



PIPE TOOLS & VISES  
SINCE 1896

Applies to: 04332, 04333,  
04334, 04336, 04337



PES4DB  
PES4DBM



PES2DB

## USER MANUAL

# Double Squeeze™ PE Squeeze Tools

### PRIOR TO USE

- Only trained personnel should use this tool. Read and understand instructions before operating. A mock squeeze-off is recommended for users not familiar with the squeeze procedure and the anatomy of the tool.
- Verify all parts are clean and free of debris that may hinder operation.
- REED PE Squeeze Tools are to be used on polyethylene (PE) pipe only.
- Manual REED Squeeze Tools must be operated by hand and without the use of power tools.
- The use of additional leverage (i.e. cheater bars) is not needed. The tool was designed to give adequate leverage with the incorporated slide handle.

### TOOL OPERATION REMINDERS

- When satisfactory flow control cannot be obtained with one tool, REED recommends a double squeeze-off. This means using two squeeze tools in series.
- Be aware of the recommended squeeze/release rates to avoid pipe damage (2 inches/min. [51 mm/min.] squeeze and ½ inch/min. [13 mm/min.] release). Rates should be slowed further in colder weather. Consult the local utility for recommendations regarding squeeze and release rates.
- A squeeze should be performed a minimum of 12 inches (305 mm) or 3 times the pipe diameter (whichever is greater) from fittings, fusions, or previously squeezed pipe. Refer to ASTM standard designation F1041-02 for more information.

### WARNING

Cold temperatures can affect the pipe integrity during the squeeze. Squeeze and releases rates need to be slowed in temperatures below 50° F [10°C]. Cold temperatures can affect the squeeze (below 50° F [10°C]) and result in a less than desirable flow control. Give adequate time for the pipe to relax during the squeeze (5-15+ minutes) and perform a double squeeze-off if necessary.

## REED MANUFACTURING

1425 West 8th Street Erie, PA 16502 USA Phone: 800-666-3691 or +1 814-452-3691 Fax: +1 814-455-1697 reedsales@reedmfgco.com  
www.reedmfgco.com

# SQUEEZE PROCEDURE

## WARNING

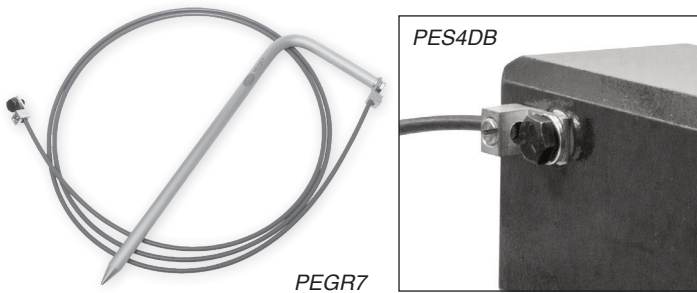
Avoid binding the tool. Keep the squeeze bars parallel to each other to avoid tool damage. Check bottom bar pockets are clear of debris to ensure proper closure of the tool.

## Squeezing PE Pipe

1. Raise the top bar using the feed screw and sliding handle for the pipe size you are squeezing.
2. Assemble the helper handle where needed.
3. Follow your company policy concerning static electric discharge at this stage of the procedure.

### NOTE: REED strongly recommends use of the PEGR7 Static Grounding Device #04621 with PE Squeeze Tools.

The threaded connection for the PEGR7 is on the head. Use a grounding accessory as a precaution against static build-up. Dissipate the charge and minimize the possibility of ignition. Additional information and precautions on static electricity is available in the *PPI Handbook of Polyethylene Pipe*.



4. Lift and swing out bottom bar and mount onto the pipe. Close the bottom bar, ensuring the rod nuts are set securely in the bottom bar pockets.

## CAUTION

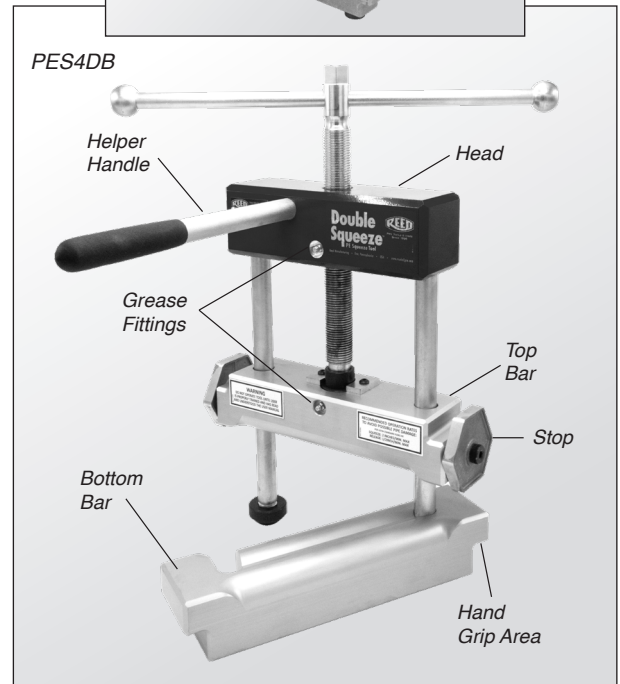
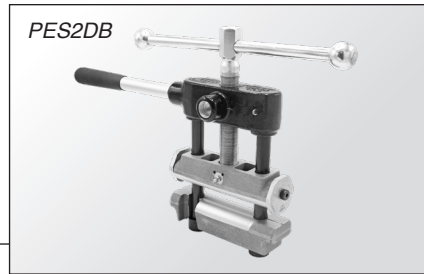
Center the pipe along the width of the bars and square the pipe relative to the tie rods.

5. Select both pipe stops based on pipe diameter and SDR. Position both pipe stops so that the corresponding flat is facing the bottom bar. Stops must match one another.
6. Turn the feed screw to squeeze the pipe. Momentary pauses will allow the pipe to relax and will result in less user fatigue. Recommended squeeze rate to avoid pipe damage is 2 inches/min. [51 mm/min] maximum. Squeeze until pipe stops are contacted or feed screw will no longer turn and there is satisfactory flow control.

## CAUTION

Stop squeezing when pipe stops contact bottom bar, further squeezing will cause tool damage.

**NOTE:** Pipe stops don't need to contact bottom bar to satisfactorily control flow.



## Releasing PE Pipe

1. Slowly and carefully release the pipe by unscrewing the feed screw while carefully watching the squeeze bars for movement. The recommended release rate to avoid pipe damage is ½ inch/min. [13 mm/min] maximum.
2. When the squeeze bars, due to internal pipe pressure, no longer assist the operator in the release, unscrew and remove the tool from the pipe.
3. Rerounding the pipe can optionally be done by rotating the tool 45°-90° and applying enough force to round pipe.
4. Inspect squeezed section for damage before covering. Procedures should be followed that will prevent the same area from being squeezed-off more than once.

## Care and Maintenance

1. Wipe down and clean the tool.
2. Store the tool in a dry place.
3. Keep the feed screw and nut clean and free of debris. Failure to perform this maintenance will make it more difficult for the operator to achieve the force necessary for a successful shutoff.
4. Periodically grease the nut and bearing cavity. (2 grease fittings are mounted on the tool).



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