



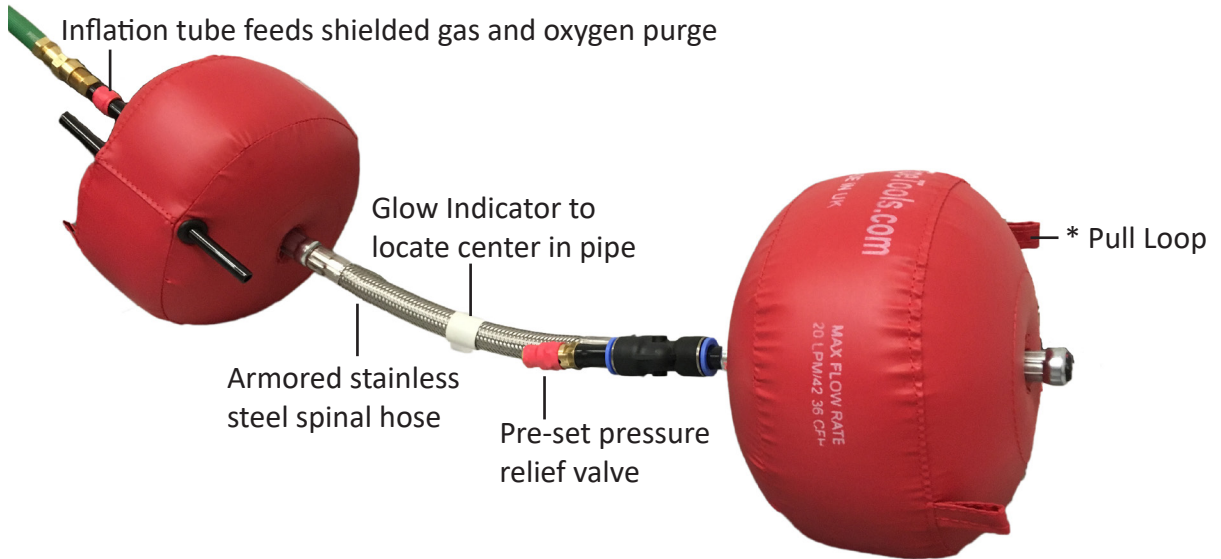
PIPE & INDUSTRIAL TOOLS

Operator's & Safety Manual



P.B.S. - Purge Bag Systems

Purge Bag System



DO NOT OVER INFLATE OR INFLATE TOO QUICKLY OR SYSTEMS WILL NOT FUNCTION AND YOU WILL DESTROY THE SYSTEM.

Part Number	Description
1002	2 inch - 50 mm nominal & 44-57 mm internal
1003	3 inch - 75 mm nominal & 58-84 mm internal
1004	4 inch - 100mm nominal & 80-110 mm internal
1005	5 inch - 125mm nominal & 103-135 mm internal
1006	6 inch -150 mm nominal & 124-162 mm internal
1007	8 inch - 200 mm nominal & 175- 213 mm internal
1008	10 inch - 250 mm nominal & 230-265 mm internal
1009	12 inch - 300 mm nominal & 265-305 mm internal
Special Order Only Below	
1010	14 inch - 350 mm nominal & 330-355 mm internal
1011	16 inch - 400 mm nominal & 380-408 mm internal
1012	18 inch 450 mm nominal & 430-455 mm internal
1013	20 inch 500 mm nominal & 485 -510 mm internal
1014	22 inch 550 mm nominal & 535 - 560 mm internal
1015	24 inch 600 mm nominal & 585-610 mm internal
1016	26 inch 650 mm nominal & 635-660 mm internal
1017	28 inch 700 mm nominal & 685 -710 mm internal
1018	30 inch 750 mm nominal & 735 -760 mm internal
1019	32 inch 800 mm nominal & 785-810 mm internal
1020	34 inch 850 mm nominal & 835-860 mm internal
1021	36 inch 900 mm nominal & 885 - 910 mm internal
1022	40 inch 1000 mm nominal & 990 -1015 mm internal
1023	42 inch 1050 mm nominal & 1040-1065 mm internal

* Always remove bags from pipe using pull loops. Pulling inert gas line feed will void warranty!





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Operator Instructions for PBS Purge Bags

Read and understand the instructions for safe performance. If uncertain about working with B&B PBS Purge Bags, always contact B&B prior to using the product. Understand the correct operations, applications and limitations. Store this safety manual in a clear area and always at a readily accessible site. Be especially aware of specific hazard signs. Extra copies are obtainable at B&B Pipe and Industrial Tools.

1. Make sure PBS bag is deflated before use and insertion into pipe.
2. Attach shielded gas line to the bag with a female 1/4 inch NPT fitting. Attach black hose on PBS system. Make sure you have enough feed hose to fully insert bag all the way to the weld point.
3. Insert bag into end of Pipe or Fitting and push into the weld point. If bag placement is at a distance from opening use a "fishing" wire or equivalent to push the bag into the pipe. Use pull tabs sewn into bag to fasten a fish line to the bag.
4. Use glow in the dark middle tape tab to align purging bags. Meaning, if the inside of the pipe is too dark to see the bag, look for glow in the dark tape sewn on the center of the bag to line up the bag with the root pass/weld point.
5. Once the bag is in place, turn on shielded gas.
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6. Inflate at max rate of 20 LPM or .71 CFM (42.36 CFH). If instructions are not followed, warranty is voided.
7. Root gap must be blocked with tape or equivalent to insure shielded gas does not escape before weld process.
8. Bags will inflate with gas then auto releases valve to purge chamber near weld point.
9. Monitor oxygen content with oxygen monitor and when adequate welding climate is achieved, begin weld process.
10. Do not turn off shielding gas. Pressure must remain throughout root pass welding process to ensure oxygen purge.
11. When removing bags, make sure weld area is cool. Do not use feed lines to pull bags! Use sewn in pull tabs to remove bags!

