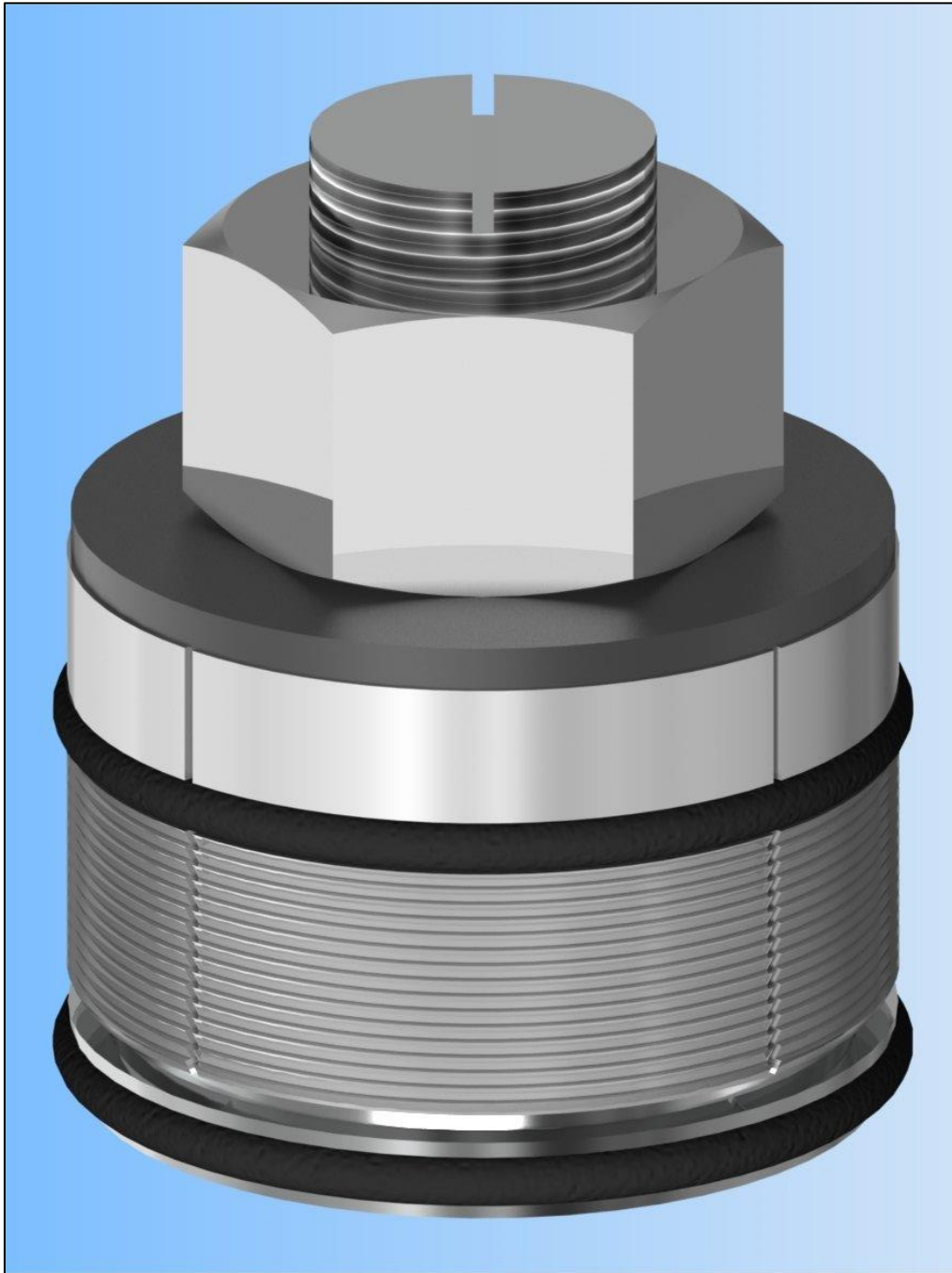


# SOCKET WELD PLUG

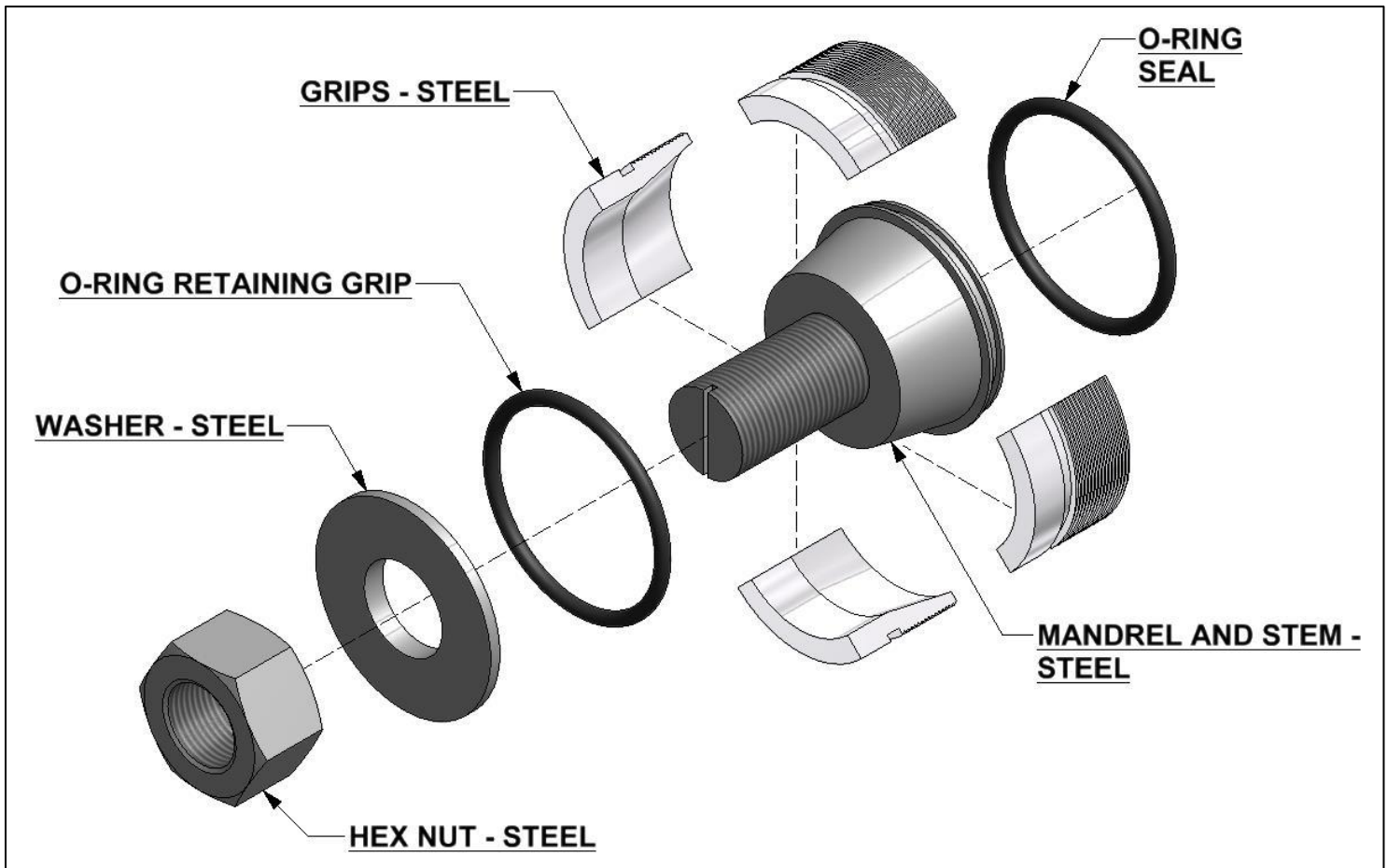


SIZES: 1/2" – 2"

**THAXTON**

A DIVISION OF HY-TECH MACHINE, INC.

# SOCKET WELD PLUG



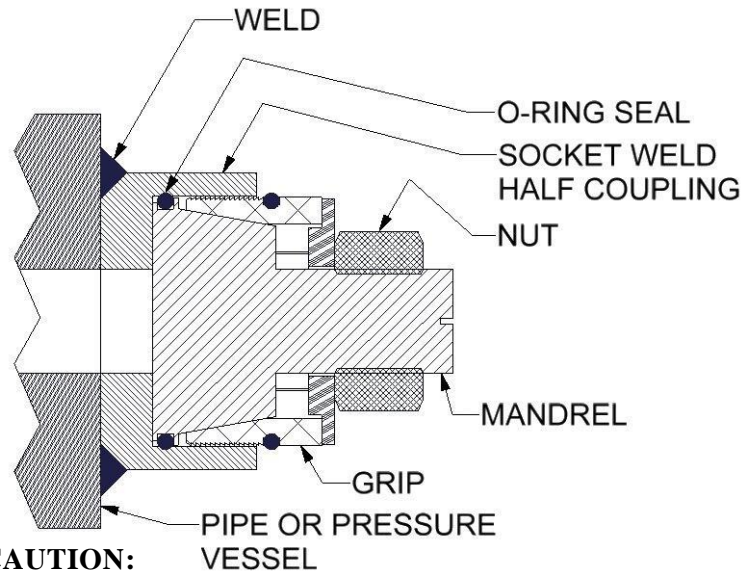
## **Steel, Zinc Plated, Pre-Tested**

- Standard Sizes 1/2", 3/4", 1", 1-1/4", 1-1/2", 2" (special sizes available on request.)
- Made to fit specific inside diameters with tolerances of plus or minus 0.005"
- Standard Socket Weld Plugs have a solid stem (no vent)
- The Socket Weld Plug, shown above, eliminates the need for welding plugs or nipples onto standard socket weld openings in order to conduct pressure tests.
- Socket Weld Plugs can also be furnished with a filling or venting connection similar to the type "C" stopper.

Thaxton Standard Pipe Stoppers are factory tested up to 1,500 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. (new o-ring 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](http://www.thaxtonplugs.com) or call toll free (1-800-331-3827) for product and ordering information.



# **THAXTON SOCKET WELD 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. IF AIR OR COMPRESSED GAS IS USED AS A TEST MEDIUM, A SAFETY GAG AND BARRIER SHOULD BE INSTALLED TO PREVENT ACCIDENTAL DISCHARGE OF PLUG. **-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.**

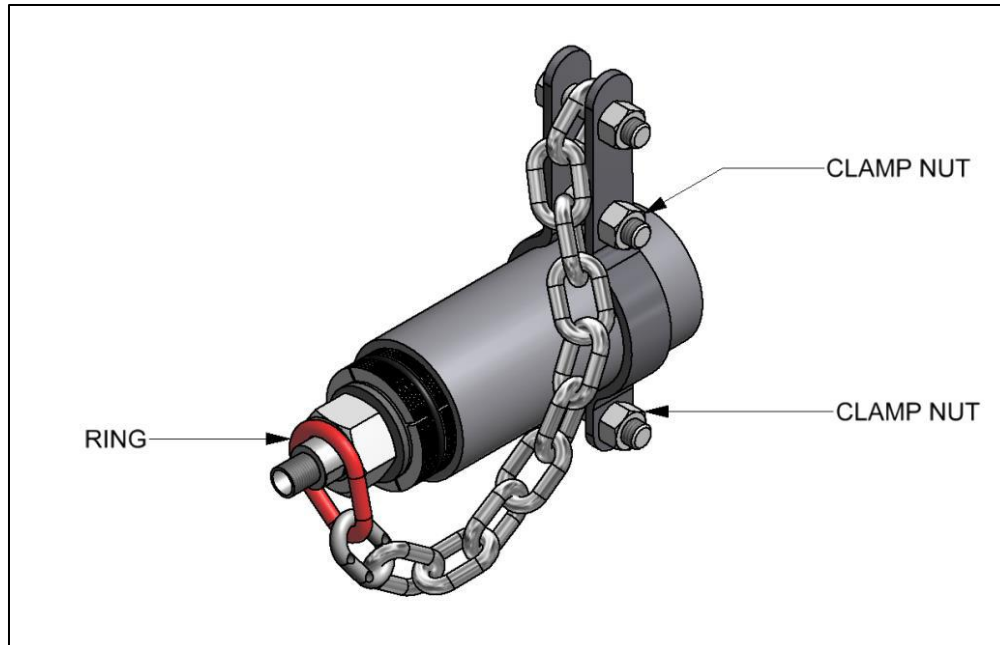
## **INSTALLATION:**

- 1) REMOVE ANY ACCUMULATED DIRT, RUST PARTICLE, SCALE, ETC. FROM INSIDE OF SOCKET. SPECIAL CLEANING OF FITTING IS NOT NECESSARY.
- 2) REMOVE BURRS OR SHARP EDGES THAT COULD DAMAGE THE O-RING SEAL OR INTERFERE WITH THE PROPER OPERATION OF THE STOPPER.
- 3) APPLY A SMALL AMOUNT OF LUBRICATION OR LIGHT GREASE TO THE O-RING SEAL TO EASE THE INSTALLATION.
- 4) HOLDING STOPPER AT SLIGHT ANGLE, INSERT AS FAR AS POSSIBLE INTO SOCKET WELD FITTING. STOPPER SHOULD REST AGAINST THE SOCKET WELD.
- 5) TIGHTEN HEX NUT UNTIL GRIP SEGMENTS ARE FIRMLY SEATED.
- 6) INSTALL SAFETY GAG. [SEE INSTRUCTIONS ON REVERSE]
- 7) FILL PIPE WITH WATER AND VENT ANY REMAINING AIR. THIS CAN BE ACCOMPLISHED BY ELEVATING THE VENT END SLIGHTLY. IF PLUG IS SOLID, OTHER STEPS WILL BE NEEDED TO VENT AIR. [CALL THAXTON] WATER SHOULD RUN IN A STEADY STREAM WITHOUT BUBBLING. **ALL AIR MUST BE VENTED BEFORE PRESSURIZATION!**
- 8) CLOSE ALL VALVES, PORTS, VENTS, ETC.
- 9) BEGIN TESTING BY SLOWLY INCREASING PRESSURE INTO PIPE.
- 10) BEING CAREFUL NOT TO STAND IN FRONT OF PLUG, ***RETIGHTEN THE HEX NUT WHILE INCREASING PRESSURE.***

## **REMOVAL:**

- 1) SHUT OFF THE PRESSURE SOURCE.
- 2) **SLOWLY** OPEN VALVE TO RELEASE STORED PRESSURE. RAPID RELEASE OF PRESSURE COULD CAUSE PLUG TO ACCIDENTLY DISCHARGE.
- 3) COMPLETELY DRAIN THE PIPE ASSEMBLY.
- 4) LOOSEN HEX NUT ONE OR TWO TURNS.
- 5) USING A RUBBER Mallet, TAP THE MANDREL FORWARD AND THE HEX NUT ON EACH SIDE. THIS WILL RELEASE THE GRIPS.
- 6) SLIDE STOPPER OUT OF PIPE.

# SAFETY GAG INSTALLATION INSTRUCTIONS



WHEN PROPERLY INSTALLED, ACCORDING TO OUR INSTRUCTIONS, THE **THAXTON PIPE STOPPER** IS A SAFE TOOL THAT WILL GIVE MANY YEARS OF SATISFACTORY SERVICE. HOWEVER, AS AN EXTRA SAFETY FACTOR, WE RECOMMEND USE OF A SAFTEY GAG. IT SHOULD BE INSTALLED AFTER THE PLUG IS IN PLACE AND BEFORE PRESSURE IS ADDED.

- 1) LOOSEN CLAMP NUTS ON SAFETY GAG AND SLIDE THE UNIT OVER THE END OF THE PIPE.
- 2) PLACE RING OVER THE END OF THE STOPPER, MAKING SURE THAT IT IS RESTING AGAINST THE STOPPER.
- 3) SLIDE CLAMP BACK UNTIL THE CHAIN IS SLIGHTLY TIGHT, LEAVING ROOM TO RETIGHTEN STOPPER HEX NUT.
- 4) TIGHTEN CLAMP NUTS SO THE SAFETY GAG WILL NOT MOVE.
- 5) PROCEED WITH PLUG INSTALLATION INSTRUCTIONS.



*A DIVISION OF HY-TECH MACHINE, INC.*

25 Leonberg Road  
Cranberry Township, PA 16066  
1-800-331-3827  
FAX: (724) 776-6811  
[www.thaxtonplugs.com](http://www.thaxtonplugs.com)  
Email: [info@hy-techinc.com](mailto:info@hy-techinc.com)