

## INSTALLATION PROCEDURE

### **PRESSED STEEL ECONOMY CLAMPS:**

The Skinner Pressed Steel Economy Clamps are designed for use on Steel, Ductile and Cast Iron pipes to repair pit holes, splits, and corrosion leaks. This clamp can be used on pipes for Gas, Water, Oil, or Ammonia. Sizes and pressure ratings are as follows:

Size	Width	Bolt Torque	Max. Working Pressure
3"	Narrow	60 ft/lb	1000 psi
4"	Narrow	60 ft/lb	1000 psi
5"	Narrow	60 ft/lb	1000 psi
6"	Narrow	60 ft/lb	1000 psi
8"	Narrow	60 ft/lb	1000 psi
10"	Narrow	60 ft/lb	1000 psi
12"	Narrow	60 ft/lb	1000 psi
14"	Narrow	60 ft/lb	1000 psi
16"	Narrow	60 ft/lb	800 psi
18"	Narrow	60 ft/lb	800 psi
20"	Narrow	60 ft/lb	800 psi
24"	Narrow	60 ft/lb	800 psi

Size	Width	Bolt Torque	Max. Working Pressure
3"	Wide	60 ft/lb	500 psi
4"	Wide	60 ft/lb	500 psi
5"	Wide	60 ft/lb	500 psi
6"	Wide	60 ft/lb	500 psi
8"	Wide	60 ft/lb	400 psi
10"	Wide	60 ft/lb	400 psi
12"	Wide	60 ft/lb	300 psi
14"	Wide	60 ft/lb	300 psi
16"	Wide	60 ft/lb	300 psi
18"	Wide	60 ft/lb	200 psi
20"	Wide	60 ft/lb	200 psi
24"	Wide	60 ft/lb	200 psi

#### **Installation Procedure:**

Step #1	Thoroughly clean the damaged area with a wire brush. Remove all pipe scale, rust, and foreign material. This will help insure a "bubble tight" seal.
Step #2	Back off the ends of the bolts, but do not remove them. Separate halves and fit around pipe.
Step #3	On the "Wide" design, center the gasket over the area of the leak. Make sure the gasket extends past the damaged area. On the "Narrow" design, center the Cone Plug directly over the pinhole leak.
Step #5	Tighten the bolts evenly to the recommended torque shown above.
Step #6	Pressure test the complete installation for leaks.
Step #7	Check for leaks before leaving repair site.

#### **GASKET Material:**

Cone Plugs and Strip Gaskets are standard Buna-N (Nitrile Rubber) rated at 250 F Max to -20 F Min Temp, Cone Plugs are also available in Natural Rubber rated at 250 F Max to -76 F Min.

**IMPORTANT:  
DO NOT EXCEED TEMPERATURE OR PRESSURE RATINGS!**