Koch Engineering
Koch Pipeline
Lockwood Greene
LTV Energy
M-Wave Marketing
Mahr Corp
Marathon Oil
Midway Tool
Miller Brewery
Mobil
Monsanto
Mustang Hydraulics
MW Kellogg
NASA
National Oilwell Varco
Nomac Drilling
Northern Natural Gas
O’Brien & Gere
Parsons
Petrobras
Pfizer
PPG
Procter & Gamble
Ram Instruments
Rmax
Raytheon United Engineers
Santos
Sappi Fine Paper
Seaway Crude
Shell
Sinergia Soluciones
Solvay Solexis
Southern Natural Gas
Stepan
Stone Container
Sunoco Pipeline
Terasen Pipeline
Tinker AFB
Twin Rivers Technologies
Unit Drilling
Vetco Gray
Weyerhaeuser
Wissington Sugar Factory

Industries Served

Chemical Processing
Food Processing
Oil & Gas Production
Pharmaceutical
Pipeline
Pulp & Paper
Well Drilling (Mud Pump Relief)

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