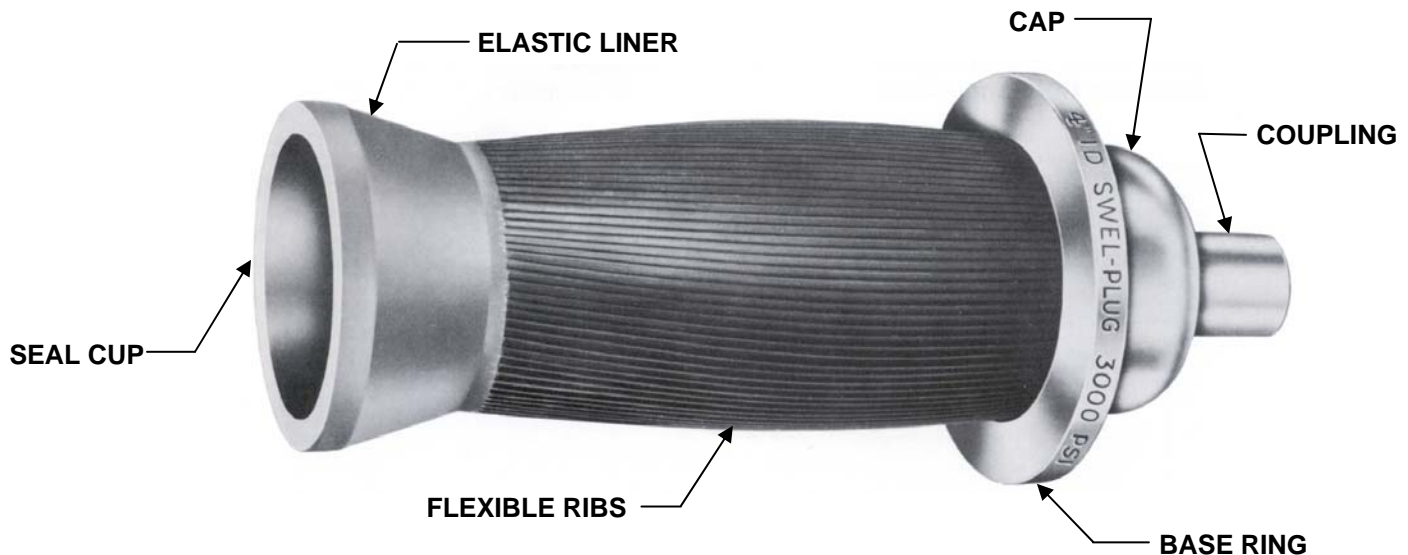


## OPERATING INSTRUCTION FOR SWEL-PLUG PRESSURE TEST PLUG



### INSTALLING

1. Attach shut-off valve or other desired fittings and connections to plug via coupling in plug cap. It is recommended that any auxiliary hardware be light and compact.
2. Remove any accumulated dirt, rust particles, scale, etc. from inside surface of pipe end. Special cleaning or grinding of pipe is not necessary. Remove burrs or sharp edges that could damage seal cup.
3. Holding plug in slightly angular position, place lower edge of seal cup on lip of pipe. While exerting slight forward pressure, compress seal up to permit insertion in pipe end, raising plug into alignment with pipe at same time.
4. Push plug forward until stop ring is butted against pipe end. Rotating plug counterclockwise will facilitate insertion. If fit is extremely tight, moisten outer surface of seal cup with water for easier insertion.

### FILLING TEST ASSEMBLY

1. After plug is properly positioned, connect to pressure source.
2. Fill assembly with testing medium and vent or bleed as required. (In Hydrostatic Testing do not close vent until water flows out in a steady stream, indicating all trapped air has been bled off.) Filling or venting operations can be accomplished through the plug. Therefore SWEL-PLUG Pressure Test Plugs often are used in pairs or series to close all openings of test assembly.
3. Close all valves, ports, vents, etc.
4. Pressurize and begin testing.

**CAUTION:** Pressure Testing generally is recognized as an inherently hazardous operation, hence general basic safety precautions should be observed: Check rating and condition of all connections, flanges, valves and other components and equipment against planned test pressure: Check calibration and condition of pressure gage: Vent all air if hydrostatic testing: Provide automatic pressure cutoff or locate pressure source away from test assembly: Do not stand in front of test plug or other closure while assembly is under pressure.

### REMOVING

1. Release pressure.
2. Completely drain or vent assembly.
3. Pull plug out of pipe.

**CAUTION:** It is important to relieve all pressure from assembly before attempting to extract plug. Any residual pressure imposed on plug during removal may be harmful to seal cup and may result in injury to operator or others.

### STORAGE AND MAINTENANCE

Service life of a SWEL-PLUG Pressure Test Plug closely parallels the degree of care during storage and it is recommended that plugs be:

1. Stored in racks and suspended from stop ring.
2. Placed in upright position, standing on seal cup end.
3. Or, in larger sizes, nestled in support cradle of shipping crate