



## **HIGH PRESSURE PLUG INSTALLATION PROCEDURE**

1. Clean (with solvent) and brush tubes to be plugged to approximately a four inch depth.
2. Establish Internal Profile of tube by taking internal measurements with an internal micrometer and GO NO GO gauge. The plug size selection will be based on these measurements.
3. Internally polish or hone tubes at the 0-ring location to provide better sealing surface.
4. Selected size Beta Model Mechanical Seal Plug is ready for insertion into tube with nut loose and jaws retracted (relaxed). Depending on the internal diameter the 0-ring may go in with or without interference. Ensure internal tube surface is cleaned and inspected for defects and irregularities which would prevent proper sealing.
5. Upon insertion into tube the jaws are ramped along the wedge ring taper via the tightening of the nut. The body can be restrained via inserting a correctly sized Allen wrench into the hex opening or using a standard wrench on the body flats on the body end. A spacer is used to recess the jaw/seal location (if required).
6. As the jaws are expanded the 0-ring seals are compressed thereby sealing the tube. Do not over-tighten. Refer to Torque Chart guidelines for applicable Torque Range per size.
7. In certain applications, it may be required to "double nut" the plug in order to prevent loosening, especially in smaller plug sizes.
8. Normally, the plug is inserted at the face of the tube sheet, however, the plug may be installed fully internal to the tube with the use of special nuts and tooling.

Note: For stainless steel sizes 202 and 203, a 1/8" Allen wrench is used; sizes 204 and 205 require a 3/16" Allen wrench.