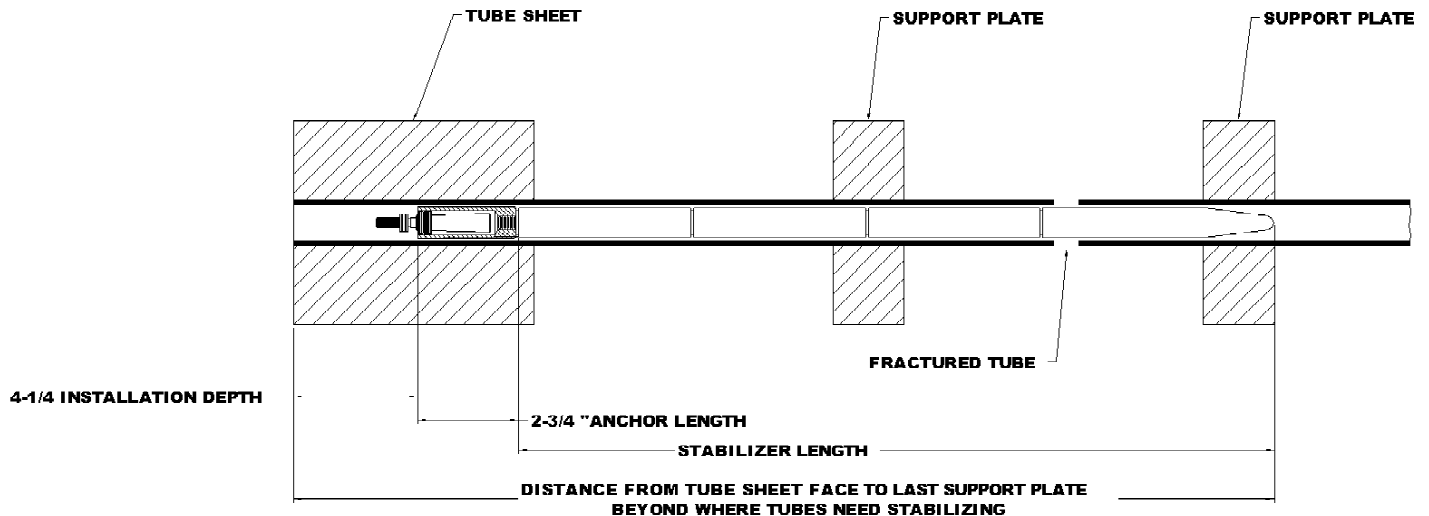


TUBE STABILIZER (ROD & CABLE TYPE) INSTALLATION PROCEDURES**DESCRIPTION**

Tube Stabilizers prevent vibration of fractured or damaged tubes in a heat exchanger. Damage may occur to adjacent tubes if not properly stabilized. The Stabilizer is inserted through the damaged section of the tube and anchored into the tube sheet. The stabilizer extends minimally from the tube sheet, through the fractured or damaged section of tube and through the support plate beyond the fracture.

Some tubes, which are fractured, dented or otherwise damaged, may prevent the stabilizer from being installed. In those cases, smaller diameter stabilizers or stabilizing all adjacent tubes should be evaluated. The Stabilizer Anchor is to be installed into the tube in the area where the tube is restrained by the tubesheet. The tube I.D., in the location where the Stabilizer Anchor will be located needs to be clean and free of dirt and debris. The tube I.D., in the location where the Pop-A-Plug will be installed needs to be prepared in accordance with EST document DC4000 and DC 4010. Never use Stabilizers in tubes that have more than 0.02" (0.5mm) clearance above the anchor OD.

**TUBE STABILIZER INSTALLATION REFERENCE**

World Headquarters:
Expansion Seal Technologies
 2701 Township Line Road
 Hatfield, PA 19440-1770 USA
 Tel: 1-215-721-1100 Fax: 1-215-721-1101
 Toll-Free: 1-800-355-7044

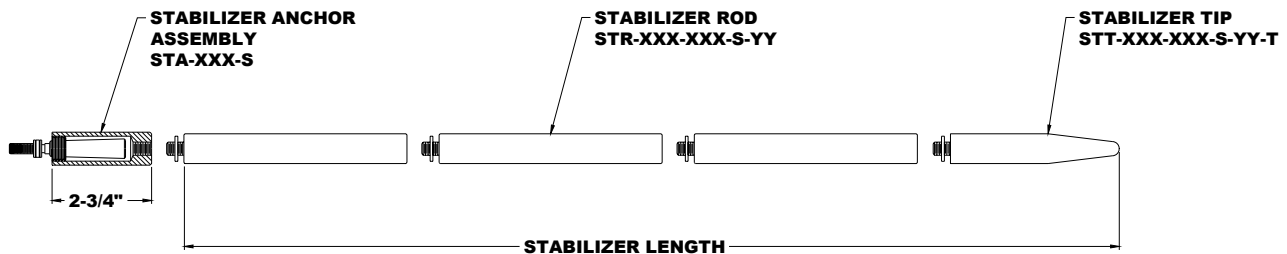
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ROD INSTALLATION

Remove the thread protecting caps from the Stabilizer Rods and the Tip. Assemble the Tip to Stabilizer Rod by fully engaging the thread and firmly tightening the joint using locking pliers or similar. The lock washer should prevent loosening of the joint. A thread lock compound may be used on each connection as an additional precaution against loosening. If access to the tube is limited, the threaded connections of the stabilizer can be assembled together as the stabilizer is being positioned in the tube.

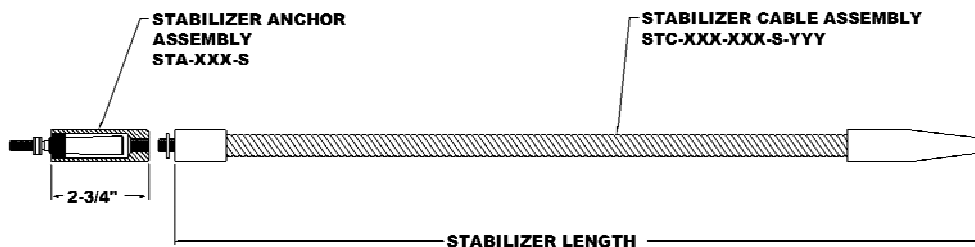
Repeat step 1 for the remaining connections between Stabilizer Rods until desired length is achieved.



TUBE STABILIZER ROD AND TIP ASSEMBLY

CABLE INSTALLATION

Remove the thread-protecting cap from the Cable assembly. Feed Cable into tube.



TUBE STABILIZER CABLE ASSEMBLY



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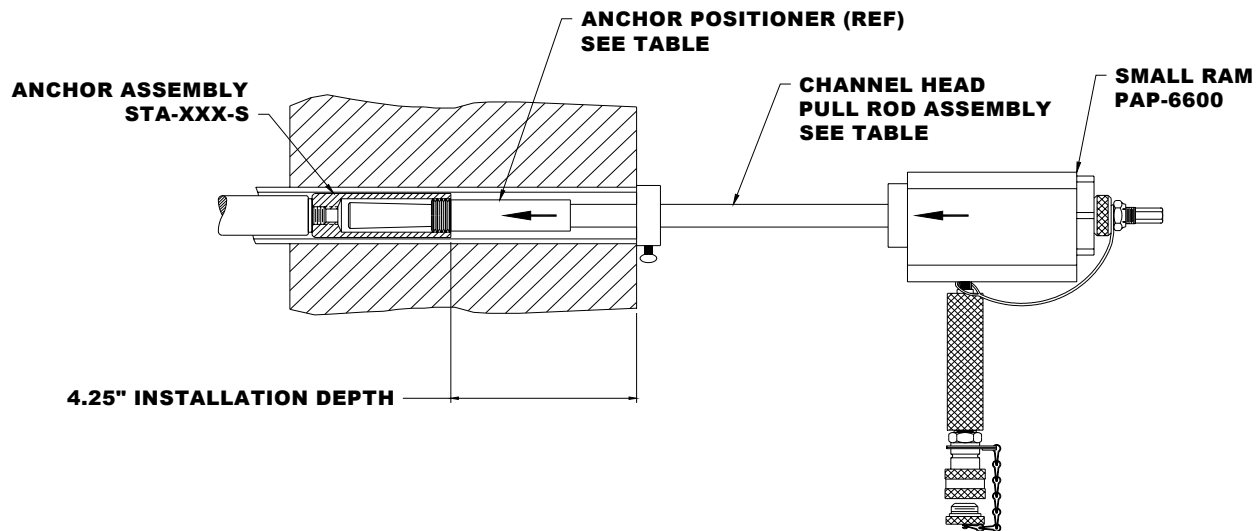
ANCHOR INSTALLATION

Connect Anchor to assembled Stabilizer Rods or Cable assembly. The lock washer should prevent loosening of the joint. A thread lock compound may be used as an additional precaution against loosening. Ensure that compound does not contact outside surface of the Anchor.

Fully engage the exposed thread of the Anchor Assembly into the Channel Head Pull Rod Assembly. (See page 3 for installation equipment). Remove the knurled nut and insert the Pull Rod Assembly through the hydraulic ram - verify that air and hydraulic hoses are fully engaged and tightened. Reattach the knurled nut and firmly tighten to remove slack from the Channel Head Pull Rod Assembly. Ensure the positioner on the Channel Head Pull Rod Assembly is the correct positioner for the Stabilizer Anchor being installed (See Table).

If the tubesheet thickness is 5" (127mm) or greater, the Anchor Assembly is to be positioned so that the near end of the Anchor Assembly is 4.25" (108mm) into the tube. For stabilizing tubes where the tubesheet is less than 5" (127mm), contact EST Customer Service.

The Anchor is installed when the Breakaway connecting it to the Channel Head Pull Rod Assembly fractures. With the Anchor Assembly at the proper installation depth as indicated above, depress the pump pedal, the ram will stroke. If Breakaway does not fracture and the hydraulic pressure exceeds 7000psi (480 Bar), STOP. Depress front of pump pedal and ram will retract. Tighten the knurled nut and depress the pump pedal. Installation of the Anchor should not require more than two full strokes of the ram. If the Breakaway has not fractured after two full strokes, stop and call EST Customer Service for assistance.



WARNING!!! ENSURE PROPER POSITIONER IS USED WHEN INSTALLING ANCHOR ASSEMBLY (SEE TABLE). THIS POSITIONER WILL BE A DIFFERENT SIZE THAN THE ONE USED TO INSTALL THE POP-A-PLUG IN THE TUBE.

QUESTIONS? Contact EST Customer Service at any of the following locations with questions.

In USA and Canada: tel: 800-355-7044, fax: 215-721-1101, e-mail: info@expansionseal.com

In Europe: tel: +31-172-418841, fax: +31-172-418849; e-mail: info@estgrp.nl

In Asia: tel: +65-6745-8560, fax: +65-6742-8700, e-mail: estasia@singnet.com.sg

On the Internet www.estgrp.com

Expansion Seal Technologies is part of the EST Group of companies. **EST Group** provides a complete range of repair products, services and replacement parts covering the life cycle of tubular heat exchangers and condensers; additionally EST provides products and services to facilitate pressure testing pipe, piping systems, pressure vessels and their components. Visit EST Group on the internet at www.estgrp.com



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TUBE ID RANGE (in)	TUBE ID RANGE (mm)	ANCHOR PART NUMBER	ANCHOR THREAD	ROD EXTENSION		TIP EXTENSION		CABLE ASSEMBLY		1 FT CHANNEL HEAD PULL ROD ASSEMBLY	ANCHOR POSITIONER (REF)
				ROD OD	PART NUMBER	TIP OD	PART NUMBER	CONNECTOR & TIP OD	PART NUMBER		
.501 - .520	12.73 - 13.22	STA-500-S	10-32	7/16	STR-500-520-S-YY	7/16	STT-500-520-S-YY-T	0.47	STC-500-520-S-XXX	CHA-400-440-01	PP-400-440
.521 - .540	13.23 - 13.73	STA-520-S	10-32	7/16	STR-500-520-S-YY	7/16	STT-500-520-S-YY-T	0.47	STC-500-520-S-XXX	CHA-400-440-01	PP-400-440
.531 - .550	13.49 - 13.97	STA-530-S	1/4-28	1/2	STR-530-580-S-YY	1/2	STT-530-580-S-YY-T	0.51	STC-530-580-S-XXX	CHA-400-440-01	PP-400-440
.541 - .560	13.74 - 14.24	STA-540-S	1/4-28	1/2	STR-530-580-S-YY	1/2	STT-530-580-S-YY-T	0.51	STC-530-580-S-XXX	CHA-400-440-01	PP-400-440
.561 - .580	14.25 - 14.75	STA-560-S	1/4-28	1/2	STR-530-580-S-YY	1/2	STT-530-580-S-YY-T	0.53	STC-530-580-S-XXX	CHA-460-500-01	PP-460-500
.571 - .590	14.50 - 14.99	STA-570-S	1/4-28	1/2	STR-530-580-S-YY	1/2	STT-530-580-S-YY-T	0.53	STC-530-580-S-XXX	CHA-460-500-01	PP-460-500
.581 - .600	14.50 - 14.99	STA-580-S	1/4-28	1/2	STR-530-580-S-YY	1/2	STT-530-580-S-YY-T	0.53	STC-530-580-S-XXX	CHA-460-500-01	PP-460-500
.601 - .620	15.27 - 15.76	STA-600-S	1/4-28	9/16	STR-600-660-S-YY	9/16	STT-600-660-S-YY-T	0.56	STC-600-660-S-XXX	CHA-460-500-01	PP-460-500
.621 - .640	15.77 - 16.27	STA-620-S	1/4-28	9/16	STR-600-660-S-YY	9/16	STT-600-660-S-YY-T	0.56	STC-600-660-S-XXX	CHA-520-580-01	PP-520-580
.641 - .660	16.28 - 16.78	STA-640-S	1/4-28	9/16	STR-600-660-S-YY	9/16	STT-600-660-S-YY-T	0.60	STC-600-660-S-XXX	CHA-520-580-01	PP-520-580
.651 - .670	16.54 - 17.02	STA-650-S	1/4-28	9/16	STR-600-660-S-YY	9/16	STT-600-660-S-YY-T	0.60	STC-600-660-S-XXX	CHA-520-580-01	PP-520-580
.661 - .680	16.79 - 17.27	STA-660-S	1/4-28	9/16	STR-600-660-S-YY	9/16	STT-600-660-S-YY-T	0.60	STC-600-660-S-XXX	CHA-520-580-01	PP-520-580
.671 - .690	17.04 - 17.53	STA-670-S	5/16-24	5/8	STR-670-800-S-YY	5/8	STT-670-800-S-YY-T	0.66	STC-670-800-S-XXX	CHA-520-580-01	PP-520-580
.681 - .700	17.28 - 17.79	STA-680-S	5/16-24	5/8	STR-670-800-S-YY	5/8	STT-670-800-S-YY-T	0.66	STC-670-800-S-XXX	CHA-520-580-01	PP-520-580
.691 - .710	17.55 - 18.01	STA-690-S	5/16-24	5/8	STR-670-800-S-YY	5/8	STT-670-800-S-YY-T	0.66	STC-670-800-S-XXX	CHA-600-680-01	PP-600-680
.701 - .720	17.80 - 18.30	STA-700-S	5/16-24	5/8	STR-670-800-S-YY	5/8	STT-670-800-S-YY-T	0.66	STC-670-800-S-XXX	CHA-600-680-01	PP-600-680
.721 - .740	18.31 - 18.81	STA-720-S	5/16-24	5/8	STR-670-800-S-YY	5/8	STT-670-800-S-YY-T	0.66	STC-670-800-S-XXX	CHA-600-680-01	PP-600-680
.741 - .760	18.82 - 19.32	STA-740-S	5/16-24	5/8	STR-670-800-S-YY	5/8	STT-670-800-S-YY-T	0.66	STC-670-800-S-XXX	CHA-600-680-01	PP-600-680
.751 - .770	19.08 - 19.56	STA-750-S	5/16-24	5/8	STR-670-800-S-YY	5/8	STT-670-800-S-YY-T	0.66	STC-670-800-S-XXX	CHA-600-680-01	PP-600-680
.761 - .780	19.33 - 19.83	STA-760-S	5/16-24	5/8	STR-670-800-S-YY	5/8	STT-670-800-S-YY-T	0.66	STC-670-800-S-XXX	CHA-600-680-01	PP-600-680
.781 - .790	19.84 - 20.34	STA-780-S	5/16-24	5/8	STR-670-800-S-YY	5/8	STT-670-800-S-YY-T	0.66	STC-670-800-S-XXX	CHA-600-680-01	PP-600-680
.791 - .810	20.09 - 20.57	STA-790-S	5/16-24	5/8	STR-670-800-S-YY	5/8	STT-670-800-S-YY-T	0.75	STC-670-800-S-XXX	CHA-700-780-01	PP-700-780
.801 - .820	20.35 - 20.84	STA-800-S	5/16-24	5/8	STR-670-800-S-YY	5/8	STT-670-800-S-YY-T	0.75	STC-670-800-S-XXX	CHA-700-780-01	PP-700-780
.811 - .830	20.60 - 21.08	STA-810-S	5/16-24	3/4	STR-810-840-S-YY	3/4	STT-810-840-S-YY-T	0.75	STC-810-840-S-XXX	CHA-700-780-01	PP-700-780
.821 - .840	20.85 - 21.35	STA-820-S	5/16-24	3/4	STR-810-840-S-YY	3/4	STT-810-840-S-YY-T	0.75	STC-810-840-S-XXX	CHA-700-780-01	PP-700-780
.841 - .860	21.36 - 21.86	STA-840-S	5/16-24	3/4	STR-810-840-S-YY	3/4	STT-810-840-S-YY-T	0.75	STC-810-840-S-XXX	CHA-700-780-01	PP-700-780
.861 - .880	21.87 - 22.37	STA-860-S	5/16-24	3/4	STR-810-840-S-YY	3/4	STT-810-840-S-YY-T	0.75	STC-810-840-S-XXX	CHA-700-780-01	PP-700-780
.881 - .900	22.38 - 22.87	STA-880-S	5/16-24	3/4	STR-810-840-S-YY	3/4	STT-810-840-S-YY-T	0.75	STC-810-840-S-XXX	CHA-700-780-01	PP-700-780
.891 - .910	22.63 - 23.11	STA-890-S	5/16-24	3/4	STR-810-840-S-YY	3/4	STT-810-840-S-YY-T	0.85	STC-810-840-S-XXX	CHA-800-860-01	PP-800-860
.901 - .920	22.88 - 23.38	STA-900-S	5/16-24	3/4	STR-810-840-S-YY	3/4	STT-810-840-S-YY-T	0.85	STC-810-840-S-XXX	CHA-800-860-01	PP-800-860
.921 - .940	22.39 - 23.87	STA-920-S	5/16-24	3/4	STR-810-840-S-YY	3/4	STT-810-840-S-YY-T	0.85	STC-810-840-S-XXX	CHA-800-860-01	PP-800-860
.931 - .950	23.65 - 24.13	STA-930-S	5/16-24	3/4	STR-810-840-S-YY	3/4	STT-810-840-S-YY-T	0.88	STC-810-840-S-XXX	CHA-800-860-01	PP-800-860
.941 - .960	23.88 - 24.10	STA-940-S	5/16-24	3/4	STR-810-840-S-YY	3/4	STT-810-840-S-YY-T	0.88	STC-810-840-S-XXX	CHA-800-860-01	PP-800-860

The following designates:

Anchor part number: S is the material designator, 316 stainless steel

Rod extension part number: YY is the length in inches (Standard Rod length is 12in, 24in, 36in, 48in & 72in)

Tip extension part number: YY is the length in inches (Tip lengths can vary depending on Stabilizer length)

Cable assembly part number: XXX is the length in inches

The extended length of the Channel head assembly, allows the installer to properly position the Anchor into the tube to the required installation depth.



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SPECIALISTS IN TUBE TESTING, SLEEVING AND PLUGGING TECHNOLOGY

AN ISO-9001 REGISTERED COMPANY

Pop-A-Plug® Tube Stabilizers



Tube Stabilizers

P2 High Pressure Plugs

CPI Plugs™

Perma Plugs™

Boiler Tube Plugs

Ram Packages

Manual Installation Tools

Plug Removal Tools

Effectively Stabilizes Weakened or Fractured Heat Exchanger Tubes

EST's Pop-A-Plug® Tube Stabilizers are ideal for any type of heat exchanger tube from high pressure feedwater heaters to surface condensers. Pop-A-Plug® Tube Stabilizers are available in any length and are anchored into position using proven Pop-A-Plug® System technology.



- Installs using standard Pop-A-Plug® Ram Packages
- Stabilizer Rods & Anchors are available to fit tubes ranging from .501" to .960" I.D. (12.73mm to 24.10mm).
- Stabilizer Anchors available in kits of ten.
- Standard material: Stainless Steel. Other alloys are available upon request.
- Choose from two styles: Rod type or Cable type.
- Choose from two Stabilizer tip configurations: Bullet or Wedge.
- Quality Assurance System: Manufactured under a Quality Assurance Program certified to ISO 9001 and several U.S. nuclear industry standards including ANSI N45.2, NQA-1, and 10CFR 50 Appendix B.



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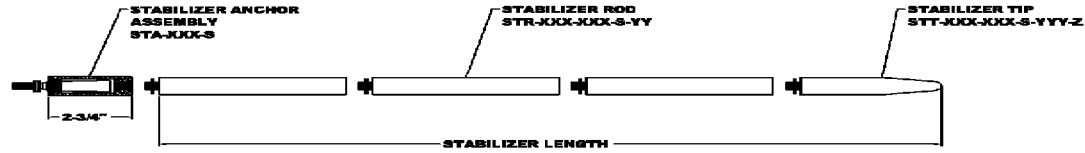
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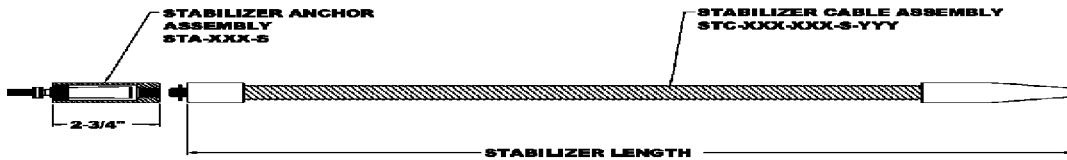
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AN ISO-9001 REGISTERED COMPANY

Tube Stabilizers



TUBE STABILIZER ROD TYPE ASSEMBLY



TUBE STABILIZER CABLE TYPE ASSEMBLY

Tube ID Range		Anchor Part Number	Anchor Thread	Stabilizer Rod		Stabilizer Tip		Cable Assembly		1FT Channel Head Pull Rod Assy Part Number
(in)	(mm)			Rod OD	Part Number	Tip OD	Part Number	Connector & Tip OD	Part Number	
.501-.520	12.73-13.22	STA-500-S	10-32	7/16	STR-500-520-S-YY	7/16	STT-500-520-S-YY-Z	.47	STC-500-520-YYY	CHA-400-440-01
.521-.540	13.23-13.73	STA-520-S	10-32	7/16	STR-500-520-S-YY	7/16	STT-500-520-S-YY-Z	.47	STC-500-520-YYY	CHA-400-440-01
.531-.550	13.49-13.97	STA-530-S	1/4-28	1/2	STR-530-580-S-YY	1/2	STT-530-580-S-YY-Z	.51	STC-530-540-YYY	CHA-400-440-01
.541-.560	13.74-14.24	STA-540-S	1/4-28	1/2	STR-530-580-S-YY	1/2	STT-530-580-S-YY-Z	.51	STC-530-540-YYY	CHA-400-440-01
.551-.570	14.00-14.48	STA-550-S	1/4-28	1/2	STR-530-580-S-YY	1/2	STT-530-580-S-YY-Z	.53	STC-560-580-YYY	CHA-460-500-01
.561-.580	14.25-14.75	STA-560-S	1/4-28	1/2	STR-530-580-S-YY	1/2	STT-530-580-S-YY-Z	.53	STC-560-580-YYY	CHA-460-500-01
.571-.590	14.50-14.99	STA-570-S	1/4-28	1/2	STR-530-580-S-YY	1/2	STT-530-580-S-YY-Z	.53	STC-560-580-YYY	CHA-460-500-01
.581-.600	14.76-15.26	STA-580-S	1/4-28	1/2	STR-530-580-S-YY	1/2	STT-530-580-S-YY-Z	.53	STC-560-580-YYY	CHA-460-500-01
.601-.620	15.27-15.76	STA-600-S	1/4-28	9/16	STR-600-660-S-YY	9/16	STT-600-660-S-YY-Z	.56	STC-600-620-YYY	CHA-460-500-01
.621-.640	15.77-16.27	STA-620-S	1/4-28	9/16	STR-600-660-S-YY	9/16	STT-600-660-S-YY-Z	.56	STC-600-620-YYY	CHA-520-580-01
.641-.660	16.28-16.78	STA-640-S	1/4-28	9/16	STR-600-660-S-YY	9/16	STT-600-660-S-YY-Z	.60	STC-640-660-YYY	CHA-520-580-01
.651-.670	16.54-17.02	STA-650-S	1/4-28	9/16	STR-600-660-S-YY	9/16	STT-600-660-S-YY-Z	.60	STC-640-660-YYY	CHA-520-580-01
.661-.680	16.79-17.27	STA-660-S	1/4-28	9/16	STR-600-660-S-YY	9/16	STT-600-660-S-YY-Z	.60	STC-640-660-YYY	CHA-520-580-01
.671-.690	17.04-17.53	STA-670-S	5/16-24	5/8	STR-670-800-S-YY	5/8	STT-670-800-S-YY-Z	.66	STC-670-780-YYY	CHA-520-580-01
.681-.700	17.28-17.79	STA-680-S	5/16-24	5/8	STR-670-800-S-YY	5/8	STT-670-800-S-YY-Z	.66	STC-670-780-YYY	CHA-520-580-01
.691-.710	17.55-18.01	STA-690-S	5/16-24	5/8	STR-670-800-S-YY	5/8	STT-670-800-S-YY-Z	.66	STC-670-780-YYY	CHA-600-680-01
.701-.720	17.80-18.30	STA-700-S	5/16-24	5/8	STR-670-800-S-YY	5/8	STT-670-800-S-YY-Z	.66	STC-670-780-YYY	CHA-600-680-01
.721-.740	18.31-18.81	STA-720-S	5/16-24	5/8	STR-670-800-S-YY	5/8	STT-670-800-S-YY-Z	.66	STC-670-780-YYY	CHA-600-680-01
.741-.760	18.82-19.32	STA-740-S	5/16-24	5/8	STR-670-800-S-YY	5/8	STT-670-800-S-YY-T	.66	STC-670-780-YYY	CHA-600-680-01
.751-.770	19.08-19.56	STA-750-S	5/16-24	5/8	STR-670-800-S-YY	5/8	STT-670-800-S-YY-Z	.66	STC-670-780-YYY	CHA-600-680-01
.761-.780	19.33-19.83	STA-760-S	5/16-24	5/8	STR-670-800-S-YY	5/8	STT-670-800-S-YY-Z	.66	STC-670-780-YYY	CHA-600-680-01
.781-.790	19.84-20.34	STA-780-S	5/16-24	5/8	STR-670-800-S-YY	5/8	STT-670-800-S-YY-Z	.66	STC-670-780-YYY	CHA-600-680-01
.791-.810	20.09-20.57	STA-790-S	5/16-24	5/8	STR-670-800-S-YY	5/8	STT-670-800-S-YY-Z	.75	STC-790-880-YYY	CHA-700-780-01
.801-.820	20.35-20.84	STA-800-S	5/16-24	5/8	STR-670-800-S-YY	5/8	STT-670-800-S-YY-Z	.75	STC-790-880-YYY	CHA-700-780-01
.811-.830	20.60-21.08	STA-810-S	5/16-24	3/4	STR-810-940-S-YY	3/4	STT-810-940-S-YY-Z	.75	STC-790-880-YYY	CHA-700-780-01
.821-.840	20.85-21.35	STA-820-S	5/16-24	3/4	STR-810-940-S-YY	3/4	STT-810-940-S-YY-Z	.75	STC-790-880-YYY	CHA-700-780-01
.841-.860	21.36-21.86	STA-840-S	5/16-24	3/4	STR-810-940-S-YY	3/4	STT-810-940-S-YY-Z	.75	STC-790-880-YYY	CHA-700-780-01
.861-.880	21.87-22.37	STA-860-S	5/16-24	3/4	STR-810-940-S-YY	3/4	STT-810-940-S-YY-Z	.75	STC-790-880-YYY	CHA-700-780-01
.881-.900	22.38-22.87	STA-880-S	5/16-24	3/4	STR-810-940-S-YY	3/4	STT-810-940-S-YY-Z	.75	STC-790-880-YYY	CHA-700-780-01
.891-.910	22.63-23.11	STA-890-S	5/16-24	3/4	STR-810-940-S-YY	3/4	STT-810-940-S-YY-Z	.85	STC-890-920-YYY	CHA-800-860-01
.901-.920	22.88-23.38	STA-900-S	5/16-24	3/4	STR-810-940-S-YY	3/4	STT-810-940-S-YY-Z	.85	STC-890-920-YYY	CHA-800-860-01
.921-.940	22.39-23.87	STA-920-S	5/16-24	3/4	STR-810-940-S-YY	3/4	STT-810-940-S-YY-Z	.85	STC-890-920-YYY	CHA-800-860-01
.931-.950	23.65-24.13	STA-930-S	5/16-24	3/4	STR-810-940-S-YY	3/4	STT-810-940-S-YY-Z	.88	STC-930-940-YYY	CHA-800-860-01
.941-.960	23.88-24.10	STA-940-S	5/16-24	3/4	STR-810-940-S-YY	3/4	STT-810-940-S-YY-Z	.88	STC-930-940-YYY	CHA-800-860-01



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