



ALH SYSTEMS LTD

2½"-6" NON-TAP PLUG OPERATING MANUAL & PARTS LIST

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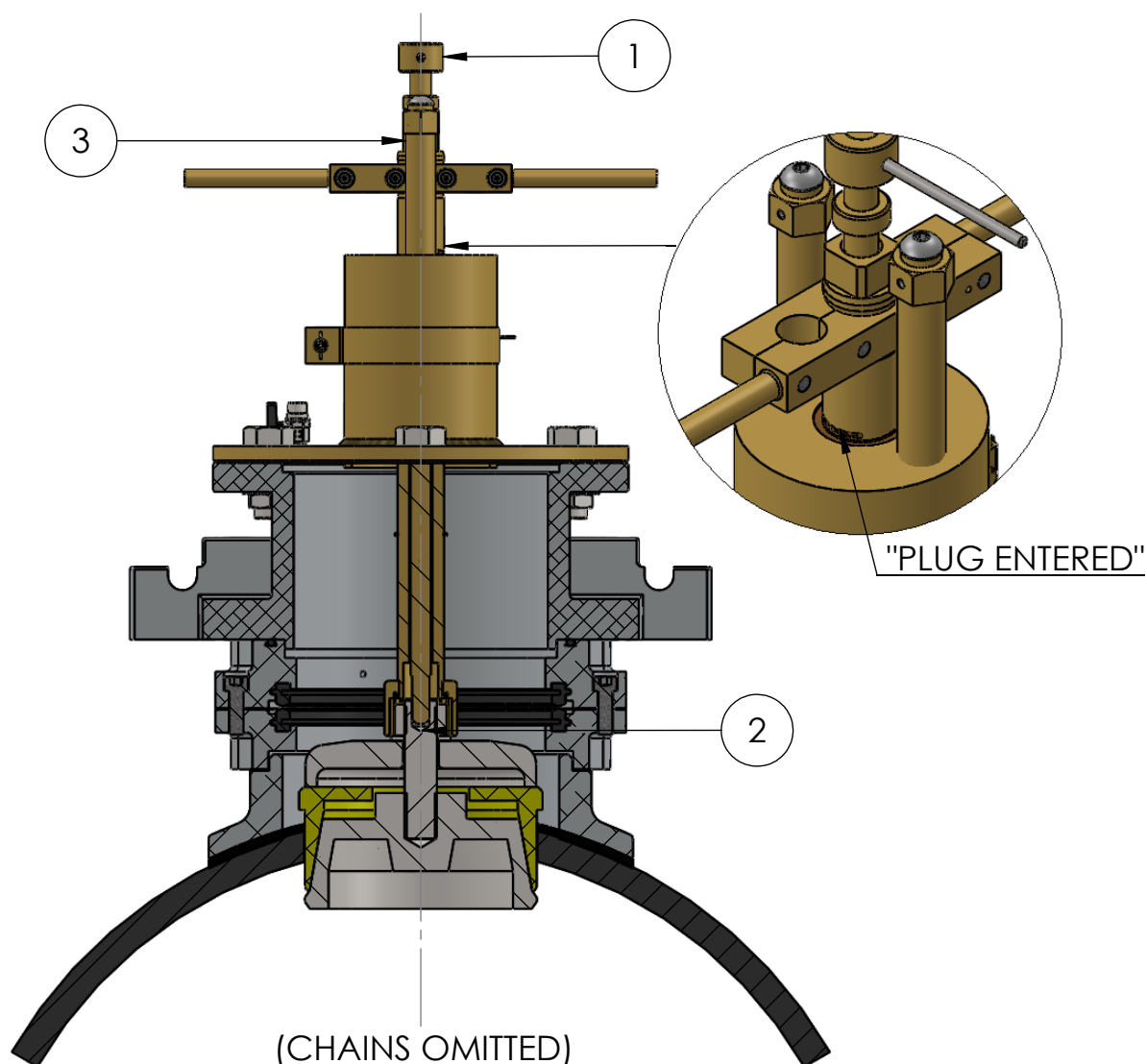


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INSERTION - STEP 1



1. SCREW RETAINING SCREW (1) INTO STUD (2)
2. WITH JACKING SCREW (3) IN CENTRELINE OF PIPE AXIS, BOLT PLUG CARRIER ASSEMBLY ONTO VALVE.
3. OPEN VALVE GATE AND LOWER PLUG INTO PIPE, UNTIL "PLUG ENTERED" MARK FLUSH WITH TOP FACE OF CARRIER BODY.

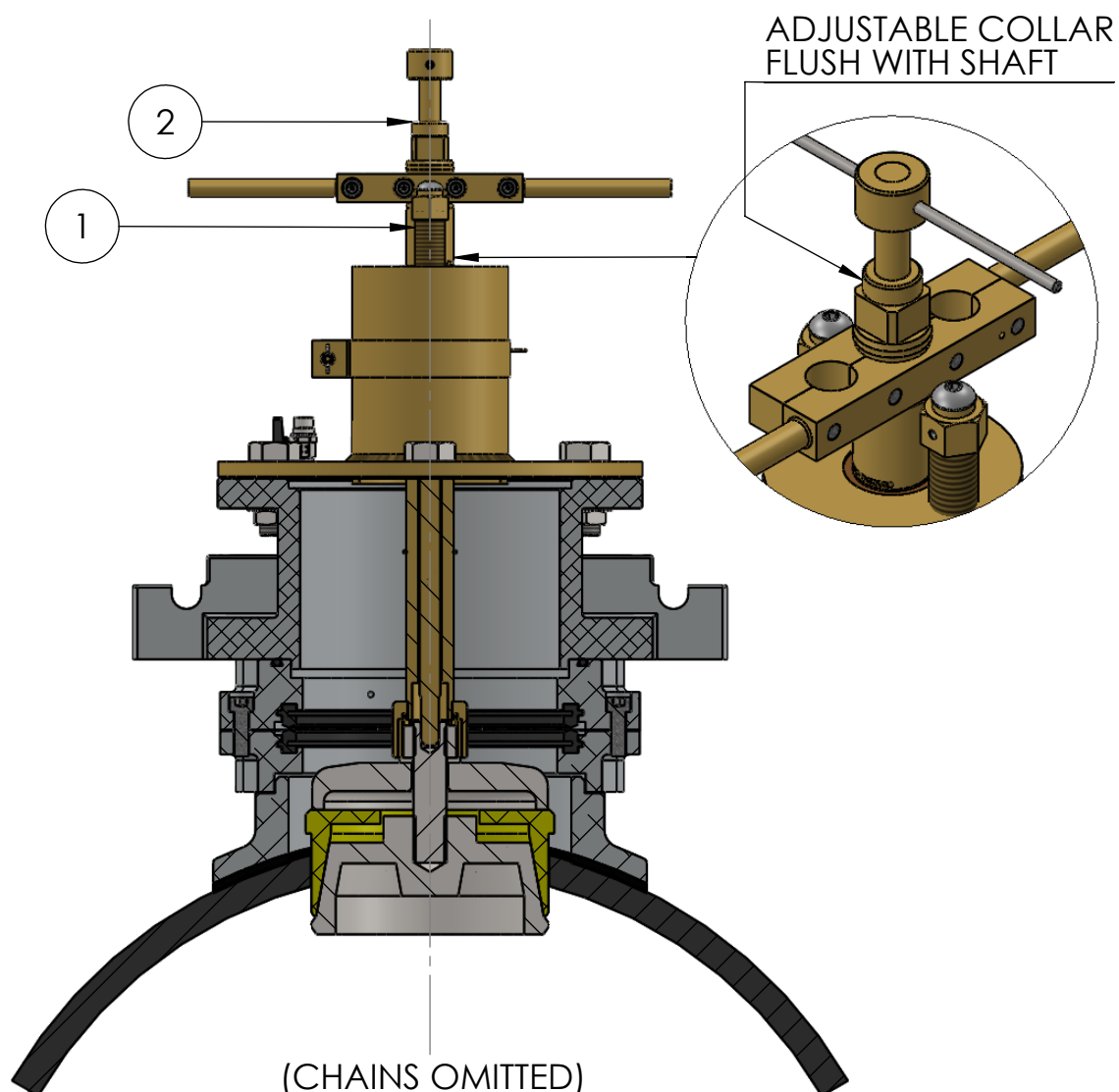


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STEP 2



1. SCREW DOWN JACKING SCREWS (1) SO THEY ARE TIGHT
2. SET ADJUSTABLE COLLAR (2) FLUSH WITH TOP FACE OF OPERATING SHAFT

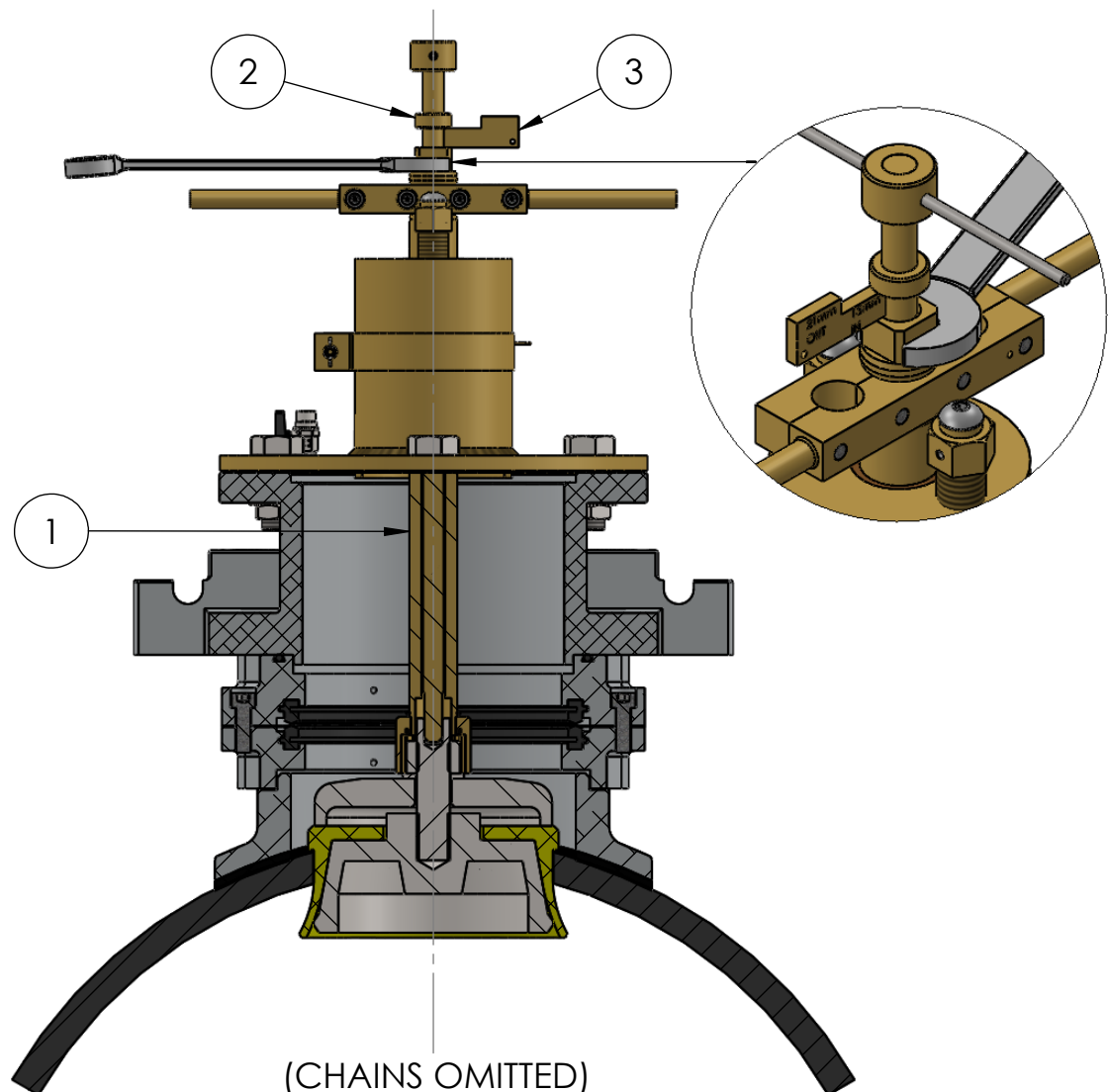


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STEP 3



1. ROTATE OPERATING SHAFT (1) CLOCKWISE UNTIL ADJUSTABLE COLLAR (2) ALLOWS "IN" SETTING GAUGE (3) TO FIT.
NOTE - TAKE CARE NOT TO DISTURB ADJUSTABLE COLLAR WITH SPANNER
2. CHECK SEAL BY OPERATING PRESSURE RELEASE VALVE
3. UNSCREW RETAINING SCREW, UNBOLT AND REMOVE PLUG CARRIER
4. IF NO FURTHER WORK IS REQUIRED ON MAIN, REMOVE VALVE AND SADDLE.
5. CHECK AROUND PLUG WITH LEAK DETECTING FLUID
6. WRAP PLUG STUD AND CAP WITH ANTI CORROSION TAPE IF NEEDED

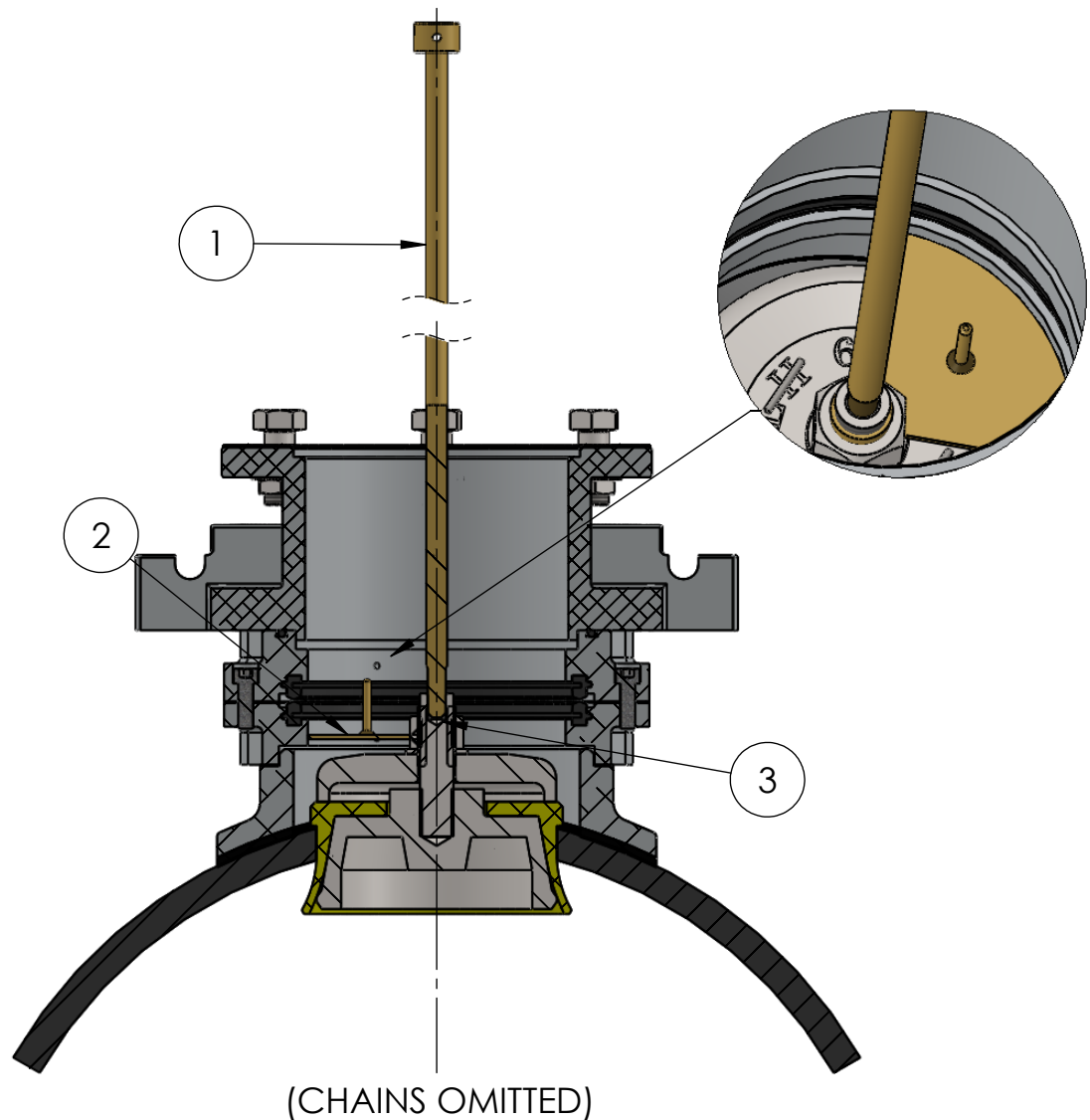


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REMOVAL - STEP 1



1. WITHDRAW RETAINING SCREW (1) FROM TOOL AND SLIDE ON CENTRING GAUGE (2)
2. SCREW RETAINING SCREW (1) INTO PLUG STUD (3)
3. ALIGN VALVE SO GAUGE IS CENTRAL TO VALVE BORE WHEN ROTATED AT TOP AND BOTTOM OF SPINDLE
4. SECURE WITH CHAINS ONCE CENTRAL WITH PLUG THEN REMOVE RETAINING SPINDLE AND CENTRING GAUGE.

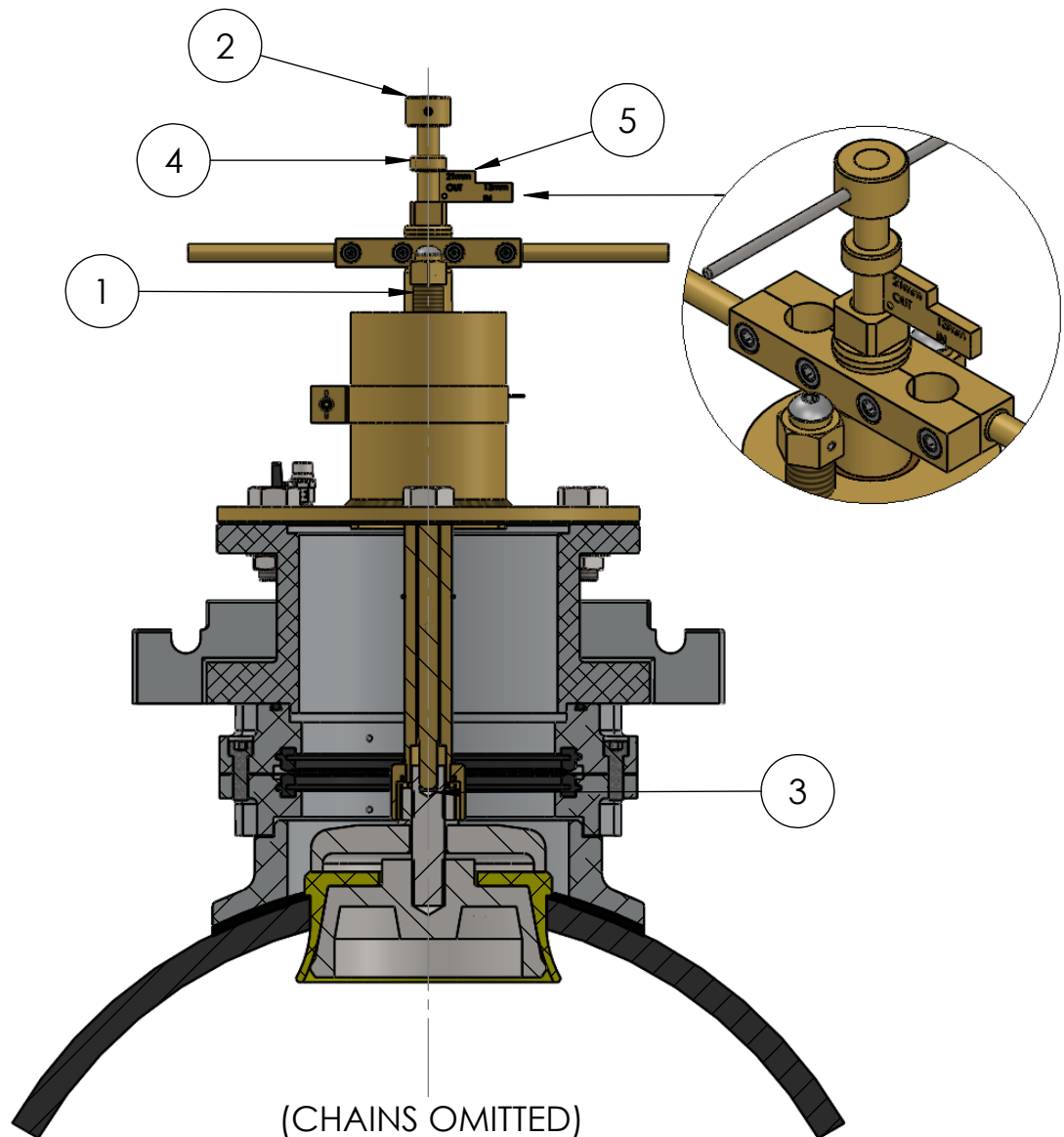


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STEP 2



1. WITH JACKING SCREW (1) IN CENTRE LINE OF PIPE AXIS, SCREW RETAINING SCREW (2) INTO PLUG STUD (3) AND BOLT PLUG CARRIER ASSEMBLY ON TO VALVE
2. SCREW DOWN JACKING SCREWS (1) FULLY
3. SET ADJUSTABLE COLLAR (4) TO "OUT" POSITION USING SETTING GAUGE (5)

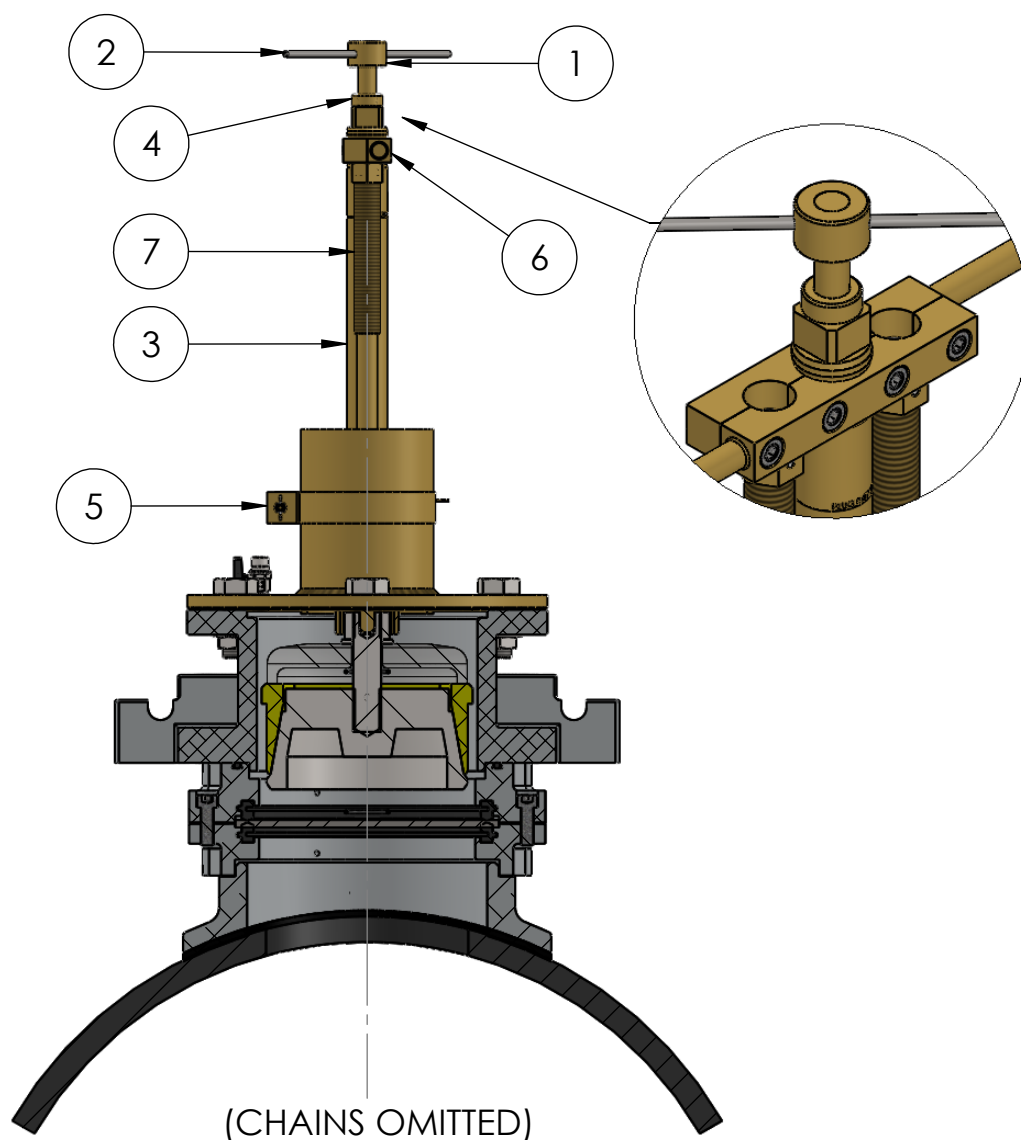


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STEP 3



1. HOLD RETAINING SCREW (1) STEADY WITH TOMMY BAR (2), ROTATE OPERATING SHAFT (3) ANTI-CLOCKWISE UNTIL IT MEETS ADJUSTABLE COLLAR (4). (NOTE - IF RETAINING SCREW HAS NOT MOVED DOWNWARDS AFTER 2-3 TURNS OF OPERATING SHAFT, TAP RETAINING SCREW WITH HAMMER TO BREAK SEAL)
2. ALIGN TRAILING EDGE OF ROTATION GUIDE (5) WITH RETAINING SCREW TOMMY BAR (2). ROTATE RETAINING SCREW (1) **CLOCKWISE** THROUGH 90° I.E. TOMMY BAR IN LINE WITH LEADING EDGE OF ROTATION GUIDE.
3. LIFT ROTATING HANDLE (6) AND LOCATE ON TOP OF JACKING SCREWS (7).
4. SCREW UP JACKING SCREWS (7) TO EXTRACT PLUG. WHEN THEY ARE FULLY UNSCREWED, LIFT PLUG VIA HANDLE (6) AND CLOSE VALVE GATE.
5. **DO NOT RE-USE PLUG GASKET.**

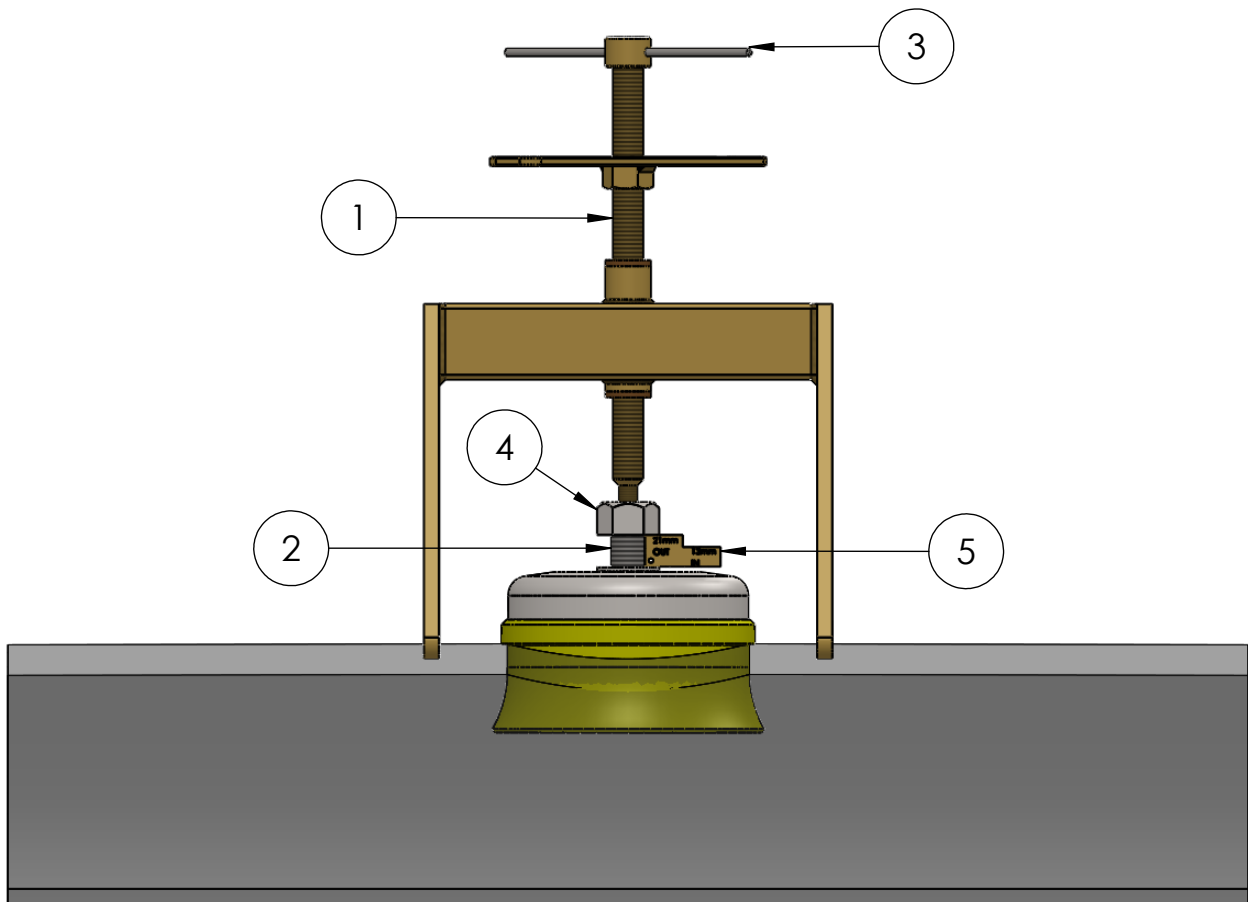


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REMOVING USING STRONGBACK -STEP 1



1. SCREW RETAINING SCREW (1) INTO PLUG STUD (2) USING TOMMY BAR (3)
2. USING A SPANNER UNSCREW PLUG NUT (4) TO "OUT" POSITION USING SETTING GAUGE (5).

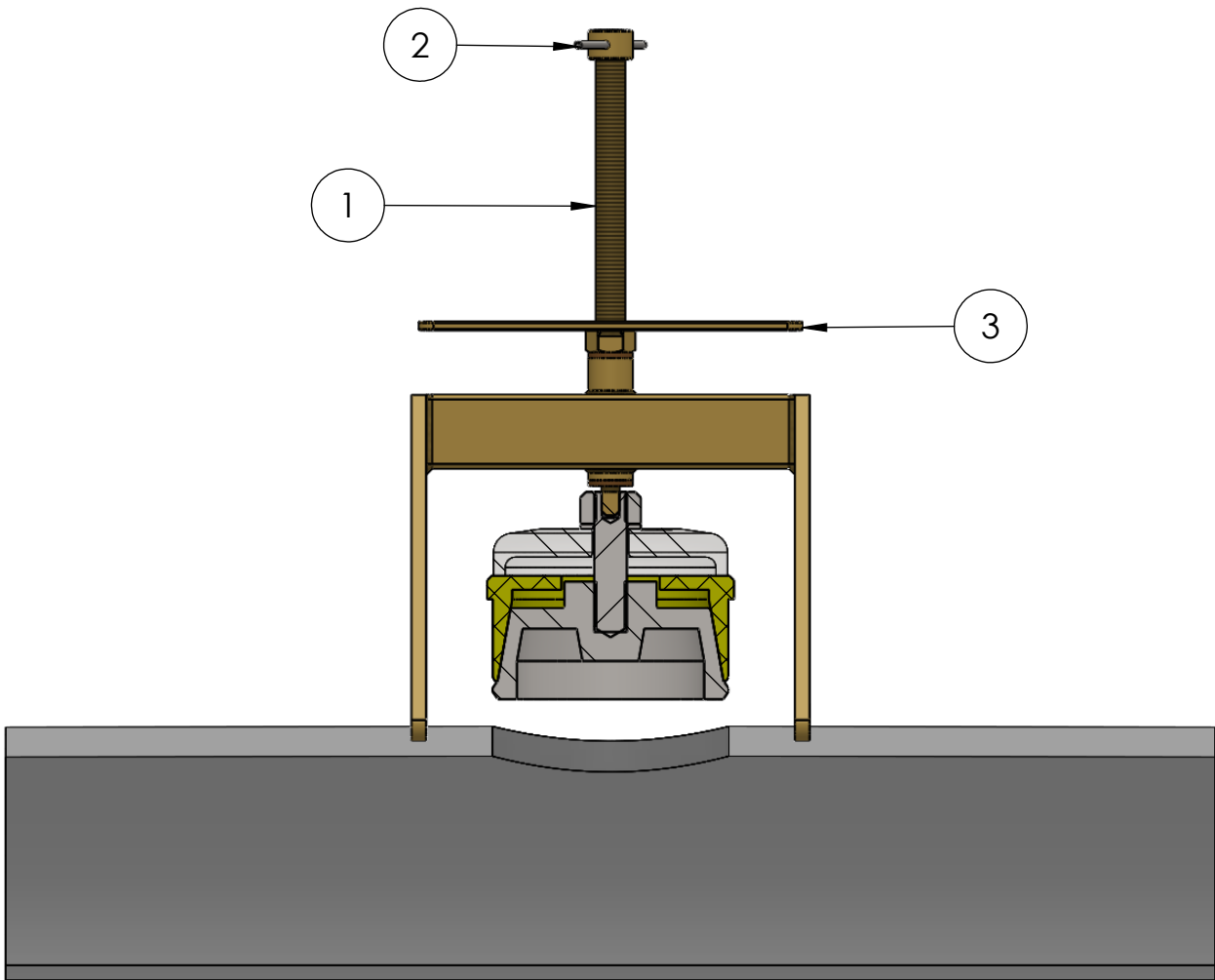


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REMOVAL USING STRONGBACK -STEP 2



1. IF RETAINING SCREW (1) HAS NOT MOVED DOWNWARDS TAP WITH HAMMER TO BREAK SEAL
2. ROTATE RETAINING SCREW TOMMY BAR (2) 90° CLOCKWISE
3. HOLD RETAINING SCREW STEADY WITH TOMMY BAR AND ROTATE WRENCH (3) DOWNWARDS TO BUSH THEN CONTINUE TO ROTATE WRENCH (3) TO EXTRACT PLUG
4. **DO NOT RE-USE PLUG GASKET**

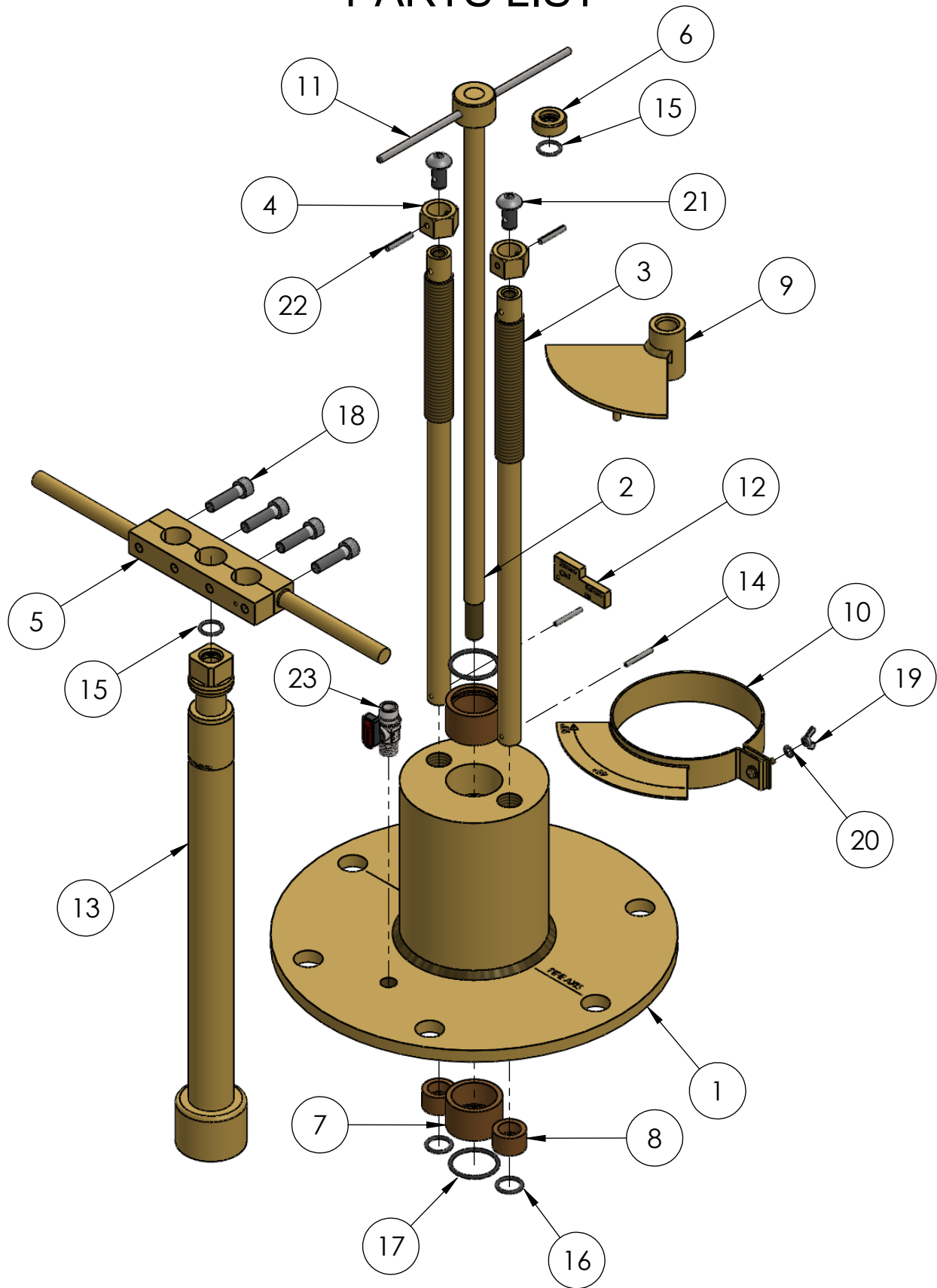


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NON-TAP PLUG TOOLING PARTS LIST



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NON-TAP PLUG TOOLING PARTS LIST

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	238-0001	COVER	1
2	238-0003	RETAINING SCREW	1
3	238-0004	JACKING SCREW	2
4	238-0005	JACKING SCREW NUT	2
5	238-0006	ROTATION HANDLE	1
6	238-0007	ADJUSTABLE COLLAR	1
7	238-0008	BUSH	2
8	238-0009	JACKING SCREW BUSH	2
9	238-0010	CENTRING GUIDE	1
10	238-0011	ROTATION GUIDE	1
11	238-0013	TOMMY BAR	1
12	238-0014	SETTING GAUGE	1
13	238-9001	OPERATING SHAFT	1
14	M1130	SELOC PIN	2
15	M1041	O RING	2
16	M1042	O RING	2
17	M1062RM	O RING	2
18	S0042	CAP HEAD BOLT	4
19	S0122	WING NUT	1
20	S0285	FLAT WASHER	1
21	S0009	BUTTON HEAD SCREW	2
22	M4810	SELOC PIN	2
23	M3098	BALL VALVE	1
24	M2291	SPANNER	1

PART NUMBER	DESCRIPTION
002-9002	2½" NTP
002-9003	3" NTP
002-9004	4" NTP
002-9005	5" NTP
002-9006	6" NTP

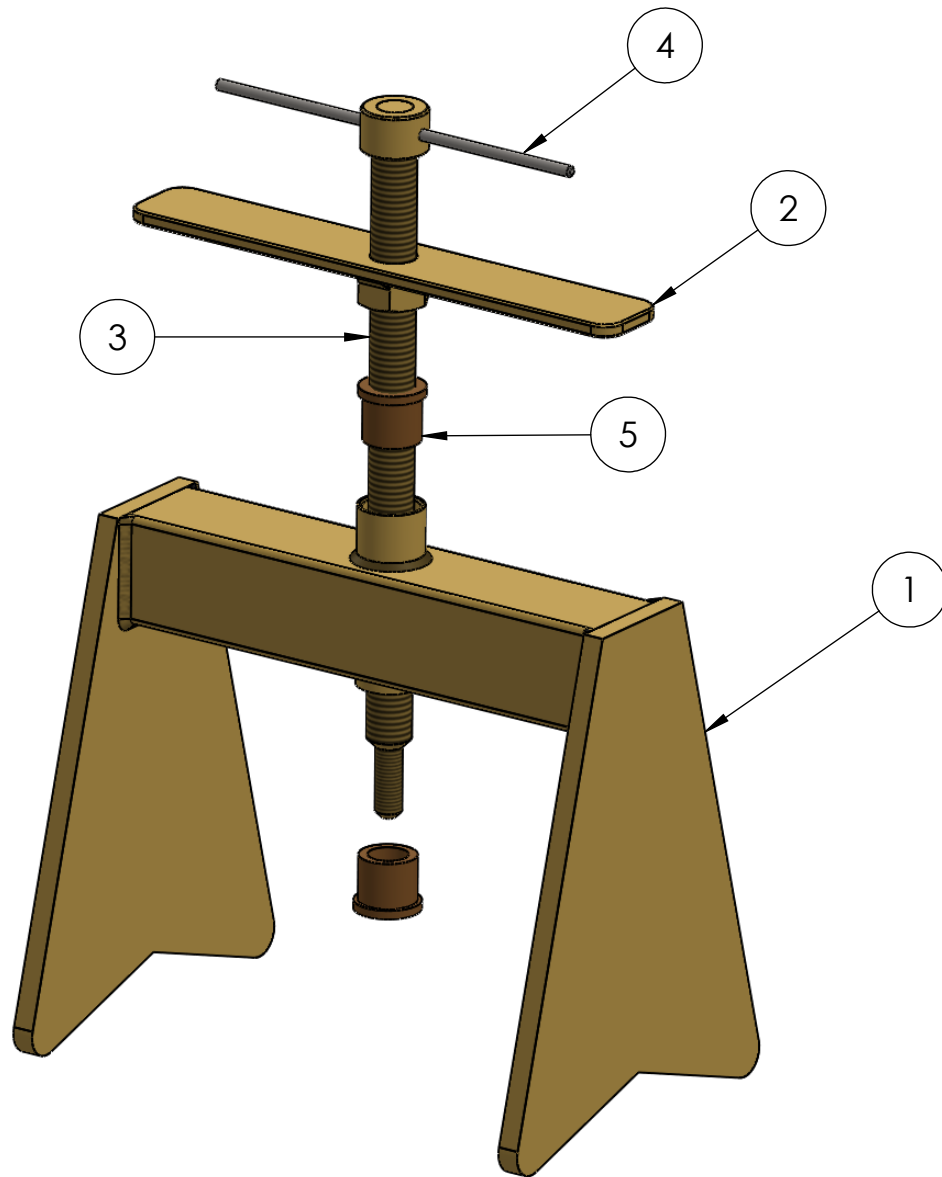


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NON-TAP PLUG STRONGBACK PARTS LIST



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	238-0015	STRONGBACK	1
2	238-0016	WRENCH	1
3	238-0012	EXTRACTION SCREW	1
4	238-0013	TOMMY BAR	1
5	M2165	BUSH	2



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