



Operations and Maintenance Procedures

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O & M Section	SCUD Task # 260
Sections: Const. & Emergency	Revision Date 5-23-17

Squeeze off Plastic Pipe

SCOPE AND PURPOSE

This procedure is to provide personnel performing squeeze off operations on plastic pipe with a safe and effective procedures to ensure the integrity of the piping system.

RESPONSIBILITY

SCUD Supervisors, or other designees, are responsible to ensure that squeeze off operations are performed as described in this procedure.

PERSONNEL SAFETY (Where Applicable)

- Personnel should be aware of the possibility of electro-static build up in PE pipelines.
- As a general safety precaution, squeeze offs should be performed in a separate bell-hole/location from blowing/escaping gas.
- Static suppression spray must be applied to the pipe surface area to be squeezed off, to aid in the dissipation of any possible static buildup.
- Squeeze off tools should be properly grounded.

EQUIPMENT AND MATERIALS

Squeeze off tool equipped with over-squeeze protection stops
 Static Electricity Elimination Tools
 System maps and drawings as needed
 Other equipment and materials as needed

OPERATOR QUALIFICATION

This activity is a covered task under the Operator Qualification Plan and may only be performed by or directed and observed by an individual who is currently qualified to perform squeeze off on plastic pipe. Refer to the OQ Plan for specific qualification requirements.

INSTRUCTIONS

Squeeze Off

- Verify the correct pipeline segment and proper location for the squeeze off.
- Squeeze-off tools shall be selected and operated in accordance with the manufacturer's instructions.
- Tools must be electrically grounded before they are brought near or attached to the pipe. Tool should be equipped with ground cables and ground rods. If they are not so equipped, these can be installed by using a set of jumper cables with a ground rod. Static electricity ignition prevention steps and pipe and tool grounding measures must be in place and monitored throughout the squeeze off and associated operations.
- Inspect the outside pipe wall for surface damage and remove any dirt or debris in the area to be squeezed (make sure tracer wire will not interfere with the squeeze-off).
- Place the tool on the pipeline to be shut down, avoiding existing fittings and joints that could be affected by the pipe deformation.
- Using the proper squeeze tool, and with proper gap stops, perform the squeeze. Operate the tool slowly, allowing the plastic to conform to the compressed shape slowly to prevent damage to the pipeline. If the temperature is 32 degrees or below the squeeze off must be operated even slower to allow more time for the cold pipe to conform.
- If the squeeze-off tool is equipped with a locking device to prevent the separation of the squeeze-off tools bars/ jaws, lock the bars/jaws of the squeeze-off tool.
- DO NOT OVER-SQUEEZE THE PIPE!!!!

Tool Removal

- When the project is complete, slowly remove the squeezer allowing the pressure to equalize in the system and allow the pipe to return to its original shape to prevent damage to the pipe wall.
- Inspect the squeezed-off section of the pipe for damage. Permanently mark the squeezed pipe area and note the squeeze location on the appropriate forms or drawings

Prepared by: SIF	Approved by:	Date:2/7/2008
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k. Proceed with backfilling.

REPORTING/NOTIFICATION

Complete documentation in accordance with Operation and Maintenance Manual.

RELATED PROCEDURES

None

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