

## Installation instructions

### Flexible pressure tool for BandJoint $\varnothing$ 225-800 mm

#### Pressure tool contents

Handle with pressure bands for flexible tool  $\varnothing$ 225 – 800.

Longitudinal pressure band for flexible pressure tool for casing joint 630 mm. Also available for casing joint 1020 mm.

All pressure bands are equipped with a safety valve.

Pressure rail for flexible tool for casing joint 630 mm. Also available for casing joint 1020 mm.

Pressure tube and reduction box for flexible pressure tool.

Pressure band for flexible tool for casing joint 630 mm. Also available for casing joint 1020 mm.

Pressure band and pressure rail for flexible tool for casing joint 630 mm. Also available for casing joint 1020 mm.



#### Maintenance

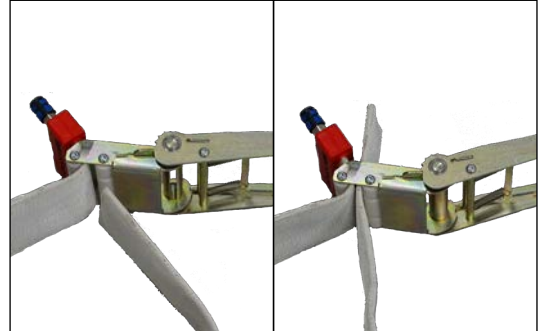
At regular intervals inspect tubes, tools, and safety equipment for damage.

## Installation instructions

### Flexible pressure tool for BandJoint ø 225-800 mm

#### Installing circumferential pressure tube in buckle tool

Insert the circumferential pressure tube in the handle for the flexible pressure tool as illustrated.



#### Installing BandJoint

Install the BandJoint in accordance with Weld Joint Manual p. 2.3.1-2.3.6.

It is recommended to install tape in the weld zones to ensure a long service life of the pressure tubes. Remove the tape, before leakage testing.

Now install the flexible pressure tool as described in the following.



#### Installing pressure tool

Place the pressure band for the flexible tool loosely on top of the casing joint.

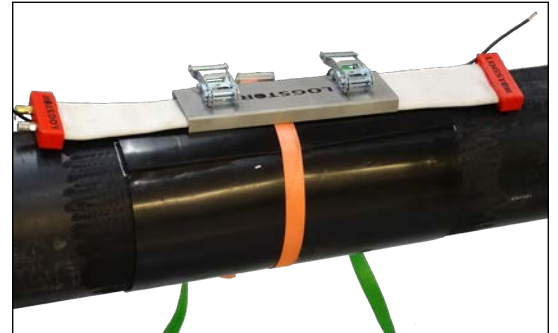


## Installation instructions

### Flexible pressure tool for BandJoint $\varnothing$ 225-800 mm

#### Installing pressure tool, continued

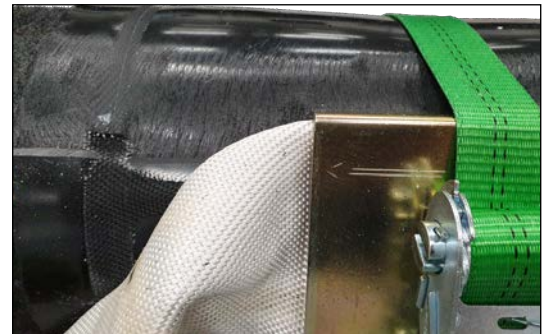
Place the pressure rail loosely over the tube.



Center the pressure rail and tube on the casing joint, so the pressure rail overlaps approx. 20 mm in relation to the overlap on the casing joint. Fix it with straps.



The arrows of the pressure rail are flush with the edge of the overlap on the casing joint at both ends.



Place the handle with pressure tube, as it appears from the illustration.

Pull the pressure tube around the pipe and insert it back into the handle.

Place the pressure tube, so it is 20-30 mm outside the rim of the casing joint.

Make sure the pressure tube is not twisted.



## Installation instructions

### Flexible pressure tool for BandJoint $\varnothing$ 225-800 mm

#### Installing pressure tool, *continued*

When the pressure tube has been placed in the handle and tightened, the two bolts must be in the middle of the pressure rail.



Pull the pressure tube tight, until the circumferential joint edge becomes visible through the pressure tube, corresponding to a pull of approx. 15-20 kg.

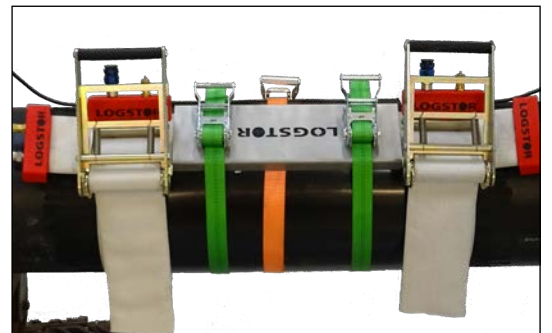
Repeat the procedure at the other end of the casing joint.



Be careful not to damage the terminals on the casing joint.



When the flexible pressure tool has been correctly installed as it appears from the illustration, connect the compressed air tubes.



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### Flexible pressure tool for BandJoint $\varnothing$ 225-800 mm

#### Connecting pressure tubes

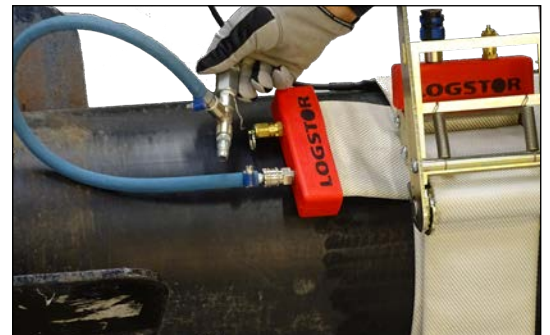
Connect the red tube (high pressure) to the reduction box.

Adjust the pressure on the reduction box to 1.5 bar. The pressure on the reduction box is guiding.

When the PDA is connected, check the pressure according to the PDA.



Install the small coupling on the longitudinal pressure band.



Install the big couplings on the circumferential pressure bands.



The valve of the distributor must be in closed position, until all pressure tubes have been connected.





## Installation instructions

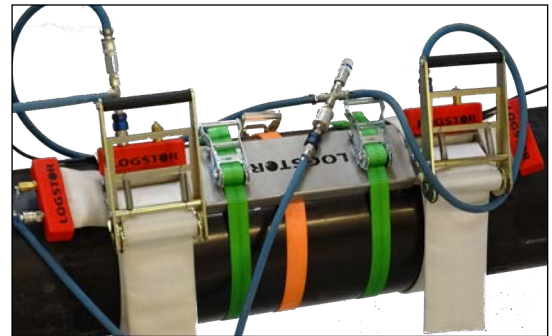
### Flexible pressure tool for BandJoint ø 225-800 mm

#### Connecting pressure tubes *continued*

Connect the blue tube (low pressure) to the reduction box.



When all tubes have been connected, open the valve, so the pressure bands are pressurized.



Connect welding cables, sense cables, and return air tube from the reduction box to the front of the WeldMaster/WeldMaster Light.

Connect the two cables from the WeldMaster/WeldMaster Light to the terminals in the casing joint - take care to make a good connection. Fasten the clamps.



Check that the pressure on the PDA is 1.5 bar. The WeldMaster/WeldMaster Light monitors that the pressure is within the allowable tolerances during the weld process (1.4 – 1.7 bar).

Now continue the installation as described in the Weld Joint Manual p. 2.3.12 and the WeldMaster section.

