Caldertech
making the right connections


# Non-Hydraulic Squeeze Off Tools

## Operating Instructions

**Models: 125mm, 63mm, 63mm HD, 32mm Poket Squeeze Tool, Mini Squeeze Tool**
Revision: 02

Designed and Manufactured in the UK

# Helping you make the right connections.

# Contents

# 01. Introduction

## General Description

These tools have been designed to limit the flow in PE pipe from 16mm to 125mm (dependant on model) with a range of SDR squeeze plates for pipe work in accordance with Gas Industry Standards GIS/PL2-7 Part 7 Squeeze-off tools and equipment.

These products (Caldertech Manual Squeeze Tools) have been manufactured, inspected and tested in accordance with the ISO9001 quality control systems and procedures in place at Caldervale Technology Ltd, Dewsbury.

**Some Units covered in this manual have rotating pre-sized limiting plates that are used to limit the squeeze gap and prevent over compression of the PE pipe.**

## Important!

This tool should be used in accordance with the pipe manufacturers' recommendations and in line with local codes of practice.

This manual outlines the operation of the squeeze off tooling and forms a part of the product to which it relates. It should be kept for the life of the product. Any amendments issued by Caldervale Technology Ltd should be incorporated in the text. The manual should be passed to any subsequent holder or user of this product.

Caldervale Technology Ltd has a policy of continuous improvement in product quality and design. Caldervale Technology Ltd therefore reserves the right to change the specification of its models at any time, without prior notice.

**It is the responsibility of the operator to ensure that the PE pipe is suitable for squeeze off application if in doubt contact the PE pipe manufacturer for confirmation.**

### Before Using

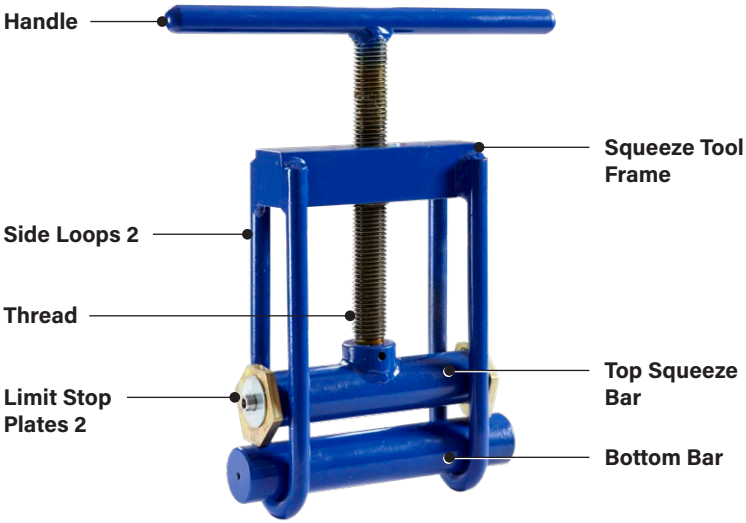
It is important to ensure all component parts are present and in serviceable condition. In addition, the setting of the limit stop (buffer) plates should be checked before every operation to ensure they are correct for the pipe size and wall thickness rating. Wrongly set buffer plates may cause insufficient or excessive pipe compression leading to pipe-wall damage, leakage or injury.

## 02. Safety Instructions

1. Read and understand the whole manual before using any squeeze tool.
2. It is imperative that all possible precautions are made to avoid unexpected movement of the tool during use.
3. To avoid injury the bottom bars should be removed or locked in position with the jack extended for transportation.
4. Operatives should wear eye protection, gloves, safety headwear and footwear when using the equipment.
5. A single squeeze tool cannot be guaranteed to provide 100% closure, where this is required users are advised to consider using 2 squeeze tools.

# 03. Operation

## Instructions for Use




1. Remove the Bottom bar from the loops in the mainframe.
2. Set the limit stop plates (if present) to the correct pipe diameter and SDR rating of the pipe to be squeezed. If the plates do not have the correct sizes, check for another set, exchange if necessary. The plates are set correctly when the correct end face is pointing downwards and positioned to contact the bottom bar when this is re-fitted.
3. Position the frame over the pipe to be squeezed and slide the bottom bar into the loops of the mainframe beneath the pipe, position the pipe centrally between the squeeze bar and bottom bar. If the bottom bar has a spacer bar on it this must point downwards when the tool is upright.
4. Commence turning the handle clockwise to apply squeeze pressure.
5. Continue the turning action until the squeeze bar has fully closed the pipe, and the limit stop plates prevent further compression.

## Removal After Squeeze Off

1. Unscrew the squeeze bar anticlockwise until the pipe is no longer in contact with the squeeze bars. This may require carrying out in controlled stages to prevent flow surges and excessive pressure drops in the pipework as the system fills up.
2. Allow the section of squeezed pipe to reform to its original shape, this may take several hours.
3. A selection of rerounding tools are available to help the pipe regain its original shape. These can be found at www.caldertech.com

## Storage

Replace the BOTTOM BAR into the FRAME. Turn the handle fully clockwise until the LIMIT PLATES come into contact with the BOTTOM BAR.

1. Place inside the carrying bag if included with the tool.
2. Ensure the tool is clean and dry before storing.

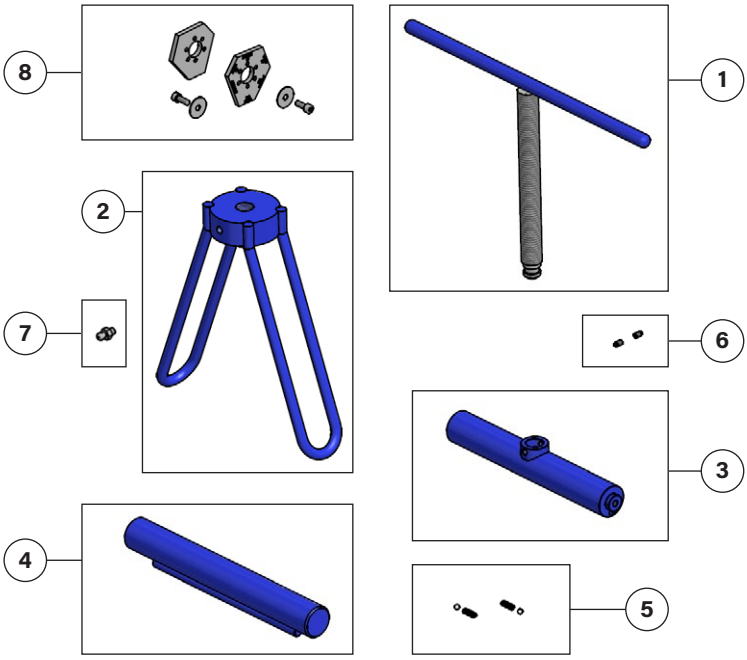
## Routine Maintenance

1. Grease screw thread at regular intervals.
2. The 125mm model is fitted with a grease nipple. It is recommended that this is used (where possible) at regular intervals to keep the screw thread properly lubricated.

# 04. 125mm 'A' Frame Squeeze Off Tool Specifications

| | |
|---|---|
| **Materials:** | Mild Steel EN3A, Chrome Plated Tube |
| **Finish:** | Powder Coating / Zinc Plated (Steel) |
| **Dimensions (HxWxD):** | 350mm x 420mm x 90mm |
| **Weight:** | 9.2kg |
| **Min Pipe Diameter** | 63mm |
| **Max Pipe Diameter:** | 125mm |
| **Product Codes:** | 02-31-801 (SDR11 and SDR17.6),<br>02-31-803 (SDR21),<br>02-31-804 (SDR 17.6),<br>02-31-805 (SDR11),<br>02-31-806 (SDR 11/17/26),<br>02-31-807 (SDR11 63/90/110 and SDR11 2"/3"/4" IPS) |

# 05. 125mm A Frame Squeeze Off Tool Parts Diagram

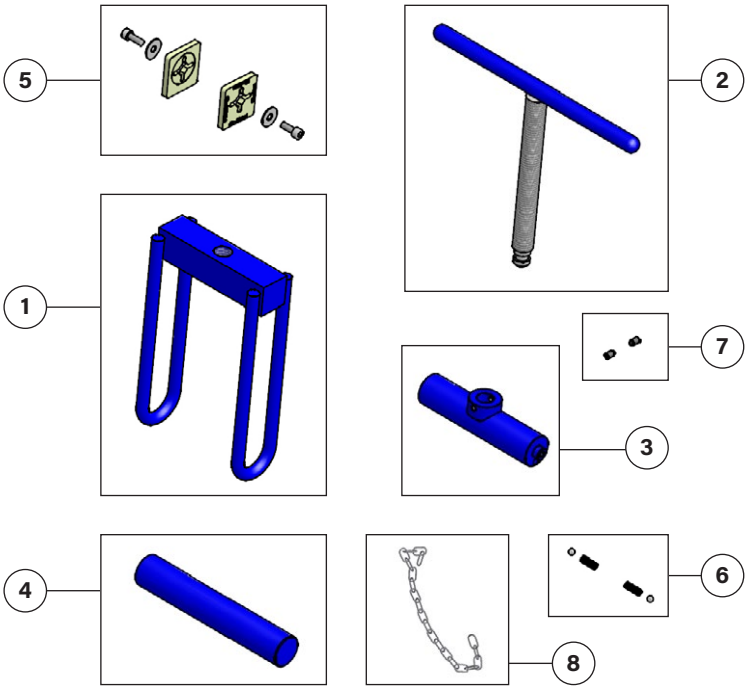



| Part | Product Code | Description |
|---|---|---|
| 1 | 02-31-843 | Handle and thread |
| 2 | 02-31-844 | 'A' Frame |
| 3 | 02-31-845 | Top Squeeze Bar |
| 4 | 02-31-835 | Bottom Squeeze Bar with Spacer Bar |
| 5 | 02-31-838 | Spring and Ball Bearing Kit |
| 6 | 02-31-846 | Squeeze Bar Grub Screws |
| 7 | 02-31-847 | Grease Nipple |
| 8 | 02-31-842 | Squeeze Plates SDR 21 |
| | 02-31-837 | Squeeze Plates SDR 11 & 17.6 |
| | 02-31-840 | Squeeze Plates SDR 17 |
| | 02-31-839 | Squeeze Plates SDR 11 |

# 06. 63mm Squeeze Off Tool Specifications

| | |
|---|---|
| **Materials:** | Mild Steel EN3A, Chrome Plated Tube |
| **Finish:** | Powder Coating / Zinc Plated (Steel) |
| **Dimensions (HxWxD):** | 300mm x 300mm x 60mm |
| **Weight:** | 4.8kg |
| **Min Pipe Diameter** | 20mm |
| **Max Pipe Diameter:** | 63mm |
| **SDR:** | 11, 17, 17.6, 26 |
| **Product Code:** | 02-31-202 |

# 07. 63mm Squeeze Off Tool Parts Diagram

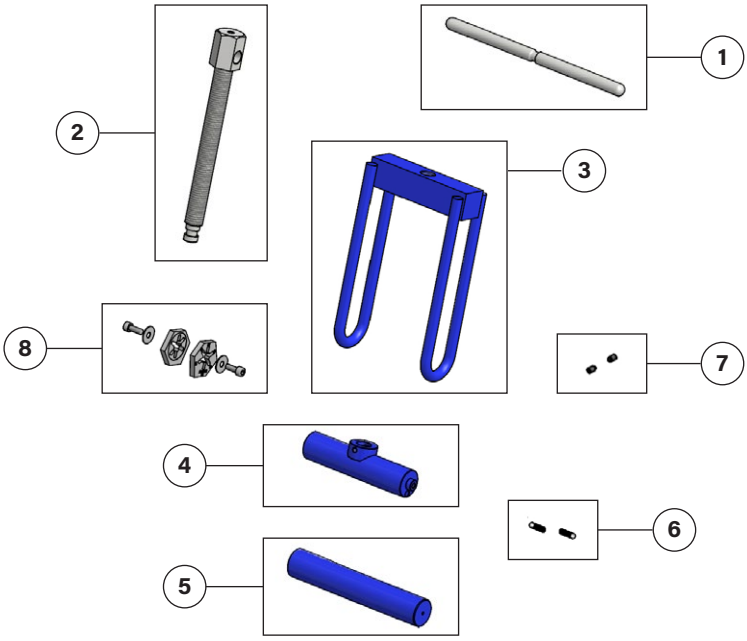



| Part | Product Code | Description |
|---|---|---|
| 1 | 02-31-250 | Main Frame |
| 2 | 02-31-251 | Handle and Thread |
| 3 | 02-31-252 | Top Squeeze Bar |
| 4 | 02-31-253 | Bottom Squeeze Bar |
| 5 | 02-31-270 | Squeeze Plate Kit SDR11 |
| 6 | 02-31-271 | Squeeze Plate Kit SDR17.6 |
| 7 | 02-31-272 | Squeeze Plate Kit SDR17 |
| 8 | 02-31-273 | Squeeze Plate Kit SDR 26 |
| | 02-31-673 | Spring and Ball Bearing Kit |
| | 02-31-254 | Squeeze Bar Grub Screws |
| | 02-31-257 | Retaining Chain (Selected Models Only) |

# 08. 63mm Super Heavy Duty Squeeze Off Tool Specifications

| | |
|---|---|
| **Materials:** | Mild Steel EN3A, Chrome Plated Tube |
| **Finish:** | Powder Coating / Zinc Plated (Steel) |
| **Dimensions (HxWxD):** | 300mm x 300mm x 60mm |
| **Weight:** | 4.8kg |
| **Min Pipe Diameter** | 20mm |
| **Max Pipe Diameter:** | 63mm |
| **SDR:** | 11, 17, 17.6, 26 |
| **Product Code:** | 02-31-401 |

# 09. 63mm Super Heavy Duty Squeeze Off Tool Parts Diagram

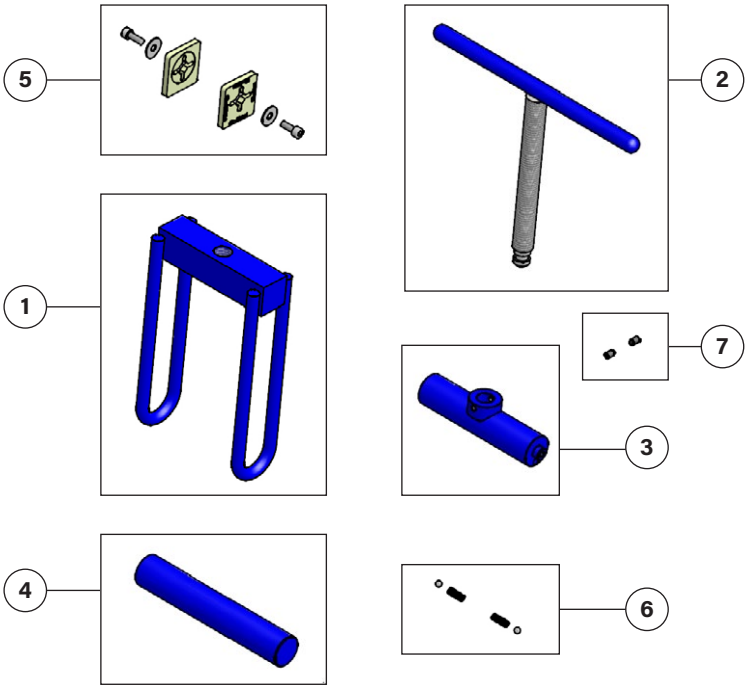



| Part | Product Code | Description |
|---|---|---|
| 1 | 02-31-258 | Removable Handle |
| 2 | 02-31-259 | Thread with hex head |
| 3 | 02-31-250 | Main Frame |
| 4 | 02-31-252 | Top Squeeze Bar |
| 5 | 02-31-253 | Bottom Squeeze Bar |
| 6 | 02-31-673 | Spring and Ball Bearing Kit |
| 7 | 02-31-254 | Squeeze Bar Grub Screws |
| 8 | 02-31-270 | Squeeze Plate Kit SDR11 |
| | 02-31-271 | Squeeze Plate Kit SDR17.6 |
| | 02-31-272 | Squeeze Plate Kit SDR 17 |
| | 02-31-273 | Squeeze Plate Kit SDR 26 |

# 10. 32mm Heavy Duty Squeeze Off Tool Specifications

| | |
|---|---|
| **Materials:** | Mild Steel EN3A, Chrome Plated Tube |
| **Finish:** | Powder Coating / Zinc Plated (Steel) |
| **Dimensions (HxWxD):** | 200mm x 130mm x 55mm |
| **Weight:** | 3kg |
| **Min Pipe Diameter** | 16mm |
| **Max Pipe Diameter:** | 32mm |
| **Product Code:** | 02-31-004 |

# 11. 32mm Heavy Duty Squeeze Off Tool Parts Diagram

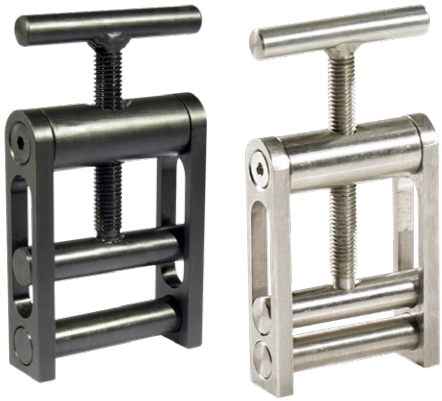



| Part | Product Code | Description |
|---|---|---|
| 1 | 02-31-030 | Main Frame |
| 2 | 02-31-031 | Handle and Thread |
| 3 | 02-31-032 | Spare Top Squeeze Bar |
| 4 | 02-31-033 | Bottom Squeeze Bar |
| 5 | 02-31-036 | Squeeze Plate Kit SDR11 |
| 6 | 02-31-673 | Spring and Ball Bearing Kit |
| 7 | 02-31-034 | Squeeze Bar Grub Screws |

# 12. Pocket Squeeze Off Tool Specifications

| | |
|---|---|
| **Materials:** | Mild Steel EN3A, Chrome Plated Tube<br>Stainless Steel (02-31-011 only) |
| **Finish:** | Powder Coating / Zinc Plated (Steel) |
| **Dimensions (HxWxD):** | 140mm x 85mm x 30mm |
| **Weight:** | <1Kg |
| **Min Pipe Diameter** | 16mm |
| **Max Pipe Diameter:** | 42mm |
| **SDR:** | All SDR Ratings |
| **Product Codes:** | 02-31-001,<br>02-31-011 (Stainless Steel Model) |

***Note:*** *This unit does not have limit stop plates included.*



# 13. Mini Squeeze Off Tool Specifications

| | |
|---|---|
| **Materials:** | Mild Steel EN3A, Chrome Plated Tube |
| **Finish:** | Powder Coating / Zinc Plated (Steel) |
| **Dimensions (HxWxD):** | 170mm x 80mm x 30mm |
| **Weight:** | <1Kg |
| **Min Pipe Diameter** | 16mm |
| **Max Pipe Diameter:** | 32mm |
| **SDR:** | All SDR Ratings |
| **Product Code:** | 02-31-002 |

***Note:*** *This unit does not have limit stop plates included.*

# 14. Warranty Information

## 1. Extent of Warranty

a) Subject to clauses 2 and 3, Caldervale Technology Ltd warrants to the end-user customer that its products will be free from defects in materials and workmanship, for six months after the date of purchase by the end-user customer, subject to providing proof of purchase.

b) If Caldervale Technology Ltd receives, during the warranty period, notice of a defect in product which is covered by this warranty; Caldervale Technology Ltd shall either repair or replace the product, at its option. Any replacement product may be either new or like-new, provided that it has functionality at least equal to that of the product being replaced.

c) All warranty work will be carried out by Caldervale Technology Ltd unless otherwise agreed. On-site warranty and repair or replacement services are available from authorised Caldervale Technology Ltd service facilities world-wide.

d) Customers shall prepay shipping charges for products returned to Caldervale Technology Ltd for warranty service, and Caldervale Technology Ltd will charge for return of the products back to the customer.

e) This warranty statement gives the customer specific legal rights. The customer may also have other rights which vary from country to country in the world.

## 2. Pre-conditions for Warranty Application

Caldervale Technology Ltd's warranty covers only those defects which arise as a result of normal use of the product, and this warranty shall only apply in the following circumstances:

a) All the instructions contained in the operating manual have been complied with; and

b) None of the following apply:

   i) Improper or inadequate maintenance;

   ii) Physical abuse;

   iii) Unauthorised modification, misuse or any use not in accordance with the operating manual and good industry practice;

iv) Operation outside the products specifications;

v) Improper site preparation or maintenance;

vi) Faulty pipes.

## 3. Limitations of Warranty

a) Caldervale Technology Ltd does not warrant the operation of any product to be uninterrupted or error free.

b) Caldervale Technology Ltd makes no other warranty of any kind, whether express or implied, with respect to its products. Caldervale Technology Ltd specifically disclaims the implied warranties of satisfactory quality and fitness for a particular purpose.

c) To the extent that this warranty statement is inconsistent with the law of the locality where the customer uses the product, this warranty statement shall be deemed modified by the minimum necessary to be consistent with such local law.

d) To the extent allowed by local law, the remedies provided in this warranty statement are the customer's sole and exclusive remedies.

e) This tool has been designed for the range of pipes available at the time of its design and development. Caldervale Technology Ltd can accept NO liability for the unit's ability or otherwise to work with new or different pipes that subsequently appear in the market place.

**Please complete this information and keep it safely with your proof of purchase receipt. You will require it for any warranty claim.**

Where purchased: _____

Date of purchase: _____

Name of purchaser: _____

Address of purchaser: _____

_____

_____

Type of tool: _____

Serial number: _____

# 15. Certificate of Conformity

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## Certificate *of* Conformity

This document certifies that the product detailed below fully conforms to the following standard without derogation.

**GIS/PL2-7:2013 Squeeze-off tools and equipment**

**Caldertech Manual Squeeze Tools**
**125mm, 63mm, 63mm HD, 32mm HD, Pocket and Mini**

**March 2019**

**I. Smith**
Managing Director

PRODUCT CONFORMITY · CALDERVALE TECHNOLOGY LTD · UNITED KINGDOM

**Caldervale Technology Ltd**
Bretfield Court, Dewsbury, West Yorkshire WF12 9BG, UK
CRN 2769288 | ISO 9001:2015 Certified FM 30989

# 16. Service and Repair

These products has no specific calibration period, however periodic safety inspections should be carried out by the operator as specified in this manual, if in any doubt please contact the manufacturer for further information.

For service and repair please contact:

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**Caldervale Technology Ltd**
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E. sales@caldertech.com
W. caldertech.com

**AUSTRALIA / NZ**
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Malaga WA 6090, Australia
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E. sales@caldertech.com.au
W. caldertech.com.au

# 17. Decommissioning and Disposal

These give the instructions for decommissioning and disposal of the equipment and confirm how it is to be taken out of service safely, in respect of the Essential Environmental, Health and Safety Requirements.

- If a Caldertech Manual Squeeze tool has reached the end of its useful working life and cannot be refurbished it must be sent to a licensed recycling facility for treatment. That will ensure the waste hierarchy requirements are met.
- End of life treatment is the responsibility of the Customer. This can also be achieved by returning the product back to the manufacturer if required.

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