



# 1000 Series Inverted Bucket Steam Trap

## All Stainless Steel for Vertical Installation

For Pressures to 650 psig (45 bar)...Capacities to 4,400 lb/hr (2,000 kg/hr)

### Description

Armstrong 1000 Series stainless steel inverted bucket steam traps normally last three to four times longer than conventional traps used in identical services. Heat-treated stainless steel valves and seats are of the same design, material and workmanship as those used in traps for pressures up to 900 psig and temperatures to 900°F. More compact than cast iron or carbon steel equivalents, 1000 Series traps are ideal for trapping applications such as tracer lines, steam mains and heating/process applications.

The 1000 Series are guaranteed for three years.

### Maximum Operating Conditions

Maximum allowable pressure (vessel design):

Model 1010, 1011:	400 psig @ 800°F (28 bar @ 427°C)
Model 1022:	650 psig @ 600°F (45 bar @ 316°C)
	627 psig @ 700°F (43 bar @ 371°C)
	604 psig @ 800°F (41.6 bar @ 427°C)
Model 1013:	450 psig @ 800°F (31 bar @ 427°C)

Maximum operating pressure:

Model 1010:	150 psig (10 bar)
Model 1011:	400 psig (28 bar)
Model 1022:	650 psig (45 bar)
Model 1013:	450 psig (31 bar)



### Connections

Screwed NPT and BSPT  
Socketweld

### Materials

Body:	ASTM A240 Grade 304L
Internals:	All stainless steel—304
Valve and seat:	Hardened chrome steel—17-4PH or Titanium

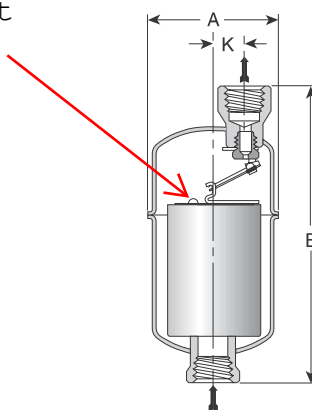
### Options

- Stainless steel internal check valve
- Thermic vent bucket 250 psig (17 bar) maximum;  
for Model 1022 15 psig (1 bar) maximum
- Wiggle wire

### Specification

Inverted bucket steam trap, type ... in all stainless steel, freeze resistant, without gaskets, with continuous air venting at steam temperature, free-floating stainless steel mechanism, and orifice at the top of the trap.

Large Vent



Model 1010 Trap

### How to Order

Specify:

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

For a fully detailed certified drawing, refer to:

1010 and 1011	CD #1006
1022	CD #1204

### 1000 Series Traps

Model No.	1010		1011		1022		1013	
	in	mm	in	mm	in	mm	in	mm
Pipe Connections	1/2, 3/4	15, 20	1/2, 3/4	15, 20	3/4	20	1	25
"A" (Diameter)	2-3/4	69.9	2-3/4	68.9	3-7/8	100	4-1/2	114
"B" (Height)	6-1/16	168	7-1/4	184	8-13/16	224	11-3/8	289
"K" (Ø Inlet to Ø Outlet)	9/16	14.3	9/16	14.3	3/4	18	1-3/16	30.2
Weight lb (kg)	1-1/2 (0.7)		1-3/4 (0.8)		4 (2)		7-1/2 (3.4)	

Designs, materials, weights and performance ratings are approximate and subject to change without notice. Visit [armstronginternational.com](http://armstronginternational.com) for up-to-date information.

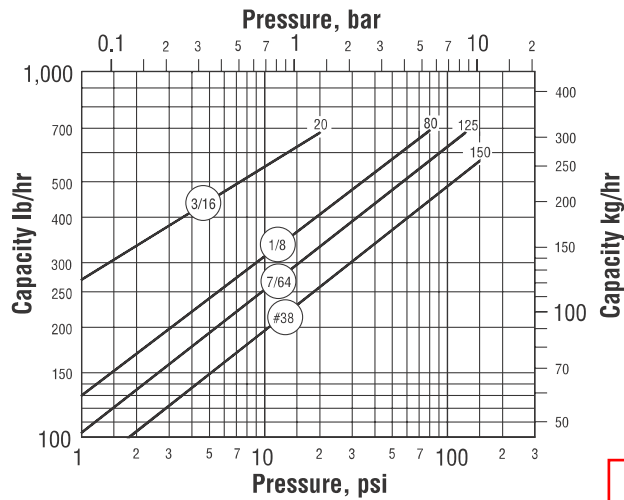
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## All Stainless Steel for Vertical Installation

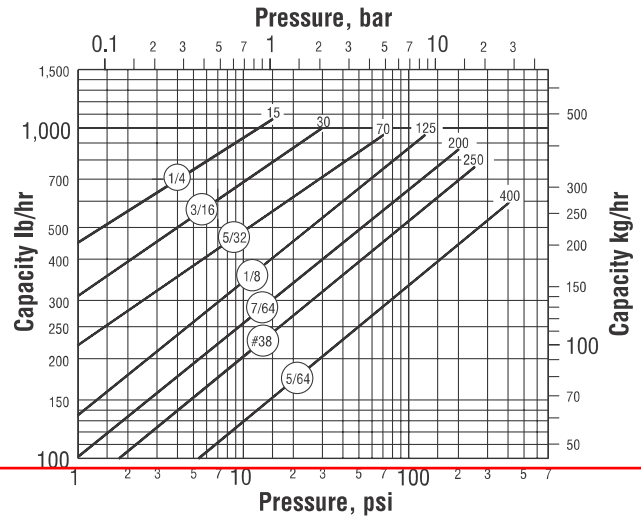
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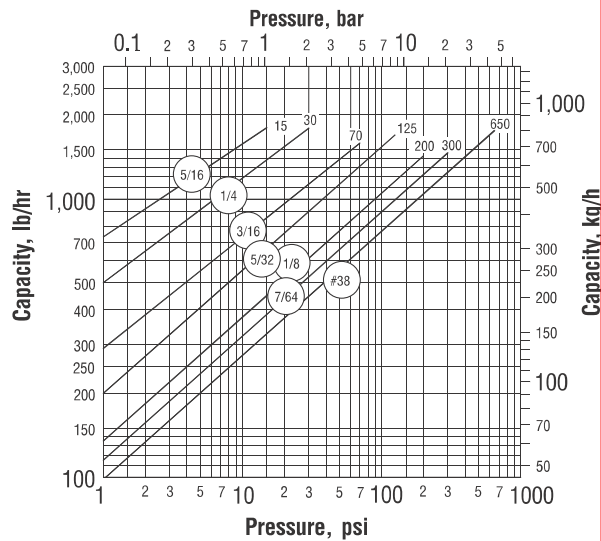
Model 1010 Capacity



Model 1011 Capacity



Model 1022 Capacity



Model 1013 Capacity

