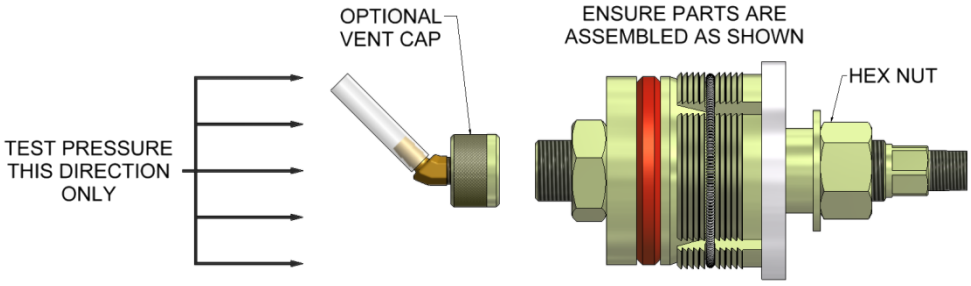
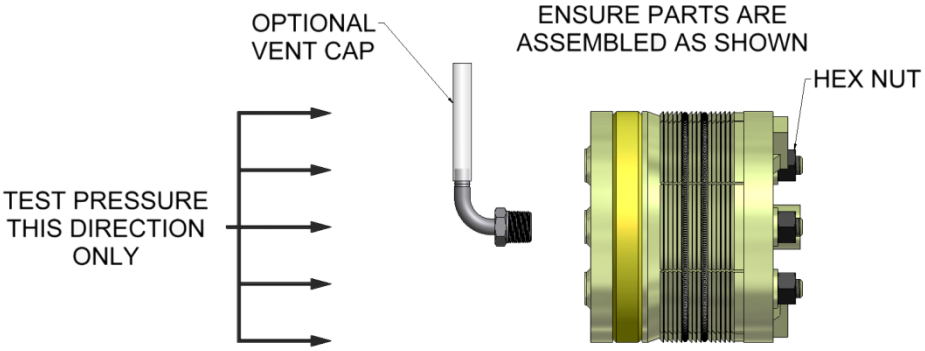
Operating Procedures for GripTight® High Pressure Test Plug

WARNING

- ⚠ Pressure testing is inherently dangerous. Strict adherence to these operating procedures and industry safety practices could prevent injury to personnel.
- ⚠ All personnel must be clear of the GripTight Test Plug during pressure testing. Never stand in the potential path of a GripTight Test Plug during testing.
- ⚠ Pressures must never exceed the maximum pressure rating of the weakest component in a system.
- ⚠ For safety, an incompressible liquid such as water should be used as the test medium. Residual air or gas must be evacuated from the pipe prior to testing. For horizontal testing applications, an optional GripTight Vent Cap (GTVC) will allow for venting of most air or gas. The GTVC is available for most GripTight Test Plugs.
- ⚠ GripTight Test Plugs are designed to withstand test pressure in the direction shown below. Do not use these plugs for reverse pressure applications.
- ⚠ Plug sizes and operating pressures do not apply to coated pipe. Contact EST Customer Service prior to using a GripTight Test Plug on any type of coated pipe or tube.



1" Through 6" GripTight High Pressure Test Plugs



8" GripTight High Pressure Test Plugs

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1. Test Preparation

Perform the steps outlined below prior to performing your pressure test.

Step/Action	*Additional Action/Information/Result*
1. Visually inspect the plug for worn or damaged components. Replace as needed.	• The surface between the Cone and Grippers must be free of friction producing dirt or corrosion. • The Seal should not contain any deformations, cuts or scores.
2. Tighten the Hex Nut(s) so the Grippers move freely to the end of the tapered Cone surface.	See table below
3. Verify that the pipe size and schedule stamped on the GripTight Test Plug is equivalent to the size of the pipe you are testing.	**NOTE:** Schedule 5 wall thickness pipe, or tubes with a wall thickness thinner than equivalent schedule 10 pipe, must have an OD restraint. Contact EST Customer Service for information.
4. Clean and dry the pipe ID.	• All moisture, debris, and excessive scale must be removed from the pipe ID to ensure a proper seal is established during the pressure test.
5. Liberally spread antiseize over both sides of the Hardened Washer and on the threads of the Shaft.	Failure to properly lubricate Shaft thread and Washer surfaces may result in unsafe operating conditions or plug leakage. **CAUTION** ⚠ Special caution must be taken when applying lubricant and handling the GripTight Test Plug. The lubricant must not come in contact with the Seal or inside of pipe or tube.

If	*then*
Grippers move freely to end of the tapered Cone surfaces,	loosen the Hex Nut(s) back to its/their original position(s) and go to the next step.
Grippers do not fully retract,	apply a light lubricant such as SAE 10w motor oil to the tapered surface of the Cone and wipe away any excess. Tighten the Hex Nut(s) so the Grippers move freely to the end of the tapered Cone surface.
you cannot easily tighten the Hex Nut(s) to allow full Gripper expansion,	do not use this plug for testing. Contact EST Group Customer Service for assistance.

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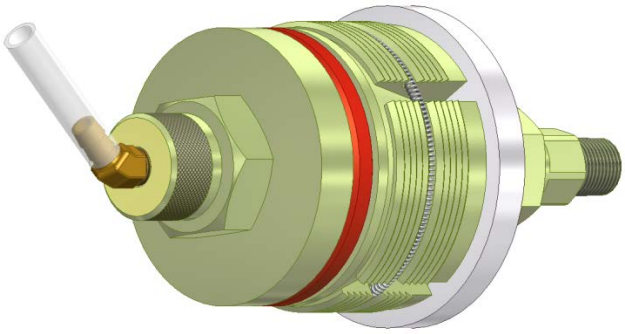


GripTight Test Plug with GripTight Vent Cap Installed

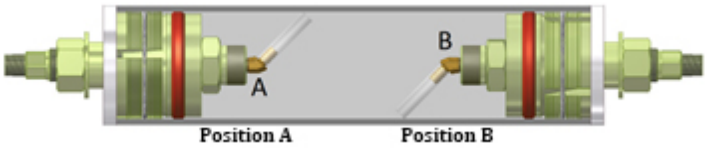
2. Installing and Using the GripTight Vent Cap

Perform the steps outlined below if you are using the optional GripTight Vent Cap (sold separately – Contact EST Group Customer Service for availability). Use of a GripTight Vent Cap to remove air from horizontal test applications is strongly recommended (see Table 2: GripTight Vent Cap Size Chart for sizing) . If you are not using the GripTight Vent Cap during your pressure test, then proceed to Section 3: Performing the Pressure Test.

Step/Action	*Additional Action/Information/Result*
1. Thread the GripTight Vent Cap on or into plug on the opposite side of the hex nut(s).	• The GripTight Vent Cap is now installed on the plug.
2. Cut or bend the Plastic Tube so that the open end just fits within the pipe ID. The open end of the plastic tube should be at the highest point within the pipe ID.	• The Plastic Tube should easily fit within the pipe.

Step/Action	*Additional Action/Information/Result*
3. Ensure GripTight Vent Cap is positioned correctly within the pipe prior to plug installation.	

If	*then*
venting air from the pipe prior to hydrostatic testing – GripTight Test Plug and Vent Cap (Position A),	install the GripTight Test Plug in the pipe with the GripTight Vent Cap Plastic Tube pointing up – towards the 12 o'clock position.
to remove test medium from the pipe following hydrostatic testing – GripTight Test Plug and Vent Cap (Position B),	install the GripTight Test Plug in the pipe with the GripTight Vent Cap Plastic Tube pointing down – towards the 6 o'clock position.
using GripTight Vent Caps in Position A and Position B,	fill the pipe from Position B and vent from Position A.

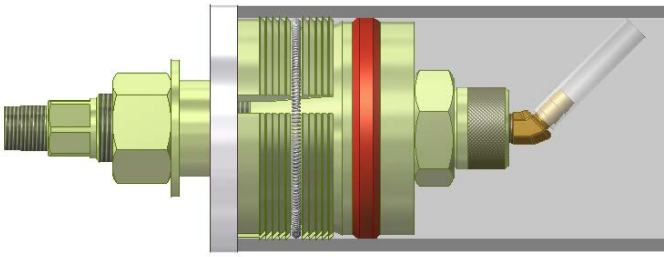


- To drain the test medium using low pressure air, introduce the compressed air through plug A. The hydrostatic test medium will be pushed out of the pipe through plug B. The pipe is drained of the test medium when air begins to come out of plug B. it may be helpful to attach a hose to plug B during this process to control the test medium.

3. Performing the Pressure Test

Perform the steps outlined below to perform a pressure test with the GripTight High Pressure Test Plug.

Step/Action	*Additional Action/Information/Result*
1. Place the GripTight Test Plug inside the pipe. The GripTight Test Plug must be able to fit with the full length of the Grippers inside the pipe.	



Note: The pipe ID must be clean, dry, and free of rust, scale, or debris.

Step/Action	*Additional Action/Information/Result*
2. Center the GripTight Test Plug within the pipe and hand tighten the Hex Nut(s) until the test plug has gripped the pipe ID. ***Note:*** Slight wiggling of the plug may allow for further hand tightening of the Hex Nut(s).	**If** / **then** using multi-shaft GripTight Test Plugs horizontally, → tighten the bottom Hex Nuts first to center the GripTight Test Plug within the pipe. using a multi-shaft GripTight Test Plug, → incrementally tighten the Hex Nuts in a star pattern.
3. Tighten the Hex Nut(s) with a calibrated torque wrench. See Table 1 for nominal and maximum installation torques.	**CAUTION** ⚠ Failure to apply at least the nominal installation torque may result in unsafe operation or leakage past the plug.
4. Install the pressure source. Inspect connections to ensure they are leak tight.	• For GripTight Test Plugs not being used to pressurize or vent the system, install a pipe cap (1" thru 6" GripTight Test Plugs) or pipe plug (8" GripTight Test Plugs) with a pressure rating that is greater than or equal to the maximum test pressure of the GripTight Test Plug being used.
5. Fill the pipe with test medium.	 • Introduce the test medium while evacuating any residual air or gas. Once all residual air or gas is vented, cap the GripTight Test Plug not connected to a pressure source. • Slowly introduce the test pressure. Test pressure must never exceed the maximum pressure rating of the weakest component in the test system. • Maximum test pressures based on 80% yield of ASTM A106 Grade B pipe is listed in Table 1.

6. Verify that GripTight Test Plug movement is within specified limits.	• Movement of the Shaft up to 0.10" (2.5 mm) is expected and acceptable. If Shaft movement is greater than 0.10" (2.5 mm), immediately release all pressure and remove the GripTight Test Plug.
	  • Examine the GripTight Test Plug components for wear. Replace as necessary.
	  • Reinstall the GripTight Test Plug, following all instructions provided.
	
	Note: Should movement of the Shaft or GripTight Test Plug after reinstallation exceed 0.10" (2.5 mm), stop the test, release all test pressure, and contact EST Group customer Service for technical assistance.

Step/Action	*Additional Action/Information/Result*
7. Perform the pressure test.	• Imperfections within the pipe being tested may cause small GripTight Test Plug leaks. • Additional tightening of the Hex Nut(s) may be required. Release all test pressure before making adjustments to the GripTight Test Plug. • Do not exceed the maximum torque for the GripTight Test Plug. See Table 1 for torque values.
8. Release all pressure from the system once the test is completed.	• Loosen the Hex Nut(s), remove the GripTight Test Plug from the pipe and then inspect the GripTight Test Plug for any deformation or damage.

4. Storage

Prior to storing, clean and dry the GripTight Test Plug. Re-lubricate the Shaft threads and between the Hex Nut(s) and mating surface as previously described in Section 1. Store the GripTight Test Plug in an area out of direct exposure to sun, UV light, or extreme temperatures. Heat in excess of 180°F (82°C) or UV light exposure will damage and prematurely degrade the Seal elements.

Questions?

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

- In USA and Canada: tel: 800-355-7044, fax: 215-721-1101, e-mail: est-info@curtisswright.com
- In Europe: tel: +31-172-418841, fax: +31-172-418849; e-mail: est-emea@curtisswright.com
- In Asia: tel: +65-6745-8560, fax: +65-6742-8700, e-mail: est-asia@curtisswright.com
- On the Internet at: http://estgroup.cwfc.com

EST Group provides a complete range of repair products, services, and replacement parts covering the life cycle of heat exchangers and condensers; additionally EST Group provides products and services to facilitate pressure testing pipe, piping systems, pressure vessels, and their components. Visit EST Group on the Internet at *http://estgroup.cwfc.com*.

Table 1 – GripTight Test Plug Installation Torque Specifications

SALES PART NUMBER	PIPE SIZE AND SCHEDULE inches	FUNCTIONAL ID RANGE inches (mm)	NOMINAL INSTALLATION TORQUE ft-lbs (N-m)	MAXIMUM INSTALLATION TORQUE ft-lbs (N-m)	MAXIMUM TEST PRESSURE(1) PsiG (BarG)
GT1P10	1" SCH 10	1.07 - 1.20 (27.2 - 30.5)	50 (67.8)	60 (81)	5000 (350)
GT125P160	1-1/4" SCH 160	1.13 - 1.24 (28.7 - 31.5)	50 (68)	75 (102)	9600 (660)
GT1P5	1" SCH 5	1.13 - 1.24 (28.7 - 31.5)	50 (68)	75 (102)	2900 (200)
GT125P80	1-1/4" SCH 80	1.25 - 1.33 (31.8 - 33.8)	50 (68)	75 (102)	7200 (500)
GT125P40	1-1/4" SCH 40/STD	1.31 - 1.43 (33.3 - 36.3)	50 (68)	75 (102)	5100 (350)
GT15P160	1 1/2" SCH 160	1.31 - 1.43 (33.3 - 36.3)	50 (68)	75 (102)	9400 (650)
GT125P10	1 - 1/4" SCH 10	1.41 - 1.49 (35.8 - 37.8)	75 (102)	150 (204)	3900 (270)
GT125P5	1-1/4" SCH 5	1.47 - 1.61 (37.3 - 40.9)	75 (102)	150 (204)	2300 (160)
GT15P80	1-1/2" SCH 80	1.47 - 1.61 (37.3 - 40.9)	75 (102)	150 (204)	6500 (450)
GT2PXXS	2" XXS	1.47 - 1.61 (37.3 - 40.9)	75 (102)	150 (204)	12000 (830)
GT15P40	1-1/2" SCH 40/STD	1.58 - 1.66 (40.1 - 42.2)	75 (102)	150 (204)	4600 (320)
GT15P10	1-1/2" SCH 10	1.66 - 1.77 (42.2 - 45.0)	75 (102)	150 (204)	3400 (240)
GT2P160	2" SCH 160	1.66 - 1.77 (42.2 - 45.0)	75 (102)	150 (204)	9200 (640)
GT15P5	1-1/2" SCH5	1.74 - 1.91 (44.2 - 48.5)	75 (102)	150 (204)	2000 (140)
GT25PXXS	2-1/2" XXS	1.74 - 1.91 (44.2 - 48.5)	75 (102)	150 (204)	12600 (870)
GT2P80	2" SCH 80/XS	1.91 - 1.99 (48.5 - 50.5)	75 (102)	150 (204)	5600 (390)
GT198T		1.98 - 2.06 (50.3 - 52.3)	75 (102)	150 (204)	see note 2
GT2P40	2" SCH 40/STD	2.04 - 2.13 (51.8 - 53.8)	75 (102)	150 (204)	3900 (270)
GT2P10	2" SCH 10	2.10 - 2.22 (53.3 - 56.4)	75 (102)	150 (204)	2700 (190)
GT25P160	2-1/2" SCH 160	2.10 - 2.22 (53.3 - 56.4)	75 (102)	150 (204)	8200 (570)
GT2P5	2" SCH 5	2.22 - 2.30 (56.4 - 58.4)	75 (102)	150 (204)	1600 (110)
GT25P80	2-1/2" SCH 80/XS	2.27 - 2.45 (57.7 - 62.2)	75 (102)	150 (204)	5900 (410)
GT3PXXS	3" XXS	2.27 - 2.45 (57.7 - 62.2)	75 (102)	150 (204)	11100 (770)
GT25P40	2-1/2" SCH 40/STD	2.44 - 2.54 (62.0 - 64.5)	150 (204)	300 (407)	4200 (290)
GT253T		2.53 - 2.63 (64.3 - 66.8)	150 (204)	300 (407)	see note 2
GT25P10	2-1/2" SCH 10	2.60 - 2.74 (65.9 - 69.6)	150 (204)	300 (407)	2400 (170)
GT3P160	3" SCH 160	2.60 - 2.74 (65.9 - 69.6)	150 (204)	300 (407)	7800 (540)
GT25P5	2"-1/2" SCH 5	2.68 - 2.78 (68.1 - 70.6)	150 (204)	300 (407)	1600 (110)
GT35PXXS	3-1/2" XXS	2.70 - 2.89 (68.6 - 73.4)	150 (204)	300 (407)	10200 (700)
GT3P80	3" SCH 80/XS	2.87 - 2.98 (72.9 - 75.7)	150 (204)	300 (407)	5200 (360)
GT296T		2.96 - 3.07 (75.2 - 78.0)	150 (204)	300 (407)	see note 2
GT3P40	3" SCH 40/STD	3.04 - 3.14 (77.2 - 79.8)	150 (204)	300 (407)	3700 (260)
GT4PXXS	4" XXS	3.12 - 3.32 (79.2 - 84.3)	150 (204)	300 (407)	9500 (660)
GT3P10	3" SCH 10	3.23 - 3.34 (82.0 - 84.8)	150 (204)	300 (407)	2000 (140)
GT3P5	3" SCH 5	3.30 - 3.41 (83.8 - 86.6)	150 (204)	300 (407)	1400 (100)
GT35P80	3-1/2" SCH 80/XS	3.33 - 3.44 (84.6 - 87.4)	150 (204)	300 (407)	4800 (330)
GT4P160	4" SCH 160	3.41 - 3.57 (86.6 - 90.7)	150 (204)	300 (407)	7400 (510)
GT35P40	3-1/2" SCH 40/STD	3.52 - 3.63 (89.4 - 92.2)	150 (204)	300 (407)	3300 (230)
GT4P120	4" SCH 120	3.60 - 3.74 (91.4 - 95.0)	150 (204)	300 (407)	6000 (410)
GT35P10	3-1/2" SCH 10	3.73 - 3.84 (94.7 - 97.5)	150 (204)	300 (407)	1700 (120)
GT35P5	3-1/2" SCH 5	3.80 - 3.91 (96.5 - 99.3)	150 (204)	300 (407)	1200 (80)
GT4P80	4" SCH 80/XS	3.80 - 3.91 (96.5 - 99.3)	150 (204)	300 (407)	4500 (310)
GT390T		3.90 - 4.01 (99.1 - 101.9)	150 (204)	300 (407)	see note 2
GT4P40	4" SCH 40/STD	4.00 - 4.11 (101.6 - 104.4)	150 (204)	300 (407)	3100(210)
GT5PXXS	5" XXS	4.03 - 4.25 (102.4 - 108.0)	150 (204)	300 (407)	8500 (590)
GT4P10	4" SCH 10	4.23 - 4.34 (107.4 - 110.2)	150 (204)	300 (407)	1500 (100)
GT4P5	4" SCH 5	4.28 - 4.47 (108.7 - 113.5)	200 (271)	380 (515)	1100 (80)

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Table 1 – GripTight Test Plug Installation Torque Specifications (continued)

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GT5P160	5" SCH 160	4.28 - 4.47 (108.7 - 113.5)	200 (271.2)	380 (515.2)	7000 (480)
GT442T		4.42 - 4.58 (112.3 - 116.3)	200 (271.2)	380 (515.2)	see note 2
GT5P120	5" SCH 120	4.53 - 4.69 (115.1 - 119.1)	200 (271.2)	380 (515.2)	5500 (380)
GT466T		4.66 - 4.82 (118.4 - 122.4)	200 (271.2)	380 (515.2)	see note 2
GT5P80	5" SCH 80/xs	4.78 - 4.91 (121.4 - 124.7)	200 (271.2)	380 (515.2)	4000 (280)
GT6PXXS	6" xxs	4.87 - 5.11 (123.7 - 129.8)	200 (271.2)	380 (515.2)	8200 (570)
GT5P40	5" SCH 40/std	5.02 - 5.14 (127.5 - 130.6)	200 (271.2)	380 (515.2)	2700 (190)
GT514T		5.14 - 5.26 (130.6 - 133.6)	200 (271.2)	380 (515.2)	see note 2
GT6P160	6" SCH160	5.16 - 5.37 (131.1 - 136.4)	200 (271.2)	380 (515.2)	6700 (460)
GT5P10	5" SCH10	5.27 - 5.39 (133.9 - 136.9)	200 (271.2)	380 (515.2)	1400 (100)
GT5P5	5" SCH 5	5.32 - 5.44 (135.1 - 138.2)	200 (271.2)	380 (515.2)	1100 (80)
GT534T		5.34 - 5.51 (135.6 - 140.0)	200 (271.2)	380 (515.2)	see note 2
GT6P120	6" SCH120	5.47 - 5.64 (138.9 - 143.3)	200 (271.2)	380 (515.2)	5100 (350)
GT562T		5.62 - 5.76 (142.7 - 146.3)	200 (271.2)	380 (515.2)	see note 2
GT6P80	6" SCH 80/xs	5.73 - 5.87 (145.5 - 149.1)	200 (271.2)	380 (515.2)	3900 (270)
GT588T		5.88 - 6.03 (149.4 - 153.2)	200 (271.2)	380 (515.2)	see note 2
GT6P40	6" SCH 40/std	6.04 - 6.17 (153.4 - 156.7)	200 (271.2)	380 (515.2)	2500 (170)
GT618T		6.18 - 6.32 (157.0 - 160.5)	200 (271.2)	380 (515.2)	see note 2
GT6P10	6" SCH10	6.33 - 6.47 (160.8 - 164.3)	200 (271.2)	380 (515.2)	1200 (80)
GT6P5	6" SCH5	6.38 - 6.52 (162.1 - 165.6)	200 (271.2)	380 (515.2)	940 (70)
GT653T		6.53 - 6.67 (165.9 - 169.4)	200 (271.2)	380 (515.2)	see note 2
GT668T		6.68 - 6.82 (169.7 - 173.2)	200 (271.2)	380 (515.2)	see note 2
GT8P160	8" SCH160	6.78 - 7.04 (172.2 - 178.8)	85 (115.2)	130 (176.3)	6400 (440)
GT8PXXS	8" xxs	6.85 - 7.09 (174.0 - 180.1)	85 (115.2)	130 (176.3)	6200 (430)
GT8P140	8" SCH 140	6.97 - 7.20 (177.0 - 182.9)	85 (115.2)	130 (176.3)	5700 (390)
GT8P120	8" SCH 120	7.16 - 7.37(181.9 - 187.2)	85 (115.2)	130 (176.3)	5100 (350)
GT730T		7.30 - 7.48(185.4 - 190.0)	85 (115.2)	130 (176.3)	see note 2
GT8P100	8" SCH 100	7.41 - 7.59(188.2 - 192.8)	85 (115.2)	130 (176.3)	4100 (280)
GT8P80	8" SCH 80/xs	7.60 - 7.75(193.0 - 196.9)	85 (115.2)	130 (176.3)	3400 (240)
GT769T		7.69 - 7.84(195.3 - 199.1)	85 (115.2)	130 (176.3)	see note 2
GT8P60	8" SCH 60	7.78 - 7.93(197.6 - 201.4)	85 (115.2)	130 (176.3)	2800 (190)
GT787T		7.87 - 8.02(199.9 - 203.7)	85 (115.2)	130 (176.3)	see note 2
GT8P40	8" SCH 40/std	7.95 - 8.10(201.9 - 205.7)	85 (115.2)	130 (176.3)	2200 (150)
GT8P30	8" SCH 30	8.04 - 8.19(204.2 - 208.0)	85 (115.2)	130 (176.3)	1900 (130)
GT8P20	8" SCH 20	8.10 - 8.25(205.7 - 209.6)	85 (115.2)	130 (176.3)	1700 (120)
GT820T		8.20 - 8.35(208.3 - 212.1)	85 (115.2)	130 (176.3)	see note 2
GT8P10	8" SCH 10	8.30 - 8.45(210.8 - 214.6)	85 (115.2)	130 (176.3)	980 (70)
GT8P5	8" SCH 5	8.38 - 8.53(212.9 - 216.7)	85 (115.2)	130 (176.3)	720 (50)

(1) NEVER use a test pressure greater than the maximum pressure rating of any component in the system. Test pressure specified in Table 1 is equivalent to 80% of the pressure that will yield ASTM A106 Grade B pipe at minimum specification. The test pressure for higher and lower strength pipes will differ proportionally. The maximum test pressure for higher strength pipe must never exceed the highest test pressure listed for that pipe OD. DO NOT use with internally coated pipe: Contact EST Group for technical issues.

(2) Sizes which do not have a test pressure listed differ from standard pipe sizes. These plug sizes are normally used to test tubing. For use of these GripTight Test Plug sizes in tubing with a minimum yield strength of 35 ksi (240 MPa), the maximum test pressure is estimated by the test pressure listed for the equivalent or next larger pipe OD with the equivalent or next thinner wall thickness. The test pressure for higher and lower strength tubes will differ proportionally. The maximum test pressure for higher strength tubes must never exceed the highest test pressure listed for the equivalent or next larger pipe OD. NEVER use a test pressure that exceeds the maximum pressure rating of any component in the system.

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Table 2: GripTight Vent Cap Size Chart

Pipe Size inches (mm)	SCH 5	SCH 10	STD	SCH40	XS	SCH80	SCH120	SCH160	XXS
1.25 (31.8)	GTVC-0088	GTVC-0088	*	*	*	*	*	*	*
1.50 (38.1)	GTVC-0088	GTVC-0088	GTVC-0088	GTVC-0088	GTVC-0088	GTVC-0088	*	*	*
2.00 (50.8)	GTVC-0088	GTVC-0088	GTVC-0088	GTVC-0088	GTVC-0088	GTVC-0088	*	GTVC-0088	GTVC-0088
2.50 (63.5)	GTVC-0125	GTVC-0125	GTVC-0125	GTVC-0125	GTVC-0088	GTVS-0088	*	GTVC-0088	GTVC-0088
3.00 (76.2)	GTVC-0125	GTVC-0125	GTVC-0125	GTVC-0125	GTVC-0125	GTVC-0125	*	GTVC-0125	GTVC-0088
3.50 (88.9)	GTVC-0125	GTVC-0125	GTVC-0125	GTVC-0125	GTVC-0125	GTVC-0125	*	*	GTVC-0125
4.00 (101.6)	GTVC-0150	GTVC-0125	GTVC-0125	GTVC-0125	GTVC-0125	GTVC-0125	GTVC-0125	GTVC-0125	GTVC-0125
5.00 (127.0)	GTVC-0150	GTVC-0150	GTVC-0150	GTVC-0150	GTVC-0150	GTVC-0150	GTVC-0150	GTVC-0150	GTVC-0125
6.00 (152.4)	GTVC-0150	GTVC-0150	GTVC-0150	GTVC-0150	GTVC-0150	GTVC-0150	GTVC-0150	GTVC-0150	GTVC-0150
8.00 (203.2)	GTVC-0075	GTVC-0075	GTVC-0075	GTVC-0075	GTVC-0075	GTVC-0075	GTVC-0075	GTVC-0075	GTVC-0075

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