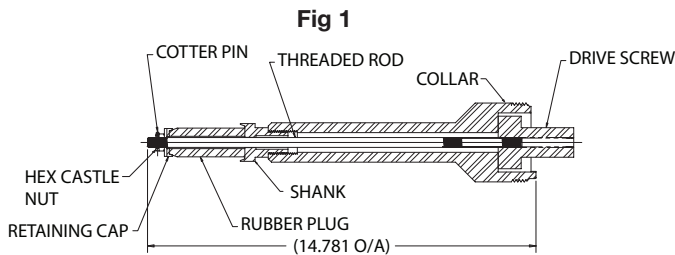


Operating Instructions

A. Preparation for Insertion of "Pig Friendly" Plug

- Assemble inserting/extracting tooling shown #682586– Fig 1.
DO NOT GREASE RUBBER PLUG.
(When engaging drive screw, do not over tighten. Stop when drive screw just stops spinning freely on threaded rod.



- Insert the inserting/extracting tool into hole in plug bottom until rubber stopper extends through bottom of plug. Shank should rest on the bottom of the plug – Fig 2.
- Rotate drive screw clockwise 15 revolutions. This expands the rubber stopper and secures the tool to the plug – Fig 2.
- Attach combined crank and lifting yoke to the H-17440 4SW stopping machine. Rotate crank counter-clockwise until operating tube and guide tube are exposed with enough room to secure the spring and spring bearing on the plug once it is secured to the stopping machine.
- Install spring and spring bearing on operating tube – Fig. 3.

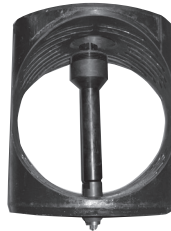


Fig 2

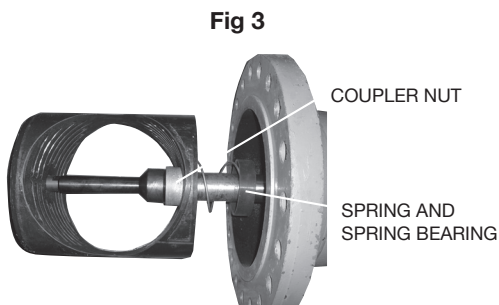


Fig 3

- Attach the plug to the stopping machine – Fig 3.
 - Insert square on drive screw into operating tube.
 - Align lug on top of collar with matching recess or slot in end of guide tube of machine.
 - Slide coupler nut over collar threads and tighten securely by hand.
 - Install spring and bearing onto plug boss.

- Rotate machine crank clockwise to retract plug and inserting/extracting tool, to rear most position, leaving 7" of the plug extended beyond bottom of the stopping machine flange – Fig 4.



Fig 4

- Position stopping machine on gate valve. ENSURE THE HOLE IN THE PLUG IS ALIGNED WITH THE PIPE WHEN THE STOPPING MACHINE IS ATTACHED TO THE GATE VALVE.
- Bolt stopping machine to gate valve with gasket in place (assure gasket is in serviceable condition).

B. "Pig Friendly" Plug Inserting Operation

- Close relief valve on gate valve, and open the bypass.

CAUTION: WHEN LIFTING THE ASSEMBLY DO NOT ALLOW WEIGHT TO REST ON PLUG AT ANY TIME AS DAMAGE TO PLUG COULD RESULT.

- Open gate valve fully.
- Use chalk to mark where the top of clamp bar is located relative to the guide post – Fig 5.
- Advance plug by rotating stopping machine crank, or double handled ratchet, counter-clockwise until squared section on operating tube screw is exposed. (Approximately 280 revolutions, 10" plug – 33.25" movement of clamp bar; 12" plug – 34.25" movement).
- Loosen wing nut and shift clamp bar from contact with guide post to contact with squared section of operating tube screw, then tighten wing nut.
- Rotate crank, or double-handed ratchet handle, counter-clockwise approximately 15 revolutions to release the inserting/extracting tool from the plug.
- Loosen wing nut and shift clamp bar from contact with squared section of operating tube screw to guide post, then tighten wing nut.
- Retract operating tube with the inserting/extracting tool attached to the rearmost position by rotating crank clockwise until it stops (approximately 280 revolutions).



Fig 5

(continued)

Operating Instructions (continued)

9. Fully close gate valve.
10. Close bypass valve and open relief valve.
11. Remove stopping machine.

C. "Pig Friendly" Plug Extracting Operation

1. Attach combined crank and lifting yoke to H-17440 4SW stopping machine.
2. Rotate crank counter-clockwise until ends of operating and guide tubes are exposed.
3. Attach inserting/extracting tooling to stopping machine.
 - a. Insert square on drive screw into operating tube.
 - b. Align lug on top of collar with matching recess or slot in end of guide tube of machine.
 - c. Slide coupler nut over collar threads and tighten securely by hand.
4. Retract inserting/extracting tool to rearmost position by rotating crank clockwise.
5. Position stopping machine on gate valve. Bolt stopping machine to gate valve with gasket in place (assure gasket is in serviceable condition).
6. Close relief valve, then open bypass.
7. Open gate valve fully.
8. Advance tool by rotating crank, or double handled ratchet, counter-clockwise until 1/2" of squared section is exposed on operating tube screw (approximately 280 revolutions, 10" plug – 33.25" movement clamp bar; 12" plug – 34.25" movement). Since the clamp bar moves with the plug note the origin of the clamp bar before advancing the plug into position. The distances given are from the clamp bar origin.
9. Loosen wing nut and shift clamp bar from contact with guide post to contact with squared section of operating tube screw. This allows the rubber plug to be expanded and "lock" onto the plug then tighten the wing nut.
10. Rotate crank or double-handled ratchet wrench clockwise approximately 15 revolutions to expand the rubber on the tool into the opening at the bottom of plug.

CAUTION: WHEN LIFTING THE ASSEMBLY DO NOT ALLOW WEIGHT TO REST ON TOOL AT ANY TIME AS DAMAGE TO TOOL COULD RESULT.

11. Loosen wing nut and shift clamp bar from contact with squared section of operating tube screw to guide post, then tighten wing nut.
12. Retract the operating tube with the inserting/extracting tool attached to the rearmost position by rotating crank clockwise until it stops (approximately 280 revolutions).
13. Fully close gate valve.
14. Close bypass and open relief valve.
15. Remove the stopping machine and tool.

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