DURA-FLO INVERTED BUCKET STEAM TRAPS

Pressures To 250 PSIG (17.2 barg)
Temperatures to 450°F (232°C)

**Hardened Stainless Steel Valve and Seat** — Long life and maximum corrosion resistance.

**Stainless Steel Bucket** — Long lasting, rugged and naturally resistant to water hammer.

**Inexpensive** — Low maintenance and initial cost.

**Repairable in-line** — All working parts lift out of top of trap.

**Cast Iron Body** — Durable heavy wall construction provides years of reliable service.

**Suitable for Wide Variety of Loads/Applications** — Horizontal and vertical models in thirteen body sizes.

**Resists Dirt and Scale** — Valve and seats positioned at top of traps and internal stainless strainer available on most horizontal models ensure long service.

**APPLICATIONS**

- Steam Lines
- Process Equipment
- Steam Cookers
- Steam Heated Vats
- Pressing Machinery
- Unit Heaters
- Oil Preheaters
- Converters
- Coils
- Rotating Drum

**OPTIONS**

- Repair Kits
- Canadian Registration # OE 0591.1C

**MODELS**

- **G80S** — Low capacity horizontal w/integral strainer
- **G81S** — Medium low capacity horizontal w/integral strainer
- **G82S** — Medium capacity horizontal w/integral strainer
- **G83S** — Medium high capacity horizontal w/integral strainer
- **G84** — High capacity horizontal
- **G85** — Super high capacity horizontal
- **G86** — Ultra high capacity horizontal
- **G21** — Medium low capacity vertical
- **G22** — Medium capacity vertical
- **G23** — Medium high capacity vertical
- **G24** — High capacity vertical
- **G25** — Super high capacity vertical
- **G26** — Ultra high capacity vertical

**OPERATION**

**Trap Closed** — After trap is installed and primed, steam entering the trap collects in the top of the bucket, floating the bucket and forcing the valve into its seat.

**Trap Begins to Open** — As condensate begins to flow into the trap, steam and air are forced from the bucket. This causes the bucket to begin losing buoyancy, tending to pull the valve from its seat.

**Trap Discharges** — When enough condensate has entered the trap, displacing the steam and air, the bucket drops, pulling the valve from the seat and allowing condensate and air to discharge.

**Trap Closes** — As the flow of condensate stops, steam enters the trap and refloats the bucket, forcing the valve into its seat. The cycle then repeats as more condensate reaches the trap.

Installation Tip: Always install STV Test & Block Valve as part of trap station — SEE PAGE 354

Installation Tip: Add Uniflex Pipe Coupling for ease of maintenance - SEE PAGE 374

**APPLICATIONS**

- Steam Lines
- Process Equipment
- Steam Cookers
- Steam Heated Vats
- Pressing Machinery
- Unit Heaters
- Oil Preheaters
- Converters
- Coils
- Rotating Drum

**OPTIONS**

- Repair Kits
- Canadian Registration # OE 0591.1C

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- **G80S** — Low capacity horizontal w/integral strainer
- **G81S** — Medium low capacity horizontal w/integral strainer
- **G82S** — Medium capacity horizontal w/integral strainer
- **G83S** — Medium high capacity horizontal w/integral strainer
- **G84** — High capacity horizontal
- **G85** — Super high capacity horizontal
- **G86** — Ultra high capacity horizontal
- **G21** — Medium low capacity vertical
- **G22** — Medium capacity vertical
- **G23** — Medium high capacity vertical
- **G24** — High capacity vertical
- **G25** — Super high capacity vertical
- **G26** — Ultra high capacity vertical

**OPERATION**

**Trap Closed** — After trap is installed and primed, steam entering the trap collects in the top of the bucket, floating the bucket and forcing the valve into its seat.

**Trap Begins to Open** — As condensate begins to flow into the trap, steam and air are forced from the bucket. This causes the bucket to begin losing buoyancy, tending to pull the valve from its seat.

**Trap Discharges** — When enough condensate has entered the trap, displacing the steam and air, the bucket drops, pulling the valve from the seat and allowing condensate and air to discharge.

**Trap Closes** — As the flow of condensate stops, steam enters the trap and refloats the bucket, forcing the valve into its seat. The cycle then repeats as more condensate reaches the trap.

Installation Tip: Always install STV Test & Block Valve as part of trap station — SEE PAGE 354

Installation Tip: Add Uniflex Pipe Coupling for ease of maintenance - SEE PAGE 374
**DURA-FLO**

**INVERTED BUCKET STEAM TRAPS**

**SPECIFICATION**

Furnish and install as shown on the plans, inverted bucket traps capable of discharging condensate, air and other non-condensible gases without loss of steam. These traps shall have a heavy cast iron body, hardened stainless steel valve and seat, all stainless steel linkage and bucket, and an asbestos free fiber cover gasket.

**MAXIMUM OPERATING CONDITIONS**

PMO: Max. Operating Pressure  
see orifice selection

TMO: Max. Operating Temperature  
saturated at pressure

PMA: Max. Allowable Pressure  
250 psig (17.2 barg)

TMA: Max. Allowable Temperature  
450°F (232°C)

**MATERIALS OF CONSTRUCTION**

Body & Cover  
.................Cast Iron ASTM-A-126/A48

Bucket & Linkage  
...........................Stainless Steel

Valve & Seat  
............................Hardened Chrome Steel

Standpipe  
.................................Steel Pipe

Cover Gasket  
..............................Asbestos Free Fiber

---

**DURA-FLO Dimension Table**

<table>
<thead>
<tr>
<th>Trap</th>
<th>End Connections</th>
<th>A (Inches)</th>
<th>B (Inches)</th>
<th>C (Inches)</th>
<th>Weight Lbs (kg)</th>
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<tbody>
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<td>80S</td>
<td>½, ⅜</td>
<td>5 ¼</td>
<td>2 ⅜</td>
<td>3 ½</td>
<td>7 (3.2)</td>
</tr>
<tr>
<td>81S</td>
<td>½, ⅜, ⅜</td>
<td>5 ¼</td>
<td>2 ⅜</td>
<td>4 ⅜</td>
<td>8 (3.6)</td>
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<tr>
<td>82S</td>
<td>½, ⅞</td>
<td>7 ½</td>
<td>3 ¼</td>
<td>5 ¾</td>
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<tr>
<td>83S</td>
<td>½, ⅞, ⅞</td>
<td>8 ½</td>
<td>5 ¼</td>
<td>7 ¾</td>
<td>32 (14.5)</td>
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<tr>
<td>84</td>
<td>1, ⅞</td>
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<tr>
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<td>8 ¾</td>
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<tr>
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<td>9 ¾</td>
<td>11 ¼</td>
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<tr>
<td>21</td>
<td>½, ¼</td>
<td>6 ¼</td>
<td>4 ½</td>
<td>—</td>
<td>6.5 (2.9)</td>
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<tr>
<td>22</td>
<td>½, ⅜</td>
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<td>24</td>
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<td>25</td>
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<tr>
<td>26</td>
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<td>16 ⅝</td>
<td>10 ⅛</td>
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<td>200</td>
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<td>55</td>
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<td>830</td>
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<td>220</td>
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</table>

For Kg/Hr Multiply by .454
**DURA-FLO**  
**INVERTED BUCKET STEAM TRAPS**  
**PCA REPAIR KITS**

Quick, easy and economical  
Simplifies and standardizes inventory  
All stainless steel corrosion resistant internal parts  
Hardened stainless steel condensate valves and seats for extra long life

**MODELS**
- **80S**–Orifice ratings 20, 80, 125, 150  
- **81S & 21**–Orifice ratings 15, 30, 70, 125, 200, 250  
- **82S & 22**–Orifice ratings 15, 30, 70, 125, 200, 250  
- **83S & 23**–Orifice ratings 15, 30, 60, 80, 125, 180, 250  
- **84 & 24**–Orifice ratings 15, 30, 60, 80, 125, 180, 250  
- **85 & 25**–Orifice ratings 15, 30, 60, 100, 130, 180, 225, 250  
- **86 & 26**–Orifice ratings 15, 25, 40, 60, 80, 125, 180, 250

**FTN SERIES FLOAT & THERMOSTATIC STEAM TRAPS**  
**REPAIR KITS**

High quality replacement kits  
Rebuild existing F & T Traps far more economically than replacement  
Quick, easy and economical  
Simplifies and standardizes inventory  
All stainless steel corrosion resistant internal parts  
Hardened stainless steel condensate valves and seats for extra long life  
Repairs other leading manufacturers’ F & T Traps

**MODELS**
- **FTN-15** available in ¾”, 1”, 1¼”, 1½” and 2”  
- **FTN-30** available in ¾”, 1”, 1¼”, 1½” and 2”  
- **FTN-75** available in ¼”, 1”, 1¼”, 1½” and 2”  
- **FTN-125** available in ¾”, 1”, 1¼”, 1½” and 2”

All ¾” and 1” kits as well as 1¼” FTN-15 and FTN-30 kits supplied with cover assembly.  
All 1½” FTN-75 and FTN-125 kits as well as all 1¾” and 2” kits supplied as mechanism complete.  
See page 323 for Capacity Charts

Consult factory for latest crossover fitments.
THREADED STAINLESS STEEL DURA-FLO
INVERTED BUCKET STEAM TRAPS

Pressures to 650 PSIG (45 barg)
Temperatures to 800°F (425°C)

Hardened Chrome Steel Valve and Seat — Long life and maximum corrosion resistance.
Stainless Steel Bucket — Long lasting, rugged and naturally resistant to water hammer.
Inexpensive — Low maintenance and initial cost.
Stainless Steel Body — Durable heavy wall construction provides years of reliable service and resists corrosion and freezing.
Suitable for Wide Variety of Loads/Applications — Horizontal models in three body sizes.
Resists Dirt and Scale — Valve and seats positioned at top of traps ensure long service.
Maintenance Free (TSBT-_S) — Sealed design prevents unnecessary tampering.
Repairable Model (TSBT-_R) — Removable cover allows pressure change or repair with existing Dura-Flo PCA kits.

MODELS

NPT CONNECTION
● TSBT-LS — Low Capacity, 400 PSIG
● TSBT-MS — Medium Capacity, 400 PSIG
● TSBT-HS — High Capacity, 650 PSIG

NPT CONNECTION, REPAIRABLE
● TSBT-LR — Low Capacity, 400 PSIG
● TSBT-MR — Medium Capacity, 400 PSIG
● TSBT-HR — High Capacity, 650 PSIG

APPLICATIONS
● Steam Lines
● Process Equipment
● Steam Cookers
● Steam Heated Vats
● Pressing Machinery
● Unit Heaters
● Oil Preheaters
● Converters
● Coils
● Rotating Drum

OPERATION

After trap is installed and primed, steam entering the trap collects in the top of the bucket, floating the bucket and forcing the valve into its seat. As condensate begins to flow into the trap, steam and air are forced from the bucket. This causes the bucket to begin losing buoyancy, tending to pull the valve from its seat. When enough condensate has entered the trap, displacing the steam and air, the bucket drops, pulling the valve from the seat and allowing condensate and air to discharge. As the flow of condensate stops, steam enters the trap and refloats the bucket, forcing the valve into its seat. The cycle then repeats as more condensate reaches the trap.
THREAD STAINLESS STEEL DURA-FLO
INVERTED BUCKET STEAM TRAPS

SPECIFICATION

Furnish and install as shown on the plans, inverted bucket traps capable of discharging condensate, air and other non-condensable gases without loss of steam. These traps shall have a stainless steel sealed body, hardened chrome steel valve and seat and an all stainless steel linkage and bucket. The repairable model traps shall have a removable cover to allow repair or pressure change.

MAXIMUM OPERATING CONDITIONS

PMO: Max. Operating Pressure See Orifice Selection
TMO: Max. Operating Temperature Saturated at PMO
PMA: Max. Allowable Pressure 400 psig (28 barg)
or 650 psig (45 barg)
TMA: Max. Allowable Temperature 800ºF (425ºC)

MATERIALS OF CONSTRUCTION

Body .................................................. AISI 304 SS
Cover (Repairable only) ......................... AISI 304 SS
Bucket ............................................... AISI 304 SS
Bucket Clip ....................................... AISI 304 SS
Lever .................................................. AISI 304 SS
Inlet Tube ......................................... AISI 304 SS
Valve ................................................. Hardened Chrome Steel AISI D3
Valve Seat .......................................... Hardened Chrome Steel AISI D3
Connector .......................................... AISI 304 SS
Cover Gasket (Repairable only) Spiral Wound 304 SS w/Grafoil

Maximum Capacity—(lbs/hr)

<table>
<thead>
<tr>
<th>Trap</th>
<th>Orifice</th>
<th>Differential Pressure</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>Size</td>
<td>5 (0.34)</td>
</tr>
<tr>
<td>TSBT-LS &amp; LR</td>
<td>3/32</td>
<td>200</td>
</tr>
<tr>
<td>TSBT-MS &amp; MR</td>
<td>1/4</td>
<td>15</td>
</tr>
<tr>
<td></td>
<td>3/16</td>
<td>30</td>
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<tr>
<td></td>
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<tr>
<td></td>
<td>1/8</td>
<td>125</td>
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<td></td>
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<td>3/32</td>
<td>250</td>
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<tr>
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<td>5/64</td>
<td>400</td>
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<tr>
<td>TSBT-HS &amp; HR</td>
<td>1/4</td>
<td>40</td>
</tr>
<tr>
<td></td>
<td>3/16</td>
<td>80</td>
</tr>
<tr>
<td></td>
<td>1/8</td>
<td>250</td>
</tr>
<tr>
<td></td>
<td>7/64</td>
<td>300</td>
</tr>
<tr>
<td></td>
<td>3/32</td>
<td>650</td>
</tr>
</tbody>
</table>

For Kg/Hr Multiply by .454
UNIVERSAL MOUNT
STAINLESS STEEL
DURA-FLO
INVERTED BUCKET STEAM TRAPS

Pressures to 650 PSIG (45 barg)
Temperatures to 800°F (425°C)

**Easy Trap Replacement** — Universal two bolt swivel mounting simplifies removal from system.

**Simple Installation** — Stainless mounting Block mounts permanently into system. Trap installs via two bolt universal mount connection.

**Hardened Chrome Steel Valve and Seat** — Long life and maximum corrosion resistance.

**Stainless Steel Bucket** — Long lasting, rugged and naturally resistant to water hammer.

**Inexpensive** — Low maintenance and initial cost.

**Stainless Steel Body** — Durable heavy wall construction provides years of reliable service and resists corrosion and freezing.

**Suitable for Wide Variety of Loads/Applications** — Horizontal models in three body sizes.

**Resists Dirt and Scale** — Valve and seats positioned at top of traps ensure long service.

**Maintenance Free (USBT-_S)** — Sealed design prevents unnecessary tampering. Trap can be inspected and replaced without breaking pipe.

**Repairable Model (USBT-_R)** — Removable cover allows pressure change or repair with existing Dura-Flo PCA kits.

**MODELS**

**UMT CONNECTION**
- **USBT-LS** — Low Capacity, 400 PSIG
- **USBT-MS** — Medium Capacity, 400 PSIG
- **USBT-HS** — High Capacity, 650 PSIG

**UMT CONNECTION, REPAIRABLE**
- **USBT-LR** — Low Capacity, 400 PSIG
- **USBT-MR** — Medium Capacity, 400 PSIG
- **USBT-HR** — High Capacity, 650 PSIG

**UMT CONNECTOR BLOCKS**
- **UMTC** — Standard connector (1/2" & 3/4" only)
- **UMTCY-RH** — Right Hand Connector w/Y strainer*
- **UMTCY-LH** — Left Hand Connector w/Y strainer*
- **UMTVS-BB** — Connector with Isolation Valves, Strainer, Blowdown Valve and Test Port

**APPLICATIONS**
- Steam Lines
- Process Equipment
- Steam Cookers
- Steam Heated Vats
- Pressing Machinery
- Unit Heaters
- Oil Preheaters
- Converters
- Coils
- Rotating Drum

---

**OPERATION**

After trap is installed and primed, steam entering the trap collects in the top of the bucket, floating the bucket and forcing the valve into its seat. As condensate begins to flow into the trap, steam and air are forced from the bucket. This causes the bucket to begin losing buoyancy, tending to pull the valve from its seat. When enough condensate has entered the trap, displacing the steam and air, the bucket drops, pulling the valve from the seat and allowing condensate and air to discharge. As the flow of condensate stops, steam enters the trap and re-floats the bucket, forcing the valve into its seat. The cycle then repeats as more condensate reaches the trap.

For information on Big Block UMTVS-BB Connector See Page 344
UNIVERSAL MOUNT STAINLESS STEEL DURA-FLO INVERTED BUCKET STEAM TRAPS

SPECIFICATION

Furnish and install as shown on the plans, inverted bucket traps capable of discharging condensate, air and other non-condensable gases without loss of steam. These traps shall have a stainless steel sealed body, hardened chrome steel valve and seat and an all stainless steel linkage and bucket. It shall also have a universal mount connection. The optional repairable traps shall have a removable cover to allow repair or pressure change.

MAXIMUM OPERATING CONDITIONS

PMO: Max. Operating Pressure See Orifice Selection
TMO: Max. Operating Temperature Saturated at PMO
PMA: Max. Allowable Pressure 400 psig (28 barg) or 650 psig (45 barg)
TMA: Max. Allowable Temperature 800°F (425°C)

MATERIALS OF CONSTRUCTION

Body .................................................. AISI 304 SS
Shaft (Sealed only)....................... AISI 304 SS
Bucket .............................................. AISI 304 SS
Bucket Clip ........................................ AISI 304 SS
Lever .................................................. AISI 304 SS
Inlet Tube .......................................... AISI 304 SS
Valve ................................................. Hardened Chrome Steel AISI D3
Valve Seat ......................................... Hardened Chrome Steel AISI D3
Swivel Connector ......................... AISI 304 SS
Cover Gasket (Repairable only)Spiral Wound 304 SS w/Grafoil

Maximum Capacity—(lbs/hr)

<table>
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<tr>
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<th>Orifice Size (mm)</th>
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<td>Size (inches)</td>
<td>Size (mm)</td>
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<td>125</td>
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<tr>
<td></td>
<td>7/64</td>
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DIMENSIONS inches (mm) AND WEIGHTS pounds (kg)

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<th>Dimensions</th>
<th>Weight lbs (kg)</th>
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<td>2 ½&quot; (70)</td>
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<td>2 ½&quot; (70)</td>
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<td>2 ½&quot; (70)</td>
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<td>4</td>
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<tr>
<td>USBT-HS</td>
<td>3&quot; (99)</td>
<td>8</td>
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For Kg/HR Multiply by .454