

Installation Instructions for Oseco Safety Plug Assemblies

TYPICAL FREE VENT SAFETY PLUG SHOWN:

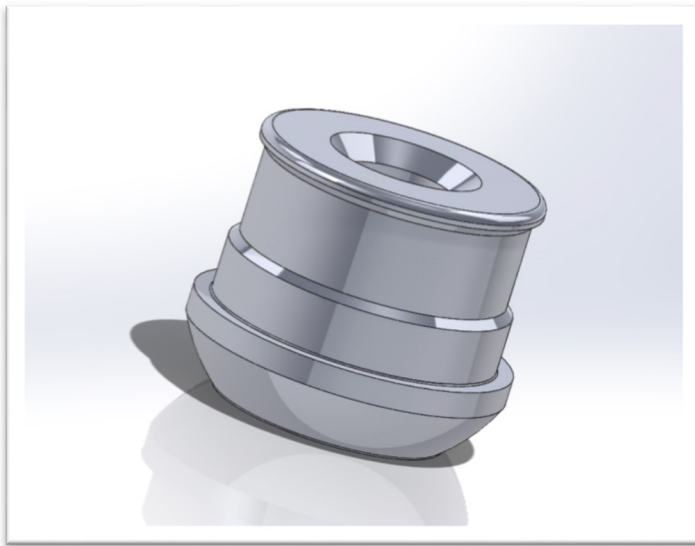


Figure 1

1.0 SAFETY



WARNING!

- 1) All Safety Plug installations should be located to allow full unrestricted discharge of a ruptured Safety Plug when over-pressure of the system occurs.
- 2) Never locate a Safety Plug installation where the discharge from a ruptured Safety Plug could directly impact personnel or equipment.
- 3) Venting of a Safety Plug discharge should always be routed to a safe disposal area.

IMPORTANT

A Safety Plug is a precision piece of equipment. Handle it with extreme care.

- Avoid scratching, bending, denting, or otherwise damaging the dome area of the disc or housing/body of the unit.

- Always wear appropriate personal protective equipment when installing Oseco Safety Plugs.
- The Oseco Safety Plug assemblies are design to be used with 1502 series Weco Unions Only! Installation using any other type of connection will fail. Always ensure that the union size, figure number, and pressure rating are identical to those marked on the Safety Plug assembly
- Oseco Safety Plug assemblies should be discarded if the component size, figure number or pressure rating cannot be positively identified due to wear and tear of markings.
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2.0 SAFETY PLUG PREPARATION

- 1) Thoroughly inspect and clean all seating surfaces of the Safety Plug assembly. Do not scrape or scratch any seating surface.
- 2) Inspect the assembly for signs of damage, including dents in the body or warping of the body. The dome of the disc should be free from dents or damage. A damaged Safety Plug assembly should be discarded.

3.0 OSECO SAFETY PLUG INSTALLATION



WARNING!

If the assembly is installed incorrectly, it can significantly alter the burst pressure of the disc, endangering personnel and/or causing damage to equipment.

3.1 FREE VENT SAFETY PLUG INSTALLATION

- 1) OSECO recommends that the Safety Plug is installed no less than 8 pipe diameters from the fluid end. Installation directly on the fluid end could reduce the service life of the disc.
- 2) Place the elastomer seal and the Safety Plug assembly onto the figure 1502 female sub as shown if figure 1 & 2.

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- 3) Place the 1502 hammer union nut onto the assembly and tighten using sufficient hammer force to achieve desired seal. Excessive force can cause damage compromising the functionality of the unit. Use only appropriate force and install with care.

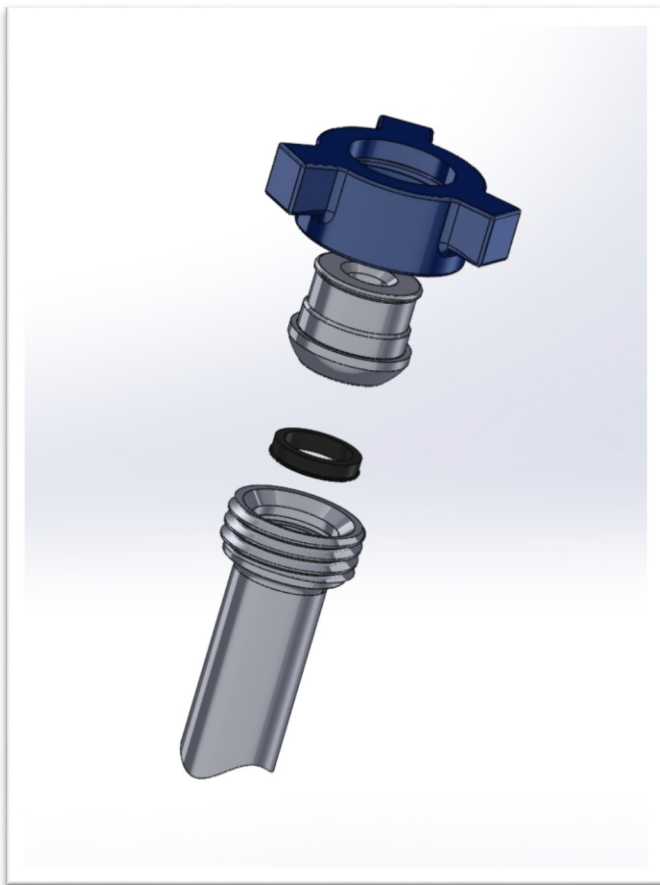


Figure 2

* The Elastomer seal, Hammer nut and retention clip are not included with the Safety Plug assembly

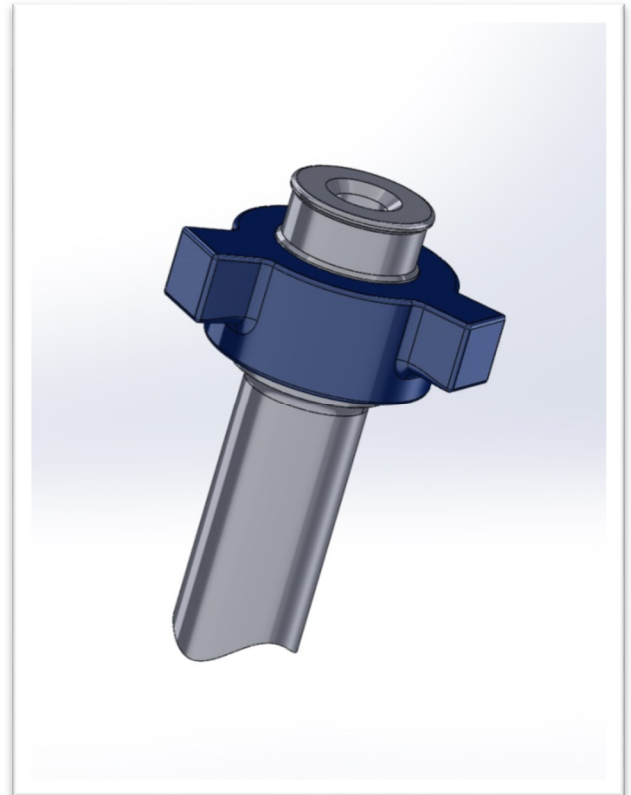


Figure 3

OSECO strives to be a leader in customer service. As part of OSECO's customer service efforts, we offer Safety Plug training and 24 hour assistance. OSECO recommends all personnel responsible for disc installations attend an installation training seminar.

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3.1 Threaded Outlet Installation:

- 1) Assemble detachable nut joint segments, hammer union nut, and retainer clip as shown in figure 4 & 5.
- 2) Place the elastomer seal and the Safety Plug / nut assembly onto the figure 1502 female sub as shown in figure 6.
- 3) Place the 1502 hammer union nut onto the assembly and tighten using sufficient hammer force to achieve desired seal.

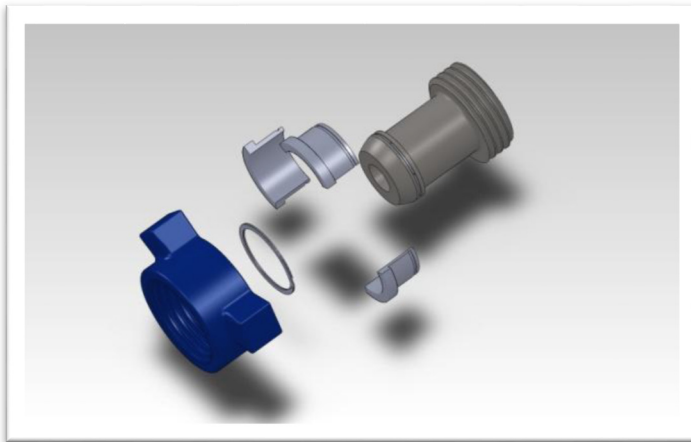


Figure 4

* The Elastomer seal, Hammer nut and retention clip are not included with the Safety Plug assembly

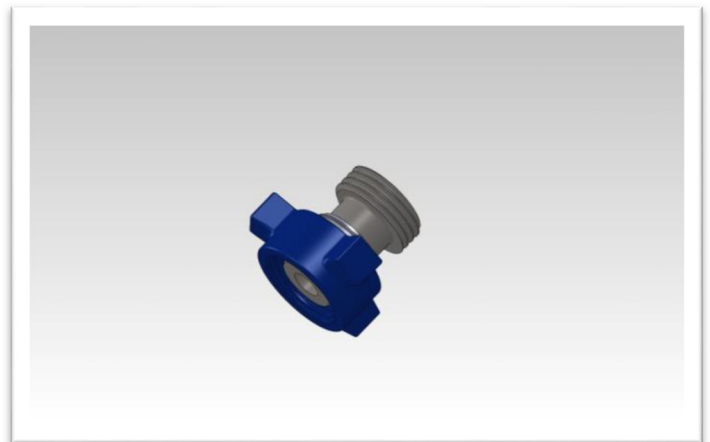


Figure 5

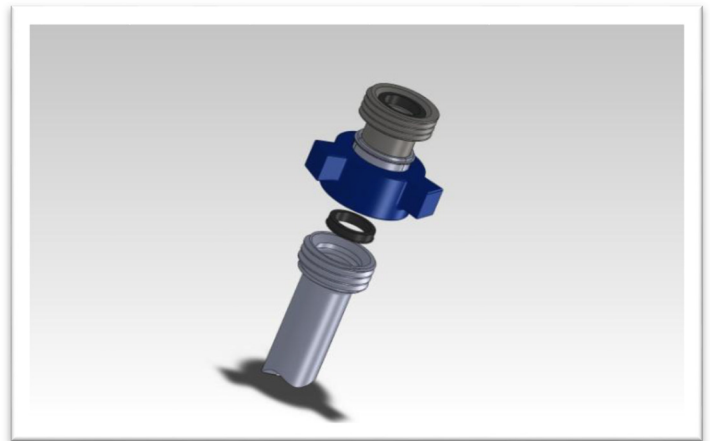


Figure 6

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4.0 Inspection Process:

- 1.) The Oseco Safety Plug should be inspected prior to each installation. If the inspection reveals any damage to key functional areas of the assembly discard immediately. Functional areas include outlet threads, inlet hammer union flange area, the disc, and any seating surface.
- 2.) Dimensional inspection: The Internal bore diameter and outer diameter of the safety plug body should be inspected before each use. Table 1.0 contains minimum and maximum values for these dimensions.
- 3.) Pressure Testing: When performing pressure tests do not exceed 90% of the rated burst pressure of the safety plug.
- 4.) If the Safety plug assembly is removed from service with the intention of use at a later date, ensure that the assembly is stored in its original container to avoid damage.

Table 1.0: Dimensional Inspection Min/Max Values

Size/ Configuration	Internal Bore Dia.		Outer Diameter	
	Min	Max	Min	Max
2 Inch Free	1.370"	1.380"	3.676"	3.696"
2 Inch Threaded	1.370"	1.380"	3.260"	3.280"
3 Inch Threaded	2.490"	2.510"	4.59"	4.610"

