Owner's Manual

C177-A2 Hydraulic Squeeze Off Tool



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DO NOT OPERATE THESE TOOLS UNLESS THESE INSTRUCTIONS HAVE BEEN CAREFULLY READ AND UNDERSTOOD

SAFETY WARNING:

DO NOT OPERATE THESE TOOLS UNLESS THESE INSTRUCTIONS HAVE BEEN CAREFULLY READ AND UNDERSTOOD. FAILURE TO FOLLOW THESE INSTRUCTIONS MAY RESULT IN DAMAGES, INCLUDING WITHOUT LIMITATION DEFECTS, DETERIORATION, WEAR, ERROR, FAILURE OF THE SQUEEZE OFF TOOL, OR INJURY, INCLUDING WITHOUT LIMITATION DEATH AND INCAPACITATION. FOOTAGE TOOLS INC. EXPRESSLY DISCLAIMS ANY AND ALL LIABILITY FOR DIRECT, INDIRECT, INCIDENTAL, SPECIAL, BODILY, EXEMPLARY OR DAMAGES OF ANY KIND, WHETHER FORESEEABLE OR UNFORESEEABLE, ARISING OUT OR IN CONNECTION WITH THE FAILURE TO COMPLY WITH THIS OWNER'S MANUAL.

WARNING:

- DO NOT EXCEED THE RECOMMENDED SQUEEZE AND RELEASE RATES. TEMPERATURES BELOW 32°F (0°C) REQUIRE SLOWER SQUEEZES AND RELEASES. RELEASES ARE MORE CRITICAL THAN SQUEEZES; THUS, SLOWER RATES ARE REQUIRED. CONSULT YOUR LOCAL UTILITY REGARDING THEIR SPECIFIC RECOMMENDATIONS FOR THIS PROCEDURE.
- WHEN PERFORMING A SQUEEZE, STAY A MINIMUM OF 3 TIMES THE PIPE DIAMETER FROM FITTINGS, FUSIONS, OR PREVIOUSLY SQUEEZED SECTIONS OF PIPE. NEVER SQUEEZE A PIPE IN THE SAME PLACE TWICE OR PIPE DAMAGE MAY RESULT.
- ENSURE THE GROUNDING SYSTEM IS PROPERLY PLANTED IN THE SOIL TO REDUCE THE CHANCES OF STATIC DISCHARGE.
- USE EXTREME CAUTION WHEN OPERATING THE TOOL NEAR LIVE ELECTRICAL WIRES, BURIED UTILITIES, OR OTHER HAZARDS.
- IN CASE OF MALFUNCTION, IMMEDIATELY STOP USING THE TOOL AND CONTACT A QUALIFIED TECHNICIAN FOR INSPECTION AND REPAIR.
- WHEN OPERATING THIS TOOL, SAFETY EQUIPMENT, INCLUDING SAFETY GLASSES ARE REQUIRED.
- BEFORE PERFORMING A SQUEEZE, CLEAN THE POCKETS ON THE UNDERSIDE OF THE LOWER BAR/STATIONARY BAR AND WHERE THE SIDE SHAFTS/CYLINDER RODS WILL CONTACT THE LOWER BAR/STATIONARY BAR. REINSPECT AFTER TOOL IS LOWERED INTO POSITION ON PIPE JUST PRIOR TO SQUEEZE.

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SAFETY WARNING:

WARNING:

- DO NOT MODIFY OR ALTER THE TOOL IN ANY WAY. ONLY USE FOOTAGE TOOLS REPLACEMENT PARTS PROVIDED BY THE MANUFACTURER OR AUTHORIZED DISTRIBUTOR.
- FOR HYDRAULIC SQUEEZE TOOLS: INSPECT HYDRAULIC HOSES FOR SIGNS OF DAMAGE OR CUTS AND REPLACE IF NECESSARY. ENSURE HYDRAULIC FITTINGS ARE FULLY ENGAGED.
- BEFORE PERFORMING A SQUEEZE, ENSURE THE PIPE IS CENTRED BETWEEN SIDE SHAFTS/CYLINDER RODS AND THE TOOL IS IN AN UPRIGHT POSITION.
- FOR HYDRAULIC SQUEEZE TOOLS: BEGIN TO ENGAGE THE SAFETY LOCK DOWN BOLTS WHEN THE UPPER BAR/SLIDING BAR IS APPROXIMATELY ONE INCH FROM TOUCHING THE GAUGE STOP.
- FOR HYDRAULIC SQUEEZE TOOLS: ENSURE YOU READ AND UNDERSTAND HOW TO OPERATE THE NEEDLE VALVE IF INSTALLED ON HYDRAULIC PUMP.
- WHEN SQUEEZING HDPE PIPE, DUE TO THE NATURE OF THE MATERIAL, IT MAY BE NECESSARY TO DOUBLE SQUEEZE AND VENT TO ATMOSPHERE BETWEEN THE SQUEEZED SECTIONS IN ORDER TO ACHIEVE FLOW CONTROL.
- KEEP AWAY FROM ANY HIGH-PRESSURE HYDRAULIC LEAKS. A HIGH-PRESSURE JET OIL CAN CAUSE SERIOUS INJURY. REPAIR IMMEDIATELY.

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This Hydraulic Squeeze Off Tool is sold in two basic configurations; manual release, and fine controlled release. The manually controlled unit does not have a needle valve in the pump hose. The fine controlled unit has a needle valve with a built-in orifice in the hose. It is critical that the operator knows the unit he is working with and that he refer to the appropriate section in these instructions.

The hand pump contains a 2-position control valve. Rotating the control valve lever (or knob) fully forward, will allow oil to be pumped through the hose, through the needle valve (if so equipped) and to the tool to control the squeeze operation. Similarly, rotating the control valve lever fully backward will allow oil to return from the tool to release (open) it. A bypass valve, set at 10,000 PSI, is built into the pump to prevent over pressurization.

PRELIMINARY ASSEMBLY:

1. Ensure the hand pump is filled with good quality, ISO 32 weight, hydraulic oil. To check or refill, connect the pump to the tool, retract the cylinder, and release system pressure. (Failure to follow this instruction may result in overfilling the reservoir – this could result in reservoir failure due to excessive pressure and possible injury.) Remove the cap and fill to the indicated level with the pump level and resting horizontally on the base, then recap. Cleanliness is critical while checking and refilling. Use a funnel with a filter. Do not allow any dirt to enter the reservoir.

2. To connect the C615-A105 static grounding kit, mount the grounding tool lead to the squeeze off tool using the supplied ¼" hardware in the ¼" X 20 drilled and tapped hole in the body of the tool. This hole is located in the top bar, below and to the left of the “Footage Tools” nameplate. *(Figure 1)*

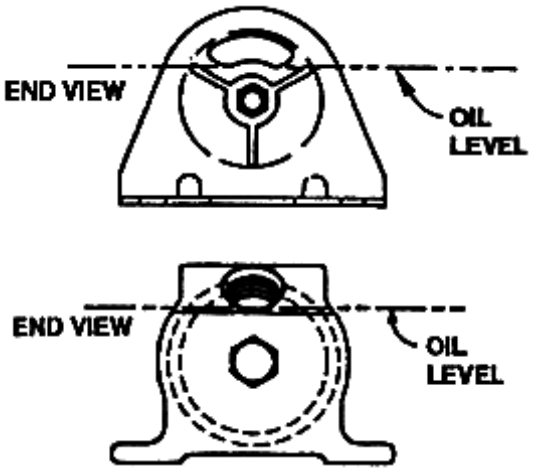




Figure 1

DO NOT OPERATE THESE TOOLS UNLESS THESE INSTRUCTIONS HAVE BEEN CAREFULLY READ AND UNDERSTOOD

OPERATING INSTRUCTIONS:

A. Installation of Pipe

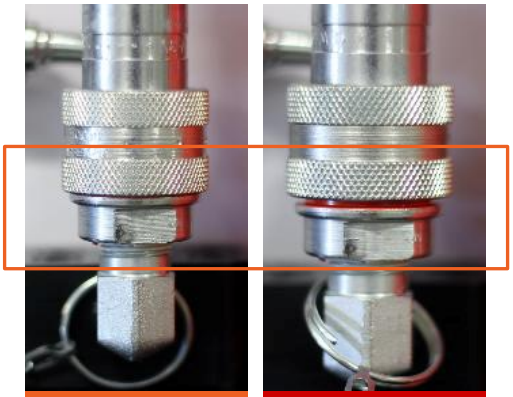
1. Fully install the grounding spike in firm soil near the tool and work area. Moist soil is required to ensure good contact to ground. Soak the area, if necessary, where the spike will be inserted. This is critical as this grounding system should remove any static electric charge that is created when the flow of gas is cut off during the squeeze operation, thereby reducing the chances of sparks being created.

WARNING: Inspect the tool to ensure that it is clean and free from any dirt that may hinder proper operation. Pay particular attention to the two stationary bar pockets where the end washer on the side shafts engage. It is critical that these pockets are clean and free of debris. Clean if necessary *(Figure 2).*



Figure 2

2. Carefully inspect the hydraulic hose to ensure there are no cuts or leaks. Ensure the hydraulic coupling is clean and then connect the hydraulic hose from the hand pump to the squeeze off tool. *(Figure 2)* To eliminate any possibility of accidental disconnection with our standard coupling, rotate the female connector collar to lock the coupling. If your pump and tool are equipped with threaded union connectors, the threaded collar must be fully threaded on, to enable pressure to reach the tool.



CORRECT | INCORRECT

To eliminate any possibility of accidental disconnection, the threaded collar must be fully threaded on, to enable pressure to reach the tool - tighten fittings until you can no longer see ORANGE paint on the inside collar.

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OPERATING INSTRUCTIONS:

A. Installation of Pipe

3. Open the tool by placing the pump control valve into the release position - fully backward.

⚠ WARNING: On tools containing a needle valve, ensure the needle valve is fully open, see section on fine controlled release below.

4. Set the adjustable gauge plates on either side of the unit to the proper pipe size and SDR setting for the pipe about to be squeezed. Ensure both sides are identical, or tool damage may result. Position the stops on the gauge plates such that they face the other squeeze bar. *(Figure 3)*

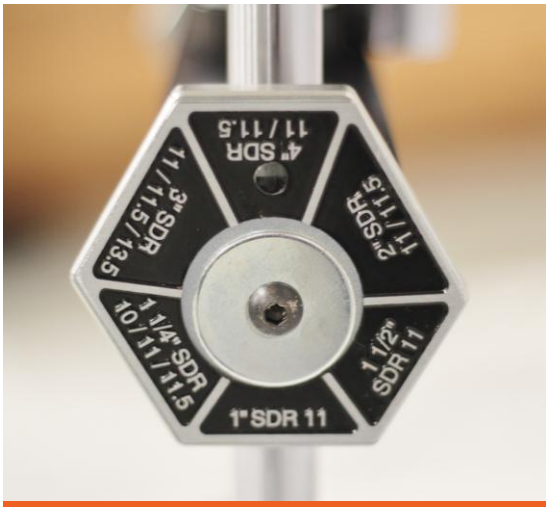


Figure 3

5. Lift and swing the stationary bar out and place the squeeze off tool over the pipe. Swing back the stationary bar and lock into position over the end washers of the side shafts. Full engagement is critical, or tool damage may result. The operator should visually check to see that the cut out in the stationary bar has fully rested against the side shaft to ensure the bar has swung fully shut. It should look closed.

The operator should then feel along the underside of the stationary bar to confirm that the bottoms of the end washers are flush with the bottom face of the stationary bar and are fully seated in the pockets on the underside of the stationary bar. *(Figure 4)* This is important so the tool cannot open accidentally and also ensure there is equal load on both sides. Failure to comply with this step may result in tool damage.

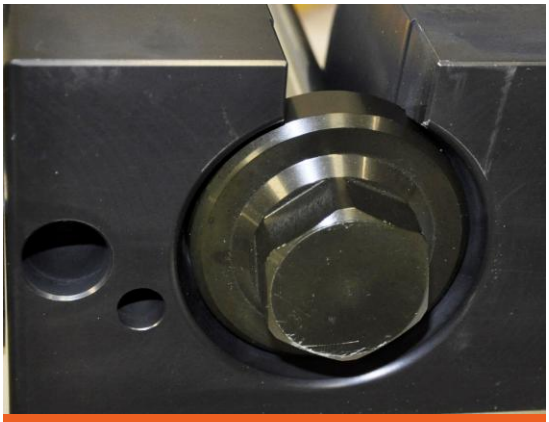


Figure 4

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OPERATING INSTRUCTIONS:

B. Squeezing the Pipe

1. Close the needle valve (if so equipped) and set the control lever (or knob) on the hydraulic pump to the squeeze position – fully forward and pump the handle to advance the squeeze bars toward the pipe. Position the tool centrally on the pipe. An equal space on both sides should be observed between the pipe wall and side shafts. Adjust as needed. If this is not done, tool and pipe damage may result. During the squeeze off, keep the tool at right angles to the pipe. *(Figure 5 & 6)*

2. The rate of squeeze is very important in preventing pipe damage. Do not exceed 2" per minute squeeze rate. Advance the squeeze bars until 50% of the pipe's original diameter has been squeezed. It is important to wait a few minutes so that the pipe material has a chance to relax (5 minutes is recommended). Increase this time in colder weather, below 32°F (0°C). Consult your local utility for their specific recommendations regarding the prescribed squeeze rate.

3. Continue squeezing the pipe slowly until a further 25% of the pipe's diameter has been squeezed. Again, pause to let the pipe have time to relax. (5 minutes)

4. Continue slowly squeezing until the gauge plate stops just comes into contact with the stationary bar. Slower rates should be used below 32°F (0°C).

DO NOT CONTINUE SQUEEZING ONCE GAUGE STOPS HAVE BEEN REACHED OR TOOL DAMAGE MAY RESULT. Keep in mind, it may not be necessary to squeeze the pipe all the way to the gauge stops to obtain satisfactory flow control. *(Figure 7)*



Figure 5



Figure 6

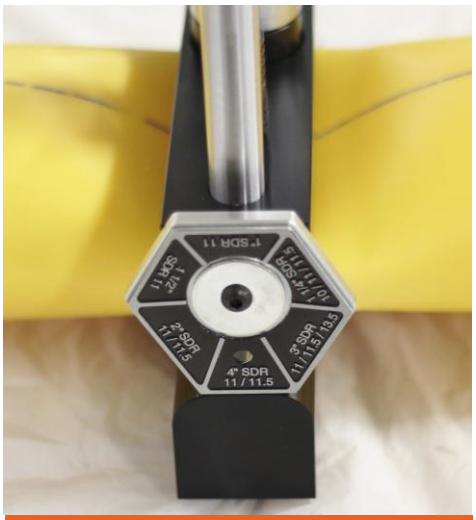


Figure 7

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OPERATING INSTRUCTIONS:

B. Squeezing the Pipe

5. These hydraulic squeeze off tools feature a steel lock down bolt on each end of the top bar to allow the tool to be locked on a squeeze and the hydraulics detached or in the event the hydraulics lose pressure. To engage, screw the bolts in the top bar. An interruption in the thread will allow the bolts to drop down into contact with the two pockets in the sliding squeeze bar. The bolts need only be tightened by hand, not with a wrench. They are not intended to assist in squeezing the pipe. The squeeze off tool has more than enough power available to satisfactorily squeeze the pipe. Start threading the bolts into the barrel nuts in the top bar as the squeeze nears completion (approx. 1" before reaching the stops). *(Figure 8)* Thread the bolts as the tool continues to squeeze the pipe. Once the tool has reached the stops on both sides, the lock down bolts should be completely threaded.

6. Perform desired work on the pipe.



PRESSURE RELIEF VALVE

OPERATING INSTRUCTIONS:

C. RELEASING THE PIPE

1. Unscrew the steel lock down bolts located on each end of the clamping bars. It may be necessary to place the pump control valve into the "squeeze" mode and apply more pressure to the tool to relieve the upward strain on the bolts created by the pipe trying to bounce back. *(Figure 9)*

2. To avoid any damage to the plastic pipe, it is critical that a slow release rate be achieved. A release rate of 1/2" (12.5mm) per minute is recommended. This time allows for the plastic to "flow" decreasing the chances of pipe damage. Below 32°F., the release rate should be slower. Consult your local utility for their specific recommendations regarding their prescribed release rate.

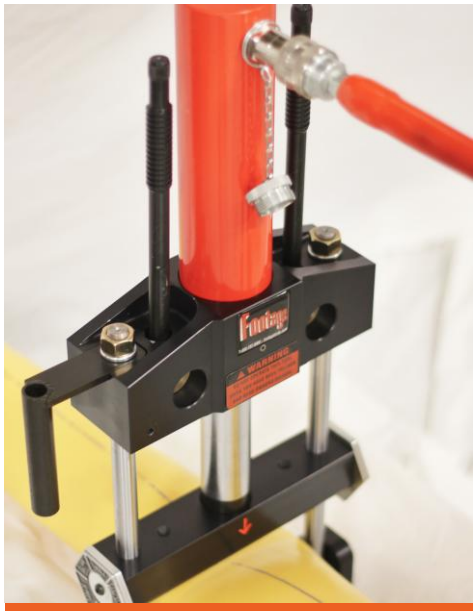


Figure 9

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OPERATING INSTRUCTIONS:

C. RELEASING THE PIPE

3. Determine the type of release mechanism supplied on the pump; either manually controlled release, or fine controlled release. Refer to the appropriate section following:

Manual release (no needle valve in line)

With the pipe squeezed and the pump control valve in the squeeze position; very slowly move the control valve towards the release position while watching the tool bars. As soon as the squeeze bars start to move, return the control valve to the squeeze position. This will stop the bars from releasing. It is very difficult to control the release rate from this initial high-pressure squeeze but operator practice will help. If the operator finds it too difficult to control, you may want to purchase the needle valve as outlined in the sections regarding controlled release / fine controlled release below. Continue this process, squeeze to release to squeeze, toggling the valve until the bars no longer move. Once bar movement has stopped, the tool should be in the most open position possible. Failure to fully open may be either from the return spring in the cylinder weakening with age or from an excessive quantity of oil in the pump reservoir.

Optional fine controlled release (needle valve with orifice in line)

Ensure the needle valve is fully closed. Slowly move the valve handle to the "release" position. As this is done, immediately the tool will start to open. Should the operator want to stop the release, return the pump control valve handle to the squeeze position. The orifice in the needle valve controls the release rate. A release rate of 1/2 inch per minute should be followed. This rate should also be slowed down in temperatures below 32°F. As the pipe opens, the pressure in the tool will decrease and the release rate will slow down. Once the pipe is sufficiently relaxed, the operator can then open the needle valve fully counter clock wise to raise the bars more rapidly for a complete release. Continue to open the tool until it can be removed from the pipe. Failure to fully open may be either from the return spring in the cylinder weakening with age or from an excessive quantity of oil in the pump reservoir.

4. To remove the tool from the pipe, let the tool rest by the sliding bar on the pipe. Lift the stationary bar upwards, (towards the pipe) about 1 inch, then rotate the stationary bar clear of the pipe. The tool may now be lifted clear of the pipe.

5. If re-rounding of pipe is not to be performed, disconnect the pump. (If the hydraulic coupling was locked, rotate the collar on the female coupling until the ball aligns with the slot in the collar to allow the coupling to be separated.) The grounding spike may now be removed from the ground, and the tool and the pump repacked in the shipping container.

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OPERATING INSTRUCTIONS:

D. RE-ROUNDING THE PIPE IF REQUIRED

1. Once the tool is fully open, reposition the tool 90° from the original squeeze, on top of the peaks of the squeeze. Squeeze the pipe back to its original shape. *(Figure 10)* Consult your local utility for their specific recommendations regarding this procedure.

2. Remove the tool from the pipe as outlined in “Releasing the Pipe” detailed above. Remove the tool from the pipe and swing the stationary squeeze bar shut.

3. The grounding spike may now be removed from the ground, disconnect the hydraulic hose from the hydraulic ram at the coupling and store squeeze tool and pump safely in the shipping container.



Figure 10

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MAINTENANCE

This section contains maintenance instructions for the tool. Do not attempt any maintenance which you do not fully understand, nor that you cannot do accurately and safely with the tools and equipment available to you. If you encounter a problem that you do not understand or cannot solve, contact your Footage Tools dealer.

Ensure the tool is in good operating order by routinely:

Inspect pump fluid level (See Preliminary Assembly)	*Top up as needed*
Bleed air from the hydraulic system.	*Position tool lower than the pump. Without squeezing a pipe, open and close the tool several times to release any air into the reservoir. Top up the pump fluid level.*
Drain, flush and fill pump reservoir.	*Remove filler cap, drain fluid. (Removing the filter will result in breakage.) Re-fill and re-cap.*
Inspect hydraulic cylinder for damage.	*Replace hydraulic cylinder if needed*
Inspect tool, pump, valves and hoses for oil leakage.	*Tighten, repair or replace as required*
Inspect squeeze bars for damage.	*Replace if needed*
Inspect lock down bolts for damage.	*Replace if needed*
Inspect side shafts for damage.	*Replace if needed*
Inspect the stationary squeeze bar pockets (2) for debris.	*Clean before each use.*

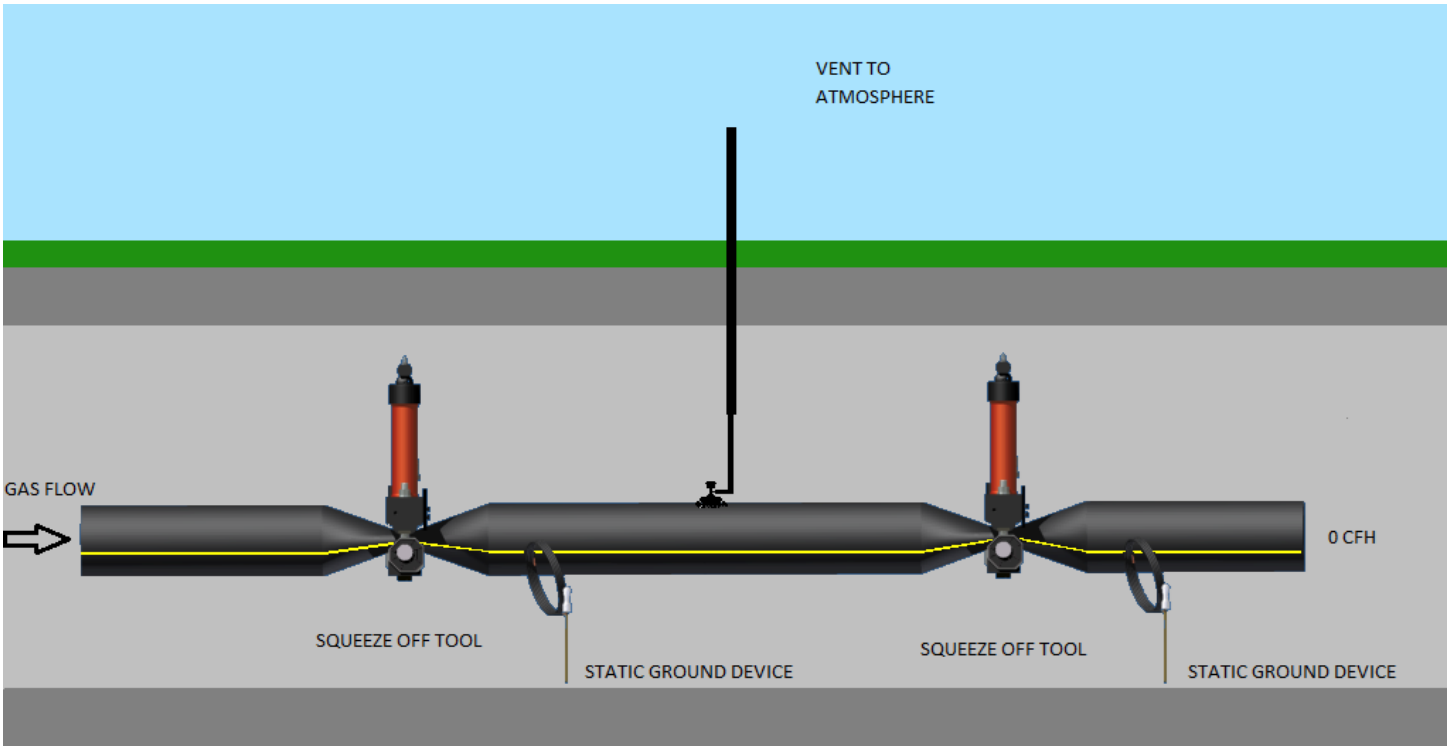
SPECIFICATIONS

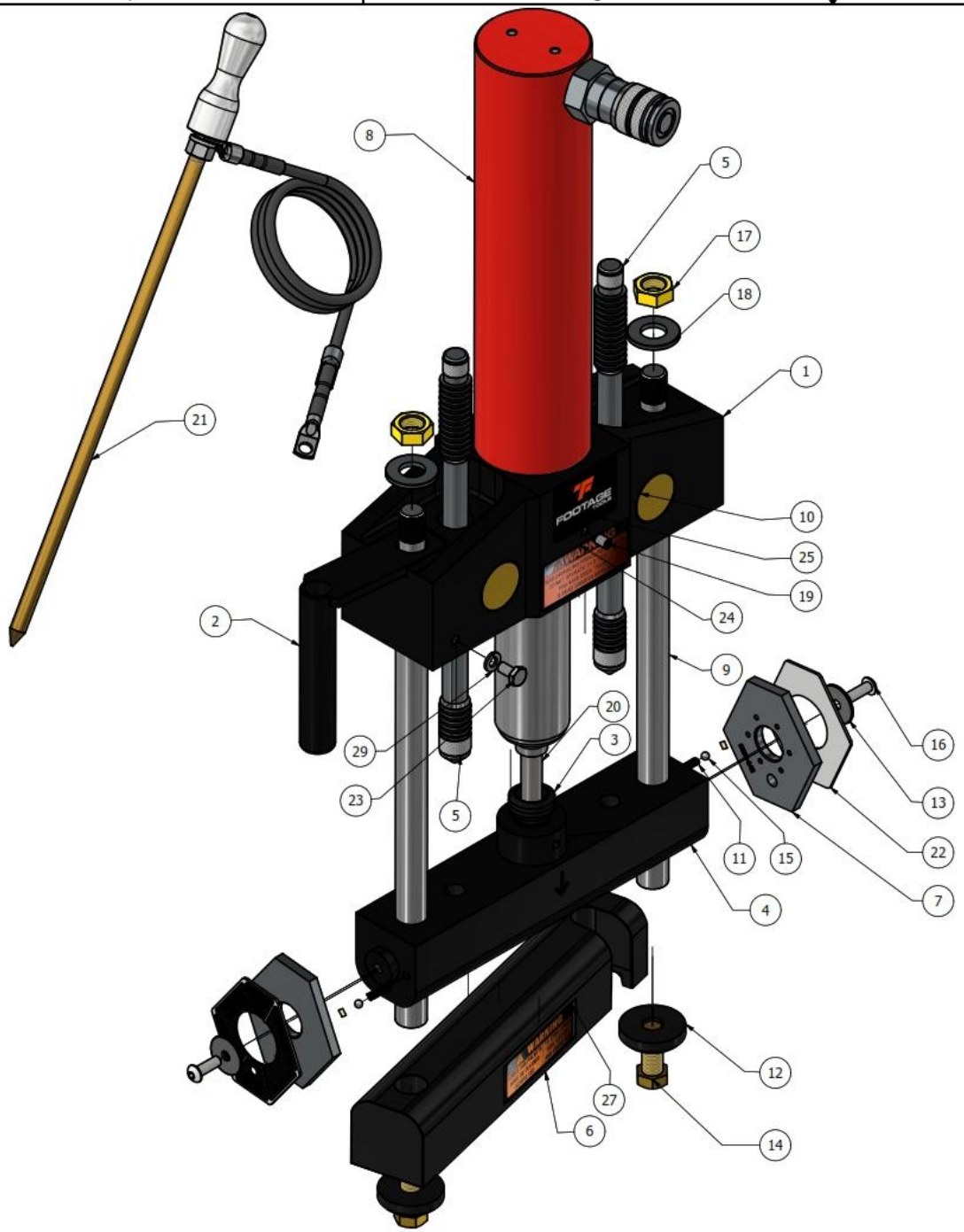
GENERAL	***C177***
Max Pipe Diameter:	*4”*
Weight:	*42 lbs.*
Operating Pressure (max):	*10,000 psig*
OPTIONAL ACCESSORIES	
Grounding Spike Kit (5 or 10 foot)	*C615-A105/C615-A110*
Pump kit with Needle Valve (c/w 0.009” orifice)	*C148-25*
Needle Valve (c/w 0.009” orifice)	*C148-40*
Pressure Gauge (0 to 10,000 psi) – (requires adapter below)	*C148-20-K*
Pressure Gauge Adapter for C177	*C148-51*
Extra-long 20’ Hose	*C177-20*

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SAFETY WARNING:

If you experience difficulty obtaining flow control when squeezing HDPE pipe, we recommend you perform a double squeeze and vent to atmosphere. Please consult your local utility for their specific operating procedure.





REVISION HISTORY

REV	DESCRIPTION	ECN	DATE	BY	REVIEWED BY
-	RELEASE FOR PRODUCTION	1811	28MY10	JLN	
A	ITEM # 25 WAS LABEL-003	1879	01MY13	NN	
B	ADDED GROUNDING TOOL KIT - HD, #24 WAS LABEL-008	1916	24OC14	NN	
C	IT#24 LABEL-008 WAS LABEL-009	2010	24OC14	NN	
D	IT#7 WAS C098-14, IT#22 WAS C098-13	2029	26JN20	JLN	
E	IT#7 WAS C098-141, IT#22 WAS C098-131	2134	05MR25	RR	

QTY	PART NUMBER	DESCRIPTION	MASS (lb)	ITEM
1	--	TIE WRAP	.000	30
1	99-140-00-0004	LOCK WASHER 1/4"	.002	29
2	-	OWNERS MANUAL - C177	.000	28
2	LABEL-007	LOWER BAR INSTRUCTION STICKER	.006	27
1	C177-BOX	SHIPPING / TRANSPORT CONTAINER	.000	26
1	LABEL-010	FOOTAGE TOOLS LABEL	.003	25
1	LABEL-008	OWNERS MANUAL LABEL, 10K PSI	.010	24
1	99-100-00-0404	SCREW, CAP, HEX, 1/4-20 X 0.5 LG	.014	23
2	C098-132	GAUGE PLATE LABEL	.023	22
1	C615HD-B110	GROUNDING TOOL KIT - HD	1.858	21
1	99-114-00-0612	SHOULDER SCREW 1/2 X 1.5" LG (3/8-16 THREAD)	.135	20
2	99-150-01-0406	SHSS, 1/4-20 X 3/8" LG	.005	19
2	99-140-00-0010	LOCK WASHER 5/8"	.032	18
2	99-121-08-0010	HEX NUT 5/8-18 UNF	.036	17
2	99-104-00-0408	BUTT. HD CAP SCR. 1/4-20X3/8"-SS	.014	16
2	99-157-00-0006	STEEL BALL 3/16"	.001	15
2	99-101-08-0810	HEX CAP SCREW 1/2-20 X 1.25LG.	.104	14
2	99-145-00-0004	WASHER, FENDER 1/4"	.013	13
2	C219-12	END WASHER, 3/8 THICK	.170	12
2	C100-21	SPRING	.001	11
2	C124-11	BARREL NUT	.441	10
2	C161-13	SIDE SHAFT	1.659	9
1	C148-13	HYD. RAM, 15 TON, REWORKED	17.646	8
2	C098-142	GAUGE PL. 6 SIDED	.424	7
1	C159-13	STATIONARY BAR	3.311	6
2	C154-11	LOCK DOWN BOLT	1.030	5
1	C177-02	SLIDING BAR	3.209	4
1	C180-04	BOSS	.577	3
1	C176-1	HANDLE	.570	2
1	C177-01	TOP BAR	5.809	1

FOOTAGE PART LIST

DRAWN TA 2025-11-05

MANUFACTURING APPROVAL

TOLERANCES:
TIR 0.004
RMS 63 MAX
.X ± .02
.XX ± .01
.XXX ± 0.005

MASS 41.1 lbmass

SCALE 1 / 2
SIZE C

FOOTAGE TOOLS

TITLE
C177-A2 ASSEMBLY DWG
4" HYD. SQUEEZE OFF TOOL

DWG NO C177-A2

REV E

REMOVE ALL SHARP CORNERS UNLESS SPECIFIED OTHERWISE

SHEET 1 OF 1

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FOOTAGE TOOLS INC. LIMITED LIFETIME WARRANTY

FOOTAGE TOOLS INC, hereinafter sometimes referred to as “Manufacturer” warrants each new industrial product of its own manufacture to be free from defects in material and workmanship, under normal use and service for the life of the tool. **Warranty is void unless warranty registration form is completed either online or manually and returned to FOOTAGE TOOLS INC. within thirty (30) days from the date of purchase.** This warranty and any possible liability of **FOOTAGE TOOLS INC.** hereunder are in lieu of all other warranties, expressed, implied, or statutory, including, but not limited to, any warranties of merchantability or fitness for a particular purpose.

The parties agree that the Buyers **SOLE AND EXCLUSIVE REMEDY** against Manufacturer, whether in contract or arising out of warranties, representations, instructions, or defects shall be for the replacement or repair of defective parts as provided herein. In no event shall Manufacturers liability exceed the purchase price of the product. The Buyer agrees that no other remedy (including, but not limited to, in incidental or consequential loss) shall be available to him. If during the warranty period, any product becomes defective by reason of material or workmanship and Buyer immediately notifies Manufacturer of such defect, Manufacturer shall, at its option, supply a replacement part or request return of the product to its plant in Toronto, Canada. No parts shall be returned without prior written authorization and a return goods authorization number from Manufacturer, and this Warranty does not obligate the Manufacturer to bear any transportation charges in connection with the repair or replacement of defective parts. The Manufacturer will not accept any charges for labor and/or parts incidental to the removal or remounting of parts repaired or replaced under this Warranty.

This Warranty shall not apply to any part or product which shall have been installed or operated in a manner not recommended by **FOOTAGE TOOLS INC**, nor to any part or product which shall have been neglected, or used in any way which, in the manufacturers opinion, adversely affects its performance; nor negligence of proper maintenance or other negligence, fire, or other accident: nor if the unit has been altered or repaired outside of a **FOOTAGE TOOLS INC.** authorized dealership in a manner of which, in the sole judgement of **FOOTAGE TOOLS INC.** affects its performance stability or reliability: nor to any product in which parts not manufactured or approved by **FOOTAGE TOOLS INC.** have been used, nor to normal maintenance services or replacement of normal service items. Equipment and accessories not of our manufacture are warranted only to the extent of the original Manufacturers Warranty and subject to their allowance to us, if found to be defective by them.

The original purchaser, user is responsible for “downtime” expenses and all business costs and losses resulting from a warrantable failure. **FOOTAGE TOOLS INC.** specifically disclaims any responsibility for any damages of any kind or description, whether to property or person, in any way connected with or arising out of the use of **FOOTAGE TOOLS INC.** products. The Buyer expressly acknowledges that this Limited Lifetime Warranty does not apply to any part or product not directly purchased from the Manufacturer.

FOOTAGE TOOLS INC reserves the right to modify, alter, and improve any product or parts without incurring any obligation to replace any product or parts previously sold with such modified, altered, or improved product or part.

No person is authorized to give any other Warranty, or to assume any additional obligation on the Manufacturers behalf unless made in writing, and signed by an officer of the Manufacturer.