

I-Purge[®] AND I-Purge[®]X

INFLATABLE MODULAR BLADDER SYSTEMS OPERATIONS MANUAL



I-PURGE[®]X EXPANDABLE
MODULAR BLADDER



I-PURGE ISOLATOR[®] &
I-PURGE[®]X ISOLATOR[®]
SINGLE MODULAR BLADDER

I-PURGE[®] STANDARD
MODULAR BLADDER

Made in the U.S.A.
U.S. & Foreign Patents Pending
CE Approved

Aquasol
CORPORATION

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**PLEASE READ THIS MANUAL IN ITS
ENTIRETY BEFORE ATTEMPTING
INSTALLATION OR OPERATION.**

**Important Safety
Information**

This system is used in an environment where high pressure gases and high voltage are present. I-Purge® Modular Systems are not innately dangerous products, unless used in a manner inconsistent with the intended purpose. Please follow these safety precautions to reduce the risk of injury to persons or property.

OPERATION:

- » Improper use may cause the unit to become unstable, leading to possible damage or injury.
- » Do not use the unit for anything other than its specific intended use.
- » Do not operate the unit in a pipe that is unclean and/or has sharp edges.

WARNING:

- » Do not exceed recommended flow rates for inflation or purging. See pages 18 and 19 for instructions on maintaining proper flow rates.
- » Do not exceed the maximum inflation size for I-Purge®X.
- » Do not attempt to override any factory settings on the system. Tampering with any of the safety devices will nullify the product warranty and jeopardize personal safety.

Welcome

Thank you for purchasing an I-Purge[®], I-Purge[®]X, I-Purge Isolator[®] or I-PurgeX Isolator[®] Inflatable Modular Bladder System from the Aquasol Corporation.

The I-Purge Modular System is a CE approved inflatable bladder. The interchangeable and expandable I-Purge modules allow versatility unlike any other system. The system includes a high-heat harness, a patent-pending gas diffuser and other advanced features, making Aquasol's I-Purge a superior purging product.

For best results and enforcement of Aquasol's warranty, please read instructions prior to use.

The I-Purge Modular Systems are designed for easy operation and maintenance. All personnel using an I-Purge system should read this manual to become more familiar with proper operation.

For further details regarding the maintenance and in-field service of I-Purge, please contact the Aquasol Corporation Customer Service Department.

If you have questions or comments, please contact us at:

Aquasol Corporation

Attn: Customer Service Department

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Item ID: _____

Item Serial No.: _____

Invoice No.: _____

Ship Date: _____

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Warranty

I-Purge[®], I-Purge[®]X,
I-Purge Isolator[®] and
I-PurgeX Isolator[®]
Inflatable Modular
Bladder Systems

All units and components are factory inspected and tested for quality assurance.

Aquasol Corporation warrants to the purchaser that the I-Purge Modular System is free from defects in material and workmanship for a period of thirty (30) days from the date of shipment (stated on page 4).

Aquasol's liability is limited to the repair or replacement, at our factory, of parts found to be defective within the warranty period, as determined by Aquasol Corporation. The parts will be repaired or replaced free of charge if a Returned Goods Inspection (RGI) is issued and the unit is shipped prepaid to the Aquasol Corporation Customer Service Department. **This warranty is void if the product has been subject to misuse or abuse, including but not limited to:**

1. Tampering with the pre-set relief valve, including breaking or removing the blue tamper seal, causing the bladders to over inflate and burst.
2. Setting the inflation gas flow rate beyond the recommended value as listed on pages 18 and 19.
3. Exposing the inflatable bladders to temperature levels above 250°F (120°C).
4. Exposing any part of the unit to sharp objects and/or unprepared surfaces which may tear, puncture, or damage the purge unit.
5. In addition, submitting either the unit in its entirety and/or a portion of the unit to excessive force of any type.
6. Altering or removing the identifying markings on the product label.
7. Repairs which were not performed by the Aquasol Corporation or by one of its authorized dealers.

The seller assumes no liability for consequential damages of any kind, and the buyer, by acceptance through purchase of this product, will assume all liability for the consequences of its use or misuse by the buyer, their employees, or others.

Aquasol Corporation reserves the right to use any materials in the manufacture, repair or service of the products and to modify the design as deemed suitable, in so far as these materials or modifications maintain the stated warranty.

The Aquasol Corporation will not assume any liability for misuse due to operator error.

THESE WARRANTIES ARE EXCLUSIVE AND IN LIEU OF ALL OTHER WARRANTIES, EXPRESSED OR IMPLIED, INCLUDING WARRANTY OF MERCHANTABILITY, FITNESS FOR A PARTICULAR PURPOSE.

Product Overview

I-Purge® Inflation Modular System

Aquasol's I-Purge Inflation Modular Bladder Systems provide an air-tight seal, enabling achievement of an oxidation-free weld and even penetration beads on all pipe joints.

The I-Purge Standard Modular System is comprised of two spark-resistant inflatable bladders connected by a high-heat bridge harness.

All I-Purge Systems are equipped with Quick Connect fittings which allow for rapid assembly (and disassembly) of the components (harness and bladder modules), which can be combined in many configuration for your specific needs.

All I-Purge systems include a Tri-Flow hose to maximize efficiency, enabling bladder inflation and quick flooding of the purge area with noble gas.

A patent-pending gas diffuser comes standard with every unit (except 2" and 3" sizes) to reduce turbulence and evenly distribute inert gas through the purge area.

I-Purge®X Expandable Modular System

The I-PurgeX Expandable Modular System performs the same functions of the Standard I-Purge System with one notable difference, one size expands and contracts to fit multiple pipe sizes.

The I-PurgeX Modular System is comprised of **two expandable**, spark-resistant inflatable bladders connected by a high-heat resistant bridge harness.



I-PurgeX Modular System Sizes:

ITEM NO.	SIZE RANGE (English)	SIZE RANGE (Metric)
XABLD 2-3	2-3"	51-76 mm
XABLD 4-6	4-6"	102-152 mm
XABLD 8-12	8-12"	203-305 mm
XABLD 14-18	14-18"	356-457 mm
XABLD 20-26	20-26"	509-660 mm
XABLD 28-36	28-36"	711-914 mm
XABLD 38-48	38-48"	965-1219 mm

WARNING:

- » I-PurgeX is designed to effectively purge a specific range of pipe diameters and **should not be used in a pipe diameter other than recommended range.**

The I-Purge and I-PurgeX Isolators can be used for a wide range of applications, including purging of valves or tanks, as well as non-purging applications. I-Purge Isolator is designed to function as a pipe plug for various tasks such as pipe system sealing for servicing, cleaning and inspection.

The I-Purge and I-PurgeX Isolators are constructed of heavy duty materials designed to withstand the extreme conditions of the petrochemical, utility and construction industries.

Product Overview

I-Purge® X Expandable
Modular System
(Continued)

I-Purge Isolator® &
I-PurgeX Isolator®
Single Purge Bladder
and Pipe Plug



I-Purge® & I-Purge®X Modular System Components

All I-Purge Systems are equipped with Quick Connect fittings which allow for rapid assembly (and disassembly) of the components (harness and bladder modules), which can be combined in many configurations for your specific needs.

The Inflatable Bladders consist of two main components:

- » An inner heavy-duty polymeric inflatable bag
- » An outer spark-resistant, durable covering which protects the bag from harsh elements in the environment, including heat and dirt.

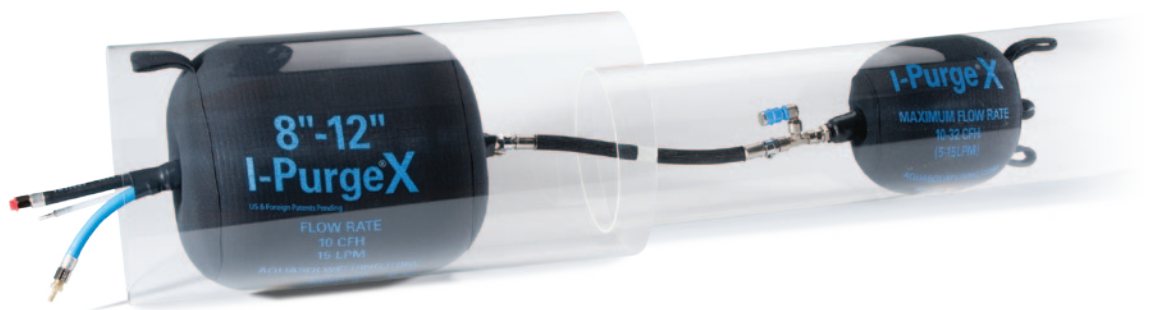
The fabric covering on I-PurgeX is flexible to allow the inflatable bladders to expand to fit several pipe diameters.

Inflatable Bladder Modules A & B

Standard tandem bladders consist of two sides, referred to as **Module A** and **Module B**:

- » **Module A** is defined as the side with gas inputs/outputs.
- » **Module B** is defined as the side which connects to the relief valve. This end is typically inserted into the pipe first. To identify the size of **Module B**, refer to the small tag sewn onto the pull loop.

One of the many benefits of the modular system is that **Modules A** and **B** do not have to be the same nominal pipe size to accommodate different applications such as valve welding, reducers, etc. For example, an 8" (203 mm) **Module A** may be connected to a 4" (102 mm) **Module B**.



The bridge harness is the connecting hose between the two inflatable bladders. It is comprised of a flexible braided fiberglass shielding over a high-heat resistant inner tube.

The central point of the bridge harness is marked with a Luminescent Indicator to easily align the center of the unit with the root gap. It is important to position the bladders equal distances from the weld joint to prevent over heating of one side, which could rupture or damage the bladder.

All I-Purge® bladders come complete with bridge harnesses of the following sizes:

SIZE	STANDARD HOSE LENGTH (English/ Metric)
2-8" (51-203 mm)	11" (279 mm)
10-12" (254-305 mm)	12" (305 mm)
14-18" (356-457 mm)	16" (406 mm)
20-24" (508-619 mm)	18" (457 mm)
26-36" (660-914 mm)	20" (509 mm)
38-44" (965-1118 mm)	36" (914 mm)
46-48" (1168-1219 mm)	42" (1067 mm)

To accommodate pre-heating and high-heat applications, extended-length harnesses offer flexibility, enabling the placement of the inflatable bladders further outside of the Heat Affected Zone (HAZ).

Extended-length harnesses are available in standard sizes: 24" (610 mm), 36" (914 mm), 48" (1219 mm), and 72" (1828 mm). Additional lengths are available upon request.

I-Purge® & I-Purge®X Modular System Components

High-Heat Resistant Bridge Harnesses



High-Heat Resistant Harness



I-Purge and I-PurgeX sizes 36" and greater are equipped with a high flow harness to expedite inflation.

I-Purge® & I-Purge®X Modular System Components

Tri-Flow Tube



The Tri-Flow Tube feature of both I Purge and I Purge X allows for three separate flows of gas (two inputs and one output) within a single tube.

The **BLUE** purge hose provides inflation to the bladders and releases the inert gas into the weld zone through the relief valve until a tight seal is achieved.

The secondary optional **BLACK** hose allows purge gas to flow directly into the weld zone, enabling faster purge time. This provides even greater flexibility as any flow rate can be used.

The two purge connections, which are made via the **BLUE** and **BLACK** hoses located on the end of Module A, are equipped with 3/8" barbed fittings and can be removed if the 1/4" female NPT fittings are preferred. If a conversion from the standard 1/4" female NPT fitting is required, Aquasol has an adapter available to convert this thread to 1/4" BSPP. For more information, contact customer service for pricing and availability.

The third clear tube is known as the Exhaust Monitor Hose Connection, which serves as the outflow passageway, displacing oxygen exhaust.

This short, clear hose, equipped with a 3/16" barbed fitting connection, conveniently connects to an oxygen monitor for analysis within the weld zone. For optimal welding conditions, use Aquasol's PRO Ox®-100, which is perfectly suited to be used in combination with the I-Purge system.

I-Purge® & I-Purge®X Modular System Components

The relief valve is located on the **Module B** bladder near the branch tee which connects to the bridge harness. The relief valve is factory set to allow precise inert gas output, maintaining the optimum seal on the pipe wall, while preventing the risk of over inflation.

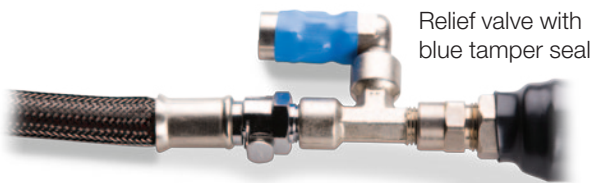
- » I-Purge systems sizes 2" and 3" feature a low profile relief valve for easy insertion into small bore pipes.

Relief Valve

Covering the relief valve and diffuser is a tamper seal to protect the factory settings.

Tamper Seal

WARNING: Under no circumstance should the tamper seal be broken, as this will void the product warranty.



As a standard accessory on I-Purge Modular Systems, a patent pending inert gas diffuser is installed on the pressure relief valve (PRV) with the primary function of reducing turbulence caused by the PRV.

The typical PRV design on other purge systems results in a turbulent gas flow into the weld zone. This can negatively impact both weld quality and weld consistency.

With the incorporation of a diffuser, the flow is dispersed in all directions after passing through a membrane designed to diffuse the inert gas flow from the PRV, therefore suppressing turbulence.

The diffuser is hermetically sealed to the PRV to ensure all inert gas emits from the same location.

Inert Gas Diffuser



US & Foreign Patent Pending

List of Parts

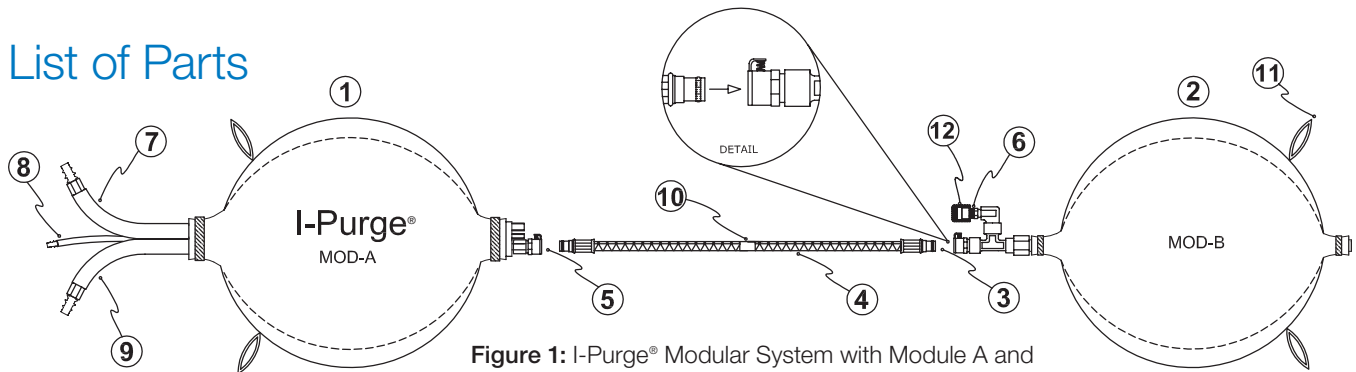


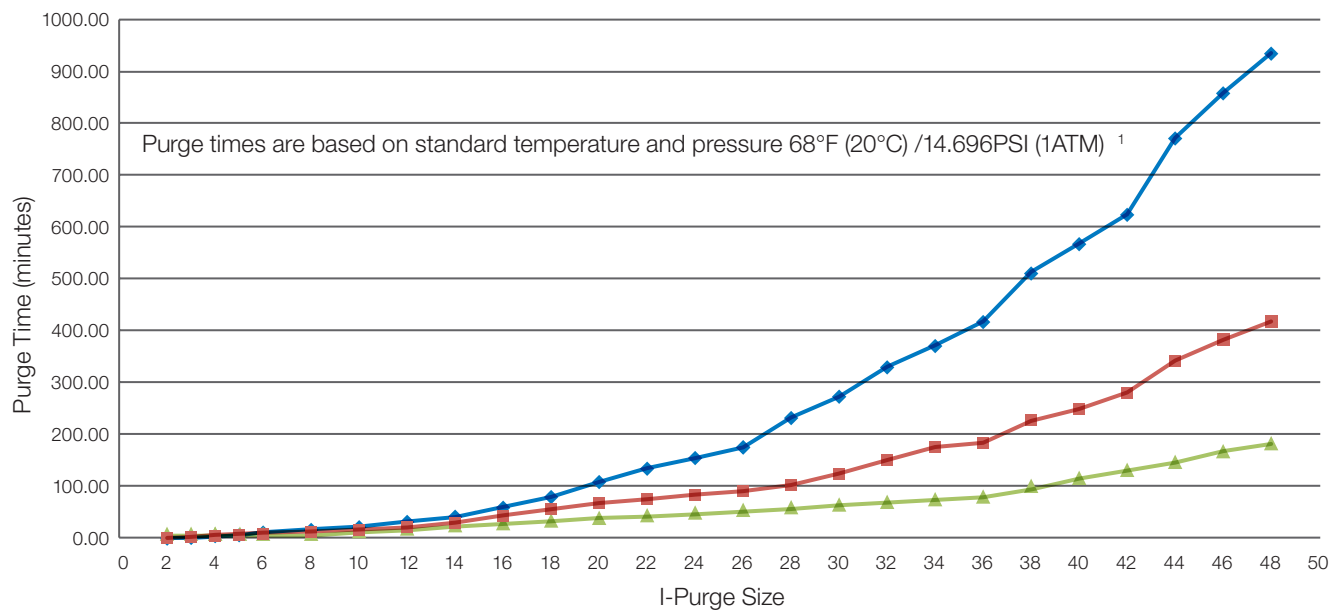
Figure 1: I-Purge® Modular System with Module A and Module B disconnected from the Bridge Harness.

1. **Module A:** Module A includes the gas inputs/outputs. Module A is printed with the bladder diameter size.
2. **Module B:** Module B includes the relief valve and diffuser. Module B is typically inserted into the pipe first. The bladder size is indicated by the tag sewn into the pull loop.
3. **Quick Connection (to Module B):** The quick connect fittings allow for rapid assembly (and disassembly) of the components, including various length harnesses and unique diameter bladders.
4. **Bridge Harness:** The bridge harness is the connecting hose between the two inflatable bladders, providing protection and reinforcement for the inner tube. It is comprised of a flexible braided fiberglass shielding over a high-heat resistant inner tube. The harnesses are available in a variety of extended lengths as an accessory to accommodate pre-heating applications.
5. **Quick Connection (to Module A):** The Quick-Connect fittings allow for rapid assembly (and disassembly) of the components, including various length harnesses and unique diameter bladders.
6. **Relief Valve:** The relief valve is factory set to allow precise inert gas output, maintaining the optimum seal on the pipe wall, while preventing the risk of over inflation.
 - » I-Purge systems 2" and 3", feature a low-profile relief valve for easy insertion into small bore pipes.
7. **BLACK Hose:** The secondary **BLACK** purge hose is designed to expedite purging by directly introducing inert gas into the weld zone.
8. **Exhaust Monitor Connection:** This short, clear hose, equipped with a 3/16" barbed fitting, conveniently connects to an oxygen monitor for analysis of the oxygen levels within the weld zone.
9. **BLUE Hose:** The **BLUE** purge hose provides inflation to the bladders and releases the inert gas into the weld zone through the relief valve and diffuser. Be sure to adjust the flow rate to the specifications listed in the I-Purge and I Purge X Recommended Gas Flow Rate charts on pages 18 and 19.
10. **Luminescent Indicator:** Located on the center of the bridge harness, allowing easy alignment of the unit with the root gap.
11. **Pull Loops:** Located on the ends of each module, the pull loops can be connected to a rope or chain to insert or remove the unit.
12. **Inert Gas Diffuser:** Attached to the relief valve is a gas diffuser to reduce turbulence and evenly distribute inert gas throughout the purge area.
 - » Covering the relief valve and diffuser is a blue tamper seal to protect the factory settings. **Do not remove this seal, as tampering with the relief valve will void the product warranty.**

The time required to purge a pipe can vary significantly depending on the configuration of flow rates, hoses, regulators, and gas points analyzers used. For this reason, we have compiled the following data sets to demonstrate the expected purge times prior to performing a weld.

Below are three sets of data, (Cases 1, 2 and 3), each representing a typical configuration which may be used in a welding environment.

Chart 1
Expected Purge Times - CASES 1, 2, & 3



Sources: 1. Journal of Research of the National Institute of Standards and Technology (2003): 108.

Chart By: AG - R8.20.2012

CASE 1 ◆

Time required to purge to 100 ppm oxygen using just the inflation inert gas (BLUE hose) @ 20 SCFH. These figures are also indicative of a capped-off secondary purge hose (BLACK) and a free-flow exhaust.

CASE 2 ■

Time required to purge to 100 ppm oxygen using both the inflation inert gas (BLUE hose) @ 25 SCFH and secondary input (BLACK hose) @ 20 SCFH.

CASE 3 ▲

Time required to purge to 100 ppm oxygen using both the inflation inert gas (BLUE hose) @ 25 SCFH and secondary input (BLACK hose) @ 50 SCFH.

This test was performed with a standard I-Purge system.

I-Purge® & I-Purge®X Assembly

Configuring the systems is simple and requires absolutely no tools.

To assemble or remove the modules from the main harness, simply push to disconnect, and then reconnect by sliding the male fitting into the coupling as demonstrated in the photos below.



I-Purge and I-PurgeX sizes 36" and greater are equipped with a high flow harness to expedite inflation.



Before the I-Purge System can be inserted into the pipe, it is critical to clean the pipe at least three linear feet (approx. 1 meter) or more depending on the length of the harness used, along the inside of each pipe, or the pipe fittings to be welded together. Cleaning the pipes is critical to achieving a pure weld and will prolong the life of the system.

I-Purge® & I-Purge®X Set-Up & Installation

Pipe Preparation

1. Prior to use, determine the length of hose(s) required to make the necessary gas connections. Argon/inert gas supply hose is available through Aquasol; please contact Customer Service for price.
2. Connect both Module A and B to the bridge harness via the Quick Connect Fittings.
3. Connect the purge gas and exhaust monitor hoses before inserting into the pipe.

IMPORTANT: The purge hoses should only be connected to an inert gas source. This gas will inflate the purge bladders and then purge the weld zone once the bladders are fully inflated.

- A. Connect the **BLUE** purge hose to a direct inert gas line using a 3/8" ID hose or 1/4" NPT connection.
- B. The use of the **BLACK** purge hose is optional. The **BLACK** purge hose can be used simultaneously with the blue purge hose to reduce purge time by evacuating oxygen more quickly. (See Chart 1 on page 13).

To use the **BLACK** hose, remove the red plug and connect the hose to a direct inert gas line using another 3/8" ID hose and the supplied barbed fitting, or simply use a 1/4" NPT connection.

IMPORTANT: If you are not using the **BLACK** hose, this line should remain capped off to prevent oxygen backflow. Do not remove the red cap unless black hose is in use.

4. If desired, connect any gas monitoring equipment to the exhaust monitor connection. The standard connection on this hose is a 3/16" barbed fitting.
5. Attach a "pull-wire" or rope to the pull loops on either end of the system to aid in insertion and removal.

Purge Gas Hose & Monitoring Hose Installation



I-Purge® & I-Purge®X Set-Up & Installation

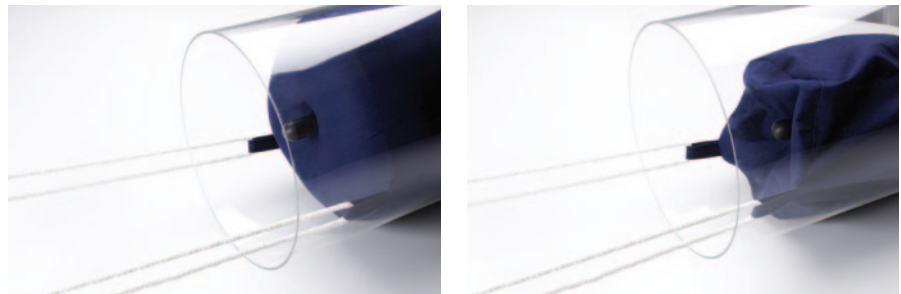
(Continued)

Preparation for Use

Once the I-Purge hoses are attached to the necessary gas lines, the system can be either pushed or pulled into place using the pull loops or “pull wires.”

Pipe Insertion

Insert the entire system and its connections into the pipe or pipe fitting. Push or pull the system as desired until it reaches the section of pipe to be welded. Using the Luminescent Indicator (reflective tape) on the bridge harness as a guide, align the indicator precisely in the center of the root gap. It is critical to position the bladders equidistant from the weld joint to prevent overheating of either bladder module.



Pull Loops inflated and deflated

Positioning of the I-Purge system is critical to achieving a proper seal on the pipe wall - **especially for larger units (14" and above).**

Before installing the I-Purge system, connect pull-wires (or rope) to the pull loops at the end of the I-Purge modules.

It is important to keep a moderate tension (approx. 5 lbs) on the pull-wires to prevent sagging of the harness during installation and operation.

While inflating the system, check each module to ensure that it is inflating evenly. If the module looks as if it may be inflating “lopsided,” the operator can adjust this by changing the tension on the pull-wires accordingly.

CAUTION: Do not pull on the loops with too much force as you risk ripping the protective fabric.

The following set-up instructions apply to any type of application in which I-Purge or I-PurgeX Isolator is used.

I-Purge Isolator® & I-PurgeX Isolator® Set-Up & Installation

Prior to inserting the system into the pipe, ensure that the pipe is free of any sharp edges, as well as any chemicals that may compromise the integrity of the unit. It is critical to clean the inside of the pipe or vessel to achieve a pure weld and prolong the life of the system.

Pipe Preparation

1. Prior to installation, ensure the module is securely connected to the **BLACK** hose before proceeding. This connection is made via a Quick Connect Fitting that can simply be snapped into place.
2. Connect the inflation gas line to the other end of the **BLACK** hose using a 3/8" ID hose or 1/4" NPT connection.
3. Connect a rope, chain, or wire to the pull loops on the ends of the bladder module. This will allow you to easily insert and remove the system.
4. Position the Isolator system in the pipe at the desired location.

Assembly and Installation

CAUTION FOR WELDING APPLICATIONS:

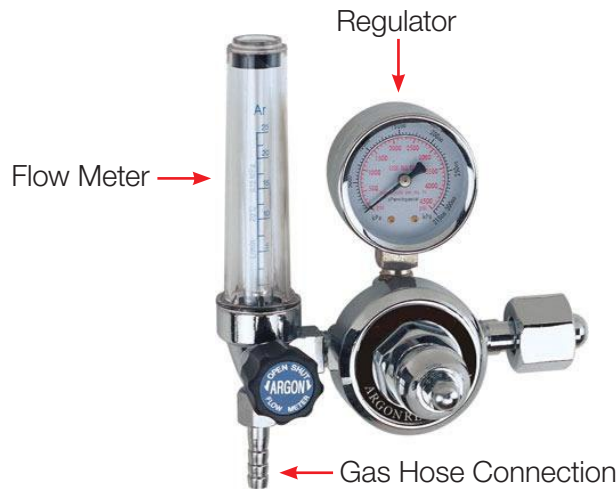
- » If the Isolator system is being used for a pipe purging application, be sure to use the appropriate inert gas as an inflation gas supply.
- » Be certain to place the Isolator system outside of the Heat Affected Zone (HAZ) and apply tension to the pull loops or pull wire to prevent the hose from coming in contact with the hot pipe.

I-Purge® Standard System Operation

One of the most critical aspects for operating any I-Purge system is regulation of the flow rate. Use of a two-stage regulator is recommended to maintain a consistent flow rate and pressure supply to the unit.

Purge Gas Flow Rates (Before Welding)

IMPORTANT: When regulating flow rates, be sure to use the appropriate regulator and flow meter with a flow scale designed for the purge gas being input through the **BLUE (INFLATION) HOSE** to the unit.



Always make sure the regulator and flow meter are designed for the gas you are using. For instance, do not use an Argon Flow Meter with Nitrogen gas to avoid damage to the bladder system.

When you are ready to begin purging the weld zone, adjust the flow rate of the **BLUE** hose to the following specifications in the **I-Purge Recommended Gas Flow Rate Chart** below:

I-PURGE RECOMMENDED GAS FLOW RATE	
SIZE	FLOW RATE
2-34" (51-864 mm)	10-32 SCFH (5-15 LPM)
36-48" (915-1219 mm)	60 SCFH (28.5 LPM)

Purge Gas Flow Rates (During Welding)

NOTE: To increase purging time, the black purge hose can be connected to another inert gas supply. To quickly flood the weld zone, this gas supply can be regulated to much higher flow rates than the blue purge hose. It may be necessary to reduce this flow rate once the area is completely purged and welding has commenced.

NOTE: The flow rate for the **BLUE (INFLATION) HOSE** can be decreased if necessary to accommodate certain welding scenarios or if the flow is affecting the weld. However, it is recommended to follow these specifications to maintain an optimum seal on the pipe wall. Unlike the standard I-Purge®, I-Purge®X must run at a specific and constant flow rate to ensure a proper and secure seal on the pipe wall.

I-Purge®X System Operation

Purge Gas Flow Rate

When you are ready to begin purging the weld zone, adjust the flow rate of the **BLUE** hose to the following specifications in the **I-Purge X Recommended Gas Flow Rate Chart** below:

I-PURGEX RECOMMENDED GAS FLOW RATE	
SIZE	FLOW RATE
2-34" (51-864 mm)	30 SCFH (15 LPM)
38-48" (965-1219 mm)	60 SCFH (28.5 LPM)

- » I-PurgeX is designed to effectively purge a specific range of pipe diameters and should **NEVER** be used for smaller or larger diameter pipe applications.
- » If an I-PurgeX unit is operated in a diameter pipe other than the recommended range, future purging operations can be severely compromised and significantly less efficient. In addition, it is possible that the I-PurgeX will fail due to excessive stress exposure to the inner and outer expandable materials of the bladders which will void the warranty.
- » If used properly within the recommended diameter range, I-PurgeX will continue to function efficiently for numerous purging operations.

I-Purge and I-PurgeX Isolator require a constant pressurized gas source such as compressed air, nitrogen, CO2, or argon.

To optimize the sealing capacity of the I-Purge the following flow rates should be used with the **BLUE** hose:

I-PURGE & I-PURGEX ISOLATOR RECOMMENDED FLOW RATES	
I-PURGE ISOLATOR	I-PURGE X ISOLATOR
10-32 SCFH (5-15 LPM)	30 SCFH (15 LPM) ONLY

I-Purge Isolator® & I-PurgeX Isolator® System Operation

Inflation Flow Rates



Deflation and Removal

When welding is complete, turn off the gas supply to the I-Purge[®] system. To reduce deflation time, it is advisable to empty the gas lines by disconnecting them from the main tank.

Use the pull loops or pull wires for easy removal.

CAUTION: Allow enough time for the pipe to sufficiently cool and deflate before withdrawing I-Purge from the pipe to ensure that the unit is not exposed to excessive heat.

Maintenance

To ensure consistently pure welds when using I-Purge[®], keep the purge bladder off the ground and away from contaminants. It is important to keep I-Purge free of dirt and debris which may compromise the weld quality.

IMPORTANT: Keep I-Purge away from sharp objects, as contact may cause damage to the product

It is recommended that when not in use, I-Purge is stored in the provided carrying bag.



Troubleshooting Guide

I-Purge® & I-Purge®X

PROBLEM	POSSIBLE CAUSE	POSSIBLE SOLUTION
The I-Purge System seems to be taking too long to inflate	Flow rate into the BLUE purge hose may be set too low	Verify flow rate is set correctly according to the I-Purge and I-PurgeX Recommended Gas Flow Rate Charts on pages 18 and 19
The I-Purge System isn't inflating or creating a tight seal	Inert gas connection may not be connected to the BLUE purge hose (or may only be connected to the BLACK purge hose)	Check to make sure there is a secure connection to the BLUE purge hose, the BLACK purge hose will not inflate the bladders
	Flow rate into the weld zone is too low	Verify the flow rate for the BLUE hose is set correctly according to the I-Purge and I-PurgeX Recommended Gas Flow Rate Charts on pages 18 and 19
	Over inflation may have occurred possibly causing the inner bag to burst	Relief valve may not have been set correctly, or may have been tampered with. The flow rate may have exceeded the maximum tolerance; contact Aquasol for assistance.
It seems to be taking too long to purge the pipe (before welding)	Low or no flow through the BLACK purge hose	Confirm that flow through the BLACK purge hose is set to desired flow rate
	Modules not positioned correctly	If possible, look through the pipe to visually determine whether there is a tight seal on the inner pipe wall, if not, reposition
The flow from the I-Purge System is interfering with the welding process (i.e. during the welding process, excessive gas flow from the root gap is creating impurities in weld).	The flow rate which is keeping the bags inflated may be too high Flow from the BLACK purge hose is too high	Verify the flow gas rate is set correctly according to the I-Purge and I-PurgeX Recommended Gas Flow Rate Charts on pages 18 and 19

Troubleshooting Guide

I-Purge® & I-Purge®X (Continued)

PROBLEM	POSSIBLE CAUSE	POSSIBLE SOLUTION
Once welding begins, the level of oxygen begins to rise	Flow rate into the weld zone is too low	Verify the flow rate for the BLUE hose is set correctly according to the I-Purge and I-PurgeX Recommended Gas Flow Rate Charts on pages 18 and 19
	Backflow into weld zone through BLACK (direct purge) hose	Ensure that the red plug is installed on the BLACK purge hose, to prevent back flow
The I-Purge System is becoming exceedingly rigid	Relief valve setting may be incorrect	Test unit externally from pipe, hold your hand over the diffuser once the bladder has fully inflated. If there is little to no flow, contact Aquasol. NOTE: Take extreme caution when inflating the bladders externally from pipe
	Flow rate into the BLUE purge hose is too high	Verify the flow rate for the BLUE hose is set correctly according to the I-Purge and I-PurgeX Recommended Gas Flow Rate Charts on pages 18 and 19

Troubleshooting Guide

I-Purge Isolator® & I-PurgeX Isolator®

PROBLEM	POSSIBLE CAUSE	POSSIBLE SOLUTION
The I-Purge Isolator seems to be taking too long to inflate	Flow rate into the BLACK purge hose may be set too low	Verify flow rate is set correctly according to the I-Purge and I-PurgeX Isolator Recommended Gas Flow Rate Charts on page 19
The I-Purge Isolator isn't inflating	Over inflation may have occurred possibly causing the inner bag to burst	Relief valve may not have been set correctly, or may have been tampered with - check tamper seal. The flow rate may have exceeded the maximum tolerance; contact Aquasol for assistance.
The I-Purge Isolator is becoming exceedingly rigid	Relief valve setting may be incorrect	Test unit externally from pipe, hold your hand over the diffuser once the bladder has fully inflated – If there is little to no flow, contact Aquasol NOTE: Take extreme caution when inflating the bladders externally from pipe
	Flow rate into the BLACK purge hose is too high	Verify the flow rate for the BLUE hose is set correctly according to the I-Purge and I-PurgeX Isolator Recommended Gas Flow Rate Charts on page 19

Contact us if you have any questions or require assistance with your I-Purge Modular System at:

Aquasol Corporation

Attn: Customer Service Department
80 Thompson Street
N. Tonawanda, NY 14120 USA

Toll Free: 1.800.564.WELD (9353)

Phone: 716.564.8888

Fax: 716.564.8889

Email: info@aquasolcorporation.com

Visit us at www.aquasolwelding.com

Technical Assistance

FAQ – Frequently Asked Questions

I-Purge®

Q: Can I use higher flow rates on the secondary (**BLACK**) purge hose than recommended?

A: You may use as high of a flow rate as you feel comfortable, although as welding begins, you will likely need to decrease this flow dramatically.

Q: How high of a temperature can I-Purge withstand?

A: The outer covering on the inflatable bags is the only component which should come into direct contact with the pipe. This material is infused with spark resistant elements which prevent it from catching fire when exposed to sparks and other exceedingly hot objects. The material itself can withstand temperatures as high as 400°F (205°C). It is advisable not to exceed a temperature of 250°F (120°C) for proper operation of the entire system.

I-Purge can accommodate higher temperatures (such as those in pre-heating welding) applications by attaching an extended length bridge harness, purchased separately through Aquasol.

Q: Can I-Purge be used in pre-heated pipe?

A: Yes. For pre-heating and high-heat applications, use a harness extension (purchased separately from Aquasol) to place the I-Purge bladders farther outside of the heat-affected zone (HAZ).

Q: How many times can I-Purge be used?

A: If used properly within the parameters established in this Operation Manual, I-Purge can be reused again and again for numerous welds. However, even though I-Purge is robustly built to withstand a great deal of wear and tear, this product is still susceptible to fatigue problems after frequent use and/or exposure to damaging elements such as extreme heat, extreme cold, and debris.

FAQ – Frequently Asked Questions

I-Purge® (Continued)

Q: How will I know if the bladders have been overinflated?

A: If you believe the bladders have been overinflated during operation, terminate gas flow immediately. When the bladders no longer hold air to any extent after an inner bladder burst, they may have been overinflated. This can be prevented by following the flow rates listed in this manual.

NOTE: Aquasol does not warrant any over-inflation system failures. Please review the Warranty and System Operation sections.

Q: Do I have to connect an oxygen monitor to the exhaust on the I-Purge?

A: It is not imperative for an oxygen monitor to be connected to the exhaust monitoring hose on I-Purge. Oxygen content can be monitored through the root gap.

Q: Can I-Purge be used in various schedule pipes for the same nominal diameter?

A: I-Purge is designed to fit any schedule pipe for each nominal pipe diameter from schedule 5 to schedule 160. Due to its unique modular design, I-Purge can also accommodate differing pipe diameters, single-sided purging requirements and pre-heated pipes by connecting an extended harness.

For additional questions, send your inquiry to:

info@aquasolcorporation.com or call **716.564.8888**

Within the US: Toll Free **800.564.9353**

FAQ – Frequently Asked Questions

I-Purge®X

Q: Can I exceed the recommended expansion size?

A: No. As stated in the warranty statement in the beginning of the manual, the unit will not function properly following an overinflation. Never exceed the maximum range labeled on the I-PurgeX.

Q: Can I-PurgeX and I-Purge (standard) components be interchanged?

A: No. Since the calibration for the pressure settings on I-PurgeX differ from those for the standard I-Purge you should not interchange parts between models.

Q: How high of a temperature can I-PurgeX withstand?

A: Similar to the standard I-Purge, I-PurgeX features a spark resistant fabric which protects the inner bladder and prevents damage from occurring. It is advisable not to exceed a temperature of 250°F (120°C) for proper operation of the entire system.

I-Purge Isolator® & I-PurgeX Isolator®

Q: Does I-Purge Isolator have to be used for pipe purging?

A: The I-Purge Isolator is designed for pipe purging before/during welding, but it has the flexibility to be used as a pipe plug in other applications such as construction, plumbing, sewage, etc.

Q: Why does the Isolator deflate if the gas supply is turned off?

A: I-Purge Isolators are equipped with a pressure relief valve to prevent over-inflation of the unit. The gas will continue to exit the inflatable bladder through the relief valve, deflating the unit. Therefore, a constant supply of gas must be maintained to keep a tight seal on the pipe wall (Refer to Isolator – System Operation on page 19).

For additional questions, send your inquiry to:

info@aquasolcorporation.com or call **716.564.8888**

Within the US: Toll Free **800.564.9353**

1. Ensure I-Purge is fully assembled (i.e. modules are securely connected to harness).
2. If necessary, connect rope, chain, or wire to the pull loops on the ends of the bladder modules. This will allow you to easily insert and remove the system.
3. Connect inert gas lines to the **BLUE** and **BLACK** hoses.
BLUE gas hose is required to inflate the purge bladders
BLACK gas hose is optional to expedite the purging process
4. Position the purge unit in the pipe to align the luminescent indicator with the root gap.
5. Turn the gas supply on to inflate the bladders and purge the weld zone. Set the flow rate correctly according to the I-Purge **Recommended Gas Flow Rate Charts** on page 18
6. Once a tight seal has been achieved, commence welding. Set the flow rate correctly according to the I-Purge **Recommended Gas Flow Rate Charts** on page 18.
The flow rate for the **BLUE** inflation hose can be decreased if necessary to accommodate certain welding scenarios or if the flow is affecting the weld.
7. For proper deflation, turn off the gas supply to deflate the bladders. Once the heat zone has sufficiently cooled and the bladders have fully deflated, remove I-Purge from the pipe. Be sure to disconnect all gas lines and monitoring equipment.
8. Clean I-Purge and store in the provided carrying bag when it is not in use.

Quick Instruction Guide

I-Purge[®]X

1. Ensure I-Purge[®]X is fully assembled (i.e. modules are securely connected to harness).
2. If necessary, connect rope, chain, or wire to the pull loops on the ends of the bladder modules. This will allow you to easily insert and remove the system.
3. Connect inert gas lines to the blue and black hoses.
4. **BLUE** gas hose is required to inflate the purge bladders.
5. **BLACK** gas hose is optional to expedite the purging process
6. Position the purge unit in the pipe using the luminescent indicator as a guide to center the system across the root gap.
7. Turn the **BLUE** gas supply on to inflate the bladders and purge the weld zone.
8. Always maintain a consistent flow rate during inflation, purging, and welding.
9. **BLUE** gas hose should transfer inert gas at the correct rate according to the **I-Purge[®]X Recommended Gas Flow Rate Chart** on page 19.
10. Once a tight seal has been achieved, commence welding.
11. After the weld is complete, turn off the gas supply to deflate the bladders. Once the heat zone has sufficiently cooled, remove I-Purge[®]X from the pipe. Be sure to disconnect all gas lines and monitoring equipment.
12. Clean I-Purge[®]X and store in the provided carrying bag when it is not in use.

Quick Instruction Guide

I-Purge Isolator® & I-PurgeX Isolator®

1. Assemble the isolator system by connecting the **BLACK** hose to the Inflatable Bladder Module. Ensure the Module is securely connected to the hose harness via the Quick Connect Fittings.
2. Connect the inflation gas line to the end of the **BLACK** hose using a 3/8" ID hose or 1/4" NPT connection.

NOTE: If the isolator is being used for a purging application, be sure to use the appropriate inert gas as an inflation gas supply.

3. If necessary, connect rope, chain, or wire to the pull loops on the ends of the bladder module. This will allow you to easily insert and remove the system.
4. Turn the gas supply on to inflate the bladder module to create a hermetic seal within the pipe.

Flow Rates for Operation: See **I-Purge** and **I-PurgeX Isolator Recommended Gas Flow Rate Chart** on page 19.

5. After the operation is complete, turn off the gas supply to deflate the module and remove from the pipe. Be sure to disconnect all gas lines and monitoring equipment.
6. Clean the isolator system and store in the provided carrying bag when it is not in use.

Parts & Accessories List

I-Purge® Standard Configuration
(Sold as a Complete System)

ITEM #	ENGLISH	METRIC	DESCRIPTION
ABLD 2	2"	51 mm	2" I-Purge® Double Purge Bag System
ABLD 3	3"	76 mm	3" I-Purge® Double Purge Bag System
ABLD 4	4"	102 mm	4" I-Purge® Double Purge Bag System
ABLD 5	5"	127 mm	5" I-Purge® Double Purge Bag System
ABLD 6	6"	152 mm	6" I-Purge® Double Purge Bag System
ABLD 8	8"	203 mm	8" I-Purge® Double Purge Bag System
ABLD 10	10"	254 mm	10" I-Purge® Double Purge Bag System
ABLD 12	12"	304 mm	12" I-Purge® Double Purge Bag System
ABLD 14	14"	355 mm	14" I-Purge® Double Purge Bag System
ABLD 16	16"	406 mm	16" I-Purge® Double Purge Bag System
ABLD 18	18"	457 mm	18" I-Purge® Double Purge Bag System
ABLD 20	20"	508 mm	20" I-Purge® Double Purge Bag System
ABLD 22	22"	558 mm	22" I-Purge® Double Purge Bag System
ABLD 24	24"	609 mm	24" I-Purge® Double Purge Bag System
ABLD 26	26"	660 mm	26" I-Purge® Double Purge Bag System
ABLD 28	28"	711 mm	28" I-Purge® Double Purge Bag System
ABLD 30	30"	762 mm	30" I-Purge® Double Purge Bag System
ABLD 32	32"	812 mm	32" I-Purge® Double Purge Bag System
ABLD 34	34"	863 mm	34" I-Purge® Double Purge Bag System
ABLD 36	36"	914 mm	36" I-Purge® Double Purge Bag System
ABLD 38	38"	965 mm	38" I-Purge® Double Purge Bag System
ABLD 40	40"	1016 mm	40" I-Purge® Double Purge Bag System
ABLD 42	42"	1066 mm	42" I-Purge® Double Purge Bag System
ABLD 44	44"	1117 mm	44" I-Purge® Double Purge Bag System
ABLD 46	46"	1168 mm	46" I-Purge® Double Purge Bag System
ABLD 48	48"	1219 mm	48" I-Purge® Double Purge Bag System

Parts & Accessories List

I-Purge® Modular Configuration
(Sold as Separate Parts)

MODULE A ITEM #	MODULE B ITEM #	ENGLISH	METRIC	DESCRIPTION
ABLD 2 MOD A	ABLD 2 MOD B	2"	51 mm	2" I-Purge® Single Purge Bag
ABLD 3 MOD A	ABLD 3 MOD B	3"	76 mm	3" I-Purge® Single Purge Bag
ABLD 4 MOD A	ABLD 4 MOD B	4"	102 mm	4" I-Purge® Single Purge Bag
ABLD 5 MOD A	ABLD 5 MOD B	5"	127 mm	5" I-Purge® Single Purge Bag
ABLD 6 MOD A	ABLD 6 MOD B	6"	152 mm	6" I-Purge® Single Purge Bag
ABLD 8 MOD A	ABLD 8 MOD B	8"	203 mm	8" I-Purge® Single Purge Bag
ABLD 10 MOD A	ABLD 10 MOD B	10"	254 mm	10" I-Purge® Single Purge Bag
ABLD 12 MOD A	ABLD 12 MOD B	12"	304 mm	12" I-Purge® Single Purge Bag
ABLD 14 MOD A	ABLD 14 MOD B	14"	355 mm	14" I-Purge® Single Purge Bag
ABLD 16 MOD A	ABLD 16 MOD B	16"	406 mm	16" I-Purge® Single Purge Bag
ABLD 18 MOD A	ABLD 18 MOD B	18"	457 mm	18" I-Purge® Single Purge Bag
ABLD 20 MOD A	ABLD 20 MOD B	20"	508 mm	20" I-Purge® Single Purge Bag
ABLD 22 MOD A	ABLD 22 MOD B	22"	558 mm	22" I-Purge® Single Purge Bag
ABLD 24 MOD A	ABLD 24 MOD B	24"	609 mm	24" I-Purge® Single Purge Bag
ABLD 26 MOD A	ABLD 26 MOD B	26"	660 mm	26" I-Purge® Single Purge Bag
ABLD 28 MOD A	ABLD 28 MOD B	28"	711 mm	28" I-Purge® Single Purge Bag
ABLD 30 MOD A	ABLD 30 MOD B	30"	762 mm	30" I-Purge® Single Purge Bag
ABLD 32 MOD A	ABLD 32 MOD B	32"	812 mm	32" I-Purge® Single Purge Bag
ABLD 34 MOD A	ABLD 34 MOD B	34"	863 mm	34" I-Purge® Single Purge Bag
ABLD 36 MOD A	ABLD 36 MOD B	36"	914 mm	36" I-Purge® Single Purge Bag
ABLD 38 MOD A	ABLD 38 MOD B	38"	965 mm	38" I-Purge® Single Purge Bag
ABLD 40 MOD A	ABLD 40 MOD B	40"	1016 mm	40" I-Purge® Single Purge Bag
ABLD 42 MOD A	ABLD 42 MOD B	42"	1066 mm	42" I-Purge® Single Purge Bag
ABLD 44 MOD A	ABLD 44 MOD B	44"	1117 mm	44" I-Purge® Single Purge Bag
ABLD 46 MOD A	ABLD 46 MOD B	46"	1168 mm	46" I-Purge® Single Purge Bag
ABLD 48 MOD A	ABLD 48 MOD B	48"	1219 mm	48" I-Purge® Single Purge Bag

Parts & Accessories List

Accessory Components

ITEM #	ENGLISH	METRIC	DESCRIPTION
ABLD-ELH-24	24"	609 mm	24" (2') Extended Length High-Heat Harness
ABLD-ELH-36	36"	914 mm	36" (3') Extended Length High-Heat Harness
ABLD-ELH-48	48"	1219 mm	48" (4') Extended Length High-Heat Harness
ABLD-ELH-72	72"	1228 mm	72" (6') Extended Length High-Heat Harness
ABLD-ELH-CUSTOM	Any size	Any size	Additional High-Heat Harness
ABLD-CNADP	N/A	N/A	1/4" Female MPT to 1/4" Female BSPP Conversion
ISO-ADAPTER-HARNESS	10'	3.05m	Isolator Adapter Harness

*Standard Hoses are not sold separately.

I-Purge®X Standard Configuration (Sold as a Complete System)

ITEM #	ENGLISH	METRIC	DESCRIPTION
XABLD 2-3	2-3"	51-76 mm	2-3" I-Purge®X Expandable Double Purge Bag System with High-Heat Harness
XABLD 4-6	4-6"	102-152 mm	4-6" I-Purge®X Expandable Double Purge Bag System with High-Heat Harness
XABLD 8-12	8-12"	203-305 mm	8-12" I-Purge®X Expandable Double Purge Bag System with High-Heat Harness
XABLD 14-18	14-18"	356-457 mm	14-18" I-Purge®X Expandable Double Purge Bag System with High-Heat Harness
XABLD 20-26	20-26"	509-660 mm	20-26" I-I-Purge®X Expandable Double Purge Bag System with High-Heat Harness
XABLD 28-36	28-36"	711-914 mm	28-36" I-I-Purge®X Expandable Double Purge Bag System with High-Heat Harness
XABLD 38-48	38-48"	965-1219 mm	38-48" I-Purge®X Expandable Double Purge Bag System with High-Heat Harness

Parts & Accessories List

I-Purge®X Standard Configuration (Sold as Separate Parts)

MODULE A ITEM #	MODULE B ITEM #	ENGLISH	METRIC	DESCRIPTION
XABLD 2-3 MOD A	XABLD 2-3 MOD B	2-3"	51-76 mm	2-3" I-Purge®X Expandable Single Purge Bag
XABLD 4-6 MOD A	XABLD 4-6 MOD B	4-6"	102-152 mm	4-6" I-Purge®X Expandable Single Purge Bag
XABLD 8-12 MOD A	XABLD 8-12 MOD B	8-12"	203-305 mm	8-12" I-Purge®X Expandable Single Purge Bag
XABLD 14-18 MOD A	XABLD 14-18 MOD B	14-18"	356-457 mm	14-18" I-Purge®X Expandable Single Purge Bag
XABLD 20-26 MOD A	XABLD 20-26 MOD B	20-26"	509-660 mm	20-26" I-Purge®X Expandable Single Purge Bag
XABLD 28-36 MOD A	XABLD 28-36 MOD B	28-36"	711-914 mm	28-36" I-Purge®X Expandable Single Purge Bag
XABLD 38-48 MOD A	XABLD 38-48 MOD B	38-48"	965-1219 mm	38-48" I-Purge®X Expandable Single Purge Bag

I-Purge®X Accessory Components (Sold as Separate Parts)

ITEM #	ENGLISH	METRIC	DESCRIPTION
ABLD-ELH-24	24"	609 mm	24" (2') Extended-Length High-Heat Harness
ABLD-ELH-36	36"	914 mm	36" (3') Extended-Length High-Heat Harness
ABLD-ELH-48	48"	1219 mm	48" (4') Extended-Length High-Heat Harness
ABLD-ELH-72	72"	1828 mm	72" (6') Extended-Length High-Heat Harness
ABLD-ELH-CUSTOM	Any size	Any size	Additional High-Heat Harness (sold in linear feet)
ABLD-CNADP	N/A	N/A	1/4" Female MPT to 1/4" Female BSPP Conversion

*Standard Hoses are not sold separately.

Parts & Accessories List

I-Purge Isolator®

ITEM #	ENGLISH	METRIC	DESCRIPTION
ISO 2	2"	51 mm	2" I-Purge Isolator® One-Sided Plug with 10' Hose and 1/4" FNPT Barb Fitting
ISO 3	3"	76 mm	3" I-Purge Isolator® One-Sided Plug with 10' Hose and 1/4" FNPT Barb Fitting
ISO 4	4"	102 mm	4" I-Purge Isolator® One-Sided Plug with 10' Hose and 1/4" FNPT Barb Fitting
ISO 5	5"	127 mm	5" I-Purge Isolator® One-Sided Plug with 10' Hose and 1/4" FNPT Barb Fitting
ISO 6	6"	152 mm	6" I-Purge Isolator® One-Sided Plug with 10' Hose and 1/4" FNPT Barb Fitting
ISO 8	8"	203 mm	8" I-Purge Isolator® One-Sided Plug with 10' Hose and 1/4" FNPT Barb Fitting
ISO 10	10"	254 mm	10" I-Purge Isolator® One-Sided Plug with 10' Hose and 1/4" FNPT Barb Fitting
ISO 12	12"	304 mm	12" I-Purge Isolator® One-Sided Plug with 10' Hose and 1/4" FNPT Barb Fitting
ISO 14	14"	355 mm	14" I-Purge Isolator® One-Sided Plug with 10' Hose and 1/4" FNPT Barb Fitting
ISO 16	16"	406 mm	16" I-Purge Isolator® One-Sided Plug with 10' Hose and 1/4" FNPT Barb Fitting
ISO 18	18"	457 mm	18" I-Purge Isolator® One-Sided Plug with 10' Hose and 1/4" FNPT Barb Fitting
ISO 20	20"	508 mm	20" I-Purge Isolator® One-Sided Plug with 10' Hose and 1/4" FNPT Barb Fitting
ISO 22	22"	558 mm	22" I-Purge Isolator® One-Sided Plug with 10' Hose and 1/4" FNPT Barb Fitting
ISO 24	24"	609 mm	24" I-Purge Isolator® One-Sided Plug with 10' Hose and 1/4" FNPT Barb Fitting
ISO 26	26"	660 mm	26" I-Purge Isolator® One-Sided Plug with 10' Hose and 1/4" FNPT Barb Fitting
ISO 28	28"	711 mm	28" I-Purge Isolator® One-Sided Plug with 10' Hose and 1/4" FNPT Barb Fitting
ISO 30	30"	762 mm	30" I-Purge Isolator® One-Sided Plug with 10' Hose and 1/4" FNPT Barb Fitting
ISO 32	32"	812 mm	32" I-Purge Isolator® One-Sided Plug with 10' Hose and 1/4" FNPT Barb Fitting

Parts & Accessories List

I-Purge Isolator® (Continued)

ITEM #	ENGLISH	METRIC	DESCRIPTION
ISO 34	34"	863 mm	34" I-Purge Isolator® One-Sided Plug with 10' Hose and 1/4" FNPT Barb Fitting
ISO 36	36"	914 mm	36" I-Purge Isolator® One-Sided Plug with 10' Hose and 1/4" FNPT Barb Fitting
ISO 38	38"	965 mm	38" I-Purge Isolator® One-Sided Plug with 10' Hose and 1/4" FNPT Barb Fitting
ISO 40	40"	1016 mm	40" I-Purge Isolator® One-Sided Plug with 10' Hose and 1/4" FNPT Barb Fitting
ISO 42	42"	1066 mm	42" I-Purge Isolator® One-Sided Plug with 10' Hose and 1/4" FNPT Barb Fitting
ISO 44	44"	1117 mm	44" I-Purge Isolator® One-Sided Plug with 10' Hose and 1/4" FNPT Barb Fitting
ISO 46	46"	1168 mm	46" I-Purge Isolator® One-Sided Plug with 10' Hose and 1/4" FNPT Barb Fitting
ISO 48	48"	1219 mm	48" I-Purge Isolator® One-Sided Plug with 10' Hose and 1/4" FNPT Barb Fitting

Parts & Accessories List

I-Purge[®]X Isolator[®]

ITEM #	ENGLISH	METRIC	DESCRIPTION
XISO 2-3	2-3"	51-76 mm	2-3" I-Purge [®] X Expandable One-Sided Plug with 10' Hose and 1/4" FNPT Barb Fitting
XISO 4-6	4-6"	102-152 mm	4-6" I-Purge [®] X Expandable One-Sided Plug with 10' Hose and 1/4" FNPT Barb Fitting
XISO 8-12	8-12"	203-305 mm	8-12" I-Purge [®] X Expandable One-Sided Plug with 10' Hose and 1/4" FNPT Barb Fitting
XISO 14-18	14-18"	356-457 mm	14-18" I-Purge [®] X Expandable One-Sided Plug with 10' Hose and 1/4" FNPT Barb Fitting
XISO 20-26	20-26"	509-660 mm	20-26" I-Purge [®] X Expandable One-Sided Plug with 10' Hose and 1/4" FNPT Barb Fitting
XISO 28-36	28-36"	711-914 mm	28-36" I-Purge [®] X Expandable One-Sided Plug with 10' Hose and 1/4" FNPT Barb Fitting
XISO 38-48	38-48"	965-1219 mm	38-48" I-Purge [®] X Expandable One-Sided Plug with 10' Hose and 1/4" FNPT Barb Fitting

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