

Hand Lever Tack and No Tack Cage Clamps

1. Description and function

The Ratchet Tack and No Tack Cage Clamp is used for alignment of pipe to be welded. The Tack Type Clamp is available for 2" – 60" pipe. The No Tack Clamp is available for 3 ½" – 60" pipe. Each clamp is designed to align only one diameter of pipe.

2. Working environment of 50 degrees to - 25 degrees Celsius

The clamp is not designed to be used at a temperature of -25 degrees.

3. Cage Clamp Nomenclature

The Ratchet Type Cage Clamp consists of a right and left frame and Ratchet Mechanism.

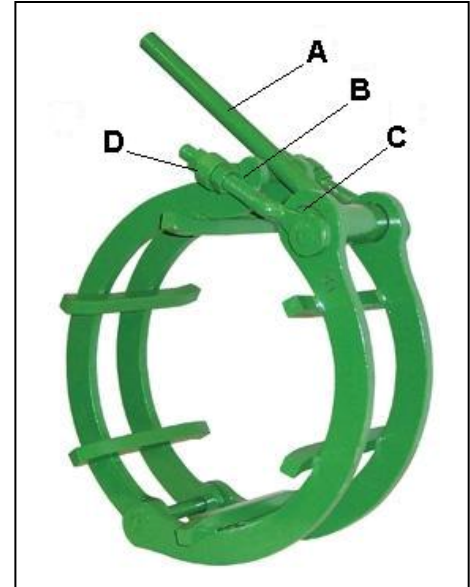
4. Operating Instructions

Tack Type Cage Clamp

- A. Release all pressure on the clamp by rotating the Handle (A) on the Cam Mechanism (C) until enough pressure has been released from the Tensioning Bar (D) to open the clamp.
- B. Lift the Tensioning Bar (D) from hook (B) on the clamp end.
- C. Open the clamp.
- D. Place the clamp on the pipe.
- E. Center the cross bars on the pipe end.
- F. Grasp the clamp handles, if applicable, and close the clamp around the pipe.
- G. Engage Tensioning Bar (D) on the hook (B) on the opposite clamp end.
- H. Rotate the Handle (A) on the Cam Mechanism (C) until the cam mechanism is over center and locked in position.
- I. Tack weld the pipe ends together at points between the cross bars.
- J. Release the clamp from the pipe by rotating the Handle (A) on the Cam Mechanism (C) until it is in contact with the cross bar of the clamp.
- K. Lift the Tensioning Bar (D) from hook (B) on the clamp end.
- L. Open the clamp.
- M. Remove the clamp from the pipe.
- N. Weld per the established procedure.

No Tack Type Cage Clamp

- A. Release all pressure on the clamp by rotating the Handle (A) on the Cam Mechanism (C) until enough pressure has been released from the Tensioning Bar (D) to open the clamp.
- B. Lift the Tensioning Bar (D) from hook (B) on the clamp end.
- C. Open the clamp.
- D. Place the clamp on the pipe.
- E. Center the cross bars on the pipe end.
- F. Grasp the clamp handles, if applicable, and close the clamp around the pipe.
- G. Engage Tensioning Bar (D) on the hook (B) on the clamp end.



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- H. Rotate the Handle (A) on the Cam Mechanism (C) until the cam mechanism is over center and locked in position.
- I. Weld per the established procedure.
- J. Release the clamp from the pipe by rotating the Handle (A) on the Cam Mechanism (C) until it contacts with the cross bar of the clamp.
- L. Lift the Tensioning Bar (D) from hook (B) on the clamp end.
- M. Open the clamp.
- N. Remove the clamp from the pipe.

5. ATTENTION! Don't use the Cage Clamp for the following:

- Should not be used as the sole support of the pipe.
- A lifting mechanism should not be attached to the clamp to lift the pipe.
- Wedges should not be driven under the frame of the clamp in an attempt to reform the pipe because it will damage the clamp and void the warranty.
- The clamp is not designed for the alignment of tees, elbows, valves and other fittings.
- The clamp should not be used with any type of device that is used to preheat the pipe prior to welding as this may result in failure of the clamp.

6. Maintenance

The clamp should be cleaned and sprayed with a light film of oil to avoid rusting after each use. The clamp should be inspected for cracks and deformation prior to each use of the clamp. The clamp should be replaced if any cracks or deformation of the clamp is present.

7. Storage

The clamp should be kept in a dry environment when not in use.