



***PIPE & INDUSTRIAL TOOLS***

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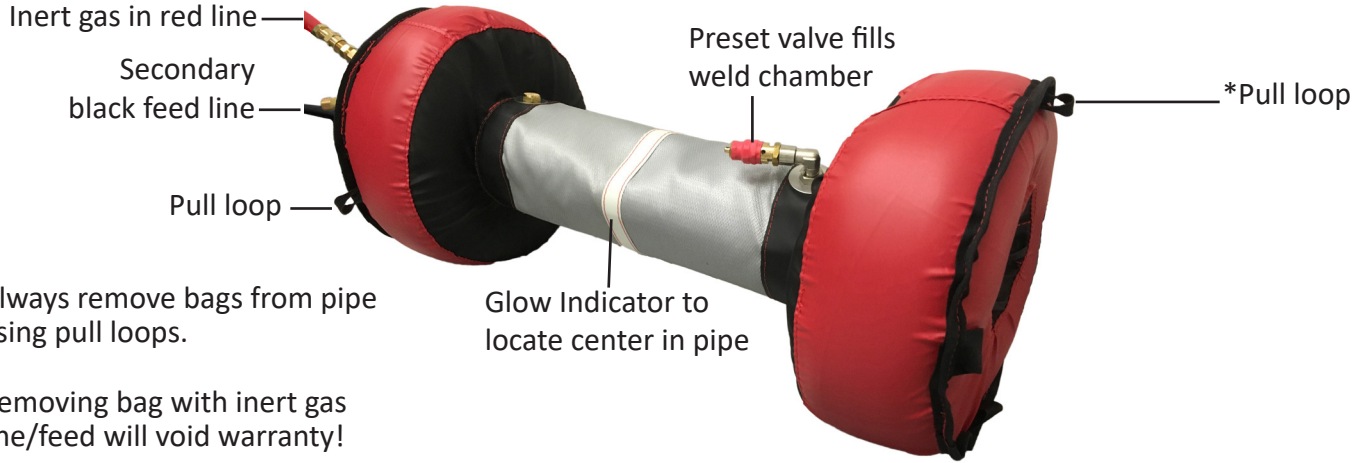
# Operator's & Safety Manual

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## Pronto Purge System

# Pronto Purge System



\* Always remove bags from pipe using pull loops.

\* Removing bag with inert gas line/feed will void warranty!

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

| PN   | Description               | Expansion Range | Ship Weight |
|------|---------------------------|-----------------|-------------|
| 1025 | 8 inch - 200 mm nominal   | 175-213 mm      | 4 lbs.      |
| 1026 | 10 inch - 250 mm nominal  | 230-265 mm      | 4.5 lbs.    |
| 1027 | 12 inch - 300 mm nominal  | 265-305 mm      | 5 lbs.      |
| 1028 | 14 inch - 350 mm nominal  | 330-355 mm      | 5.5 lbs.    |
| 1029 | 16 inch - 400 mm nominal  | 380-405 mm      | 6 lbs.      |
| 1030 | 18 inch - 450 mm nominal  | 430-455 mm      | 7 lbs.      |
| 1031 | 20 inch - 500 mm nominal  | 485-510 mm      | 7.5 lbs.    |
| 1032 | 22 inch - 550 mm nominal  | 535-560 mm      | 8 lbs.      |
| 1033 | 24 inch - 600 mm nominal  | 585-610 mm      | 8.5 lbs.    |
| 1034 | 26 inch - 650 mm nominal  | 635-660 mm      | 10 lbs.     |
| 1035 | 28 inch - 700 mm nominal  | 685-710 mm      | 12.5 lbs.   |
| 1036 | 30 inch - 750 mm nominal  | 735-760 mm      | 13.5 lbs.   |
| 1037 | 32 inch - 800 mm nominal  | 785-810 mm      | 18 lbs.     |
| 1038 | 34 inch - 850 mm nominal  | 835-860 mm      | 19 lbs.     |
| 1039 | 36 inch - 900 mm nominal  | 885-910 mm      | 20 lbs.     |
| 1040 | 40 inch - 1000 mm nominal | 990-1015 mm     | 20.5 lbs.   |
| 1041 | 42 inch - 1050 mm nominal | 1040-1065 mm    | 29.5 lbs.   |
| 1042 | 48 inch - 1200 mm nominal | 1195-1220 mm    | 33 lbs.     |
| 1043 | 54 inch - 1371 mm nominal | 1359—1384 mm    | 40 lbs.     |
| 1044 | 60 inch - 1524 mm nominal | 1512—1537 mm    | 44.5 lbs.   |
| 1045 | 72 inch - 1828 mm nominal | 1816—1841 mm    | 62 lbs.     |
| 1046 | 80 inch - 2031 mm nominal | 2019—2044 mm    | 66.5 lbs.   |

# Operator Instructions for Pronto Purge System

Read and understand the instructions for safe performance. If uncertain about working with B&B Pronto Purge System, always contact B&B prior to use. 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 Pronto Purge Bag is deflated prior to use and before insertion into pipe.
2. Connect rope, chain or wire to the pull tabs sewn into the ends of the bladder modules. This will allow easy insertion and removal of the Pronto Purge System.  
**DO NOT REMOVE BAGS BY PULLING ON GAS FEED LINES, THIS WILL DAMAGE THE SYSTEM.**
3. Connect inert gas lines to the **RED** hose and to optional **BLACK** hose.  
**RED** gas hose is required to inflate the purge bladders.  
**BLACK** gas hose is optional to speed purging process.
4. Position the Pronto Purge System in the pipe using the luminescent indicator as a guide to center the system across the root gap.
5. Once the bag is in place, turn the regulated gas supply on to inflate the bladders and purge the weld zone.  
Recommended Flow Rates for Purging:  
**RED** gas hose should transfer inert gas at a max rate of **20 LPM or .71 CFM (42.36 CFH)**.  
If instructions are not followed, warranty is voided.  
**DO NOT OVER INFLATE OR INFLATE TOO QUICKLY OR SYSTEM WILL NOT FUNCTION AND YOU WILL DAMAGE THE SYSTEM.**
6. Root gap must be blocked with tape or equivalent to insure shielded gas does not escape before weld process.
7. Bags will inflate with gas, then auto releases valve to purge chamber near weld point.
8. Monitor oxygen content with oxygen monitor and when adequate welding climate is achieved, begin weld process.
9. Once a tight seal has been achieved, begin welding while maintaining flow rate.
10. Do not turn off shielded gas. Pressure must remain throughout root pass welding process to ensure oxygen purge.
11. After the weld is complete, turn off the gas supply to deflate the bladders. Once the heat zone has sufficiently cooled, remove Pronto Purge Bag from the pipe. Be sure to disconnect all gas lines and monitoring equipment.

