

OPERATING PROCEDURE FOR SHORT VIBRA-PROOF PLUGS

WARNING!

- **ALL WARNING STATEMENTS MUST BE CAREFULLY OBSERVED TO HELP PROTECT AGAINST INJURY AND DAMAGE TO PERSONS AND PROPERTY.**
- **WHEN SYSTEM IS UNDER PRESSURE DO NOT, UNDER ANY CIRCUMSTANCES ATTEMPT TO ADJUST, MOVE, OR CHANGE THE TEST PLUG IN ANY WAY, SHAPE, OR FORM.**
- **DO NOT EXCEED THE MAXIMUM TEST PRESSURES LISTED IN TABLE 1.**

INSTALLATION PROCEDURE:

1. Prepare the tube end. Vibra-Proof plugs are to be installed in a clean, dry pipe end. Any scale or moisture present may interfere with the sealing of the plug and may reduce the pressure that the plug will be capable of holding.
2. Install the correct size Vibra-Proof plug into the end of pipe being sealed.
3. Insert the Vibra-Proof plug into pipe end and tighten compression hex nut until plug is finger-tight. Then using a calibrated torque wrench, continue tightening the compression nut to prescribed installation torques as indicated in Table 1.
4. Begin testing or in-service operation.

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5. To remove, loosen nut and withdraw from pipe.
6. Inspect the plug for wear and replace any worn components. Any component that is worn or damaged, must be replaced before attempting to use the plug. Contact the factory for information on replacement of worn or damaged parts.

TABLE 1.

PART NUMBER	PIPE SIZE	PLUG RANGE	INSTALLATION TORQUE FT-LBS (KG-M)	ROTATE NUT THIS NUMBER OF TURNS AFTER SEAL CONTACTS PIPE I.D.	MAXIMUM OPERATING PRESSURE P.S.I. (BAR)
SVPC-0075-M	3/4"	.73 - .82	2 ft-lbs (.3 kg-m)	3	100 p.s.i. (6.9 bar)
SVPC-0100-M	1"	.93 - 1.05	10 ft-lbs (1.4 kg-m)	4	100 p.s.i. (6.9 bar)
SVPC-0125-M	1-1/4"	1.13 - 1.38	10 ft-lbs (1.4 kg-m)	4	100 p.s.i. (6.9 bar)
SVPC-0150-M	1-1/2"	1.33 - 1.61	10 ft-lbs (1.4 kg-m)	1-1/2	100 p.s.i. (6.9 bar)
SVPC-0200-M	2"	1.73 - 2.07	15 ft-lbs (2.0 kg-m)	3-1/2	75 p.s.i. (5.2 bar)
SVPC-0250-M	2-1/2"	2.13 - 2.47	15 ft-lbs (2.0 kg-m)	3	50 p.s.i. (3.5 bar)
SVPC-0300-M	3"	2.73 - 3.07	15 ft-lbs (2.0 kg-m)	3	50 p.s.i. (3.5 bar)

Specifications subject to change without notice.

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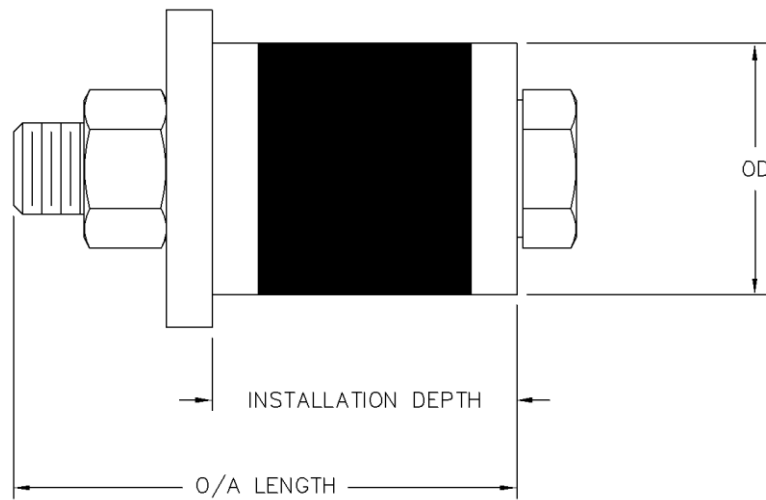


Table 2. Short Vibra-Proof Technical Specifications

PART NUMBER	PIPE SIZE	PLUG RANGE	OD	INSTALLATION DEPTH	O/A LENGTH
SVPC-0075-M	3/4"	.73 - .82	.70	1-1/4	2"
SVPC-0100-M	1"	.93 - 1.05	.90	1-1/4	2-1/4
SVPC-0125-M	1-1/4"	1.13 - 1.38	1.10	1-3/8	2-1/4
SVPC-0150-M	1-1/2"	1.33 - 1.61	1.30	1-5/8	2-1/2
SVPC-0200-M	2"	1.73 - 2.07	1.70	1-5/8	2-1/2
SVPC-0250-M	2-1/2"	2.13 - 2.47	2.10	2-1/4	3-1/2
SVPC-0300-M	3"	2.73 - 3.07	2.70	2-1/2	3-1/2

QUESTIONS? Contact EST Group Customer Service at any of the following locations with questions:

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- On the Internet: <http://estgroup.cwfc.com>

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