



Figure 1



Figure 2



Figure 3



Figure 4

1. Confirm bore of 12" temporary gate valve is 12.5 inches. If the bore of your 12" temporary gate valves is smaller than 12.5 inches immediately call Hydra-Stop technical support (708-389-5111).

2. Remove cutter from saw mandrel.

3. Install completion plug onto saw mandrel. Grease O-ring with Primolube.

4. Install saw mandrel into the P-20 housing and through the tapping machine housing. Align the bottom of completion plug so that it is flush with the bottom of the P-20 housing (See Figure 1). NOTE: If completion plug is not aligned flush with the bottom of p-20 housing the completion process as outlined in this document will not be successful.

5. Lock the saw mandrel in place using the packing nut assembly thumb screw (See Figure 2).

6) Set Completion Plug depth. Choose one of the following methods.

6A) Install stop collar onto the saw mandrel. Set the bottom of the stop collar to 6.25 inches from the top of the packing nut assembly. (See Figure 3). Tighten stop collar.

6B) Fit **Black 6.25 inch Completion Gauge** included with your Hydra-Stopper line stopping equipment over the saw mandrel. (See Figure 4). Bottom of gauge should be resting on packing nut assembly. Lower stop collar until it rests on the top of the insertion gauge. Tighten stop collar. Remove insertion gauge.

7. Mount the tapping machine / P-20 housing assembly on the temporary gate valve. Use all twelve nuts and bolts provided with equipment.

8. Install the drive unit, or the optional completion spacer bar between the feedscrew and saw mandrel. Feed down the feedscrew until drive unit or completion spacer is locked in place. If using the air drive use the 19" feed screw, for hydraulic drive use the 30" feed screw.

9. Slowly open gate valve. Equalize pressure on the top side of the completion plug by using the ball valve on the tapping machine housing.

Completion Plug Installation Instructions continued on back



Figure 5

10. Loosen the packing nut assembly thumb screw and advance the feedscrew until the stop collar reaches the top of the packing nut assembly. Please note: it will become tighter when the completion plug o-ring starts to compress. Equalization may be required to fully seat the completion plug.

11. Once the completion plug is fully seated, lock the saw mandrel in place using the packing nut assembly thumb screw. Remove the pin plugs from the fitting flange and store them in a clean, safe location.

12. Tighten the six set pins in the fitting flange to lock the completion plug in place by turning them clockwise 10-11 turns (See Figure 5). Back off each of the six set pins a half a turn. Install the pin plugs back into the flange.

13. Verify completion plug seal by opening the blow off valve on the tapping housing.

14. Turn the feedscrew counter clockwise to remove the drive unit or completion spacer bar. Loosen the packing nut assembly thumb screw.

15. Disengage the saw mandrel from the completion plug by turning counter clockwise. Pull the saw mandrel into the P-20 housing. Tighten the packing nut thumb screw to secure the mandrel.

16. Close the gate valve.

17. Remove the tapping machine from the gate valve.

18. Remove the gate valve from the fitting top flange.

19. Install the blind flange on the fitting top flange.

20. Clean and inspect installation equipment prior to storage.

21. Order replacement parts, if necessary, to replace lost, damaged or worn componets.

Questions? Please call 800.538.7867

**HYDRA-STOP**<sup>®</sup>

SOLUTIONS FOR CONTROL

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Specifications subject to change without notice.