

OPERATING INSTRUCTIONS

PAGE 1:

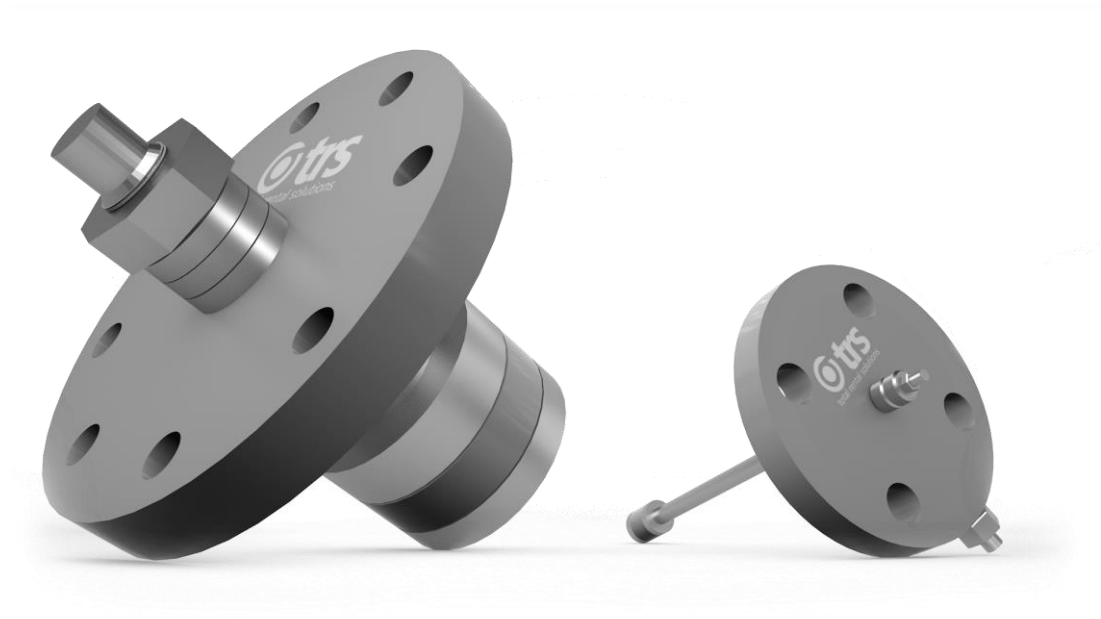
06/3509	1½" FLANGE WELD TESTER
06/3510	¾" FLANGE WELD TESTER
06/3511	1" FLANGE WELD TESTER

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06/3513	1½" FLANGE WELD TESTER
06/3515	2" FLANGE WELD TESTER
06/3518	3" FLANGE WELD TESTER
06/3522	4" FLANGE WELD TESTER
06/3526	6" FLANGE WELD TESTER

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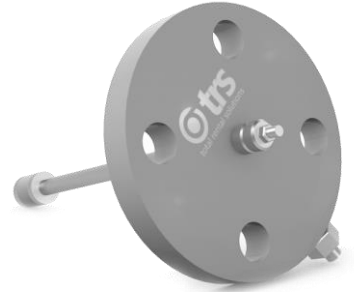
SPECIFICATION CHART



1: PREPARATION

Ensure you have the correct size tester to suit the pipe/flange being tested, including the gasket type (this will be stated on the Advice Note supplied).

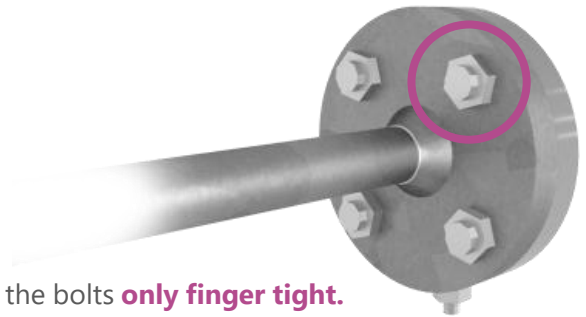
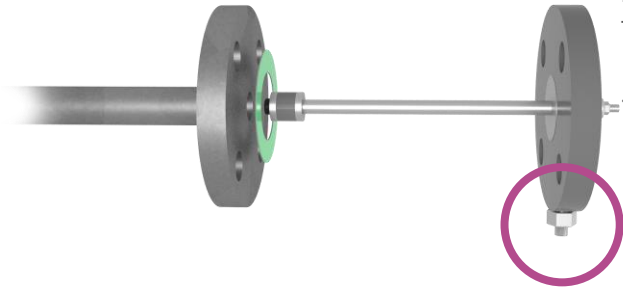
 **Check the pipe and flange is clean and damage free.**



2: INSTALLATION

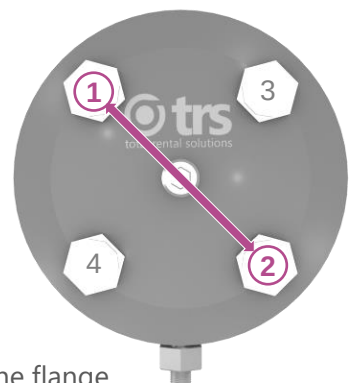
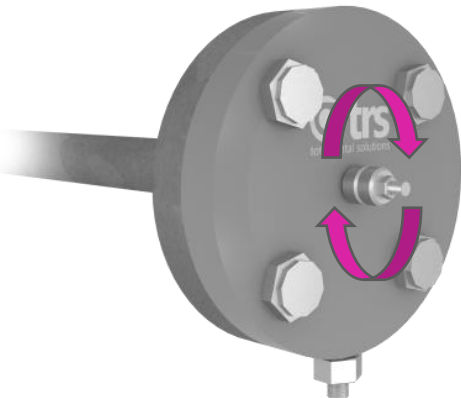
Using the correct gasket, place the Flange Weld Tester into the pipe and line up to the flange making sure the fill/vent port is in the vertical (down) position.

 At this stage, install the bolts **only finger tight**.



3: TIGHTENING

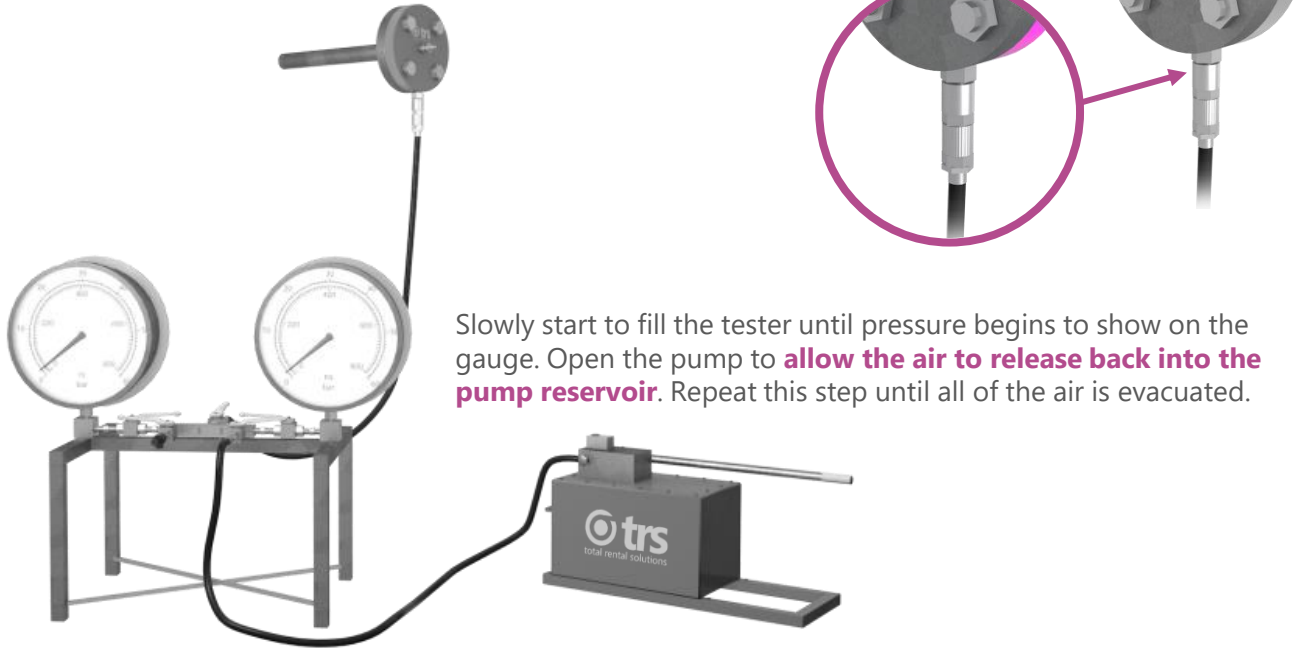
Using the correct sized spanners, hold the flats on the body and **tighten the engersising hex nut** until the main seal is compressed adequately against the inner pipe wall.



Now tighten the bolts in a **criss-cross sequence** on the flange connection. Evenly tighten opposite bolts until the gasket is sealed.

4: HYDROSTATIC TESTING

Connect the hose/pump to the fill/port on the Flange Weld Tester.



Slowly start to fill the tester until pressure begins to show on the gauge. Open the pump to **allow the air to release back into the pump reservoir**. Repeat this step until all of the air is evacuated.

Slowly increase the pressure to 50% of the required test pressure. Hold for 5 seconds, then slowly further increase until 100% of the test pressure is reached. Repeat this stage until the test pressure has stabilised.

At this stage, **close the valve and hold the test pressure for the specified holding time**.

5: REMOVAL

Ensure the test pressure is steadily released and **gauge(s) show zero**. Using the correct spanner release the energising nut. You may now release the flange bolts.



! Ensure that the pressure is at zero before complete removal of the flange bolts.

6: INSPECTION AND STORAGE

Inspect the tester for any signs of wear and damage.
Place the unit back into the transport/storage case.

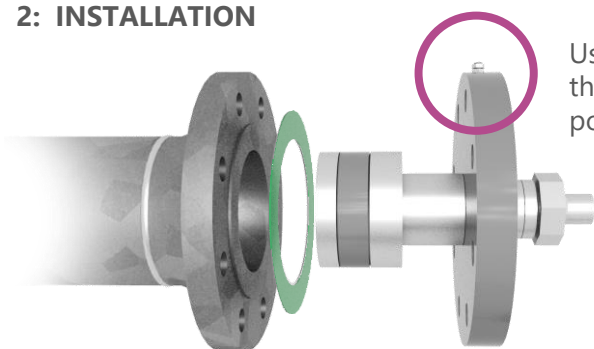
1: PREPARATION

Ensure you have the correct size tester to suit the pipe/flange being tested, including the gasket type (this will be stated on the Advice Note supplied).

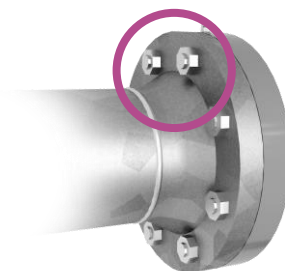
 **Check the pipe and flange is clean and damage free.**



2: INSTALLATION

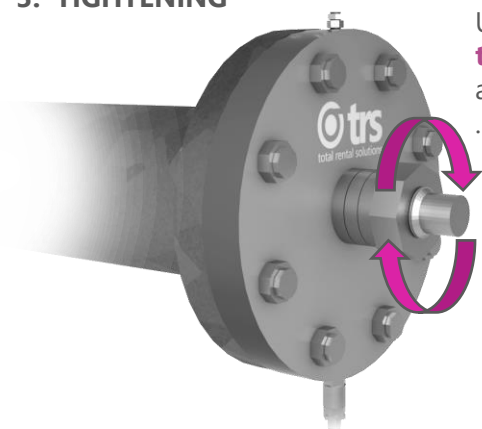


Using the correct gasket, place the Flange Weld Tester into the pipe and line up to the flange making sure the vent port is in the vertical (up) position.

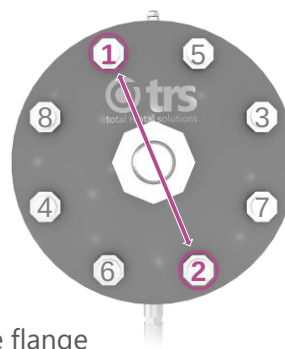


 At this stage, install the bolts **only finger tight**.

3: TIGHTENING



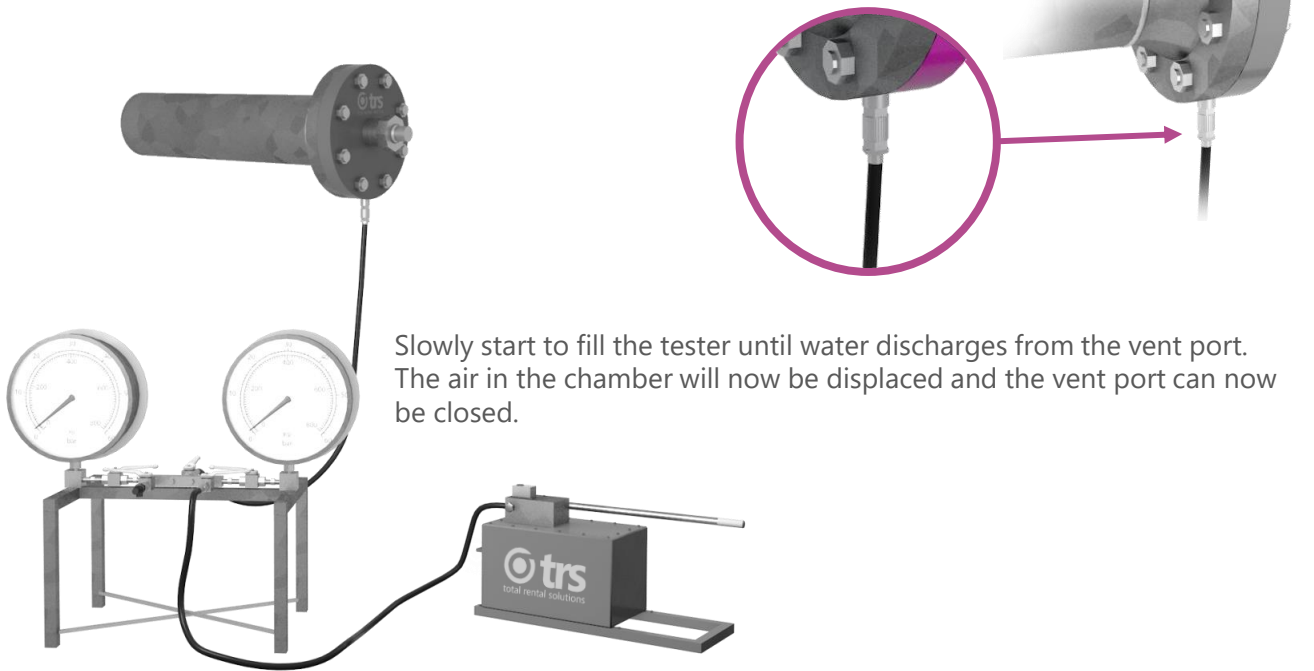
Using the correct sized spanners, hold the flats on the body and **tighten the engersising hex nut** until the main seal is compressed adequately against the inner pipe wall.



Now tighten the bolts in a **criss-cross sequence** on the flange connection. Evenly tighten opposite bolts until the gasket is sealed.

4: HYDROSTATIC TESTING

Connect the hose/pump to the fill/port on the Flange Weld Tester.



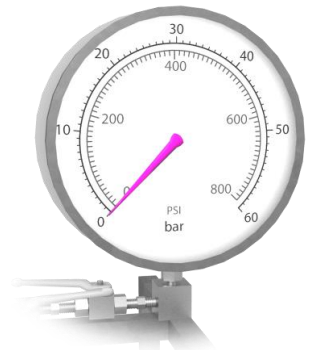
Slowly start to fill the tester until water discharges from the vent port. The air in the chamber will now be displaced and the vent port can now be closed.

Slowly increase the pressure to 50% of the required test pressure. Hold for 5 seconds, then slowly further increase until 100% of the test pressure is reached. Repeat this stage until the test pressure has stabilised.

At this stage, **close the valve and hold the test pressure for the specified holding time.**

5: REMOVAL

Ensure the test pressure is steadily released and **gauge(s) show zero.** Using the correct spanner release the engorgising nut. You may now release the flange bolts.



! Ensure that the pressure is at zero before complete removal of the flange bolts.

6: INSPECTION AND STORAGE

Inspect the tester for any signs of wear and damage. Place the unit back into the transport/storage case.

SPECIFICATION CHART

PIPE DIAMETER	1/2"	3/4"	1"	1 1/2"	2"	3"	4"	6"
Flange Diameter (ANSI 150)	89mm	99mm	108mm	127mm	152mm	190mm	228mm	280mm
Flange Diameter (ANSI 300)	95mm	117mm	124mm	155mm	165mm	209mm	254mm	317mm
Length (overall)	200mm	200mm	200mm	300mm	300mm	350mm	350mm	420mm
Pipe Schedule	80 & 40	80 & 40	80 & 40	80 & 40	80 & 40	80 & 40	80 & 40	80 & 40
Spanner Sizes	4 & 10mm	4 & 10mm	4 & 10mm	15 & 30mm	15 & 30mm	19 & 55mm	19 & 55mm	75mm
Fill Port Connector (male)	3/8" BSPT	3/8" BSPT	3/8" BSPT	3/8" BSPT	3/8" BSPT	3/8" BSPT	3/8" BSPT	3/8" BSPT
Weight (ANSI 150)	0.64kg	0.83kg	1.10kg	3.0kg	3.5kg	10.5kg	15.0kg	41.3kg
Weight (ANSI 300)	0.80kg	1.42kg	1.55kg	4.1kg	5.0kg	12.0kg	19.0kg	52.7kg
Product Code	06/3509	06/3510	06/3511	06/3513	06/3515	06/3518	06/3522	06/3526

