# 129 Series Inflatable Line Stop

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**WARNING**
Read and understand before using Petersen Line Stop Plugs! Failure to comply may result in property damage, serious injury or death! These instructions must be available to all users. Train all personnel for proper use.

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Important Safety Instructions

Safety is Everyone’s Responsibility

**WARNING**

Extremely high forces are involved in many pipeline-plugging situations that may cause injury or even death. Forces increase dramatically as pressure and pipe diameter increase. Extreme care is required to ensure the safe use of any Line Stop Plug.

- All line stop plugs must be anchored adequately.
- Debris or protrusions into the pipeline can damage a seal or reduce the pressure rating. NEVER use a test pressure greater than the capacity of the weakest pipe or component in the system.
- Consult qualified personnel if you cannot calculate the risks or forces involved.
- Do not exceed the pressures on the plug label.
- Never use equipment when a failure could result in injury or significant property damage. Inflatable devices may not be used as the primary protection for personnel downstream.
- Because of the many possible variables, these general instructions must be adapted by an engineer for each specific project. Instructions and training must be provided to all plug users and workers on the job.

**Personnel Safety**

**CAUTION**

Keep all personnel away from the plug end area.

- Wear required PPE including but not limited to eye protection, helmet, hearing protection.
- Follow all confined space safety controls. Confined space authorization, air monitor, and ventilation may be required.

**Pre-Inspections and Pre-Planning**

- Thoroughly inspect the line stop plug for abrasions, cuts, or physical damage. Clean the plug if required.
- If outside a pipe, do not inflate a line stop plug greater than 5 psi or above 5% of rated pressure.
- Gather all required tools. Have all personnel ready when installing and removing any type of line stop plug.
- Verify that the air line connections and hoses are not damaged or leaking.
- Use two accurate calibrated pressure gauges to measure the pipeline head pressure.
- Prepare to equalize pressure on both sides of the line stop plug before installation and removal.
- Use two accurately calibrated pressure gauges that agree to monitor the inflation pressure.
- Verify that the pipeline flow is stopped.

*Contact the project engineer or Petersen if needed. Safety is the highest priority.*
Pre-Work Inspection

**Safety**
Survey the work area for unsafe conditions. Verify that each person has read the Product Labels, Scope of Work, and instructions developed specific to the project.

1. Verify the Plug and Launch System components are complete.

   1. Inflatable Line-Stop Plug
   2. Centering Anchor
   3. Inflation Ram Connector
   4. Inflation Ram Sections
   5. Launch Cylinder
   6. Flange Gaskets
   7. Packing Seal
   8. Eyebolts
   9. Flange Bolts
   10. Stop Collars
   11. Inflation Ram Pulley Assembly

**NOTE**
Petersen recommends inspecting the line stop plugs after every use. Covers can be damaged when inserting into a hot tap. Often line stop plugs can be refurbished and recertified by Petersen Products to like-new condition or set interval to match quality standards.

Contact Petersen to confirm the suitability of the line stop plug if needed.
2. Gather necessary equipment and tools. Refer to Hot Tap Insertion Tool Checklist.

- 1. Ratchet Assembly
- 2. Socket
- 3. Torque Wrench
- 4. Allen Wrench
- 5. Small Allen Wrench
- 6. Tape Measure
- 7. Wrench
- 8. Marker
- 9. O-Ring Lubricant

3. If using a Retraction System, verify all Retraction System components are complete.

- 10. Ram Removal Plate Assembly
- 11. Ram Section, 24 inches
- 12. Ram Coupling
- 13. Ram Section, 36 inches
- 14. Pull Block Assembly, Retraction Ram
- 15. Pulley Assembly, 6-inch OD
Hot Tap Insertion Tool List

WARNING
Read and understand instructions before using Petersen Inflatable devices. Failure to comply may result in property damage, serious injury, or death.

Overview
The Petersen Hot Tap Insertion System can be used on almost any size pipeline or system and therefore can require a variety of tools to match. This list is intended to assist in determining which tools to prepare for a job but is not a replacement for the judgement of an experienced contractor. Different jobs may require specific tools above and beyond what is listed.

Tool List
- Ratchet Chain Puller: For inserting and securing plug and for retraction with retraction kit.
- Marker or Paint Stick: For marking on steel, fabric, or painted surfaces.
- Tape Measure: To set insertion depth on Inflation Ram or Bundling Sleeve strap lengths.
- O-Ring Lubricant: Inflation Ram and Packing Seal O-Rings.
- Allen Wrench 1/8": Set screws for 1 inch and 1-7/8-inch diameter Inflation Ram.
- Allen Wrench 3/32": Set Screws for 1-1/2-inch Inflation Ram.
- Allen Wrench 3/16": Set screws for 2-1/2-inch Inflation Ram, 1-inch stop collar, centering guides.
- Allen Wrench 1/4": Stop Collar for 1-7/8-inch diameter Inflation Ram.
- Allen Wrench 5/16": Stop Collar for 2-1/2-inch Inflation Ram.
- Pipe Wrench: Attaching NPT Launch Cylinder and Packing Seal.
- Pipe Thread Sealant: Attaching NPT Launch Cylinder and Packing Seal.

Flanged Launch Cylinder
- Torque Wrench & Socket: Match the values listed in the table below for the launch cylinder.
- Wrench: For reaction force against Torque Wrench (match socket size).

Torque Figures
- Note: Sequence the torque in a star pattern. Complete the pattern three times 30%, 70%, 100% to the sequence.

<table>
<thead>
<tr>
<th>Size</th>
<th>Bolt</th>
<th>Wrench</th>
<th>Torque</th>
</tr>
</thead>
<tbody>
<tr>
<td>3</td>
<td>5/8&quot;</td>
<td>15/16&quot;</td>
<td>16 ft·lb</td>
</tr>
<tr>
<td>4</td>
<td>5/8&quot;</td>
<td>15/16&quot;</td>
<td>110 ft·lb</td>
</tr>
<tr>
<td>5</td>
<td>3/4&quot;</td>
<td>1-1/8&quot;</td>
<td>195 ft·lb</td>
</tr>
<tr>
<td>6</td>
<td>3/4&quot;</td>
<td>1-1/8&quot;</td>
<td>195 ft·lb</td>
</tr>
<tr>
<td>8</td>
<td>3/4&quot;</td>
<td>1-1/8&quot;</td>
<td>195 ft·lb</td>
</tr>
<tr>
<td>10</td>
<td>7/8&quot;</td>
<td>1-5/16&quot;</td>
<td>310 ft·lb</td>
</tr>
<tr>
<td>12</td>
<td>7/8&quot;</td>
<td>1-5/16&quot;</td>
<td>310 ft·lb</td>
</tr>
<tr>
<td>14</td>
<td>1&quot;</td>
<td>1-1/2&quot;</td>
<td>465 ft·lb</td>
</tr>
<tr>
<td>16</td>
<td>1&quot;</td>
<td>1-1/2&quot;</td>
<td>465 ft·lb</td>
</tr>
<tr>
<td>18</td>
<td>1-1/8&quot;</td>
<td>1-11/16&quot;</td>
<td>605 ft·lb</td>
</tr>
<tr>
<td>20</td>
<td>1-1/8&quot;</td>
<td>1-11/16&quot;</td>
<td>605 ft·lb</td>
</tr>
<tr>
<td>24</td>
<td>1-1/4&quot;</td>
<td>1-7/8&quot;</td>
<td>960 ft·lb</td>
</tr>
<tr>
<td>30</td>
<td>1-1/4&quot;</td>
<td>1-7/8&quot;</td>
<td>960 ft·lb</td>
</tr>
</tbody>
</table>
1. Install Saddle and Tapping Valve on pipe, according to the manufactures instructions.
2. Position the Saddle so that when the Plug is inserted it will not be damaged by sharp edges or protrusions.

3. Measure the distance through the open Tapping Valve from the top of the uncut pipe to the top of the Flange Gasket. Add to the measurement the thickness of the pipe. The sum is $D_1$.

**NOTE**
Write the measurements in the boxes to use later.
5. Install the Hot Tapper Drill Adapter to the Tapping Valve. See the Hot Tap Drill manufacturer for detailed operation and maintenance information.

6. Connect the air supply to the valve and saddle area.

**NOTE**
Inspect for leaks BEFORE using the Hot Tap Drill Equipment. Use the Test Port on the hot tap sleeve, nozzle or valve. Once the drill is used the valve will be pressurized. Fix all leaks before using the drill.

7. Open the Tapping Valve completely.

8. If possible, open the Chip Valve on the Hot Tapper Drill Adapter, to allow chips to be washed out and to provide differential pressure to capture the coupon/cut-out.
9. Drill the Hot Tap Hole into the pipeline. Then retract the drill. Close the Tapping Valve.

10. Remove the Hot Tap Drilling Equipment.
Bundling the Pipe Plug

Bundle the plug before inserting into a plug. Bundling is easier with two personnel.

1. Inflate and stretch out the plug. – max 5% rated pressure when not supported in a pipe.

2. Roll each end inward.

3. Continue folding inward. Maintain even folds on each end.

4. Fold until the end discs touch to the inside.

5. Fold the cylinder to create a round bundle. Verify that the sealing rings are inside.

6. Add rubber bands. Tuck in the bottom corners to reduce the length of the bundle.

7. Verify that the top corners are tucked down so that the plug fits in the hot tap hole.

8. Only use enough rubber bands so that the bundle is smaller than hot tap hole.

Installing the Ram Adapter

The Inflation Rams are available with Thread and Set Screw type connections.

NOTE
If a ram end adapter is not needed, see step 5.

1. If needed, clean the Inflation Port, Flange Gasket, and Ram Adapter.

2. Inspect the torque on the Flange Nuts.

<table>
<thead>
<tr>
<th>Bolt Size</th>
<th>Torque</th>
</tr>
</thead>
<tbody>
<tr>
<td>1/2”</td>
<td>80 ft·lb</td>
</tr>
<tr>
<td>5/8”</td>
<td>159 ft·lb</td>
</tr>
<tr>
<td>3/4”</td>
<td>254 ft·lb</td>
</tr>
<tr>
<td>7/8”</td>
<td>400 ft·lb</td>
</tr>
</tbody>
</table>

3. Place the Ram Adapter end on the Inflation Port Flange. Align the Set Screw Pockets on the Ram Adapter with the Plug Directional Arrows.

4. Tighten the Ram Adapter Nuts to secure the ram adapter. Use a star pattern to apply balanced torque. Complete the pattern three times 30%, 70%, 100% to the torquing sequence.

See Torque Figures on page 4.
5. Apply O-Ring grease to the connectors.

![Ram Adaptor Connector](image1)

6. Install one section of the Inflation Ram to the Plug.

![Plug and Inflation Ram](image2)

7. Align the Plug Orientation Line with a Set Screw. This will later align the plug inflation direction with the pipe direction. Torque each set screw. See the figure for torque guidelines.

<table>
<thead>
<tr>
<th>Screw Size</th>
<th>Torque</th>
</tr>
</thead>
<tbody>
<tr>
<td>#10</td>
<td>30 in·lb</td>
</tr>
<tr>
<td>1/4&quot;</td>
<td>76 in·lb</td>
</tr>
<tr>
<td>3/8&quot;</td>
<td>276 in·lb</td>
</tr>
</tbody>
</table>
8. Use a Marker to mark the Inflation Ram on the opposite end of the plug with the Plug Orientation Line on the Set Screw.

**NOTE**
DO NOT mark the Orientation Line on the Launch Cylinder. Plugs can shift in the Launch Cylinder before deploying. Marking the Ram will assure the Plug Orientation alignment with the Pipe.

![Diagram showing Inflation Ram, Orientation Mark, and Set Screw]

9. Measure the distance from the Plug Flange where it meets the fabric to the end of the FIRST Inflation Ram section. The distance is **D2**.

**NOTE**
Write the measurement in the boxes to use later.

![Diagram showing Plug Flange, Measure Distance, and Inflation Ram Section]
10. Slide the Centering Anchor onto the Inflation Ram section. Secure the Centering Anchor with Set Screws or a Stop Collar, depending on the model. The Centering Anchor should be flush with the bottom of the Plug Flange.

**NOTE**
Shown with Set Screw.

11. Apply o-ring grease to the entire length of the Inflation Ram.
12. Slide the Flange Gasket and packing seal on the inflation ram. Insert plug into the Launch Cylinder.

**NOTE**
Do not damage the packing seal.

13. If required, install the Retraction Post Base. The Retraction Post aids the removal of the plug, after work is completed.

14. Add a temporary Stop Collar on the Ram to hold the Packing Seal in place.

15. Insert the Eye Bolts. Orient the eye bolts in line, not parallel. Verify that the Eye Bolts don’t interfere with the valve on the Packing Seal.

16. Install the remaining flange bolts.

17. Lightly lubricate the Bolt and Nut threads. Tighten the Bolts to secure the Packing Seal to the Launch Cylinder Flange. Use a star pattern for balanced torque. Complete the pattern three times 30%, 70%, 100% to the torqueing sequence. See Torque Figures on page 4.
18. Measure the distance from the base of the Launch Cylinder, including the gasket, to the top of the Packing Seal or Retraction Post Base. This is **D3**.

**NOTE**
Write the measurement in the box to use later.

19. Calculate the measurement **D4**, the Stop Collar Distance for plug insertion.

**NOTE**
Write the measurement in the box to use later.

\[
\text{Measurement } D1 + \text{ Measurement } D3 = D4
\]

Find **D1** on page 5.
Find **D3** above.
20. Calculate the measurement \( D_5 \), the Stop Collar Position. If there is only one ram section, then \( D_5 \) will be a negative number and one should measure down from the end of the ram to make the mark in Step 21.

**NOTE**
Write the measurement in the box.

\[
\begin{array}{c}
\text{Measurement } D_4 - \\
\text{Measurement } D_2 \\
\text{Stop Collar Position } = D_5 \\
\end{array}
\]

Find \( D_4 \) on page 14.
Find \( D_2 \) on page 11.

21. Install the remaining Ram sections. Use the \( D_5 \) length to measure from the first Ram section. Mark on the Inflation Ram the exact measurement needed.

22. Attach the Stop Collar to the Inflation Ram at mark.

23. Mark the Set Screw on the last Inflation Ram section with an orientation line. Verify that the mark aligns with the mark on the first Inflation Ram section.
24. If required, add a Strongback at the end of the Inflation Ram.

NOTE
High forces may require a Strongback to secure the Plug Flange.

A) Attach the Anchor Lugs.
B) Thread the rods into the Anchor Lugs with a nut and washer on each rod.
C) Tighten and secure the Strongback to the Anchor Lugs.
D) Attach the Ratchet Puller to the Eye Bolts and over the Inflation Ram End Pulley.

25. Attach the Inflation Ram Pulley Assembly to the end of the Inflation Ram. Torque all setscrews.

26. If possible, align the Inflation Valve and the Pressure Monitor Port with mark on the Inflation Ram for a better visual of proper plug alignment.
27. Verify that the Gasket is between Launch Cylinder and tapping valve. then **Bolt** the Launch Cylinder to the Tapping Valve.

28. Bolt the Launch Cylinder to the Tapping Valve Flange. Use a star pattern for balanced torque. Complete the pattern three times 30%, 70%, 100% to the torqueing sequence. **See Torque Figures on page 4.**

### Plug Insertion

1. Measure the height from the top of the packing seal to the bottom of the pulley assembly. This is **D6**. The dimension is required to verify that the plug is fully retracted, when removing the plug.

**NOTE**
Write the measurement in the box.
2. Attach the Ratchet Puller to the Eye Bolts and over the Inflation Ram End Pulley.

![Ratchet Puller and Eye Bolt]

**CAUTION**
The Inflation Ram may rise until the centering guide contacts the packing seal.

3. Open the Tapping Valve.

![Tapping Valve]

4. Use the Gauge to check the pipeline pressure. Fix any possible leaks. Verify that the pipeline pressure is not greater than half the plug rated inflation pressure.

![Gauge]
CAUTION
The Inflation Ram may fall when the stop collar is removed.

5. Stop the flow in the Pipeline. Remove the temporary Stop Collar on the Packing Seal. Lower the Plug.

6. As the plug lowers, verify that the Mark on the Ram aligns with the pipeline to maintain correct orientation.

7. Lower the Ram until the Stop Collar on the Ram is touching the Retraction Post Base or Packing Seal. Use the Ratchet Puller as needed to insert the plug.

8. Anchor the plug in place with the Rachet Puller or Strongback.
Air Inflation Kit

If using water inflation skip to the water inflation section, page 18.

Pressure Monitor Side

A) Connect the Pressure Monitor Hose and Inflation Hose to the Inflation Ram Assembly.
B) Attach one or two Gauges to the Pressure Monitoring Valve Assembly.
C) Connect the Low Pressure Alarm to the Pressure Monitor Hose.
D) Connect the Pressure Monitoring Valve Assembly to the Low Pressure Alarm.

Inflation Side

E) Connect one Gauge to the Inflation Controller.
F) Connect the Relief Valve to the Inflation Controller.
G) Connect the Inflation Hose to the Inflation Controller.

CAUTION
Close the valve on the Inflation Controller before connecting air supply.

H) Connect the Inflation Source Air line to the Inflation Controller.
2. If using a Low Pressure Alarm, set the alarm according to alarm set procedure.

**NOTE**
Petersen recommends to use two calibrated gauges to verify the Plug Inflation Pressure.

![Image](image1.png)

**NOTE**
Trip hazard. Keep the hoses coiled when not in use to prevent equipment damage.

**CAUTION**
Do not over inflate. Maintain the pressure at 2X the pipeline pressure, but less than maximum rated plug pressure.

3. Adjust the Regulator on the Inflation Controller. Do not over inflate the plug.

4. Inflate the Plug. Monitor pressure with the Pressure Monitor Assembly.

![Image](image2.png)

5. Turn on the Low Pressure Alarm. If the pressure drops below the alarm setpoint the alarm will sound.
Troubleshooting

**CAUTION**
Do not inflate more than 20% over the pipeline head pressure until the Inflation Ram is anchored into the correct position.

When inserting a plug into a vertical pipeline:
- The plug may sag down into an empty pipe or float up in a full pipe causing a poor seal.

For proper deployment in a vertical pipeline:
- Push the plug into the pipeline so that about ¾ the plug is in the pipeline.
- Inflate plug to approximately 5% above pipeline pressure.
- As the plug starts to inflate, the inflation pressure should pull the plug into the pipeline as the plug expands.
- Use the Ratchet Puller to pull the plug until the stop collar stops the Inflation Ram at the insertion distance.
- If the plug does not completely seal, repeat the process several times.
Plug Deflation for Air Inflated Plugs

NOTE
The plug will deflate if the existing pressure is higher than the head pressure.

1. Deflate the plug. Disconnect the air source and open the valve on the Pressure Monitor Assembly.
2. The Vacuum Generator may be used to deflate the larger plugs with air.

Water Inflation Controller

Overview
The 1.5” Port Pump is rated for 100 gpm max flow and 100 psi max air source.
Operating the Water Flow Totalizer:

- Press the **Display** button **once** to display the total volume of water ever used by this pump.
- Press the **Display** button **again** to display the Batch (amount of water used).
- Press the **Display** button **again** to show Flow Rate.
- To reset the Batch to Zero to track the quantity of water: display the **Batch** then press and hold the **Display** button.
- To change units from gallons to liters: hold the **Calibrate** button and press the **Display** button.

Assembling the Water Hoses and Pressure Monitoring Lines

1. Attach the Water Hose and Pressure Monitor Hose to the Inflation Ram Pulley Assembly.

2. Attach the other end of the Pressure Monitor Hose to the Low Pressure Alarm.

3. Attach Pressure Monitor Valve Assembly to the Low Pressure Alarm.
4. Attach the two Gauges to the Pressure Monitor Valve Assembly.

5. Attach the Water Hose to the Water Pressure Monitor Assembly and to the Water Inflation Controller outlet.

6. Attach the water supply line to the Water Source Connection of the Water Inflation Controller.

7. Connect the air source line to the Pump Air Source Connection of the Water Inflation Controller.
Inflate the Plug

**CAUTION**
Do not over inflate. The maximum rated pressure requires a fully inserted plug into a clean steel pipe.

If the pipeline is more than half full of liquid:

- The plug can be inflated directly with water.

If the pipeline is less than half full of liquid:

- The plug must first be inflated with air to take shape.
- Inflate to the lesser of 5 psi or 10% above the pipeline pressure.

**CAUTION**
For maximum safety remove as much air as possible.

1. Inflate with air to the lesser of 5 psi or 10% above the pipeline pressure.
2. Zero the Batch Counter on the Flow Totalizer.
3. Inflate the plug with water. Periodically close the Water Inflation Valve to release air pressure.
4. Open the valve at the Pressure Monitor Assembly to release any air.

**NOTE**
Do not allow the pressure to drop below 5 psi from 5% of the line pressure.

5. Close the Pressure Monitor Valve and continue inflating with water.
6. Use the Batch counter on the Water Inflation Controller to monitor the amount of water.
7. Once the Pressure Monitor Valve is only releasing water, then all the air is out.
8. To monitor the inflation pressure with a water hose that is filled with water:
   - Add 0.433 psi to the gauge readings for every foot that the gauge is above the invert of the pipe.

**CAUTION**
Do not exceed the maximum rated pressure.

9. Monitor the pressure when filling the Plug.
10. High pressure plugs can be topped off with air or nitrogen after they are filled with water.
11. Turn on the Low Pressure Alarm. If the pressure drops below the alarm setpoint then the alarm will sound.
Deflating with Water Inflated Plug

1. Close the valve on the Plug Water Inflation Hose.

2. Switch the Water Hoses to the other connection ports. The hose that was connected on the Water Source Connection is now connected to the water pump outlet. The hose that was connected to the water pump outlet is now connected to the Water Source Connection.

3. Verify that the Water Pump Outlet hose drains into a tank or area that can collect the water pumped out of the plug.

4. Zero the batch counter to track the output.

5. Open the valves on the Water Inflation Hose and begin deflating the Plug.

6. Continue pumping until water completely stops trickling.

NOTE
The pipeline pressure can trap water and deflate the plug. Reinflate the plug to purge the water as needed.
NOTE
Maximum vertical lift from the pipe invert is 18 ft. The Pump will only lift 18 ft on the inlet side. Pipeline pressure can assist with water deflation. If needed, Petersen can make plugs that displace water with air for lifts over 18 ft. Never exceed the pressure rating of the Plug when displacing water. Stop adding air when water no longer discharges from Pump outlet. Continue deflating until all air is out of Plug.

NOTE
As the water is displaced with air the Plug may float if submerged and the water and air will be evacuated by the Pump. Remove the Plug only after it is deflated completely.

Plug Removal

1. Remove the inflation and pressure monitoring hoses from the inflation ram.
2. Open valve on Inflation Ram Pulley Assembly to allow air to vent when removing the Plug from the pipe.
3. Remove the Ratchet Puller.
4. Remove the Strongback, if using a Strongback.
5. If using a Retraction System, attach the Retract System.

NOTE
The Retraction Post is rated for 5 feet of Ram in a vertical position.

6. Replace Inflation Ram Pulley Assembly with a pull block to give more lift.

7. Attach the Ratchet Puller to the Pull Block and over the Retraction Post Pulley.

NOTE
The stop collar must be on the inflation ram at all times.

8. After one section of the Inflation Ram is retracted, attach a Stop Collar at the lower Ram section to prevent the Ram from falling back down into the pipe.

9. Remove the Inflation Ram one section at a time. Move the Pull Block down each time.
10. Repeat until the Plug is fully in the Launch Cylinder. Use the measurement from D6 to verify that the inflation ram is fully retracted. See D6 on page 17.

11. Once the Plug is fully retracted, close the Tapping Valve.

12. Drain the Launch Cylinder.

13. Disassemble the assembly in the reverse order it was assembled.
Plug Storage and Cleaning

1. Before and after each use, clean the plug and inspect for surface tears, cuts or any other damage.
2. Clean with mild soap and water.
3. The plug can be inflated for cleaning and inspection. Do not exceed 5% of the plugs rated pressure.
4. Do not allow the plug to remain in sunlight for long periods of time to prevent damage.
5. Verify that the plug is empty of water and dry prior to storage in a dry location.
6. Keep the instructions with the plug.

Do not use the product if there is significant wear or damage or return to Petersen for repair and recertification.

Call Petersen with any questions or suggestions relating to the use of any Petersen product.

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