

PLEASE READ THESE INSTRUCTIONS CAREFULLY BEFORE APPLYING THE BLASTING PLUG

1. Prepare the pipe-ends with Blasting Plugs when the pipes are lying still before the blasting process. Insert a Blasting Plug in each pipe-end. Never use one Blasting Plug. Always use two plugs on both pipe-ends that run against each other. In the oven: Make sure the temperature of the Blasting Plug remains < 100°C
2. If your blasting plugs are equipped with a clamping spoke, practice fitting and removing the blasting plugs before you start production. For tensioning, turn the handle in the middle to the right. For releasing tension, turn the handle to the left. Always release tension first, before removing the blasting plug. You can fine-tune the tensioning force by adjusting the spring in the clamping spoke.



Fig. 1

3. Make sure that the blasting plug is pushed inside the pipe-end as deeply as possible. When used for the first time, the blasting plugs have a tight fit. After a couple of runs, fitting becomes easier. If fitting is difficult you can use a rubber hammer, but be careful not to damage the blasting plug.



4. If there is space between the pipes during heating or blasting, the plugs can damage due to heat or impact of steel grit. The blasting plug can be equipped with special options to prevent damage. Contact Dhatec for more information.
5. After blasting, the blasting plugs can easily be removed by pulling on the handgrips or three-way spoke. This can be done while the pipes are turning or in a resting position, but always make sure you work in a safe way. If your blasting plugs are equipped with a clamping spoke, make sure you release tension of the clamping spoke first, by turning the handle in the middle to the left. After that, the blasting plug can be removed.
6. Transport the blasting plugs back to the beginning of the process.

NOTE:

- Extra rubber underlays are available for applying the same blasting plug on pipes with smaller wall thicknesses (up to 5 mm wall thickness range).
- When used correctly the blasting plug will last between 500-1000 runs depending on the process. Some parts of the blasting plug are exchangeable for repair. Contact Dhatec for more information.

For more options and instructions regarding blasting plugs, see: www.dhatec.nl