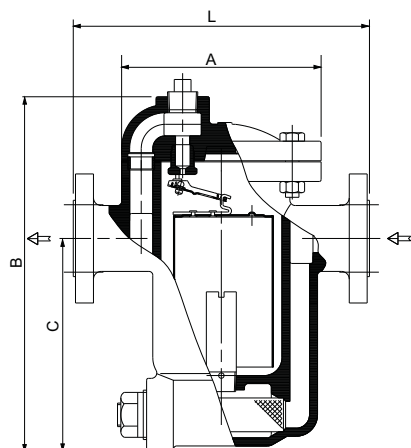


# 680F Series Inverted Bucket Steam Traps

Ductile Iron for Horizontal Installation, with Integral Strainer  
For Pressures to 17 bar...Capacities to 2 000 kg/h



## Description

The most reliable steam trap known – the inverted bucket – provides efficient condensate drainage of virtually all types of steam-using equipment. Put the inverted bucket to work in a tough ductile iron package with an integral strainer, and you have the best of both worlds. Because they operate efficiently for longer periods of time, Armstrong ductile iron inverted buckets add solid energy savings to lower replacement/labor costs. All Armstrong ductile iron inverted bucket steam traps are repairable for even bigger maintenance savings.

A unique leverage system multiplies the force provided by the bucket to open the valve against system pressure. The mechanism is free-floating, and has no fixed pivots to create wear or friction.

Because the mechanism is located at the top of the trap, no dirt can collect on the orifice. Small particles of dirt are held in suspension until discharged by the full differential purging action when the bucket sinks, pulling the valve off the seat.

The discharge orifice is surrounded by a water seal, preventing live steam loss. Automatic air venting is provided by a small vent hole in the bucket, which provides continuous automatic air and CO<sub>2</sub> venting at steam temperature.

Inverted bucket traps drain continuously, although discharging intermittently, allowing no condensate backup. They are also resistant to water hammer.

## Connections

Integral Flanged EN1092-2 PN25

## Maximum Operating Conditions

Maximum allowable pressure : 17 bar @ 232°C  
Maximum operating pressure: 17 bar  
Maximum back pressure: 99% of inlet pressure

## Materials

Body: ASTM A395 Gr.60-40-18  
Internals: All stainless steel – 304  
Valve and seat: Stainless Steel 17-4PH H900  
Strainer: Stainless steel – 304

## Options

- Stainless steel internal check valve (add suffix CV)
- Thermic vent bucket (add suffix T)
- Large venting orifice (add suffix LV)
- Scrub wire (add suffix BVSW)

## Specification

Inverted bucket steam trap, type ... in ductile iron with integral strainer, with continuous air venting at steam temperature, with free-floating stainless steel mechanism, and discharge orifice at the top of the trap. Maximum allowable back pressure 99% of inlet pressure.

## How to Order

Specify:

- Model number
- Size and type of pipe connection
- Maximum working pressure or orifice size
- Any options required

**Table 88-1. 680F Series Side Inlet, Side Outlet Trap with Integral Strainer (dimensions in mm)**

Add suffix «CV» to model number for internal check valve, «T» for thermic vent bucket.

Model No.	681F	682F	683F
Pipe Connections	15 – 20 – 25	15 – 20 – 25	20 – 25 – 32
Test plug	1/4"	1/2"	3/4"
«A» Face-to-Face	95,2	143	178
«B» Height	179	244	314
«C» Bottom to ⌀ Inlet	113	146	187
«L» Face-to-Face (Integral Flanged EN1092-2 PN25)	150 – 150 – 160	230	260
Number of Bolts	6	6	6
Weight in kg	3,8 – 4,1 – 4,5	9 – 10 – 10,5	22,5 – 23,5 – 24

All models comply with the article 3.3 of the PED (97/23/EC).

*All dimensions and weights are approximate. Use certified print for exact dimensions. Design and materials are subject to change without notice.*

# 680F Series Inverted Bucket Steam Traps

Ductile Iron for Horizontal Installation, with Integral Strainer  
For Pressures to 17 bar...Capacities to 2 000 kg/h



Table 89-1. Model 681F Capacity

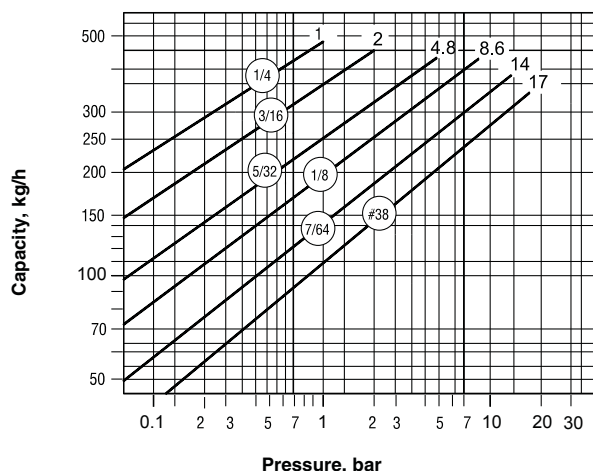


Table 89-2. Model 682F Capacity

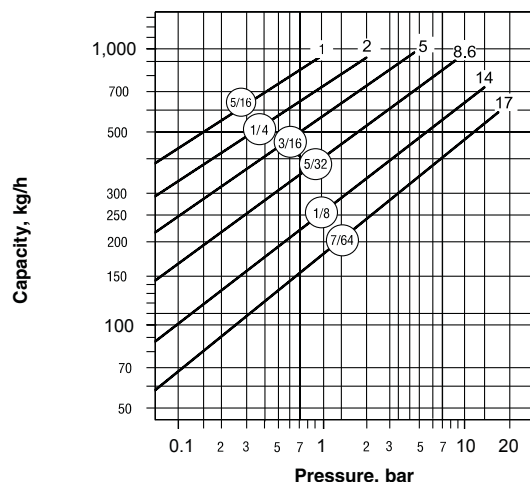
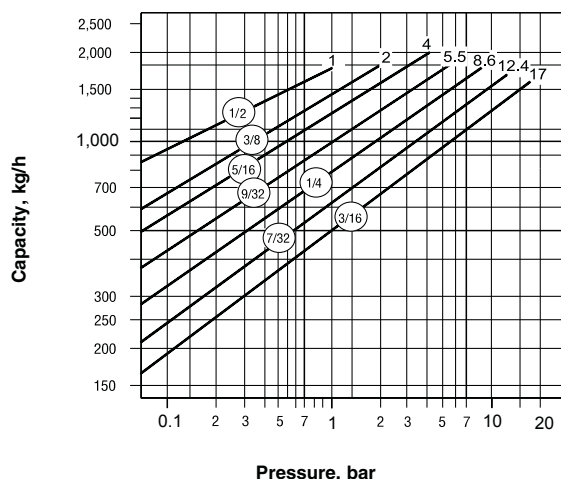


Table 89-3. Model 683F Capacity



All dimensions and weights are approximate. Use certified print for exact dimensions. Design and materials are subject to change without notice.