



**Model 2400**  
**24" Steel Squeeze Tool**

**Operations Manual**

**Model 2400  
24" Pipe Squeezer**

**Tool Specification**

Maximum Pipe Size:	24" IPS, (610mm) .312WT (7.9mm)
Operating Pressure:	3,200 PSIG
Operating Force:	260 Tons
Maximum Operating Pressure:	4,000 PSIG
Maximum Operating Force:	324 Tons
Dimensions:	108" x 56" x 16", 36" Stand Leg
Weight:	4,160 Lbs.
Cylinders:	Twin Equalized Operating Cylinders, One Retraction Cylinder
Cylinder Fluid Capacity:	18 Gallons Each

**Pump Specification**

Dimensions:	27" x 27" x 43"
Weight:	300 Lbs. with Hydraulic Fluid
Tank Hydraulic Capacity:	30 Gallons
Hydraulic Oil:	MF 32 Standard, ISO 32
Internal Bypass Relief Valve	
Assembly Mounted on 12" Solid Rubber Tires	

**Regent 24" Steel Squeeze Tool Operating instructions:**

- 1.) Tool to be positioned over pipe. Select pinch location. Remove and clean insulation from exterior of pipe within a three-foot minimum where pipe is to be squeezed. Examine pinch area for location of seam, girth welds, excessive pitting and possible weak spots. Avoid these areas.
- 2.) Steel Squeeze Tool should be suspended by eyehook or other lifting points on top frame for best balance and positioning while squeezing steel pipe.
- 3.) Once 24" tool is in place centered over the pipe, the lower jaw door should be closed and locked in position. Final closure is accomplished with the provided pin. This pin should be secured securely with the provided lock screw.
- 4.) 1/2" and 1/4" return hydraulic lines along with 3/8" compression line hoses should be attached via quick disconnects. Particular caution shall be made with regards to quick disconnects as to not allow air inclusion in lines as this will effect performance of machine. Do not break lines at any other points this will allow air into the system and machine will not function properly.

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- 5.) Move Red Handle at bottom of tank to the closed position.
- 6.) Air line should now be attached to the inlet on the pump. The air inlet regulator to be set @ 60 psi.
- 7.) Point Selector Valve to Compression Gauge.
- 8.) Opening the air valve will now initiate the compression cycle on the two 10" diameter cylinders.
- 9.) Allow squeeze tool to cycle until adequate squeeze is acquired. Typically, the pipe will be approximately 98% closed. Complete 100% closure cannot be guaranteed since conditions such as pipe age, variances in wall thicknesses, inside wall corrosion, metal content vary considerably from one section of pipe to another.
- 10.) Normal operating pressure is 3,200 psi. Maximum pressure is 4,000 psi controlled by a pressure relief valve in the pump assembly. After squeeze off is achieved, you may advance down the knurled lock rings as a manual lock off and back up for the hydraulic cylinders. Close Inlet Air Handle Valve.
- 11.) After necessary repairs are complete, first retract the knurled lock rings to top plate. Putting a slight increase in pressure on the pipe will be necessary to disengage the knurled lock rings.
- 12.) Move Selector Valve to Center Position. Both gages should now read zero pressure.
- 13.) Move Selector Valve to Retract Gauge. Open Red Handle located at bottom of hydraulic tank. Open Position is Red Handle in the Down Position.
- 14.) Open air inlet valve. Squeeze tool will now begin to retract, let machine cycle until cylinders are in full retract approximately 1/2" from top beam
- 15.) Remove hoses from unit via quick disconnects.
- 16.) Unscrew lock pin screw, remove pin open jaw, and remove squeeze tool.

All efforts have been made on this unit to provide a user-friendly control unit, which will function properly if all the above instructions are followed properly.