



# 420 Plug Setting Machine

## Sizes: 4- through 20-inches



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■ Plug holder and LOCK-O-RING® Plus Plug  
*Not included*

### ■ 420 Plug Setting Machine

#### Description

Plug setters are used for installing and retrieving completion plugs so that equipment can be removed from the pipeline after hot tapping and plugging operations are completed.

The Model 420 Plug Setting Machines is used for setting and retrieving LOCK-O-RING® Plus completion plugs from 4- to 20-inches. Its maximum working pressure is 1,480 psi (102 bar) at 100°F (38°C). Its operating temperature is -20°F (-29°C) to 180°F (82°C). Its maximum continuous rating is 180°F (82°C) at 1380 PSI (95 bar).

#### Features

The basic machine includes:

- Platform
- Ring gasket
- Bleeder valve and nipple
- Set of flange bolts and nuts
- Hex measuring rod

The measuring rod has a unique hexagon cross-section so it can be turned with a wrench, though hand turning is still an option.

- Pressure balance system

This system transfers pressure from the pipeline to the inside of the plug setter, counteracting line pressure pushing against the machine and reducing the amount of effort needed to extend the machine's control bar and set a plug.

- Non-rotating control bar

Because the control bar does not rotate, the plug holder base can be keyed to the control bar, ensuring the plug will be installed in the correct orientation.

- Drive lock

The drive lock prevents extension or retraction of the leaves of the completion plug unless the plug is properly shouldered against the ledge in the fitting flange.

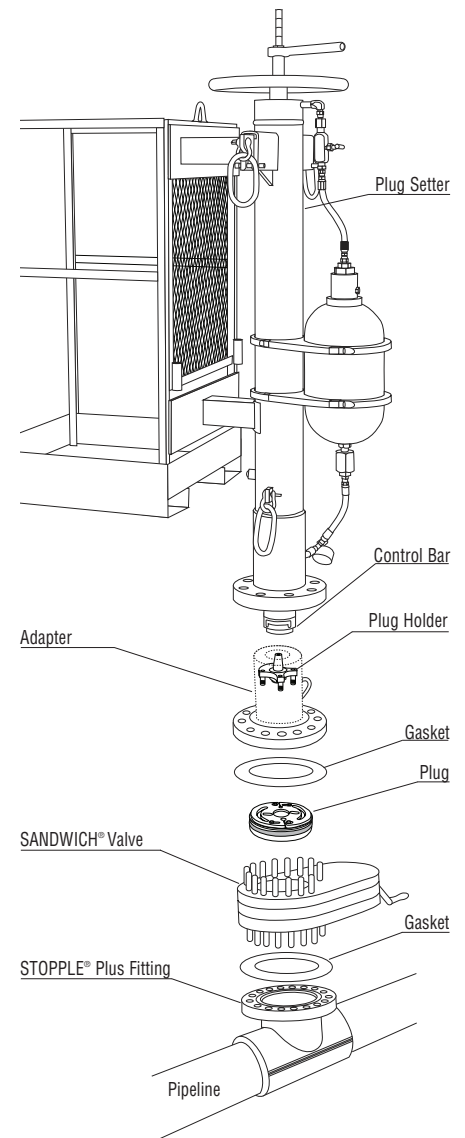
- 90-degree rotation to set plug

The plug setter's drive lever actuates 90 degrees to fully extend or retract the plug leaves, eliminating any guesswork during setting or retraction.

- 2 turns per inch lead screw

More lead means fewer turns are needed to lower or raise the control bar.

#### ■ Typical Plugging Setup



ISO 9001 Certified

USA Toll Free

**1-888-TDWmSon (839-6766)**

or contact your local TDW representative.



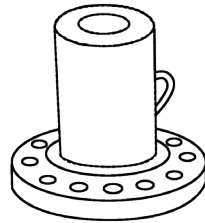
# 420 Plug Setting Machine

## Operating Specifications

Plug Setting Machine Part Number	07-1862-0000-00
Control Bar Stroke	0- to 38.5 Inches (978 mm)
LOCK-O-RING® Plus Plug Sizes	4- through 20-inch (102-508 mm)
Max. Operating Pressure	1,480 psi (102 bar) at 100°F (38°C)
Max. Operating Temperature	180°F (82°C) at 1380 psi (95 bar)
Min. Operating Temperature	-20°F (-29°C)
Feed Rate	0.50-inch per turn (12.7 mm per turn)
Length without measuring rod	66.75-inches (1695 mm)
Length with measuring rod	109.75-inches (2788 mm)
Total Weight (including platform)	660 Lbs (399-37 Kg.)

## Adapters for use with SANDWICH® Valves and LOCK-O-RING® Plus Plugs with Coupons

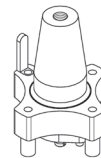
Size (Inches)	Class	Part Number
4	600	06-5091-0004-02
6	600	26-1160-0006-00
8	600	06-5091-0008-01
10	600	06-5091-0010-01
12	600	06-5091-0012-01
14	600	26-1160-0014-00
16	600	26-1160-0016-00
18	600	26-2454-0018-00
20	600	26-2454-0020-00



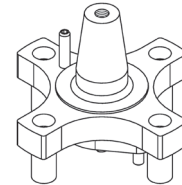
SANDWICH® Valve Adapter

## LOCK-O-RING® Plus Plug Holders

Size (Inches)	Part Number
4 - 6	05-1292-0406
8 - 20	05-1292-0820



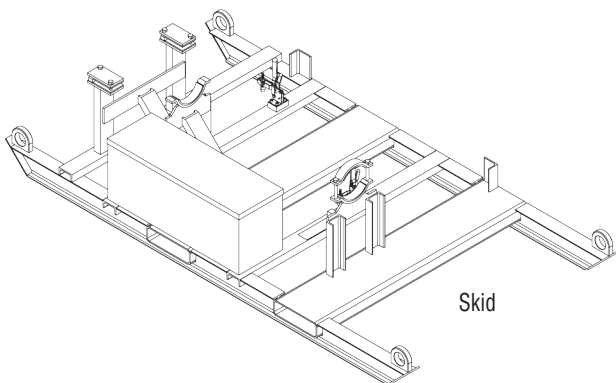
4- through 6-inch Plug Holder



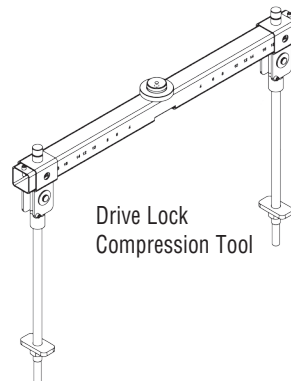
8- through 20-inch Plug Holder

Description	Part Number
Skid*	07-1911-0000-00
Drive Lock Compression Tool	07-1927-000-00

\* If skid is not purchased with the plug setting machine, there will be a special crating charge; consult factory



Skid



Drive Lock Compression Tool