



Volzhskiy Zavod
Promyshlennoy Armatury

Stainless steel Repair Clamp RHB

PRODUCT PASSPORT

TU (Technical specifications) 25.99.29-004-21203517-2017

Article. RHB.0.000-000.000



2022

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1. General information

The repair clamp RHB is used to eliminate leaks in pipelines that transport various liquids, including drinking water, air, natural gas, as well as for connecting pipe joints.

Diameter (outer pipe diameter): from 44 mm to 645 mm.

Manufactured clamp lengths: 200 mm, 300 mm, 400 mm.

Normal operating pressure: with a 44-200 mm diameter clamp – 16 bar, 210-344 mm – 10 bar, 354-645 mm - 6 bar. Clamps with a higher working pressure can also be manufactured.

Operating temperature range: NBR rubber from -20 C° to +80 C°, EPDM rubber from -20 C°, to +130 C° (up to +150 C° in a short run).

2. Product components

The repair clamp RHB consists of binding, clamping units (locks), and a rubber seal with an insert (Figure No. 1). The clamp shown in the figure comes with one clamping unit (lock). Repair clamps with two clamping units can also be manufactured.

The binding is made of stainless steel used in food production (08X18H10 or AISI 304) using a punch joint without welding.

The clamping unit comes with two bars (threaded and clamping), bolts, ergonomic handle, washers, lockers, and bushings (material: 08X18H10 or AISI 304). The bolts are treated with a special solid-lubricating anti-friction coating based on molybdenum disulfide.

The rubber seal with a “wafer” inner surface, into which a stainless steel insert is stamped or glued in, is made of ethylene-propylene rubber (EPDM) or nitrile butadiene rubber (NBR). One cell of the “wafer” of the seal is 5*5 mm or 19x19 mm, 3 mm deep. The seal is attached to the inner wall of the binding using a special adhesive or reinforced adhesive tape. The seal is a solid piece. The medium with which the clamp may be used depends on the material of the seal. Please visit the manufacturer’s website www.vzpa.ru for more information about the table of acceptable substances. The repair clamp RHB is manufactured according to the current technical documentation of the manufacturer TU 25.99.29-004-21203517-2017, certificate of conformity No. 0741028.

3. Field of use

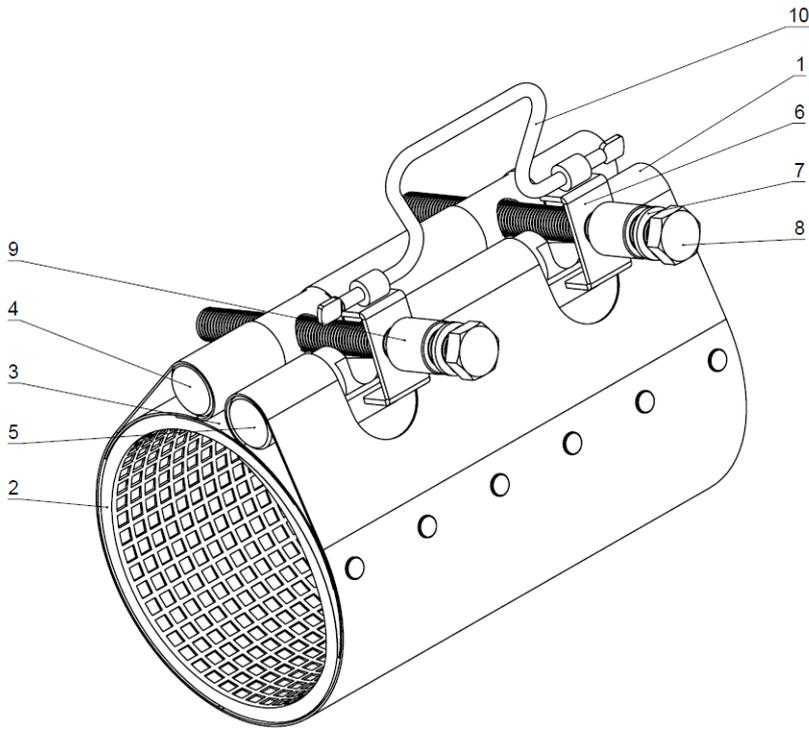
The repair clamp RHB eliminates leaks in pipelines in the following cases: transversal cracks on cast-iron pipes with an axial deviation of up to 2°, the formation of large holes, longitudinal cracks, damages caused by welding, pipe fractures, needle holes. With the repair clamp, you can connect PE steel, cast iron, and polyethylene pipes of the same diameter. Can be assembled on pipes made of gray and malleable cast iron, carbon and stainless steel, concrete and asbestos cement, plastic, and polyethylene.

4. Package set

Binding - 1 pc., rubber seal with insert - 1 pc., threaded rod - 1 pc., clamping rod - 1 pc., handle - 1 pc. The number of bolts, washers, lockers, and bushings is determined by the length of the coupling: with an L=200 mm long coupling - 2 pcs., L= 300 mm - 3 pcs., L=400 mm - 4 pcs.

If the repair clamp RHB comes with two clamping units, the parts are multiplied by two.

Fig.1



1. Binding
2. Rubber seal
3. Insert
4. Threaded rod
5. Clamping rod
6. Locker
7. Washer
8. Bolt
9. Bushing
10. Handle

5. Instructions on use

1. The repair clamp RHB must be at least 145 mm longer than the length of the crack on the pipe. For polyethylene pipes, it must be at least 50% longer.
2. The repair clamp RHB must be at least three times longer than the damage.
3. If you connect PE pipes of the same diameter or pipe valves and polyethylene pipes, the distance between the connected ends should not exceed 5 mm.
4. The maximum allowable deviation of the axes of pipelines is 2° . The maximum alignment deviation should not exceed 3 mm.

Please keep in mind that a clamp is only a repair tool. The pipeline may start leaking again because if the integrity of the pipeline was damaged, the pipeline is more corrodible and its strength properties are downgraded. It is recommended to do an overhaul repair or replace the pipeline.

6. Product storage and transportation

The repair clamp RHB is delivered pre-assembled and packed in corrugated cardboard boxes or soft plastic packaging. Storage conditions of the product must comply with groups 1, 2 of GOST 15150-69. Use a covered vehicle during transportation and, if needed, additionally pack the product to avoid any significant deformation of the factory box and the clamp body

7. Installation instructions

1. Prior to installation, make sure that you have selected the correct repair clamp in terms of diameter. Clean the pipe and remove dirt and corrosion from the pipe surface. Put marks on the pipe where the ends of the clamp will be placed. Once assembled, use these marks to ensure that the clamp is installed in the correct position. Lubricate the spot on the pipe with soapy water where the clamp will be attached. Do not use greasy lubricants.

2. Partially unscrew the bolts (8) from the threaded rod (4).
3. Pull the handle (10) to open the coupling, then release the lockers (6) from the clamping rod (5).
4. Slide the clamp on the damaged area of the pipeline.
5. Insert the lockers (6) into the grooves of the clamping rod (5) using the handle (10).
6. Tighten the bolts (8) with a wrench or an impact wrench.

Tighten until the desired result, based on the operating pressure in the pipeline. Maximum torque: for M12 studs – 100 Nm, for M14 – 150 Nm, for M16 – 200 Nm (according to the datasheet 37.001.131-89). Wait 20 minutes and then tighten again achieving the same torque. If the repaired pipeline is placed in the ground, consolidate the soil around the clamp and cover it with sand to avoid subsidence at the spot where the repair works have been carried out.

8. Labeling

Each product is labeled with an identification tag. The label contains the following information: manufacturer, product name, diameter (mm), product length (mm), production date, article number. By default, the product is equipped with an EPDM rubber seal. If the customer requests an NBR rubber sealing, then it will be indicated on the label. Definition of the RHB.0.000-000.000 article: RHB - product name (Stainless steel Repair Clamp RHB), the first digit indicates the number of locks of the product, the second group of digits indicates the diameter of the product (mm), and the third group of digits is the length of the product (mm).

9. Disposal

The product is disposed of by disassembling it and sending it to the manufacturing plant or organizations that recycle rubber, non-ferrous and ferrous metals.

10. Manufacturer's warranty

The product that has been stored, installed, and operated according to this Product Passport has a 24-month warranty period from the date of its purchase. The expected service period is 10 years. There is only one product passport for each lot.

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