Pressed Steel Clamp

Repairs Badly Pitted and Corroded Pipe Lines



Model "PS" Wide

Model "PS" Narrow



The Pressed Steel Clamp is used for repairing badly pitted and corroded pipe lines at minimum cost.

This is not a thin spring-steel band with attached lugs. It is a 3/16 thick, heavy steel plate with inseparable wedge-shaped lugs pressed out of the material itself. This special construction prevents any give or collapse of the lug so that the full amount of take-up pressure applied by the bolts is transmitted directly to the gasket over the leak. While the clamp is heavy enough to outlast the pipe, it is still sufficiently flexible to conform to the pipe surface.

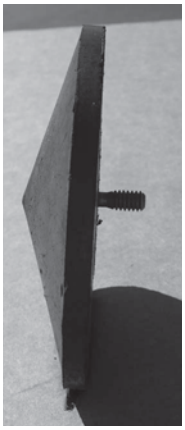
The Pressed Steel Clamp is available in two widths:
Narrow : 4" wide for pit holes, complete with Cone Plug Gasket fastened in place.
Wide: 8" wide for running corrosion spots, complete with a crescent-shaped, pressure-equalizing gasket of Skinner Special Composition for use on oil or gas lines.

Large 5/8" diameter steel bolts, plated and Iridite-dipped, are furnished with all clamps.

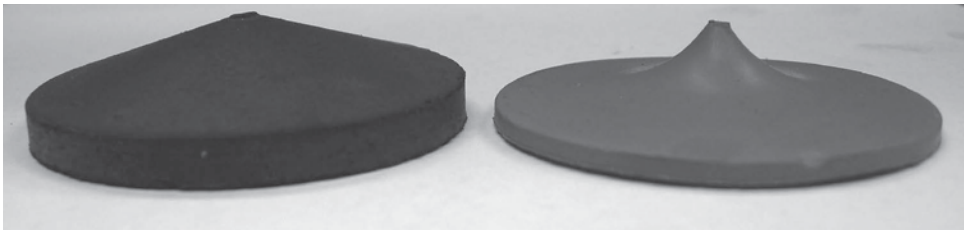
NOTE: Narrow type in sizes 3" OD through 12" comes with CP2NE Cone Plug. Narrow type in sizes 14" OD and up comes with CP2NF Cone Plug. Wide type in sizes 3" through 6" comes with SGNC #168 Strip Gasket. Wide type in sizes 8" and up come with SGN #148 Strip Gasket. 5/8" x 5" Bolts and Nuts are standard on above clamps.

Strip gaskets are Buna-N compound. Cone Plugs are Buna N but are also available as spares in either Buna-N (Black) or Natural Rubber (Red). Temperature Rating 250°F

NARROW STYLE			WIDE STYLE	
Size (inches)	Part Number	Approx. Weight (lbs.)	Part Number	Approx. Weight (lbs.)
3	089624	3.5	089625	7.0
4 OD	089623	3.75		
4	089621	4	089620	8.5
5	089617	5	089616	10.5
6 OD	089615	5		
6	089613	5.5	089612	11.25
8	089607	7	089606	14
10	089603	8	089602	17
12	089600	9	089599	19
14	089598	10	089597	20.5
16	089596	11.5	089595	23
18	089594	12.5	089593	26
20	089592	14	089591	28.5
24	089589	17.5	089588	33.5



Cone Plug w/fastener



Cone Plug - Black (Buna-N)
Max Temp 250°F

Cone Plug - Red (Natural Rubber)
Max Temp 250°F

Extra Cone Plugs for Narrow Style Clamps

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Sizes			Natural Rubber (Red)					
Thickness at Base				1/8		1/4		1/2
Cone Plug	Diameter (inches)		Code	Part Number	Code	Part Number	Code	Part Number
#1	1 9/16	w/o Fastener	CP1A	082007	CP1B	082013	CP1C	082024
		w/ Fastener			CP1E	082019		
#2	2 5/16	w/o Fastener	CP2A	082009	CP2B	082015	CP2C	082026
		w/ Fastener			CP2E	082020	CP2F	082029
#3	3 1/2	w/o Fastener	CP3A	082011	CP3B	082017	CP3C	082028
		w/ Fastener			CP3E	082022		
			Buna-N (Black)					
#1	1 9/16	w/o Fastener	CP1NA	082006	CP1NB	082012	CP1NC	082023
		w/ Fastener			CP1NE	082018		
#2	2 5/16	w/o Fastener	CP2NA	082008	CP2NB	082014	CP2NC	082025
		w/ Fastener			CP2NE	080865*	CP2NF	080866**
#3	3 1/2	w/o Fastener	CP3NA	082010	CP3NB	082016	CP3NC	082027
		w/ Fastener			CP3NE	082021	CP3NF	082030

* Standard for all 3”-12”
** Standard for all 14”-24”



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Installation Procedure

Pressed Steel Clamp

1. Thoroughly clean the damaged area of pipe with a wire brush. This will help insure a bubble tight gasket seal.
2. Use a Narrow Clamp with a Cone Plug Gasket to seal pit holes .
3. Use a Wide Clamp with a larger, crescentshaped gasket to seal corrosion spots.
4. Place the clamp around the pipe so that the leak is fully covered by the gasket.
5. Tighten the bolts evenly to the recommended torque (see table below).
6. Pressure test the completed installation for leaks.
7. Check for leaks before leaving.

Narrow			Wide	
Size	Torque	Working Pressure	Torque	Working Pressure
3”	60 ft/lbs	1000 psi	60 ft/lbs	500 psi
4”	60 ft/lbs	1000 psi	60 ft/lbs	500 psi
5”	60 ft/lbs	1000 psi	60 ft/lbs	500 psi
6”	60 ft/lbs	1000 psi	60 ft/lbs	500 psi
8”	60 ft/lbs	1000 psi	60 ft/lbs	400 psi
10”	60 ft/lbs	1000 psi	60 ft/lbs	400 psi
12”	60 ft/lbs	1000 psi	60 ft/lbs	300 psi
14”	60 ft/lbs	1000 psi	60 ft/lbs	300 psi
16”	60 ft/lbs	800 psi	60 ft/lbs	300 psi
18”	60 ft/lbs	800 psi	60 ft/lbs	200 psi
20”	60 ft/lbs	800 psi	60 ft/lbs	200 psi
24”	60 ft/lbs	800 psi	60 ft/lbs	200 psi