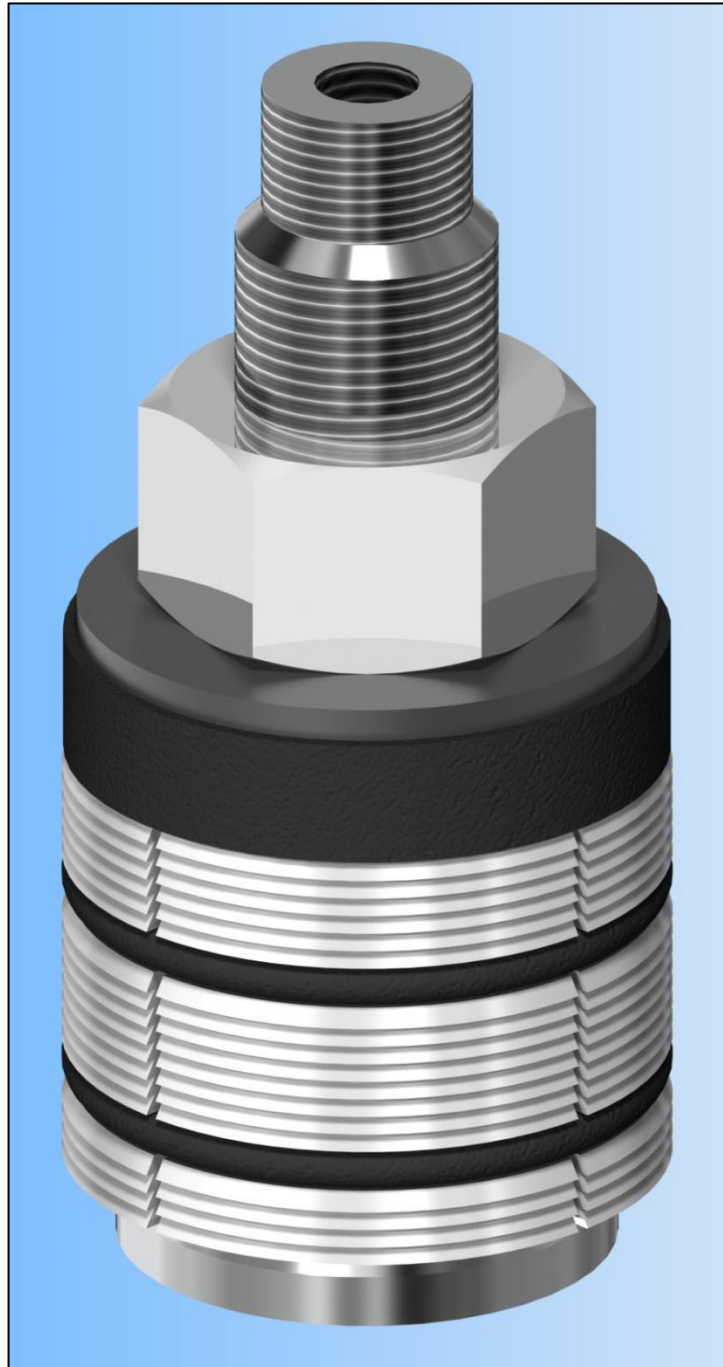


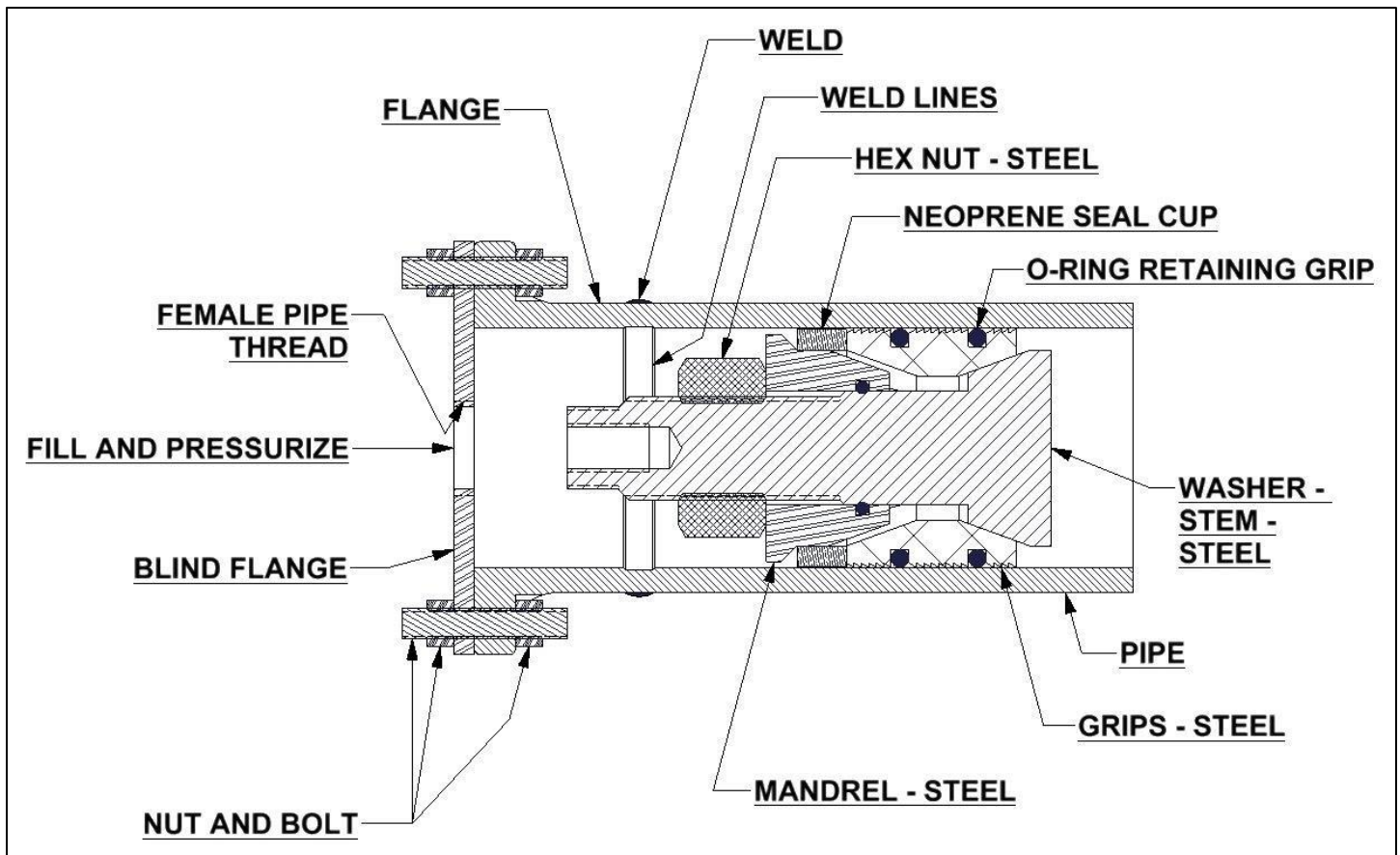
REVERSE PRESSURE PLUG



THAXTON

A DIVISION OF HY-TECH MACHINE, INC.

REVERSE PRESSURE PLUG

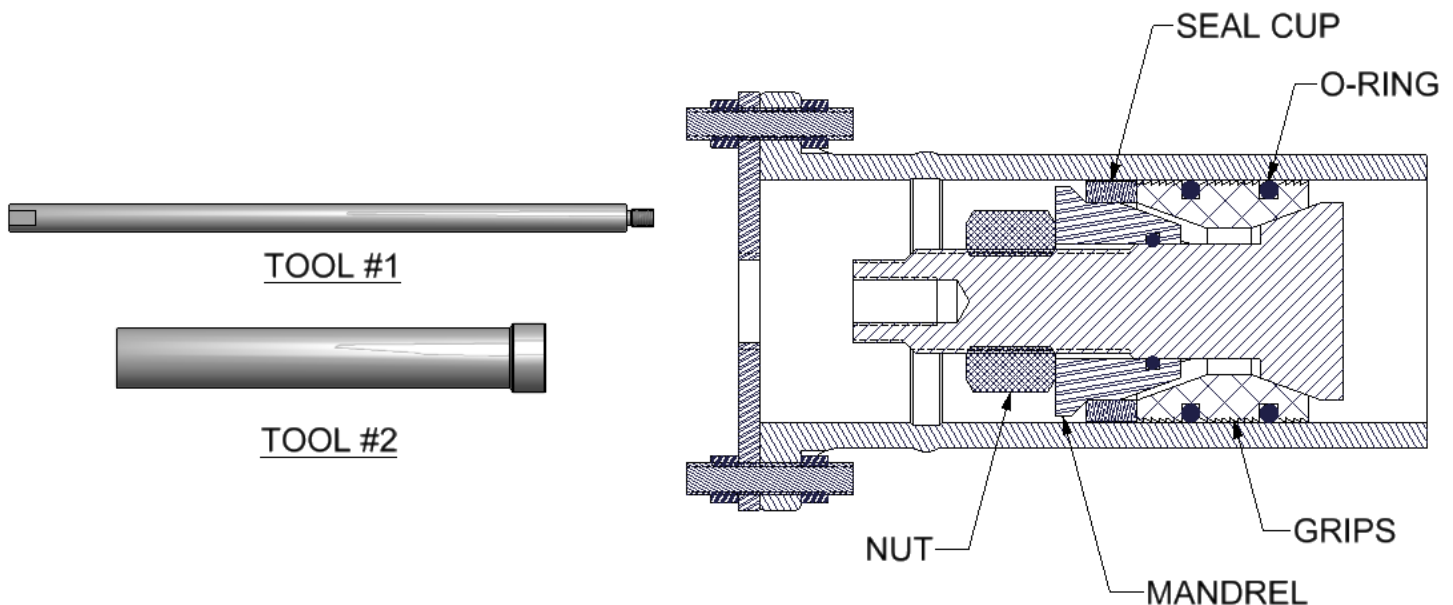


- Permits testing on short sections of welded pipe . . . on individual flange welds and nozzles on pressure vessels.
- No need to fill long sections of pipe with water to hydrostatic test a particular weld or segment of pipe.
- Reverse plugs have a solid stem and are held in place by hardened steel reverse grips.
- Seal is made with a Neoprene ring.
- Steel parts are case hardened and plated.
- Stem of each plug has an internal left hand thread to accommodate installation tools.
(See installation instructions)

Thaxton Standard Pipe Stoppers are factory tested up to 3,000 PSI, depending on size. Special sizes and higher pressures can be supplied per customer requirements. Thaxton stoppers are held in place by steel grips holding against the inside wall of the pipe when the nut is tightened . . . at the same time, a neoprene seal cup is compressed which ensures a tight seal. New neoprene seal cup and o-ring kit can be purchased directly from the factory. This prolongs the useful life of a Thaxton Pipe Stopper almost indefinitely. Visit our website at www.thaxtonplugs.com or call toll free (1-800-331-3827) for product and ordering information.

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THAXTON REVERSE PRESSURE PLUG INSTALLATION INSTRUCTIONS



A SPECIAL WORD OF CAUTION:

THAXTON, DIVISION OF HY-TECH MACHINE, INC. ENGINEERS AND MANUFACTURES A SUPERIOR HIGH PRESSURE TEST PLUG. HOWEVER, PRESSURE TESTING CAN BE AN EXTREMELY HAZARDOUS OPERATION AND SAFETY PRECAUTIONS SHOULD BE STRICTLY ADHERED TO. ALL CONNECTIONS, VALVES, FLANGES AND OTHER FITTINGS SHOULD BE CHECKED FOR SUITABILITY TO TEST PRESSURE. *-MOST IMPORTANTLY- NEVER STAND IN FRONT OF ANY TEST PLUG OR OTHER ENCLOSURE WHILE TEST IS IN PROGRESS. IF PLUG DISCHARGES DURING A TEST, SERIOUS INJURY OR DEATH COULD OCCUR.*

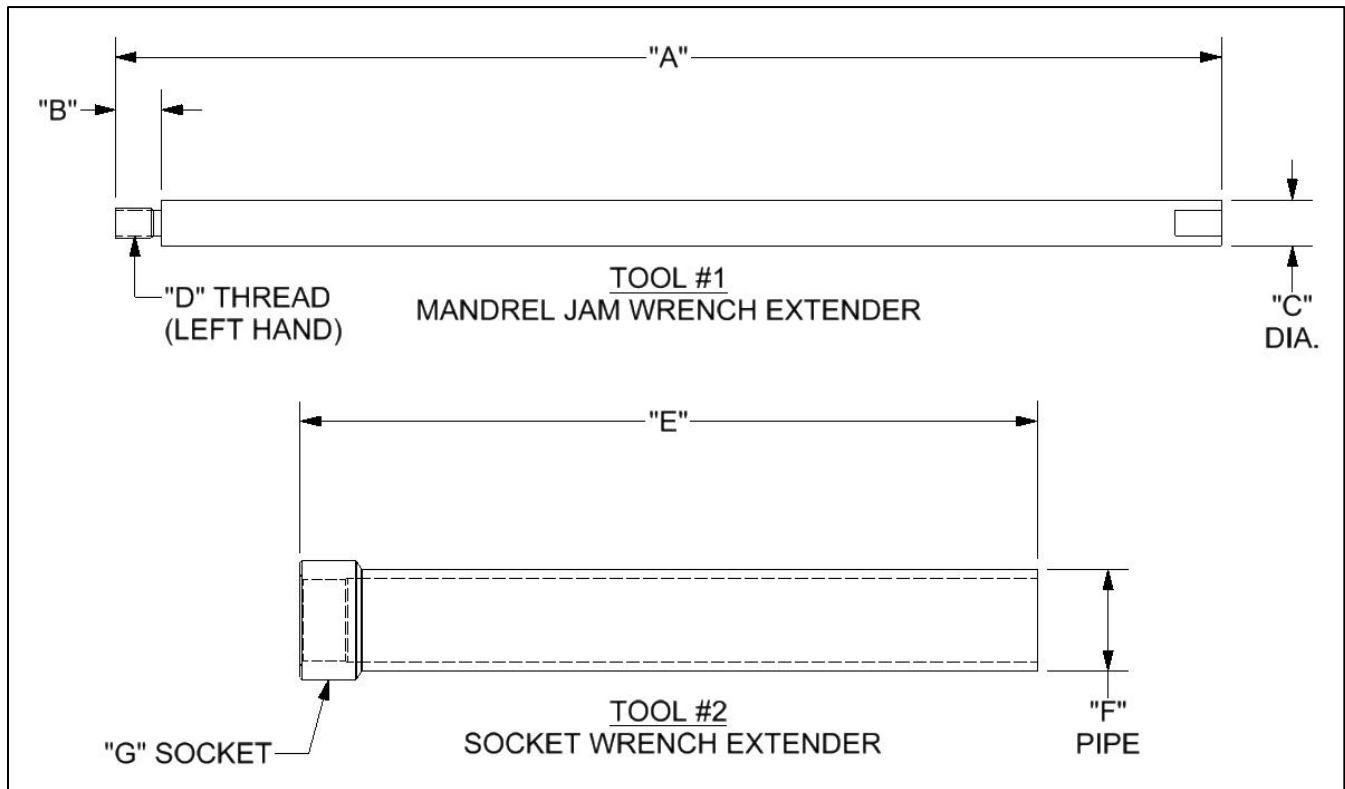
INSTALLATION:

- 1) REMOVE ANY ACCUMULATED DIRT, RUST PARTICLE, SCALE, ETC. FROM INSIDE OF PIPE END. SPECIAL CLEANING OF PIPE IS NOT NECESSARY.
- 2) REMOVE BURRS OR SHARP EDGES THAT COULD DAMAGE THE SEAL CUP OR INTERFERE WITH THE PROPER OPERATION OF THE STOPPER.
- 3) USING TOOL #1 (LEFT HAND THREAD, SEE DIAGRAM) INSERT STOPPER PAST THE WELD TO BE TESTED.
- 4) SLIDE TOOL #2 OVER TOOL #1 AND USE TO TIGHTEN HEX NUT COMPLETELY. THIS WILL EXPAND GRIPS AND FORM SEAL.
- 5) REMOVE TOOL #1 AND #2. INSTALL LEFT HAND THREADED ANCHOR SHACKLE. USING CHAIN OR CABLE, CONNECT STOPPER TO HOOK IF USED ON OUTER EDGE OF BLIND FLANGE.
- 6) INSTALL BLIND FLANGE.
- 7) FILL PIPE WITH WATER AND VENT ANY REMAINING AIR.
- 8) BEGIN TESTING BY SLOWLY INCREASING PRESSURE INTO PIPE.

REMOVAL:

- 1) SHUT OFF THE PRESSURE SOURCE.
- 2) **SLOWLY** RELEASE STORED PRESSURE.
- 3) COMPLETELY DRAIN THE PIPE ASSEMBLY BY LOOSENING BLIND FLANGE.
- 4) REMOVE BLIND FLANGE AND DISCONNECT CHAIN.
- 5) REMOVE ANCHOR SHACKLE FROM STOPPER.
- 6) INSTALL BOTH TOOL #1 AND TOOL #2. USE TOOL #2 TO LOOSEN THE HEX NUT. USE TOOL #1 TO SLIDE STOPPER OUT OF PIPE.
- 7) DRY AND CLEAN PIPE STOPPER BEFORE STORAGE.

INSTALLATION TOOLS FOR REVERSE PRESSURE PLUG



SIZE	PART # (SET)	"A"	"B"	"C"	"D" (L.H)	"E"	"F"	"G" HEX
1-1/4"	IT-RP-1.25	12"	3/4"	1/2"	3/8-16 LHNC	8"	3/4" SCH. 80	15/16"
1-1/2"	IT-RP-1.5	12"	3/4"	1/2"	3/8-16 LHNC	8"	3/4" SCH. 80	15/16"
2"	IT-RP-2	18"	3/4"	3/4"	1/2-13 LHNC	12"	1-1/4" XX	1-5/16"
2-1/2"	IT-RP-2.5	18"	3/4"	3/4"	1/2-13 LHNC	12"	1-1/4" XX	1-1/2"
3"	IT-RP-3	18"	3/4"	3/4"	1/2-13 LHNC	12"	1-1/2" XX	1-7/8"
4"-10"	IT-RP-4	18"	3/4"	1"	3/4-16 LHNF	12"	2-1/2" XX	2-1/4"
12"-20"	IT-RP-12	18"	3/4"	1"	3/4-16 LHNF	12"	3" XX	3"

HOW TO USE

- 1) Use Tool #1 to locate the reverse pressure stopper inside the pipe and beyond the weld to be tested. The left hand thread on the #1 Tool screws into the tapped hole in the mandrel.
- 2) Insert Tool #2. (the socket fits over the hex nut on the stem) Make sure the stopper is sitting square in the pipe and then tighten the hex nut in order to expand the plug and make the seal.
- 3) If high pressure, use chain or wire rope to fasten plug to blind flange to avoid blowing downstream.
- 4) After testing, reverse procedure.



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