

## HIGH LIFT UPGRADE RETROFIT INSTRUCTIONS FOR FLANGE TEST & FLANGE WELD PLUGS

This Instruction outlines how to retrofit High Lift Seals onto Flange Test and Flange Weld Plugs. The seal retrofit strictly increases the clearance between the plug and the pipe, it is not intended to change or modify the intended use of the Flange Test or Flange Weld Plug. Refer to DC2678 High Lift Flange Test Plug/Weld Plug Operating Procedures when using the upgraded product.

**Table 1. Maximum Pressure Ratings for Upgraded Flange Test & Flange Weld Plugs**

Class	Maximum Test Pressure
150 lb.	450psi (31 Bar)
300 lb.	1125psi (77 Bar)
600 lb.	1125psi (77 Bar)

### 3/4" – 1" PLUG SIZES, HIGH LIFT SEAL AND WASHER UPGRADE

1. Remove Jamnuts, seal and washers from bottom of shaft.
2. Install one washer, urethane seal, second washer and Jamnuts onto shaft threads, threading on as far as possible. Wrench tighten Jamnuts together.

### 1-1/4" – 2" PLUG SIZES, HIGH LIFT SEAL AND WASHER UPGRADE

1. Remove Jamnuts, seal and washers from bottom of shaft.
2. Lubricate the o-ring in ID of the new washer.
3. Carefully install the washer with internal o-ring onto the shaft.
4. Install the urethane seal, washer and Jamnuts onto shaft threads, threading on as far as possible. Wrench tighten Jamnuts together.

### 2-1/2" – 3" PLUG SIZES, HIGH LIFT SEAL AND WASHER UPGRADE

1. Remove Jamnuts, seal and washers from bottom of shaft.
2. Install the 1" long compression tube, provided with upgrade kit, onto the shaft.
3. Lubricate the o-ring in ID of the new washer.
4. Carefully install the washer with internal o-ring onto the shaft.
5. Install the urethane seal, washer and Jamnuts onto shaft threads, threading on as far as possible. Wrench tighten Jamnuts together.

### 4" PLUG SIZE, HIGH LIFT SEAL AND WASHER UPGRADE

1. Remove Jamnuts, seal and washers from bottom of shaft.
2. Install the 1" long compression tube, provided with upgrade kit, onto the shaft.
3. Lubricate the o-ring in ID of the new tapered washer.
4. Carefully install the tapered washer with internal o-ring onto the shaft so that tapered side will be positioned against the seal.
5. Install the urethane seal, tapered washer so that tapered side will be positioned against the seal and Jamnuts onto shaft threads, threading on as far as possible. Wrench tighten Jamnuts together.

### 6"-8" PLUG SIZES, HIGH LIFT SEAL AND WASHER UPGRADE

1. Remove Jamnuts, seal and washers from bottom of shaft.
2. Lubricate the o-ring in ID of the new tapered washer.
3. Carefully install the tapered washer with internal o-ring onto the shaft so that tapered side will be positioned against the seal.
4. Install the urethane seal, tapered washer so that tapered side will be positioned against the seal and Jamnuts onto shaft threads, threading on as far as possible. Wrench tighten Jamnuts together.

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

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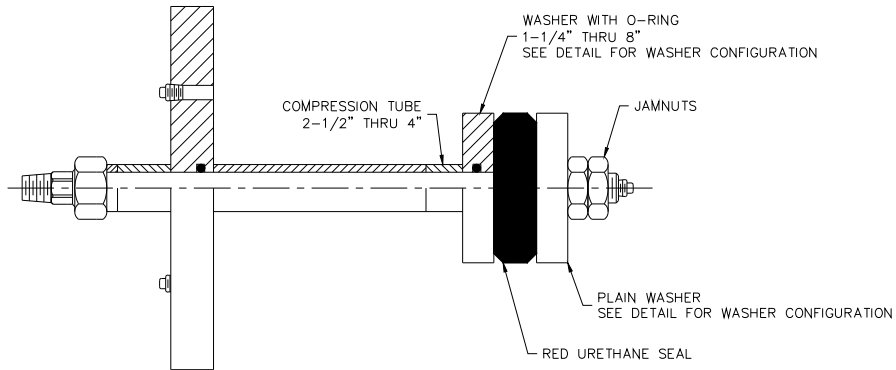


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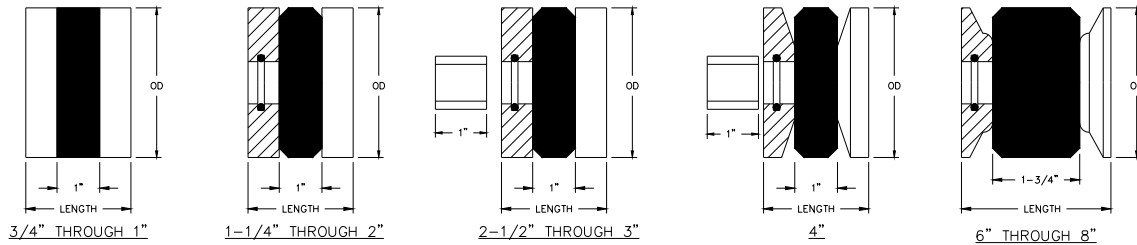
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**Figure 1. Flange Weld Test Plug and High Lift Seal and Washer Sets**



HIGH LIFT FLANGE TEST/WELD PLUG UPGRADE



**Table 1. High Lift Seal and Washer Upgrade Part Numbers**

UPGRADE KIT PART NUMBER	FLANGE SIZE	FLANGE CLASS	PIPE SCHEDULE	OD	LENGTH
HL-75P80-UG	3/4	150#	80	.67	1-1/4
HL-75P40-UG	3/4	300#	40	.75	1-1/4
HL-1P80-UG	1"	600#	80	.85	1-1/4
HL-1P40-UG	1"		40	.94	1-1/4
HL-125P80-UG	1-1/4		80	1.15	1-5/8
HL-125P40-UG	1-1/4		40	1.25	1-5/8
HL-15P80-UG	1-1/2		80	1.33	1-3/4
HL-15P40-UG	1-1/2		40	1.44	1-3/4
HL-2P80-UG	2"		80	1.69	1-3/4
HL-2P40-UG	2"		40	1.82	1-3/4
HL-25P80-UG	2-1/2		80	2.07	2"
HL-25P40-UG	2-1/2		40	2.22	2"
HL-3P80-UG	3"		80	2.52	2"
HL-3P40-UG	3"		40	2.69	2"
HL-4P80-UG	4"		80	3.39	2"
HL-4P40-UG	4"		40	3.59	2"
HL-6P80-UG	6"		80	5.26	3-3/4
HL-6P40-UG	6"		40	5.57	3-3/4
HL-8P80-UG	8"		80	7.13	4"
HL-8P40-UG	8"		40	7.48	4



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