

FA4[™]

FA9TE

FLANGE
ALIGNMENT
TOOLS



INDEX

SECTION	CONTENTS	PAGE NO.
1	INTRODUCTION	2
2	SAFETY INFORMATION	3-4
3	TECHNICAL DATA	5
4	FLANGE MISALIGNMENT DETERMINATION PROCEDURE	6
	4.1 LATERAL MISALIGNMENT	6
	4.2 ROTATIONAL (TWIST) MISALIGNMENT	7
5	FA4 TM MECHANICAL FIXED FLANGE AND ROTATIONAL ALIGNMENT TOOL	
	5.1 KIT COMPONENTS	8
	5.2 HOW THE FA4 TM WORKS	8
	5.3 INSTALLATION AND OPERATION	9-12
	5.4 EXAMINATION, MAINTENANCE AND STORAGE	13-14
	5.5 PARTS LIST	15
	5.6 WEIGHTS AND DIMENSIONS	16
	5.7 TROUBLESHOOTING	17
	5.8 APPLICATION DIMENSIONS	18
6.	FA9 ^{TE} HYDRAULIC FIXED FLANGE AND ROTATIONAL ALIGNMENT TOOL	
	6.1 KIT COMPONENTS	19
	6.2 HOW THE FA9 ^{TE} WORKS	19
	6.3 INSTALLATION AND OPERATION	20-22
	6.4 EXAMINATION, MAINTENANCE AND STORAGE	23-24
	6.5 PARTS LISTS	25-27
	6.6 WEIGHTS AND DIMENSIONS	28
	6.7 TROUBLESHOOTING	29-30
	6.8 APPLICATION DIMENSIONS	31
7.	RANGE OF APPLICATION	
	7.1 BS10, API6BX AND API6B FLANGE TABLES	32
	7.2 ASME B16.5, B16.47 AND DIN WELD NECK FLANGE TABLES	33
	7.3 SPO FLANGE TABLE	34

1. INTRODUCTION

The Equalizer FA4™ and FA9TE TOOLS are aids for use in normal maintenance and installation procedures, and enable the realignment of misaligned flanges within their respective working capacities. For example, all of the tools can be used to assist in the replacement of ring and other types of flange joint. The use of these instructions will promote safe use, and maximize the service life of the tools. It is recommended that the operator read the relevant sections of this instruction manual for the particular flange alignment tool to be used.

2. SAFETY INFORMATION

The operator MUST read this manual prior to using the tools.

Failure to comply with the following cautions and warnings could cause equipment damage and personal injury; read the manual fully!

Read all the following instructions, warnings and cautions carefully. Follow all safety precautions to avoid personal injury or property damage during system operation.

Equalizer International Ltd cannot be responsible for damage or injury resulting from unsafe product use, lack of maintenance or incorrect product and/or system operation. Contact Equalizer International Ltd when in doubt as to the safety precautions and applications. To protect your warranty, use only good quality hydraulic oil of the grade 15cSt.

Only people competent in the use of mechanical and hydraulic equipment should use these tools.

In all installations the site safety requirements must be adhered to. ALSO the safety of the operator, and when present, any assisting personnel, is of paramount importance along with the safety of others including, when present, the general public.

These instructions are only to cover the safe operation of THE EQUALIZER FA4[™] AND FA9TE FLANGE ALIGNMENT TOOLS, during normal maintenance/installation operations. All other safety aspects must be controlled by the operation supervisor.

A **CAUTION** is used to indicate correct operating or maintenance procedures and practices to prevent damage to, or destruction of equipment or other property.

A **WARNING** indicates a potential danger that requires correct procedures or practices to avoid personal injury.

A **DANGER** is only used when your action or lack of action may cause serious injury or even death.



IMPORTANT: Operator must be competent in the use of hydraulic equipment. The operator must have read and understood all instructions, safety issues, cautions and warnings before starting to operate the Equalizer equipment.



WARNING: To avoid personal injury and possible equipment damage, make sure all hydraulic components are rated to a safe working pressure of 700 bar (10,000 psi)



WARNING: Do not overload equipment. Overloading causes equipment failure and possible personal injury.

The risk of overloading can be avoided by using the Equalizer Hand Pump, which has its safety valve set to 700 bar by the factory. If alternative pumps are used, ensure they are rated at a safe working pressure of 700 bar (10,000 psi).



CAUTION: Make sure that all system components are protected from external sources of damage, such as excessive heat, flame, moving machine parts, sharp edges and corrosive chemicals.



CAUTION: Avoid sharp bends and kinks that will cause severe back-up pressure in hoses. Bends and kinks lead to premature hose failure. Do not drop heavy objects onto hoses. A sharp impact may cause internal damage to hose wire strands; applying pressure to a damaged hose may cause it to rupture. Do not place heavy weights on the hoses, or allow vehicles to roll over the hoses; crush damage will lead to premature hose failure.



WARNING: Immediately replace worn or damaged parts with genuine Equalizer parts. Equalizer parts are designed to fit properly and withstand rated loads. For repair or maintenance service contact your Equalizer distributor or service centre.



DANGER: To avoid personal injury keep hands and feet away from the tool and workpiece during operation.



WARNING: Always wear suitable clothing and Personal Protective Equipment (PPE).



DANGER: Do not handle pressurised hoses. Escaping oil under pressure can penetrate the skin, causing serious injury. If oil is injected under the skin, seek medical attention immediately.



WARNING: Never pressurize unconnected couplers. Only use hydraulic equipment in a connected system.



IMPORTANT: Do not lift hydraulic equipment by the hoses or couplers. Use the carrying handle or other means of safe transport.



CAUTION: Do not operate the equipment without lubricating all moving parts as in section 5.4, 6.4 & 7.4. Use only high pressure molybdenum disulphide grease.

3. TECHNICAL DATA

	Tool Description	Aligning Force
FA4TM	Mechanical Fixed Flange and Rotational Alignment Tool	4.0 T (40kN) from 50 ft/lbs (67.8 Nm) of torque
FA9TE	Hydraulic Fixed Flange and Rotational Alignment Tool	9.0 T (90 kN) from 10,000 psi (700 bar) of hydraulic pressure

4. FLANGE MISALIGNMENT DETERMINATION PROCEDURE

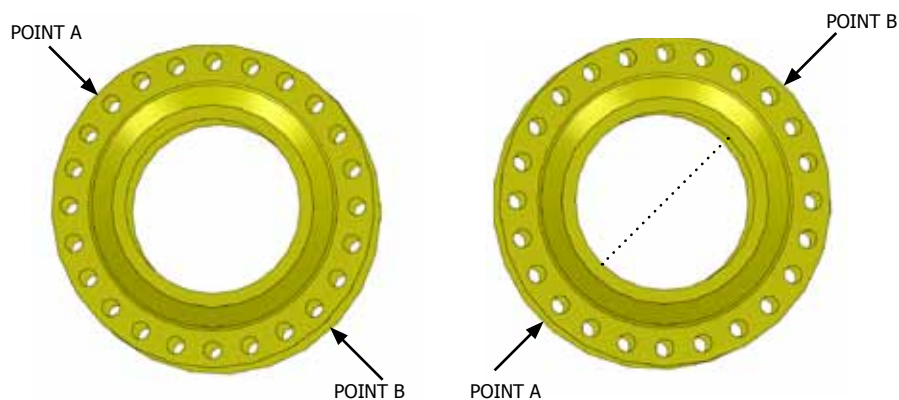
The tool being used must not be attached to a flanged joint prior to the misalignment procedure being carried out.

4.1 LATERAL MISALIGNMENT

1. Loosen and remove every second bolt around the flange , continue with this until misalignment occurs.

A flanged joint, once broken down, may spring out of alignment at any point, or in any direction around its circumference. Misalignment may not occur until only a few bolts remain.

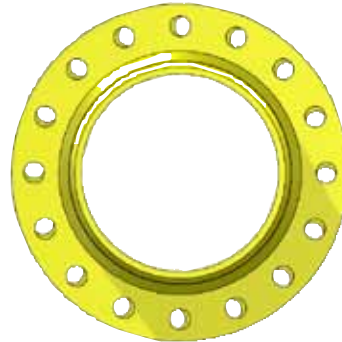
2. At this point the direction of any misalignment should become obvious. The alignment tool being used should be attached at the maximum point of misalignment (point A or B in the examples shown below).



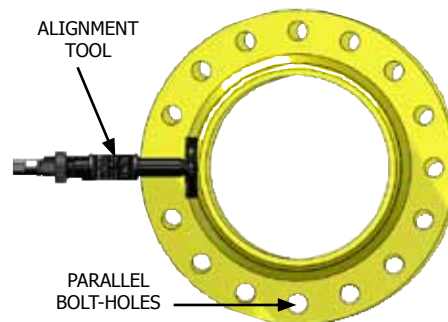
4.2 ROTATIONAL (TWIST) MISALIGNMENT

If the outer circumference of the flanges are in alignment but the operator is unable to fit the bolt into any two corresponding bolt-holes then rotational misalignment may have occurred.

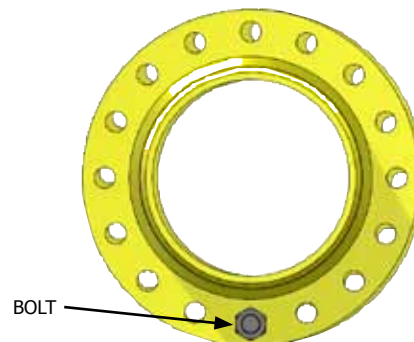
In this case the alignment tool can be attached to the most accessible point as misalignment occurs at all bolt-holes to the same degree.



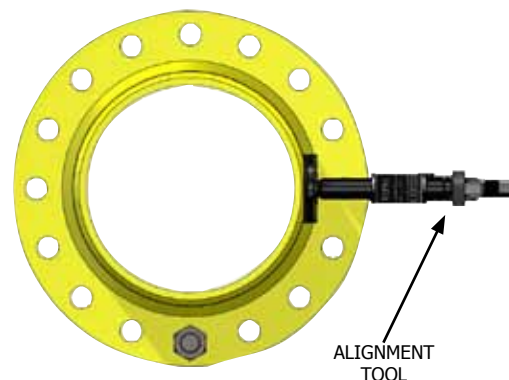
1. Attach the alignment tool at the most accessible/convenient point (as shown in sections) and use it to push the flanges out of alignment until one pair of bolt-holes becomes parallel.



2. Insert the bolt into the aligned bolt-hole and release the alignment tool. The load will transfer onto the bolt.



3. Repeat steps 1 and 2 at other points around the flange until all of the remaining bolt-holes are parallel and the rest of the bolts can be inserted.



5. FA4TM MECHANICAL FIXED FLANGE AND ROTATIONAL ALIGNMENT TOOL

5.1 KIT COMPONENTS

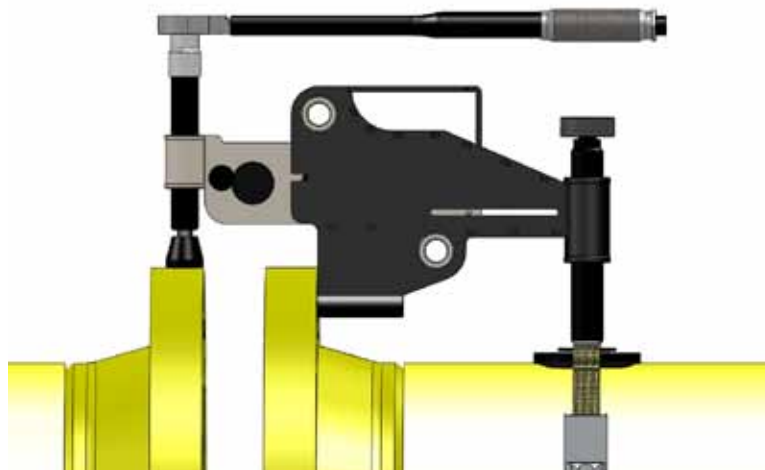
- 1 x FA4TM Tool
- 1 x 50 ft/lbs (67.8 Nm) Torque Wrench with 22 mm Socket
- 1 x Ratchet and Strap
- 1 x Instruction Manual
- 1 x Carry-Case



Product Code: FA4TMSTD

5.2 HOW THE FA4TM WORKS

1. The FA4TM is secured to the lower of the two flanges by fully inserting the lift hook into the bolt-hole at the point of greatest misalignment.
2. The drop leg is adjusted down to the pipe while the tool is held level in the bolt-hole.
3. The wing retaining screw is loosened to allow the wing to be extended out.
4. The screw bolt is turned clockwise until the friction pad comes into contact with the circumference of the opposite flange.
5. The torque wrench is set to 50 ft/lbs (max), attached to the screw bolt and turned to screw down on the flange, bringing the joint into alignment.



5.3 INSTALLATION AND OPERATION

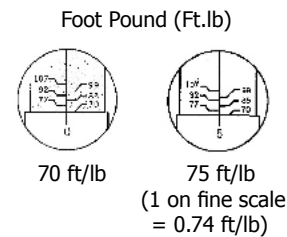
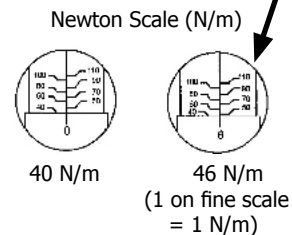


How to use the torque wrench

Balance the wrench in your left hand and unlock the knurled handle by turning the locking knob anti-clockwise. Set the torque amount by turning the knurled handle - see example 40-46 N/m

1. Turn the handle till 0 on fine scale reach 40 N/m on base scale
2. To set 46 turn handle till fine scale reach 6
3. Lock handle by turning the locking knob clockwise

Install the proper socket and attach to the tool. Pull handle till you feel and/or hear the wrench click. Setting of ft/lb scale is done in the same way as above.



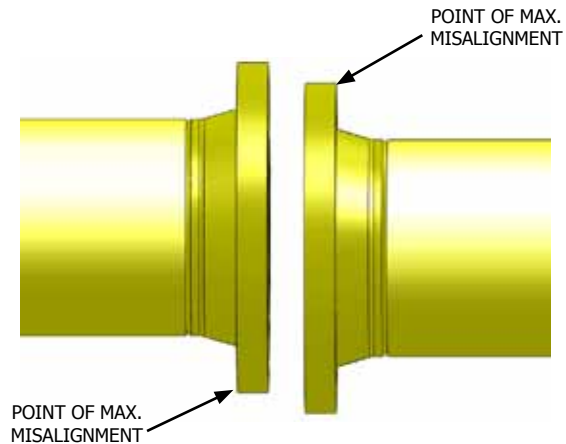
Do not pull after the wrench clicks. Use special care at low torque settings. If the wrench has not been used for some time: operate it several times at low torque to allow internal lubricant to recoat. When not in use set to lowest torque setting. Don't turn handle below lowest torque setting. Your torque wrench is a precision measuring instrument and should be treated as such. Clean only by wiping, do not use any type of cleaner which may affect the special internal lubricant with which this wrench is packed at the factory.



1. Do not attempt to turn the grip while it is locked
2. Do not turn the grip more than one turn below the lowest scale reading or above the highest scale reading

1. Carry out the Flange Misalignment Determination Procedure (see section 4) to determine the points of maximum misalignment.

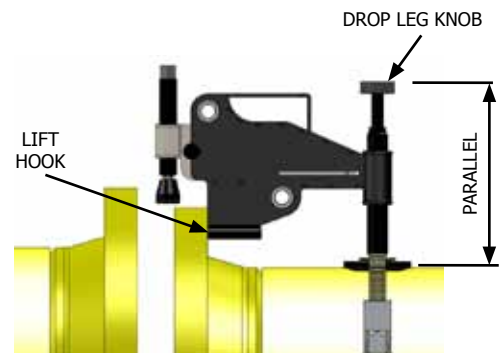
In this example the points of maximum misalignment are at the top and bottom of the joint.



2. Guide the lift hook into the bolt-hole at the maximum point of misalignment.

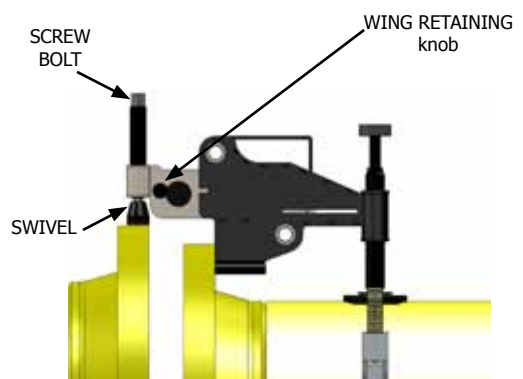
Adjust the drop leg down onto the pipe by turning the adjusting knob in a clockwise direction. The tool should be held up level within the bolt-hole during adjustment.

N.B. The tool must be parallel to the pipe at all times.

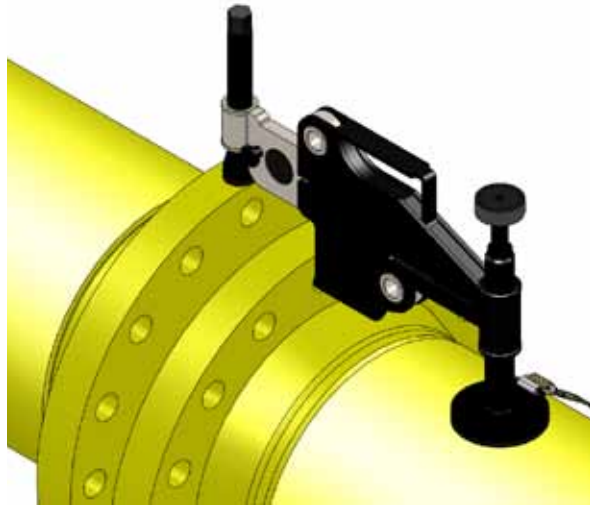


3. Loosen the wing retaining knob and extend the wing over to the opposite flange.

Rotate the screw bolt onto the surface of the opposite flange. Ensure that the tool is sitting level and that the friction pad on the base of the swivel is in full and even contact with the surface of the opposite flange.



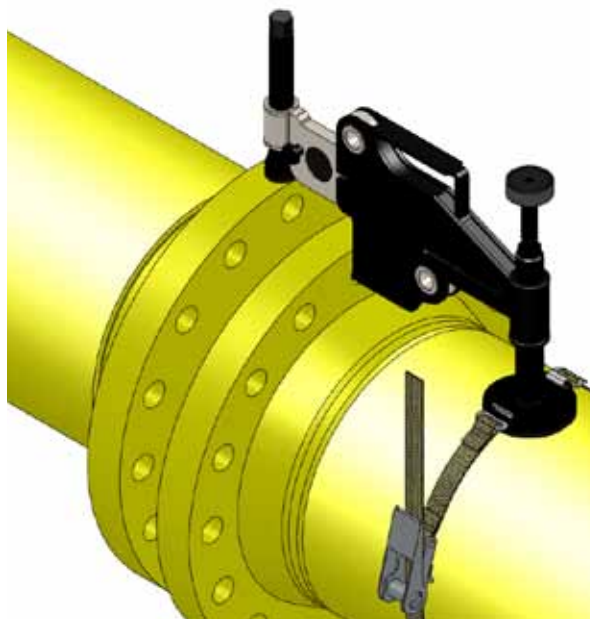
4. Attach the hook of the strap through the buckle on top of the base plate as shown.



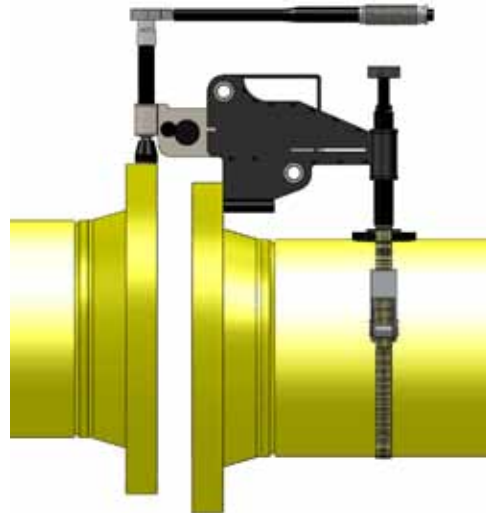
5. Now place the hook of the ratchet mechanism through the opposite side of the buckle as shown.



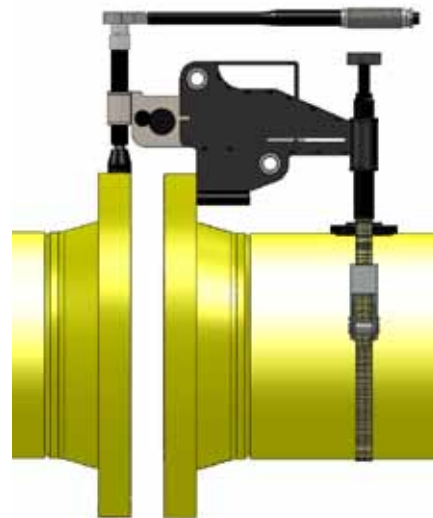
6. Feed the open end of the strap through the ratchet mechanism as shown. Tighten the strap using the ratchet mechanism.



7. The torque wrench should be set at 14 ft/lbs (19Nm) then attached to the screw bolt



8. Tighten the screw bolt in a clockwise direction until the flanges come into alignment; or the torque wrench "clicks"
 If the torque wrench has clicked and the flanges are still mis-aligned adjust the torque wrench up to 24.2 ft/lbs (33 Nm) and continue until a maximum torque wrench setting of 50t/lbs (67.8N/m) is reached or the flanges are aligned.



The maximum safe working load is 50 ft/lbs (67.8 N/m)

exceeding 50 ft/lbs will result in damage to the tool

Once in alignment the bolts may be inserted and tightened.

After replacing all of the bolts (apart from the bolt which will go into the bolt-hole in which the FA4TM is located), remove the tool by reversing steps 2 -8.

Insert the last bolt and tighten.

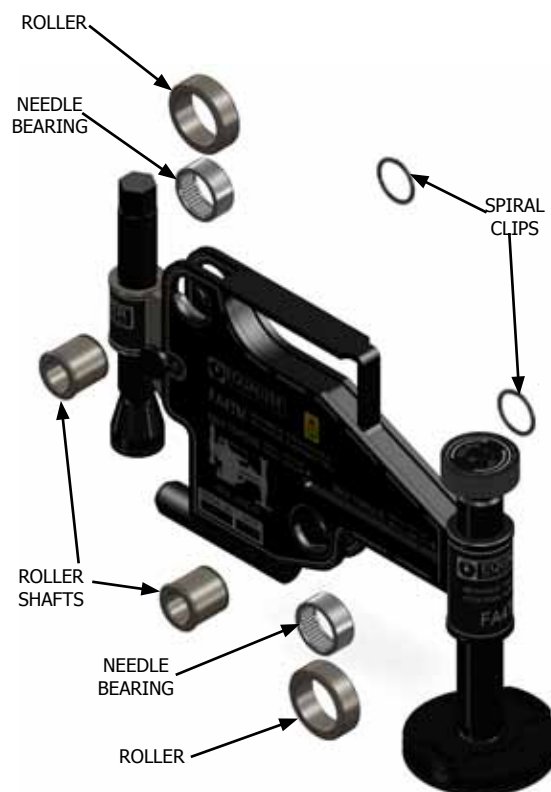


Care should be taken not to drop any of the component parts when removing them from the flange joint. This action will prevent injuries to either the operator's lower limbs, or to passers-by.

5.4 EXAMINATION, MAINTENANCE AND STORAGE

- On return from each job and before allocation against subsequent work the completeness of the Equalizer FA4™ kit must be established and items examined to ensure that they are serviceable
- Any missing or damaged items are to be replaced as soon as possible and prior to the tool being used again
- Store the FA4™ in a cool dry place and ensure all machined surfaces are greased
- Return all items to carry case when not in use
- Ensure rollers, pins and wing remain grit free and that the rollers rotate freely
- Grease all moving parts regularly:

1. Secure the tool upright on a bench.
2. Using a small flat screw driver, lever out the end of the spiral clips and then rotate anti-clockwise and remove.
3. Slide the roller shafts out in order to remove the rollers and bearings for examination.
4. Inspect the roller shafts, rollers and bearings for damage. If there is no damage present then they can be cleaned, greased and re-assembled by reversing steps 1-4



Recommended grease -
 Hi-load bearing grease
 e.g. Rocol Sapphire hi-load

5. It is important that the thrust bearing is free from dirt and corrosion and rotates freely.

6. With the use of a penetrating oil such as WD 40 or similar. Spray the oil between the thrust plate and the swivel as shown opposite.

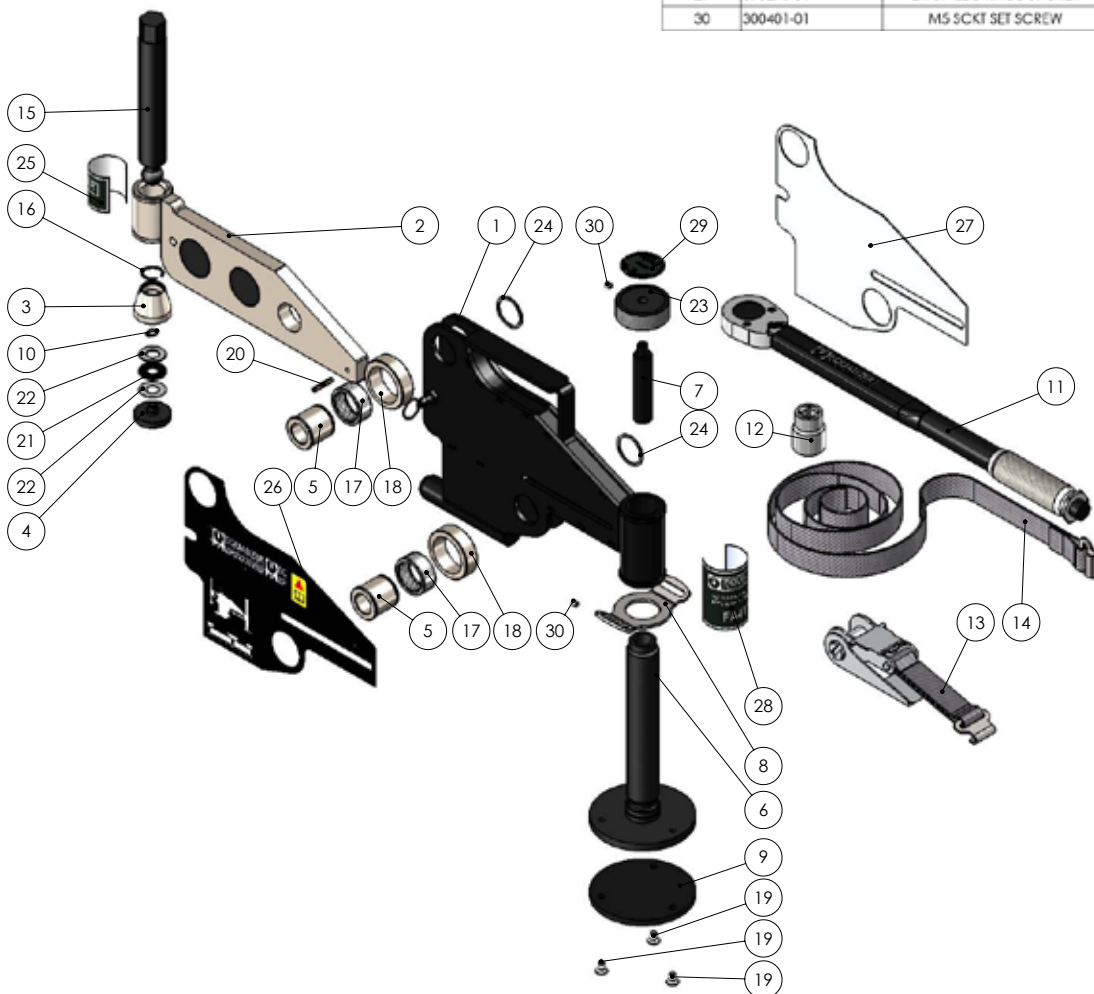


7. Ensure the thrust plate rotates freely before using the tool to align a flange joint.



5.5 PARTS LIST

ITEM NO.	PART NO	DESCRIPTION	Default/ QTY.
1	220100-01	MAIN BODY	1
2	401001-01	SLIDING ARM ASS	1
3	220300-01	SWIVEL	1
4	220400-01	FRICTION PAD	1
5	220500-01	ROLLER SHAFT	2
6	220600-01	LEG SCREW	1
7	220700-01	LEG SCREW EXTENSION	1
8	230802-01	BUCKLE	1
9	230803-01	ROUND BASE PAD FINISHED	1
10	212000-01	SPRING RING 8MM	1
11	400203-01	TORQUE WRENCH	1
12	400204-01	22 mm SOCKET	1
13	400270-01	RATCHET	1
14	400280-01	RATCHET STRAP	1
15	400301-01	SCREW BOLT	1
16	400401-01	SPRING CLIP	1
17	401501-01	NEEDLE BEARING	2
18	401601-01	OUTER ROLLER	2
19	402601-01	CTRS SCREW M6X10	3
20	403201-01	ROLLER PIN	1
21	404701-01	THRUST RACE	1
22	404801-01	THRUST WASHER	2
23	713001-01	RELEASE KNOB	1
24	901601-01	SPIROL CLIP	2
25	070004-01	LOGO FOR WING	1
26	070270-01	BODY PLATE STICKER LEFT	1
27	070271-01	BODY PLATE STICKER RIGHT	1
28	070272-01	EQUALIZER LOGO FOR BOSS	1
29	070273-01	DROP LEG KNOB STICKER	1
30	300401-01	M5 SCKT SET SCREW	2



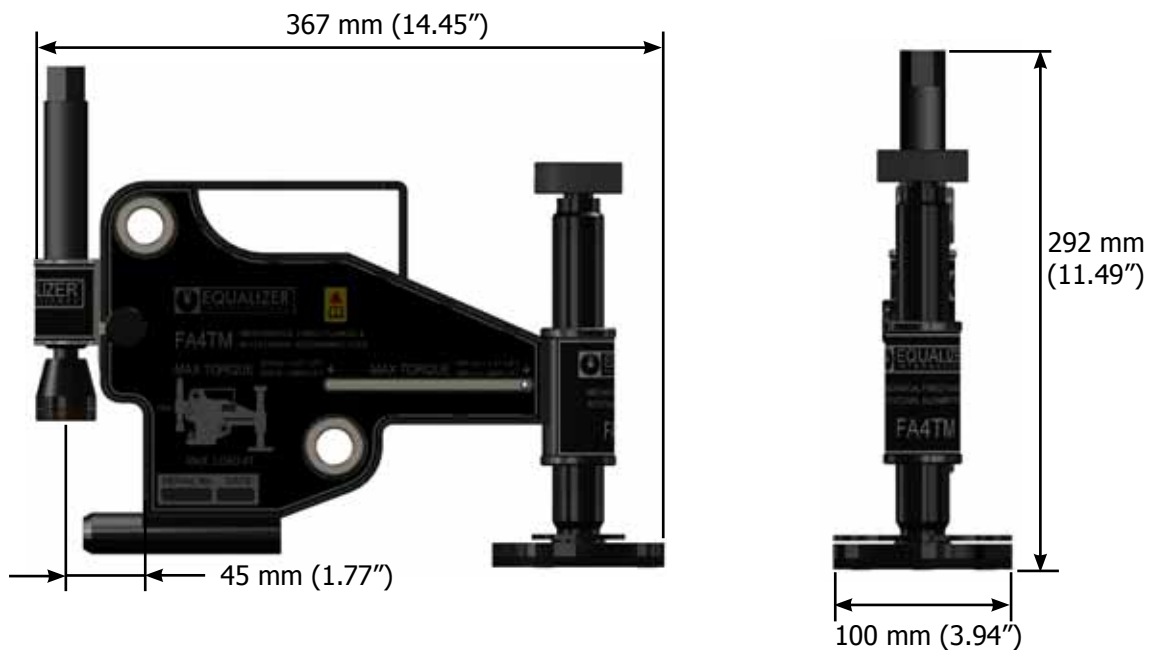
5.6 WEIGHTS AND DIMENSIONS

WEIGHTS

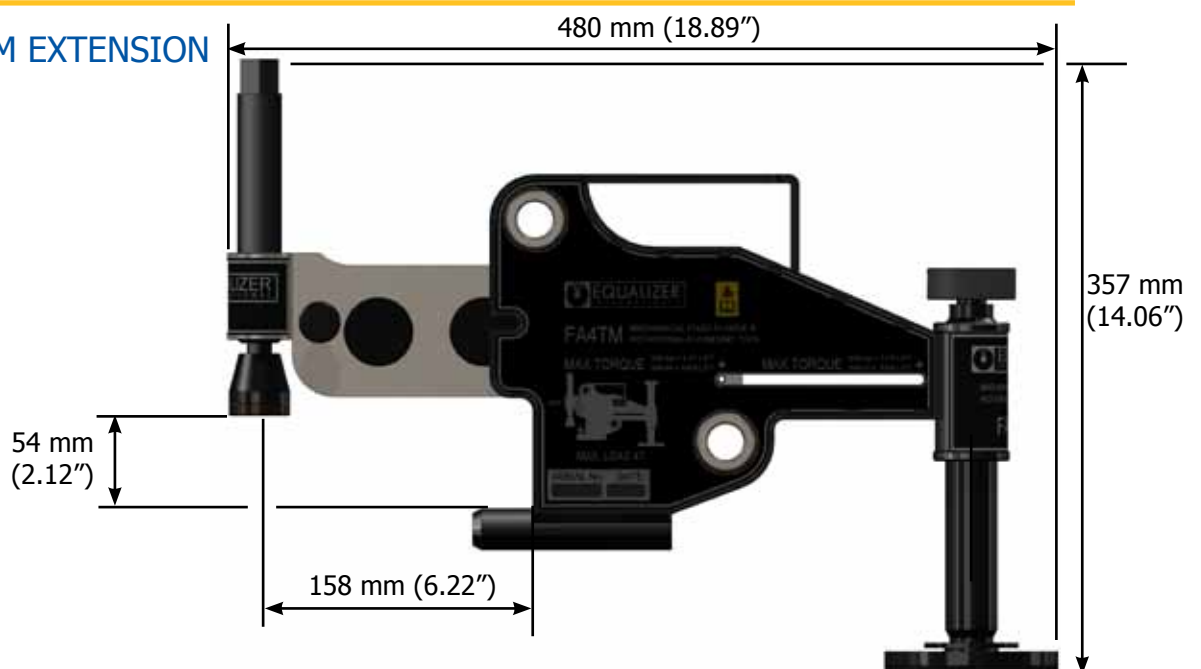
Tool only	= 8.6 kg (18.96 lbs)
Torque wrench/socket	= 0.9 kg (1.98 lbs)
Plastic Carry-Case	= 2.52 kg (5.55 lbs)
GROSS KIT WEIGHT	= 11.7 kg (25.8 lbs)

DIMENSIONS

MINIMUM EXTENSION



MAXIMUM EXTENSION



5.7 TROUBLESHOOTING

Problem: The thrust plate is sliding along the circumference of the opposite flange as the tool is aligning the joint

Grit or Dirt on wing, rollers or bearings

Ensure the rollers are rotating freely and that there is no restrictions to the rollers on the wing surfaces such as grit or dirt

Wing is at full extension

Ensure the wing has sufficient travel left in order to allow the joint to align

Problem: The tool is attached and appears to be functioning properly, but the joint will not align

There may be something restricting the joint from aligning

Check the area around the joint to establish if there is an obstruction to the joint

The joint may require more than 4.0T (40 kN) force to align

If the joint requires more force than that of the 4.0 T (40kN) tool, then another method of aligning should be adopted

Problem: The thrust plate is twisting on the circumference of the flange when the screw bolt is tightened

There may be Grit or Dirt within the swivel / thrust plate

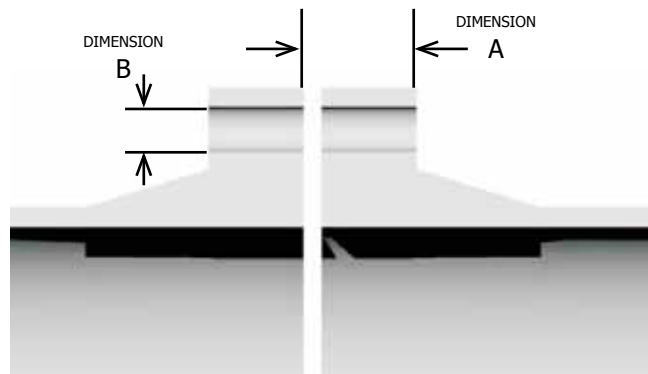
Check that the thrust plate rotates freely. If the thrust plate is not rotating then spray some penetrating liquid into the gap between the swivel and thrust plate in order to loosen it

5.8 APPLICATION DIMENSIONS

MINIMUM AND MAXIMUM FLANGE SIZES

Dimension A: must be between 30 and 133 mm (1.18" and 5.23")

Dimension B: bolt-hole diameter must be 24 mm (0.95") or greater



6. FA9TE HYDRAULIC FLANGE ALIGNMENT TOOL

6.1 KIT COMPONENTS

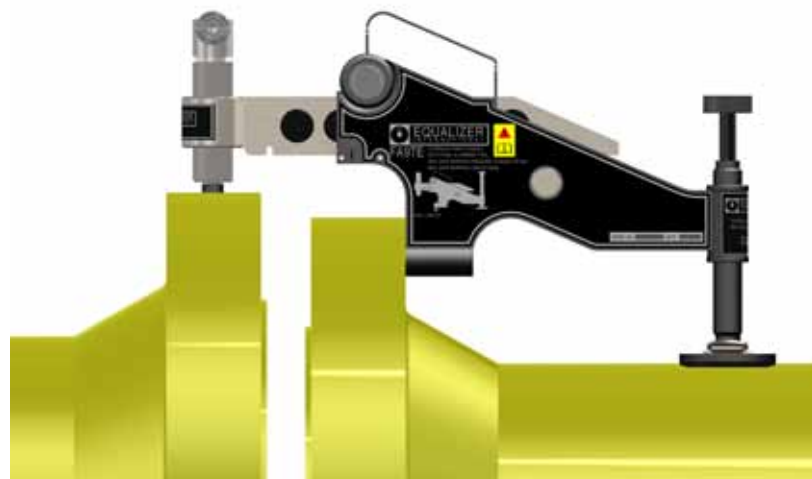
- 1 x FA9TE Tool c/w 6T Hydraulic Cylinder
- 1 x 10,000 psi (700 bar) Hydraulic Hose, 2m(78.75")
- 1 x 10,000 psi (700 bar) HP350S Sealed Hand Pump with Gauge
- 1 x Instruction Manual
- 1 x Carry-Case
- 1 x Ratchet & Strap

Product Code: FA9TESTD



6.2 HOW THE FA9TE WORKS

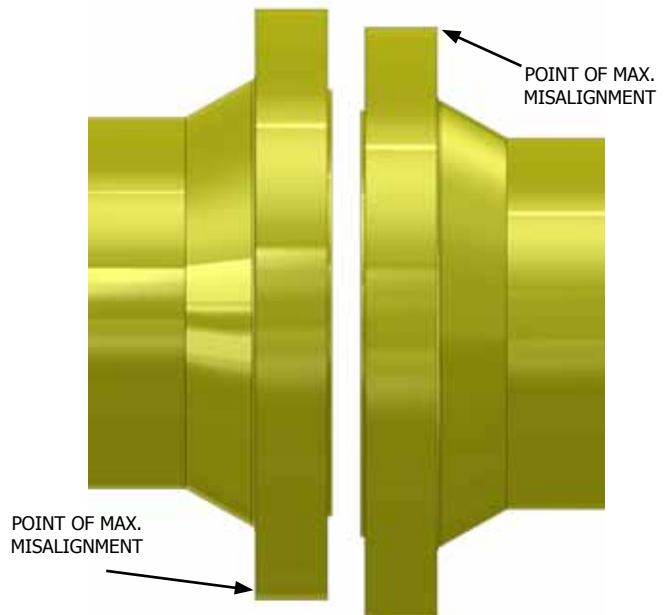
1. The FA9TE is secured to the lower of the two flanges by fully inserting the lift hook into the bolt-hole which is parallel with the bolt-hole at the point of greatest misalignment.
2. The drop leg is adjusted down onto the pipe while the tool is held up level in the bolt hole.
3. The release knob should be loosened to allow the wing to be extended out to the required distance.
4. The hydraulic cylinder should then be adjusted down onto the circumference of the flange opposite by rotating it in a clockwise direction.
5. The hydraulic hose and pump are attached to the cylinder and the hand pump is primed, bringing the joint into alignment.



6.3 INSTALLATION AND OPERATION

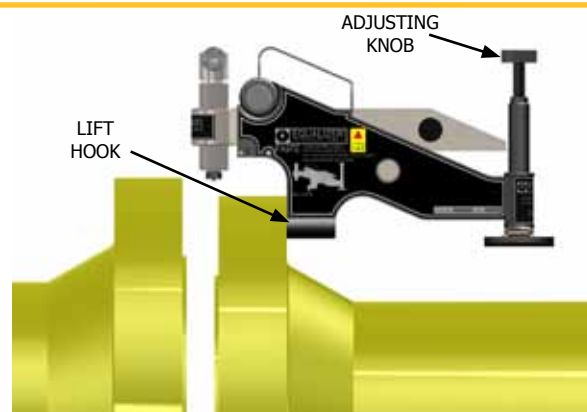
1. Carry out the Flange Misalignment Determination Procedure (see section 4) to determine the points of maximum misalignment.

In this example the points of maximum misalignment are at the top and bottom of the joint.



2. Guide the lift hook into the bolt-hole at the maximum point of misalignment.

Adjust the drop leg onto the pipe (using the adjusting knob) while holding the lift hook up level with the bolt-hole.

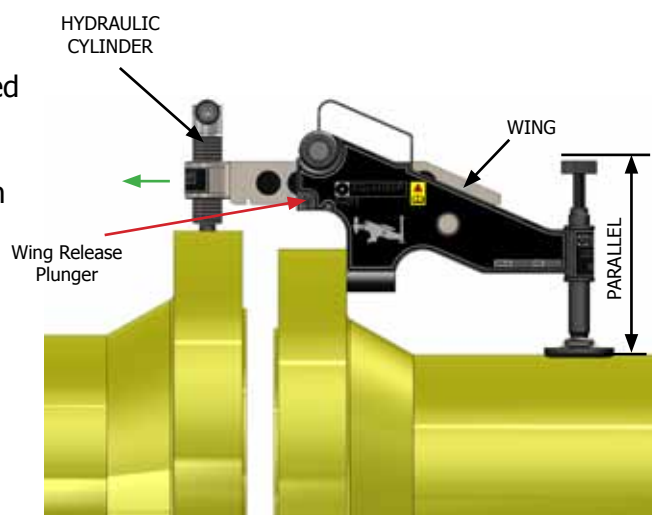


3. Loosen the wing release knob and extend the wing out to the required distance.

Rotate the hydraulic cylinder down until the base of the cylinder locates onto the surface of the opposite flange.

Ensure that the tool is sitting level and that the cylinder is in full and even contact with the surface of the opposite flange.

N.B. Ensure tool is parallel to pipe.



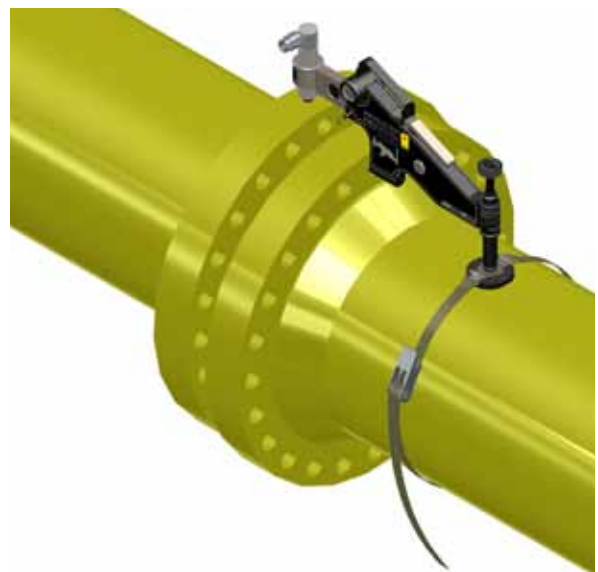
4. Attach the hook on the strap through the base plate as shown.



5. Now place the hook of the ratchet mechanism through the base on the opposite side as shown.



6. Feed the open end of the strap through the ratchet mechanism as shown. Tighten the strap using the ratchet mechanism.



7. Connect the hydraulic pump to the hydraulic hose, and the hose to the hydraulic adjusting cylinder.

Prime the pump until the joint comes into alignment.



8. Once in alignment the bolts may be inserted and tightened.

After replacing all of the bolts (apart from the bolt which will go into the bolt-hole in which the FA9TE is located), remove the tool by reversing steps 2 - 4.

Insert the last bolt and tighten.

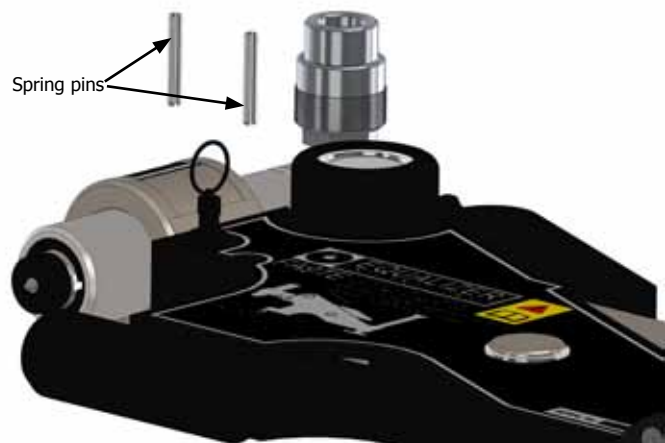


Care should be taken not to drop any of the component parts when removing them from the flange joint. This action will prevent injuries to either the operator's lower limbs, or to passers-by.

6.4 EXAMINATION, MAINTENANCE AND STORAGE

- On return from each job and before allocation against subsequent work the completeness of the Equalizer FA9TE kit must be established and items examined to ensure that they are serviceable
 - Any missing or damaged items are to be replaced as soon as possible and prior to the tool being used again
 - Store the FA9TE tool in a cool dry place and ensure all machined surfaces are greased
 - Return all items to carry case when not in use
 - Ensure rollers, pins and wing remain grit free and that the rollers rotate freely
 - Grease all moving parts regularly
-

1. Place the tool on a work bench and secure it in an upright position.
2. Remove 2 off the spring pins on the front of the main body as shown.



3. The wing can now be removed from the main body by sliding it forward.



4. Remove the circlip using a circlip pliers (not illustrated)



5. Remove the shaft and two bearings.

Inspect the bearing housing, shaft, and needle bearings for any sign of damage, dirt or grit. Clean then smear a small amount of grease onto the shaft and into the needle bearings.

Recommended grease - Rocol or Sapphire Hi-Load.



6. Remove the spirol retaining clips from the lower shaft and slide the shaft out from the main body.

The roller and needle bearing can be removed through the upper section of the tool as shown.

Inspect the roller, shaft and needle bearings for any sign of damage, dirt or grit. Clean and then smear a small amount of grease onto the shaft and into the needle bearings.

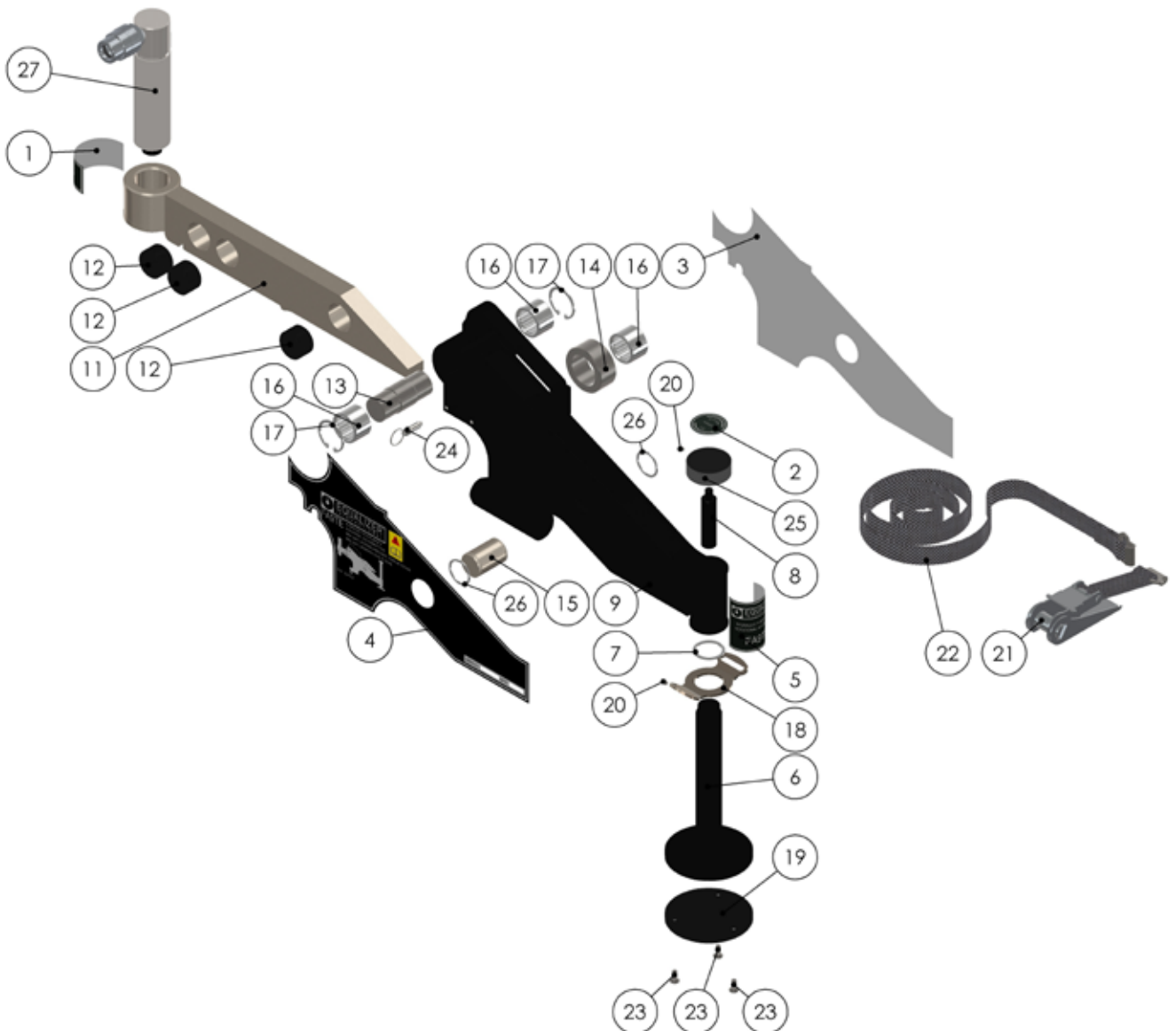
Recommended grease - Rocol Sapphire Hi-Load or equivalent Hi-Load Bearing grease



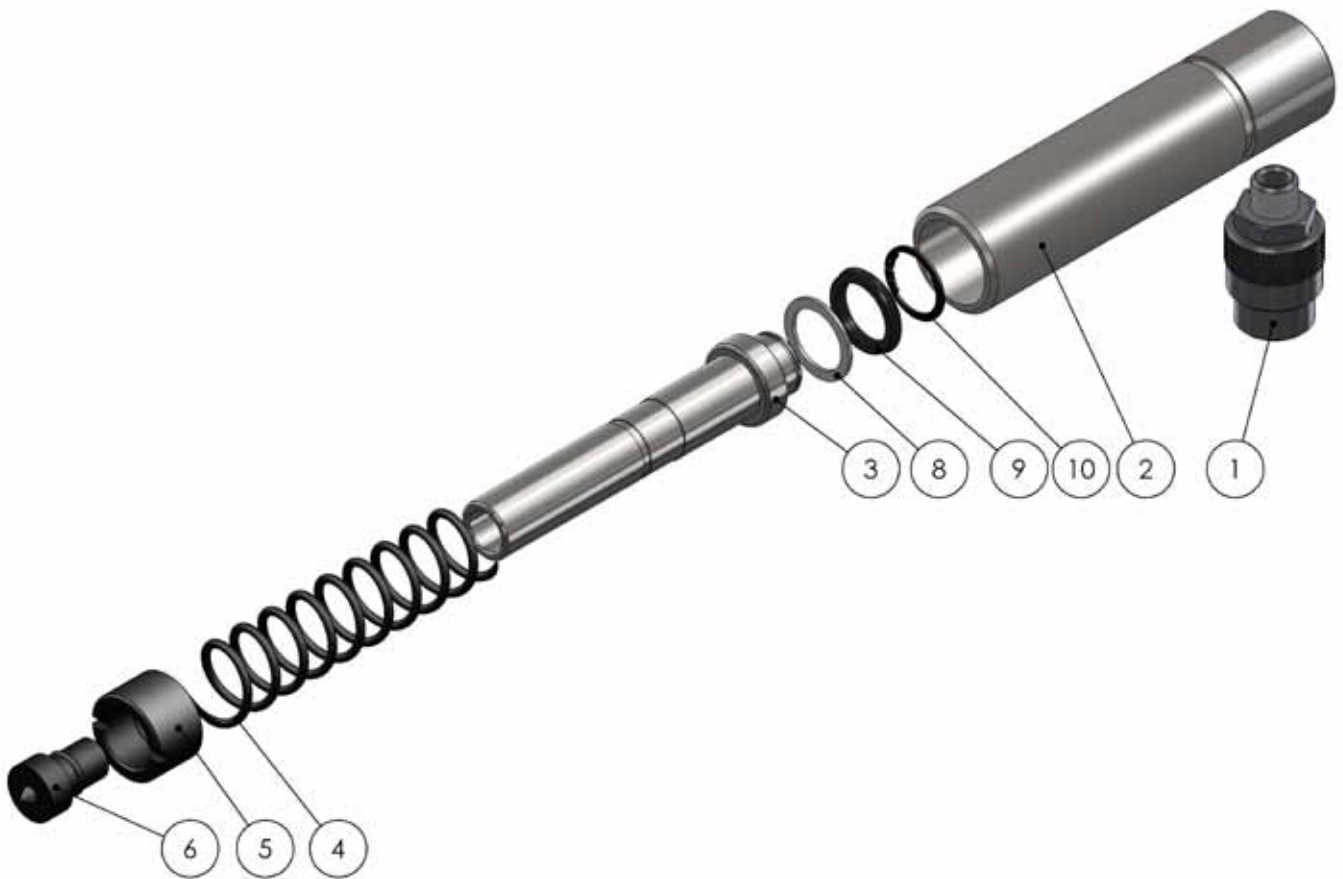
7. Re-assemble by reversing steps 2-6.

6.5 PARTS LISTS

Item	Part	Description	Qty	Item	Part	Description	Qty
01	070233-01	Logo For Wing	01 ea	16	230600-01	Needle Bearing	03 ea
02	070273-01	Drop L. Knob Sticker	01 ea	17	230700-01	Circlip O/D40	02 ea
03	070276-01	Body Plate Sticker L.	01 ea	18	230802-01	Buckle	01 ea
04	070277-01	Body Plate Sticker R.	01 ea	19	230803-01	Round Base Pad	01 ea
05	070278-01	Eq. Logo For Boss	01 ea	20	300401-01	M5 Sckt set screw	02 ea
06	220600-01	Leg Screw	01 ea	21	400270-01	Ratchet	01 ea
07	220602-01	Spirol Clip	01 ea	22	400280-01	Ratchet Strap	01 ea
08	220700-01	Leg Screw Extension	01 ea	23	400901-01	Ctrs Screw	03 ea
09	230100-01	Main Body	01 ea	24	632001-01	Spring Plunger	01 ea
10	230112-01	Spring Pin 5x36	01 ea	25	713001-01	Release Knob	01 ea
11	230200-01	Wing Arm	01 ea	26	901601-01	Spirol Clip	02 ea
12	230202-01	Plastic Insert	03 ea	27	903101-01	6T H. Cylinder	01 ea
13	230300-01	Front Roller Pin	01 ea				
14	230400-01	Rear Roller	01 ea				
15	230500-01	Rear Roller pin	01 ea				



Item	Part	Description	Qty
01	771110-01	Coupler	01 ea
02	903102-01	Puller Body	01 ea
03	903103-01	Puller Piston Rod	01 ea
04	903107-01	Compression Spring	01 ea
05	903108-01	Rod Wiper	01 ea
06	903109-01	Retaining Ring	01 ea
07	903110-01	6te Cylinder Service Kit	01 kit
08		Back-up Ring	01 ea
09		U-cup Seal	01 ea
10		Retaining Ring	01 ea



HP350S HAND PUMP

ITEM	PART No.	DESCRIPTION	KIT QUANTITY	PUMP QUANTITY
01	710101-01	PUMP HOUSING		01
	715100-01	SERVICE KIT A:		
02		- OIL FILTER	01	01
03		- O-RING	01	01
04		- RESERVOIR BLADDER	01	01
05		- REFILLING PLUG	01	01
06	710601-01	RESERVOIR		01
	725200-01	SERVICE KIT B:		
07		- TAIL BASE	01	01
08		- SCREW	04	04
09		- SPRING WASHER	04	04
10		- NUT	04	04
	715300-01	SERVICE KIT C:		
11		- O-RING	01	01
12		- BACK-UP RING	01	01
13		- PUMP PISTON	01	01
14		- SNAP RING	01	01
15		- O-RING	01	01
16		- BACK-UP RING	01	01
17		- PUMP PISTON	01	01
	715400-01	SERVICE KIT D:		
18		- HANDLE	01	01
19		- YOKE	01	01
20		- PISTON PIN	01	01
21		- YOKE PIN	01	01
22		- RETAINING RING	01	01
23		- HANDLE GRIP	01	01
24		- SCREW	01	01
	715500-01	SERVICE KIT E:		
25		- YOKE BASE	01	01
26		- SPRING PIN	01	01
	715600-01	SERVICE KIT F:		
27		- RELEASE VALVE SCREW	01	01
28		- WASHER	01	01
29		- SEAL	01	01
30		- SCREW	01	01
31		- RELEASE KNOB	01	01
32		- COUPLERS	01	01
33		- CHECK BALL	01	01
	715700-01	SERVICE KIT G:		
34		- SPRING	02	02
35		- STEEL BALL	02	02
36		- OUTLET BALL SPRING	02	02
37		- COPPER WASHER	02	02
38		- VALVE COVER SCREW	02	02
39		- STEEL BALL	02	02

ITEM	PART No.	DESCRIPTION	KIT QUANTITY	PUMP QUANTITY
	715800-01	SERVICE KIT H:		
40		- STEEL BALL	01	01
41		- SPRING END CAP	01	01
42		- L.P. SPRING	01	01
43		- O-RING	02	02
44		- OVERLOAD COVER SCREW	01	01
45		- CAP	02	02
46		- OVERLOAD COVER SCREW	01	01
47		- CONE SEAT	01	01
48		- CONE	01	01
49		- LONG SEPARATOR SPRING	01	01
	715900-01	SERVICE KIT I:		
50		- BASE PLATE	01	01
51		- SCREW	02	02
	716100-01	SERVICE KIT K:		
52		- SCREW	04	03
53		- SCREW	01	01
24		- SCREW	01	01
33		- CHECK BALL	04	03
	716200-01	SERVICE KIT L:		
54		- GAUGE COUPLER MALE	01	01
55		- GAUGE	01	01
	716300-01	SERVICE KIT M:		
56		- GAUGE COUPLER FEMALE	01	01
57		- COUPLER	01	01
58		- GAUGE PORT ADAPTOR	01	01



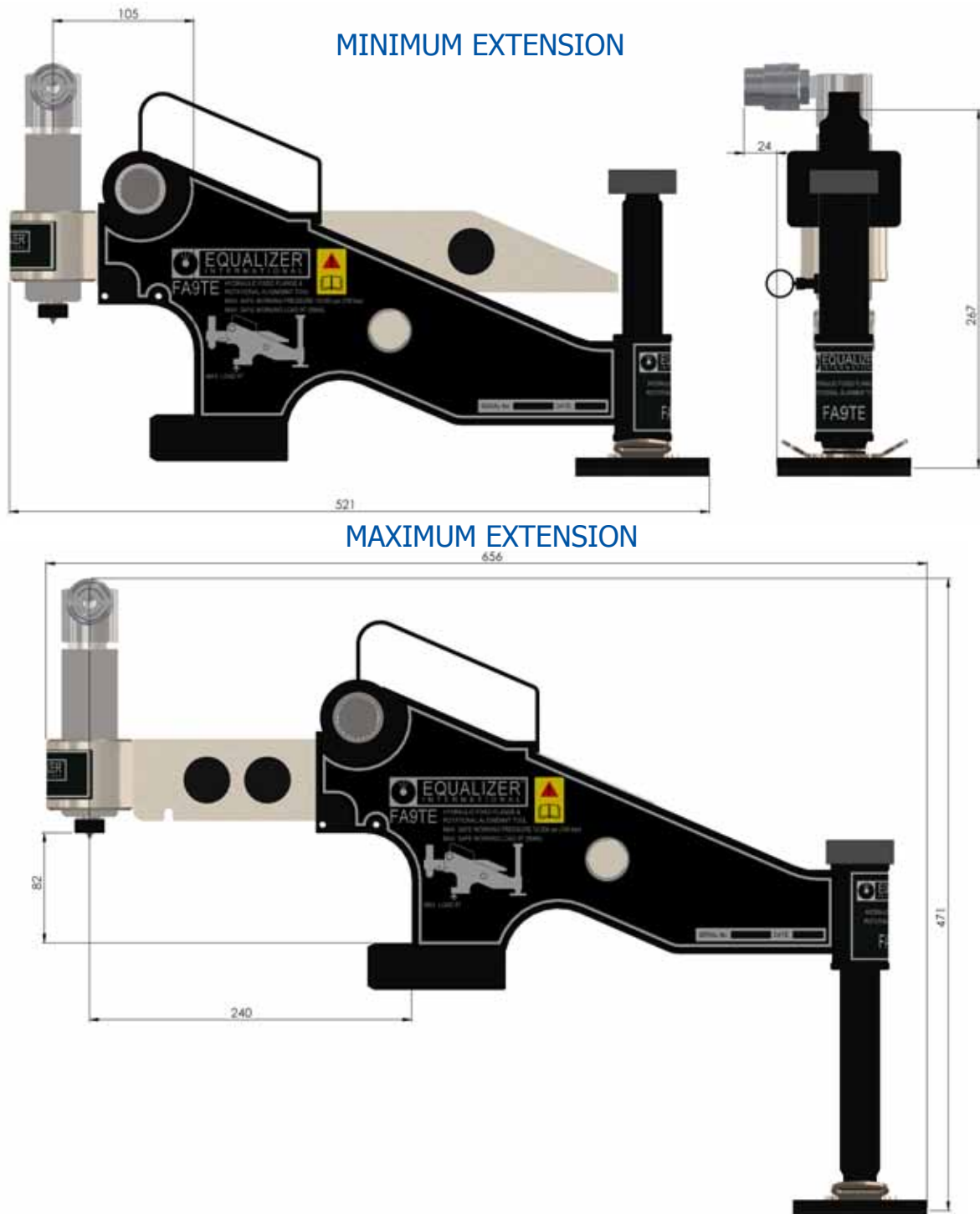
6.6 WEIGHTS AND DIMENSIONS

WEIGHTS

Tool with Hydraulic Cylinder
 HP350S Hand Pump
 Hydraulic Hose
 Plastic Carry-Case
GROSS KIT WEIGHT

= 15.5 kg (34.1 lbs)
 = 4.5 kg (9.9 lbs)
 = 1.0 kg (2.2 lbs)
 = 7.5 kg (16.5 lbs)
 = 28.5 kg (62.8 lbs)

OVERALL DIMENSIONS



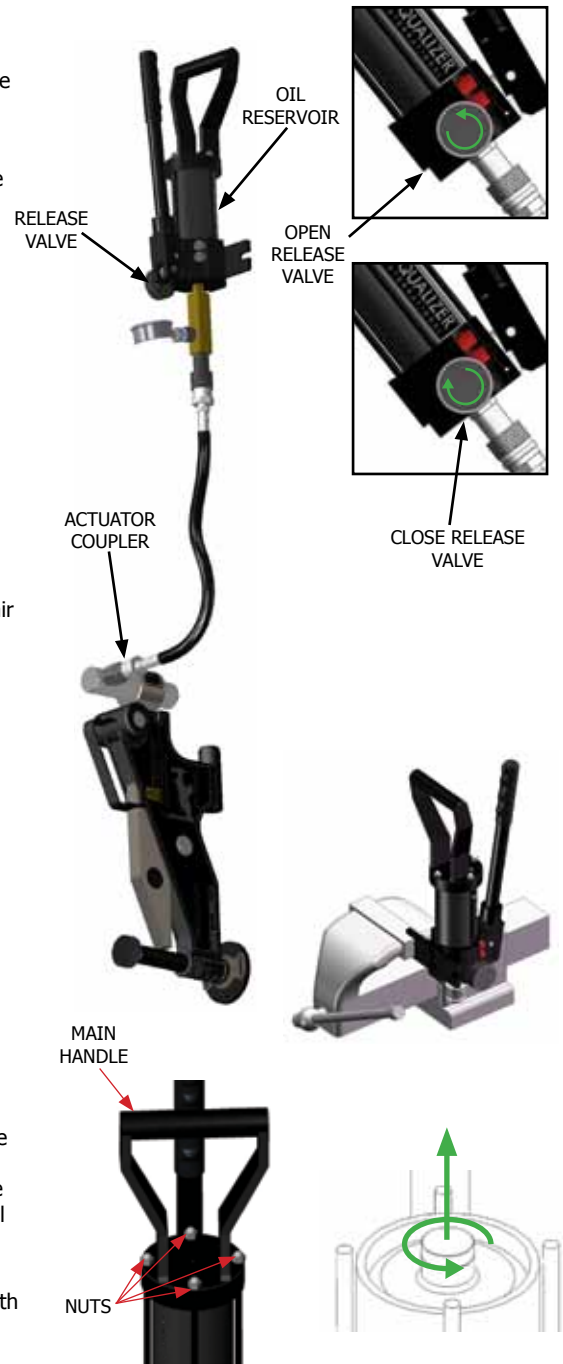
6.7 TROUBLESHOOTING

Problem: The tool is advancing but does not reach full pressure

→ Air could be present in the hydraulic system

→ Use the airlock removal procedure as follows:

1. Connect the hand pump to the tool with the hydraulic hose
2. Close the release valve on the pump, and prime the pump until the hydraulic cylinder is fully extended and a small pressure is achieved
3. With the hand pump held above the tool and the tool in an upright position, open the release valve causing any air that is within the system to be forced up through the pump and vented into the oil reservoir
4. Repeat steps 1 - 3 three or four times to ensure that all air is removed from the system and the tool will reach full working pressure
5. Disconnect the hand pump from the hydraulic hose, grip the baseplate of the hand pump body in a vice with the pump body vertical and the main handle at the top
6. Remove the four nuts holding the main handle and lift off
7. Grip the refilling plug with pliers and extract it by pulling and twisting simultaneously. Ensure the reservoir body is held down when removing the refilling plug as pulling up on the reservoir body will release the bladder within, and oil will spill out.
8. Fill the reservoir to the top with a good quality hydraulic oil of the grade 15 cSt
9. Reinsert the refilling plug, wipe away any oil, and reassemble by reversing the disassembly process



Problem: The friction pad is sliding in the circumference of the opposite flange as the tool is aligning the joint

- ↳ Grit or dirt on wing, rollers or bearings ↳ Ensure the rollers are rotating freely and that there is no restriction to the rollers on the wing surfaces such as dirt or grit
- ↳ Wing is at full extension ↳ Check that the wing is not at full extension when aligning the joint.
Ensure that there is enough extension left to allow the tool to expand as the joint is aligned.

Problem: The tool is attached and appears to be functioning properly, but the joint will not align

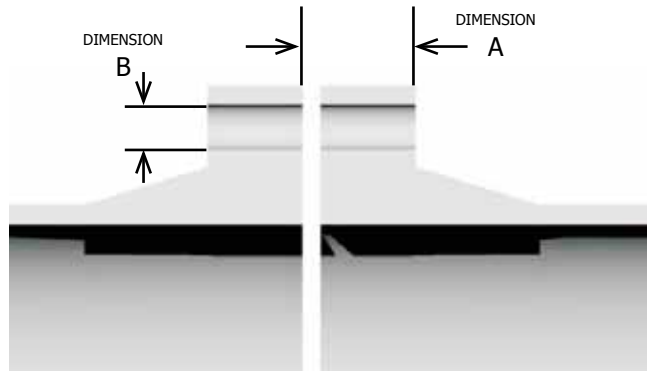
- ↳ There may be something restricting the joint at a point close to the flanges ↳ Check the area around the joint to establish if there is an obstruction to the joint
- ↳ The joint may require more than 9.0 T (90 kN) force to align ↳ If the joint requires more force than that of the 9.0 T (90 kN) tool, then another method of aligning the joint should be adopted

6.8 APPLICATION DIMENSIONS

MINIMUM AND MAXIMUM FLANGE SIZES

Dimension A: must be between 93 and 228 mm (3.66" and 9")

Dimension B: bolt-hole diameter must be 35.5 mm (1.40") or greater



7. RANGE OF APPLICATION

7.1 BS10 FLANGE RANGE OF APPLICATION

CLASS	TOOL	1/2"	3/4"	1"	1 1/4"	1 1/2"	2"	2 1/2"	3"	3 1/2"	4"	5"	6"	7"	8"	9"	10"	12"	13"	14"	15"	16"	17"	18"	19"	20"	21"	22"	23"	24"	26"	27"	29"	30"	33"	35"	36"	39"	42"	45"	48"	54"	60"	66"	72"	108"	120"
CLASS A	TOOL	FA1TM																																													
CLASS D	TOOL	FA1TM																																													
CLASS E	TOOL	FA1TM																																													
CLASS F	TOOL	FA1TM																																													
CLASS H	TOOL	FA1TM																																													
CLASS J	TOOL	FA4TM																																													
CLASS K	TOOL	FA9TE																																													
CLASS R	TOOL	FA4TM																																													
CLASS S	TOOL	FA1TM																																													
CLASS T	TOOL	FA1TM																																													

SUITABLE FOR FA1TM TOOL
SUITABLE FOR FA4TM TOOL
SUITABLE FOR FA9TE TOOL
NOT SUITABLE FOR TOOLS

API6B WELD NECK FLANGE RANGE OF APPLICATION

CLASS	TOOL	1 1/4"	1 1/2"	2"	2 1/2"	3"	3 1/2"	4"	5"	6"	7"	8"	9"	10"	11"	13 5/8"	16 3/4"	
CLASS 10K	TOOL	FA1TM																
CLASS 15K	TOOL	FA4TM																
CLASS 20K	TOOL	FA9TE																

API6B WELD NECK FLANGE RANGE OF APPLICATION

CLASS	TOOL	2 1/4"	2 1/2"	3"	3 1/2"	4"	5"	6"	7"	8"	9"	10"	11"	12"	13"	14"	15"	16"	17"	18"	19"	20"	
CLASS 2K	TOOL	FA1TM																					
CLASS 3K	TOOL	FA4TM																					
CLASS 5K	TOOL	FA9TE																					

7.2 ASME B16.5 FLANGE RANGE OF APPLICATION

CLASS	ASME B16.5 FLANGE RANGE OF APPLICATION																																																																																				
	150	160	170	180	190	200	210	220	230	240	250	260	270	280	290	300	310	320	330	340	350	360	370	380	390	400	410	420	430	440	450	460	470	480	490	500	510	520	530	540	550	560	570	580	590	600	610	620	630	640	650	660	670	680	690	700	710	720	730	740	750	760	770	780	790	800	810	820	830	840	850	860	870	880	890	900	910	920	930	940	950	960	970	980	990
CLASS 150	FA1TM																																																																																				
CLASS 300	FA4TM																																																																																				
CLASS 400	FA9TE																																																																																				
CLASS 600	FA4TM																																																																																				
CLASS 900	FA9TE																																																																																				
CLASS 1500	FA9TE																																																																																				
CLASS 2500	FA9TE																																																																																				

ASME B16.47 FLANGE RANGE OF APPLICATION

CLASS	ASME B16.47 FLANGE RANGE OF APPLICATION																																																																																				
	150	160	170	180	190	200	210	220	230	240	250	260	270	280	290	300	310	320	330	340	350	360	370	380	390	400	410	420	430	440	450	460	470	480	490	500	510	520	530	540	550	560	570	580	590	600	610	620	630	640	650	660	670	680	690	700	710	720	730	740	750	760	770	780	790	800	810	820	830	840	850	860	870	880	890	900	910	920	930	940	950	960	970	980	990
CLASS 150	FA9TE																																																																																				
CLASS 300	FA4TM																																																																																				
CLASS 400	FA9TE																																																																																				
CLASS 600	FA4TM																																																																																				
CLASS 900	FA9TE																																																																																				

DIN WELD NECK FLANGE RANGE OF APPLICATION

CLASS	DIN WELD NECK FLANGE RANGE OF APPLICATION																							
	PN16	PN25	PN40	PN64	PN100	PN160																		
CLASS PN16	FA1TM																							
CLASS PN25	FA1TM																							
CLASS PN40	FA4TM																							
CLASS PN64	FA4TM																							
CLASS PN100	FA4TM																							
CLASS PN160	FA4TM																							

SUITABLE FOR FA1TM TOOL
SUITABLE FOR FA4TM TOOL
SUITABLE FOR FA9TE TOOL
NOT SUITABLE FOR TOOLS

7.3 SPO FLANGE RANGE OF APPLICATION

CLASS	SPO FLANGE RANGE OF APPLICATION																										
CLASS 150	TOOL	FA1TM																									
	NPS	2 1/2"	3"	3 1/2"	4"	5"	6"	8"	10"	12"	14"	16"	18"	20"	22"	24"	26"	28"	30"	32"	34"	36"	38"	40"	42"	44"	46"
CLASS 300	TOOL	FA1TM												FA4TM													
	NPS	2 1/2"	3"	3 1/2"	4"	5"	6"	8"	10"	12"	14"	16"	18"	20"	22"	24"	26"	28"	30"	32"	34"	36"	38"	40"	42"	44"	46"
CLASS 600	TOOL	FA4TM												FA9TE													
	NPS	2 1/2"	3"	3 1/2"	4"	5"	6"	8"	10"	12"	14"	16"	18"	20"	22"	24"	26"	28"	30"	32"	34"	36"	38"	40"	42"	44"	46"
CLASS 900	TOOL	FA4TM												FA9TE													
	NPS	2 1/2"	3"	3 1/2"	4"	5"	6"	8"	10"	12"	14"	16"	18"	20"	22"	24"	26"	28"	30"	32"	34"	36"	38"	40"	42"	44"	46"
CLASS 1500	TOOL	FA4TM												FA9TE													
	NPS	2 1/2"	3"	3 1/2"	4"	5"	6"	8"	10"	12"	14"	16"	18"	20"	22"	24"	26"	28"	30"	32"	34"	36"	38"	40"	42"	44"	46"
CLASS 2500	TOOL	FA4TM												FA9TE													
	NPS	2 1/2"	3"	3 1/2"	4"	5"	6"	8"	10"	12"	14"	16"	18"	20"	22"	24"											
CLASS 5000	TOOL	FA4TM												FA9TE													
	NPS	2 1/2"	3"	3 1/2"	4"	5"	6"	8"	10"	12"	14"	16"	18"	20"	22"	24"											
CLASS 7500	TOOL	FA4TM												FA9TE													
	NPS	2 1/2"	3"	3 1/2"	4"	5"	6"	8"	10"	12"	14"	16"	18"	20"	22"	24"											
CLASS 10000	TOOL	FA4TM												FA9TE													
	NPS	2 1/2"	3"	3 1/2"	4"	5"	6"	8"	10"	12"	14"	16"	18"	20"	22"	24"											
CLASS 15000	TOOL	FA4TM												FA9TE													
	NPS	2 1/2"	3"	3 1/2"	4"	5"	6"	8"	10"	12"	14"	16"	18"	20"	22"	24"											

SUITABLE FOR FA1TM TOOL
SUITABLE FOR FA4TM TOOL
SUITABLE FOR FA9TE TOOL
NOT SUITABLE FOR TOOLS