

**Operating & Service Manual**  
**90114-IM**  
05/11/2011

# Airetool®

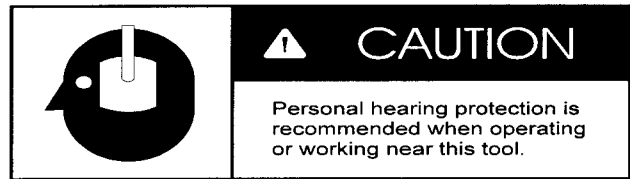
**ATT-6525**  
Tube Tester



*For additional product information visit our website at <http://www.apextoolgroup.com>*

# Safety Recommendations

**FOR YOUR SAFETY AND THE SAFETY OF OTHERS, READ AND UNDERSTAND THE SAFETY RECOMMENDATIONS AND OPERATING INSTRUCTIONS BEFORE USING THIS TOOL.**



When using this tool, basic safety practices should always be followed to reduce the risk of personal injury including the following items:

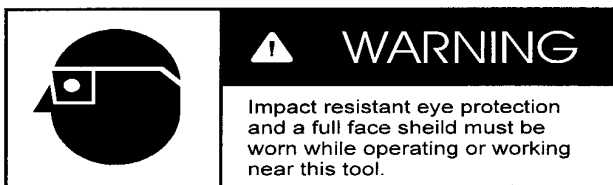
**KNOW THE TOOL** - Read the owners manual carefully. Learn its applications and limitations as well as the specific potential hazards peculiar to this tool.

**ALWAYS DISCONNECT AIR** - The air supply should be disconnected when tool is not in use and before servicing.

**NEVER ACTIVATE OUTSIDE OF TUBE** - The air control valve should never be activated unless the seal is inside of a tube I. D. the proper size for the seal.

**STAT ALERT** - Be careful and watch what you are doing. Use common sense.

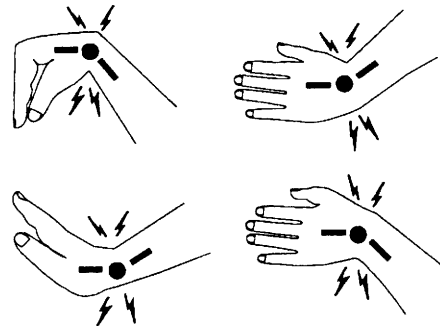
## ALWAYS WEAR PROTECTIVE EQUIPMENT



For additional information on eye and face protection, refer to Federal OSHA Regulations, 29 Code of federal regulations, Section 1910.133 Eye and Face Protection, and American National Standards Institute, ANSI A87.1, Occupational and Educational Eye and Face Protection Z87.1 is available from the American National Standards Institute, 11 West 42nd Street, New York, NY 10036.

Hearing protectors are required in high noise areas, 85 dBA or greater. The operation of tools and equipment in the area, reflective surfaces, process noises and non-resonant structures can substantially contribute to and increase the noise level in the area. Excessive air pressure above 90 psig or worn motor components can also increase sound level emitted by tool. Proper hearing conversation measures, including annual audiograms and training in the use and fit of hearing protection devices may be necessary.

Some individuals are susceptible to disorders of the hands and arms when exposed to task which involve highly repetitive motions or vibration. Those individuals predisposed to vasculatory or circulation problems may be particularly susceptible. Cumulative trauma disorders such as Carpal Tunnel Syndrome and Tendinitis can be caused by repetitions, forceful exertions of the hands and arms. These disorders develop gradually over periods of weeks, months and years.



# Safety Recommendations

\* **Tasks should be performed in such a manner that the wrists are maintained in a neutral position which is not flexed, hyperextended or turned side to side.**

\* **Stressful postures should be avoided and can be controlled through tool selection and work location.**

Any user suffering from prolonged symptoms of tingling, numbness, clumsiness or weakened grip, nocturnal pain in the hand or any other disorder of the shoulders, arms, wrists or fingers is advised to con-

sult with a physician. If it is determined that the symptoms are job related or aggravated by movements and postures dictated by the job design it may be necessary for the employer to take steps to prevent further occurrences. These steps might include, but are not limited to repositioning the work piece or re-designing the work station, reassigning workers to other jobs, rotating jobs, altering work pace and/or changing the type of tools used so as to minimize stress on the operator. Some tasks may require more than one type of tool to obtain the optimum operator/tool/task relationship.

# OPERATING INSTRUCTIONS

## Model ATT-6525 Airetool Tube Testing Guns

### PRIOR TO TESTING :

1. The tube to be tested should be cleaned before attempting to test. A air or electric driven drill fitted with a spiral brush of appropriate size should be run in each tube end for 4" to 6" deep. All loosened deposits or scale should be removed from the tubes. Attempting to test tubes with loose deposits in them may cause the loose deposit to be blown into the testing guns and could cause internal damage to the guns.

2. Also note that loose deposit in the tubes could be blown into the eyes of the plug gun operator causing injury. Both operators should always wear eye protection and or face shield when testing with the Airetool tube testing tools. **SEE PAGE 3 FOR SAFETY INSTRUCTIONS CONCERNING EYE PROTECTION.**

3. If the tubes to be tested have been chemically cleaned, please check with your Airetool representative regarding the compatibility of the test gun seals with the cleaning agent. Other types of elastomer seals are available upon request.

4. Make sure the test guns have the correct size seal and back up washer set installed for the size tube being tested. The seals and washers are considered to be correctly sized if the O. D. of the seal is within .020" to .060" (.5 to 1.5 mm) smaller than the actual tube I. D.. Using seals that are too small may cause any of the following. Premature seal wear, jamming of the test gun in the tube or expulsion of the test gun from the tube end. Replacement seals for the Model ATT-6525 tube testing guns are available upon request for any tube I. D. size from .280" thru 1.230" (7.1 thru 31.3 mm). For tube I. D. sizes larger than 1.230", contact your nearest Airetool representative. **SEE PAGE 10.** Testing guns for larger sizes available upon request.

### TESTING PROCEDURES :

**NOTE : NEVER ACTUATE THE INJECTION GUN WITH THE SEAL OUTSIDE THE TUBE END OR INSIDE A IMPROPERLY SIZED TUBE END.** The back up washers may be forced into the seal I. D. damaging, possibly completely destroying the seal.

The Model ATT-6525 Tube Testing Guns come as a set. This set consists of (1) the air injection gun and (2) the plugging gun. The air injection gun can be differentiated from the plugging gun as it contains a air control valve (10) and a bleed valve (12). The plugging gun is a slave to the injection gun and will not operate without it.

1. Attach the air supply to the air injection gun. The Model ATT-6525 test guns will be operational on plant air supplies ranging from 40 to 125 psi (3 to 8.6 bar) at a minimum of 5 cfm. If testing tube I. D.'s from .280" to .480" (7.11 to 12.19 mm) the regulator assembly # 2900579 is required. Install the regulator assembly (14) with the arrow pointing towards the gun onto reducing nipple leak tight and attach air supply line to the regulator input. For tube I. D.'s from .280" thru .480" (7.11 thru 12.19 mm), adjust the regulator to 40 to 60 psi (1.38 to 2.06 Bar) by rotating the adjustment knob while viewing a pressure gage.

2. Insert the air injection gun into one end of the tube to be tested and the plugging gun into the other end. Apply enough pressure to seat the seal (3) on the end of the tube. **Maintain this pressure throughout the test.**

3. After making sure that the plugging gun operator is ready, press the air control valve (10) on the injection gun and hold until the reading on the pressure gauge (7) stabilizes.

4. Release the button on the air control valve (10). It will automatically return to the closed position isolating the tube being tested. The tube is now under test pressure.

5. Both the injection gun and the plugging gun operators should observe the pressure gauge (7) on their respective guns. Any decrease in the air pressure indicated on the gauge (7) will indicate a leaking tube. **REMEMBER, A FALSE READING COULD BE RECEIVED IF TUBE ENDS HAVE NOT BEEN CLEANED PROPERLY.**

6. Press the bleed valve (12) on the injection gun to release or bleed off the air pressure in the tube being tested and from the air cylinders to relax the seals so the guns can be removed from the tube.

7. Remove the test guns and move to the next tube to be tested. Mark each leaking tube for repair. The total operation for testing the tube should be completed in 5 to 10 seconds. Your actual testing time will depend on the amount of time you have chosen to hold the test pressure.

# OPERATING INSTRUCTIONS

## Model ATT-6525 Airetool Tube Testing Guns

8. Go to the next tube to be tested and repeat steps two (2) thru seven (7).

### INSTALLING REPLACEMENT SEALS

Replacement seals for the Model ATT-6525 guns are supplied with the corresponding size washers. Always replace the seals and washers on both guns at the same time. **SEE SEAL SELECTION GUIDE ON PAGES 9 AND 10 OF THIS MANUAL.**

1. Remove the lock nut (1) from the end of the support tube (4) and set it aside.
2. Remove the seal and washer set (2) from the support tube (4). Discard if worn or damaged. **NOTE: BE SURE TO REPLACE WITH PROPER SIZE FOR TUBES TO BE TESTED, SEE PAGES 9 & 10 OF THIS MANUAL.** Under optimum testing conditions you should be able to test between 100 and 150 tubes per set of seals and washers.
3. When replacing the seal and washer set with the same size as removed, reverse steps 1 and 2 above for reassembly. If you are replacing the seal and washer set to test a different size tube, please keep in mind that you may also have to change the support tube assembly (5) as well. **Check chart pages 9 & 10 of this manual.** If the support tube does need to be replaced, see replacing the support tube to follow.
4. When replacing the lock nut (1) onto the support tube (4), do not use a wrench. Screw the nut on finger tight only.

A small space between the lock nut , seal and back up washers is normal. The stroke of the air piston in the air cylinder will compensate for this space.

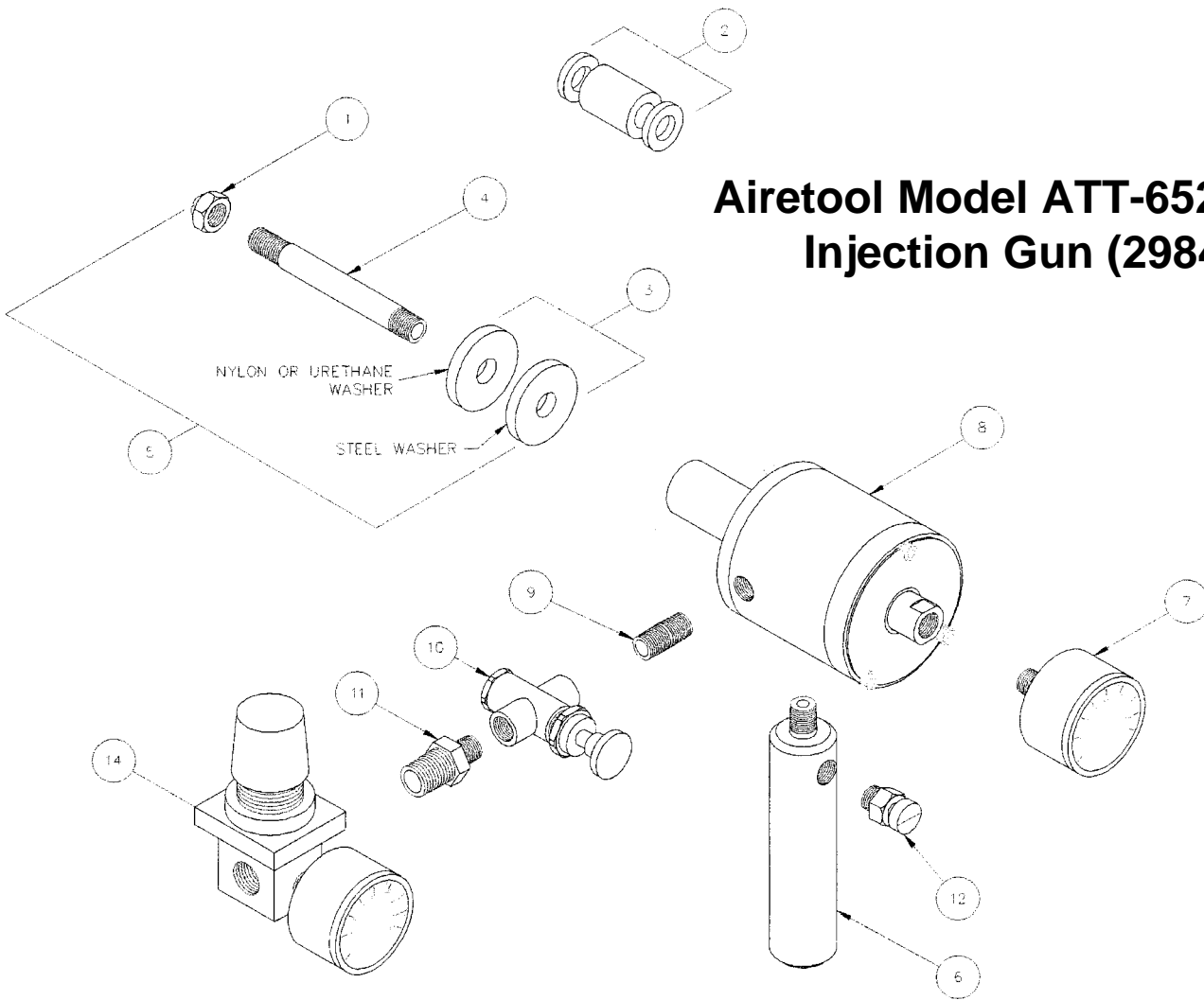
### REPLACING THE SUPPORT TUBE

The Airetool Model ATT-6525 tube testing guns are shipped with three (3) sets of support tube assemblies (5). These support tube assemblies will allow you to test tube with I. D.'s as follows:

- a. .280" thru .480" (7.1 thru 12.3 mm) tube I. D.
- b. .490" thru .830" (12.4 thru 21.2 mm) tube I. D.
- c. .840" thru 1.230" (21.3 thru 31.3 mm) tube I. D.

1. Remove the seal and washer sets (2) as previously outlined.
2. Using an open end wrench on the wrench flats provided on the piston and a small pipe wrench on the support tube (4), gently unscrew the support tube from the piston.
3. Choose the correct size support tube for the tube I. D. to be tested. All three (3) sizes support tubes will screw directly into the piston of the test gun. Use a never seize compound product to lubricate and seal the threads. Do not over tighten the support tube.
4. Repeat steps 1 thru 3 for the remaining gun.
5. Prior to replacing the seal and washer set (2) and the tube end seal and washer set (3), inspect the support tube for scars left from the replacement procedure. File smooth if present.

## Airetool Model ATT-6525 Injection Gun (2984876)

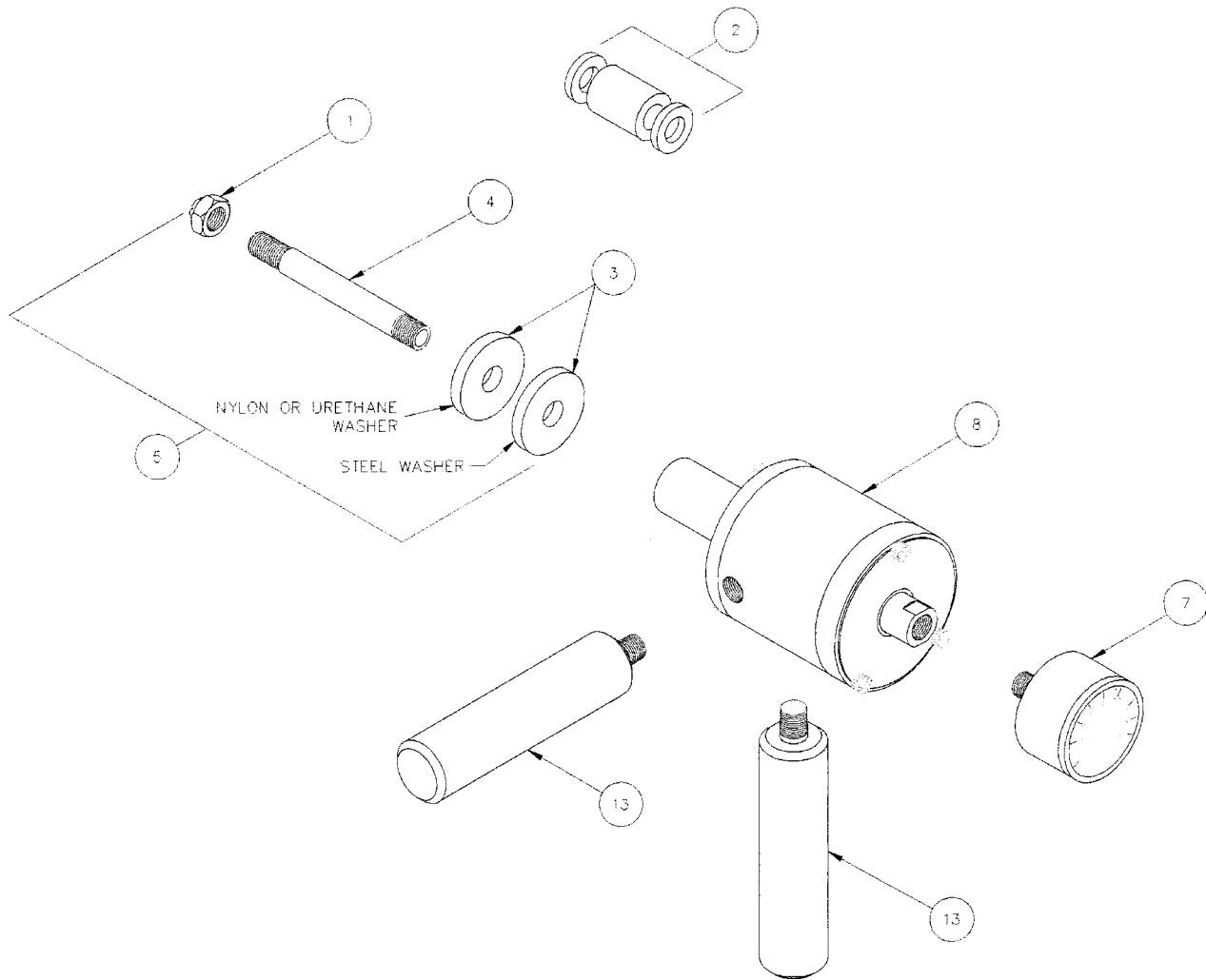


ITEM #	PART #	DESCRIPTION	QUAN.	ITEM #	PART #	DESCRIPTION	QUAN.
1	**	Lock Nut	1	8	2992150	Cylinder Body Complete	1
2	*	Seal & Backup Washer Set	1	9	8010275	Pipe Nipple 1/8" NPT	1
3	**	Tube End Seal/Washer	1	10	2984860	Air Control Valve	1
4	**	Support Tube	1	11	8010276	Reducing Nipple 1/4" - 1/8" NPT	1
5	**	Support Tube Assembly	1	12	2984862	Bleed Valve	1
6	2984867	Handle Without Bleed Valve	1	14	2900579	Regulator Assembly	1
7	2984859	Pressure Gage	1				

\* See seal/washer selection guide pages 9 & 10 .

\*\* See selection guide pages 9 & 10 .

# Airetool Model ATT-6525 Plugging Gun (2984877)



ITEM #	PART #	DESCRIPTION	QUAN.	ITEM #	PART #	DESCRIPTION	QUAN.
1	**	Lock Nut	1	5	**	Support Tube Assembly	1
2	*	Seal & Backup Washer Set	1	7	2984859	Pressure Gage	1
3	**	Tube End Seal/Washer	1	8	2992150	Cylinder Body Complete	1
4	**	Support Tube	1	13	2984868	Dead Handle	2

\* See seal/washer selection guide pages 9 & 10 .

\*\* See Selection guide pages 9 & 10 .

## Sales & Service Centers

**Note:** All locations may not service all products. Please contact the nearest Sales & Service Center for the appropriate facility to handle your service requirements.

Dallas, TX  
**Apex Tool Group  
Sales & Service Center**  
1470 Post & Paddock  
Grand Prairie, TX 75050  
Tel: 972-641-9563  
Fax: 972-641-9674

Detroit, MI  
**Apex Tool Group  
Sales & Service Center**  
2630 Superior Court  
Auburn Hills, MI 48326  
Tel: 248-391-3700  
Fax: 248-391-7824

Houston, TX  
**Apex Tool Group  
Sales & Service Center**  
6550 West Sam Houston  
Parkway North, Suite 200  
Houston, TX 77041  
Tel: 713-849-2364  
Fax: 713-849-2047

Lexington, SC  
**Apex Tool Group**  
670 Industrial Drive  
Lexington, SC 29072  
Tel: 800-845-5629  
Tel: 803-951-7544  
Fax: 803-358-7681

Los Angeles, CA  
**Apex Tool Group  
Sales & Service Center**  
15503 Blackburn Avenue  
Norwalk, CA 90650  
Tel: 562-623-4457  
Fax: 562-802-1718

Seattle, WA  
**Apex Tool Group  
Sales & Service Center**  
2865 152nd Avenue N.E.  
Redmond, WA 98052  
Tel: 425-497-0476  
Fax: 425-497-0496

York, PA  
**Apex Tool Group  
Sales & Service Center**  
3990 East Market Street  
York, PA 17402  
Tel: 717-755-2933  
Fax: 717-757-5063

Canada  
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Sales & Service Center**  
5925 McLaughlin Road  
Mississauga, Ont. L5R 1B8  
Canada  
Tel: 905-501-4785  
Fax: 905-501-4786

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