Hy-Ram Engineering

# User Manual, Operating Instructions and Specifications




# SOU63HF

## Manual Squeeze Off Unit

**PE PIPE SQUEEZE OFF**

• INNOVATION • DESIGN • MANUFACTURE • SUPPLY

Hy-Ram Engineering

Pipe tool and equipment expertise

# User Manual, Operating Instructions and Specifications

## PE Pipe Squeeze Off Ø20mm - Ø63mm Squeeze Off Unit

| Description | Product Code | Details |
|---|---|---|
| SOU63HF | 089-000241 | Ø20mm- Ø63mm SDR11-17.6 |



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## Product description

The Hy-Ram SOU63HF Squeeze Tool is designed in order that it can be used quickly and easily to stop the water/gas flow in PE pipe. 'Pipe stops' are used on the units for each diameter/SDR combination thus ensuring the pipe is squeezed to its optimum level and to prevent over squeezing.

The SOU63HF tool has been designed to limit the flow in PE pipe sizes ranging from 20mm to 63mm outside diameter and wall thicknesses of up to SDR11 (dependant on which model stops have been requested). Other diameter/SDR combinations are available on request. The Hy-Ram SOU63HF is designed in accordance with gas industry standards GIS/PL2-7:2026.

**Note:**
No other uses are considered appropriate for this unit.
To use this unit for other purposes could lead to the unit being used for dangerous applications that may cause injury and could result in bad practice and poor-quality workmanship.
The information contained in these instructions is to assist with the safe installation, operation and maintenance of the equipment.
This information should be made available to all persons who are required to work with or on the equipment.

Future amendments issued by Hy-Ram Engineering Co. Ltd. should be attached to this document.

In the case of any doubt with any aspect of this equipment, including the application, safe use and instructions within this document; contact for clarification and advice.

## Health and Safety Introduction

This document explains about the tool and how to use and maintain it and should be available to all persons who are likely to use or work with or on the tool. Understand the following statements before using the tool.

| | |
|---|---|
| **Warning** | Informs of hazardous conditions which may cause bodily harm |
| **Caution** | Informs of conditions which may cause damage to the equipment |
| **Notes** | Explains additional or helpful information |

### Warning

- Only us the unit for the application described in these instructions.
- Using this unit for any other purpose could lead to injury and/or undesirable quality.
- Wear appropriate Personal Protective Equipment (PPE). Gloves, safety eyewear, safety headwear and safety footwear are mandatory.
- The information contained in these instructions is to assist with the safe installation, operation, and maintenance of the equipment.
- Future amendments by Hy-Ram Engineering Co. Ltd. will be in this document.
- In the case of any doubt with any aspect of this equipment, including the application, safe use, and instructions within this document; contact for clarification and advice.

### Caution

- Ensure all component parts are present and in serviceable condition.
- Confirm that the pipe pressure does not exceed 16Bar working pressure.
- Take precautions to avoid unexpected pipe movement.
- Always use in accordance with approved site operating procedures, approved by the network/asset owner/water company, in line with relevant industry standards and procedures.
- A trapping risk exists from the moving parts coming together with strong force.
- Compliance with Noise at Work regulations should be observed along with the use of appropriate PPE, see ***Warning*** above.

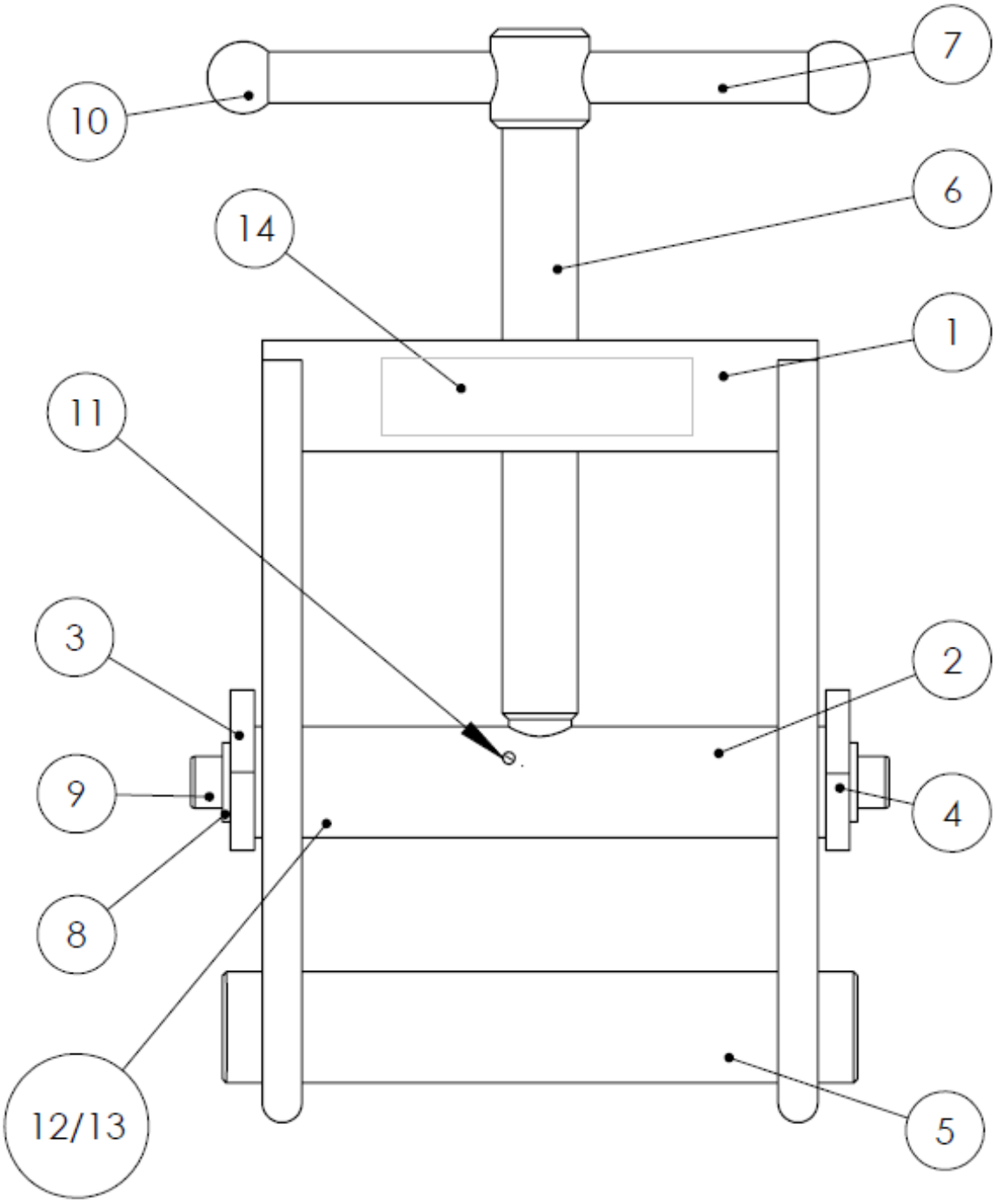
## Notes

- It is important to ensure that all component parts are present and in a serviceable condition. In addition, the stop plates should be checked against the pipe details before every squeeze off operation to ensure they are set correct for the pipe size and wall thickness rating (SDR). Wrongly set stops may cause leakage, damage to the pipe or injury.
- This unit is intended for squeezing off PE pipes within the gas and water industries. It is the responsibility of the operator to ensure that the PE pipe is suitable for squeeze off application. If in doubt contact the PE pipe manufacturer.
- Read ALL instructions and safety information before attempting to use the tool i.e. First Use.
- To avoid injury during transportation, the bottom beam should be removed or trapped in position by winding the feed screw to lower the top beam.
- Operatives should wear eye protection, gloves, safety headwear and footwear when using this equipment.
- A single squeeze tool cannot be guaranteed to provide 100% closure, where required operators are advised to consider using more than one squeeze tool.

## Photo Gallery



## Exploded View



## Component Part Numbers

| ITEM NO. | Part No | Description | QTY |
|---|---|---|---|
| 1 | 009-000056 | FRAME | 1 |
| 2 | 023-000183 | MIDDLE BEAM | 1 |
| 3 | 645-000287 | LEFT HAND STOP | 1 |
| 4 | 645-000288 | RIGHT HAND STOP | 1 |
| 5 | 023-000184 | BOTTOM BEAM | 1 |
| 6 | 400-000010 | SCREW | 1 |
| 7 | 023-000021 | TOMMY BAR | 1 |
| 8 | 760-000075 | M8 WASHER – Ø20mm x 2mm THICK | 2 |
| 9 | 200-000020 | M8 x 16mm CAP HEAD SCREW | 2 |
| 10 | 657-000018 | END CAP | 2 |
| 11 | 520-000029 | Ø3mm x 25mm SELOC PIN | 1 |
| 12 | 713-100009 | S213 COMPRESSION SPRING | 2 |
| 13 | 019-000005 | Ø1/4” STEEL BALL | 2 |
| 14 | 600-000125 | LABEL | 1 |

## Specification

| Materials | |
|---|---|
| Mild Steel | 070M20 |
| Mild Steel | 080M40 |

| Finishes | |
|---|---|
| Steel Surfaces | Zinc Plating / Chemical Black Oxide |

| Pipe Size Capacity | |
|---|---|
| Maximum Pipe Diameter | Ø63mm |
| Minimum Pipe Diameter | Ø20mm |

| Marking | |
|---|---|
| Steel Parts | Label |

| Weight | |
|---|---|
| 089-000241 | 3.8 Kg |

| Dimensions | |
|---|---|
| 089-000241 | 262mm H x 170mm W x 50mm D |

## Standards

The tool is designed and manufactured using the following design principles.

**Safety of Machinery**

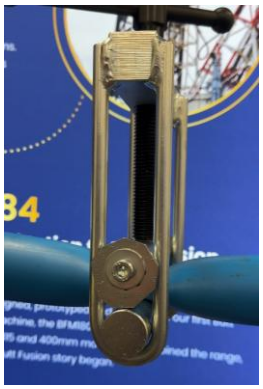
BS EN ISO 12100:2010 Safety of Machinery - General principles for design. Risk assessment and risk reduction.

**Relevant Industry Standard**

This unit is design and manufactured to meet the requirements of National Grid Gas Industry Standards GIS/PL2- 7:2026 Part 7: Squeeze-off tools and equipment.

## Operating Instructions

| Operation | | |
|---|---|---|
| 1 |  | Ensure ALL maintenance and service checks have been carried out.<br><br>⚠️ **Confirm water pressure is 16 Bar or below.** |
| 2 |  | Ensure that the pipe stops are set for the pipe to be squeezed. The diameter/SDR combination is stamped on the side of the pipe stop and should be able to be read in the 'horizontal' position (i.e. at the bottom). |
| 3 |  | Ensure the unit is in the 'open' position and ready to accept the pipe. If not, i.e. the Middle Beam is not in the 'raised' position, open the unit by turning the tommy bar (turn anti-clockwise) to raise. |
| 4 |  | Position the unit centrally on the pipe to be squeezed and slide the Bottom Beam into position. |
| 5 |  | Turn the tommy bar clockwise. Observe the Middle Beam begin to squeeze the pipe (making sure the pipe stays centrally on the Middle Beam). |

| | | |
|---|---|---|
| **6** |  | Continue until the Pipe Stops make contact with the Bottom Beam on both sides. The pipe is now squeezed to the optimum level. |
| **7** |  | To release, undo the feed screw until the Middle Beam is in the raised position. |
| **8** |  | The unit can now be taken off the pipe. |
| **9** |  | Allow the section of squeezed pipe to reform to its original shape; this may take several hours. |

## Product Calibration

This product has no calibration requirement. Periodic safety inspections should be carried out by the operator if in any doubt please contact the manufacturer for further information.

## Storage and Maintenance

- Store and transport the tool upright (vertical) in a dry and clean environment.
- The unit should be periodically serviced as per
-
- *Service* Schedule.
- There are no internal wear parts for the user to change.

## Service Schedule

| **Before each use** |
| --- |
| Visual check |

CE

**EC DECLARATION OF CONFORMITY**

1. Product description: Squeeze Off Unit

   Make: Hy-Ram
   Type: SOU63HF

2. Manufactured by: Hy-Ram Engineering Co. Ltd., Pelham Street, Mansfield, Nottinghamshire, NG18 2EY.
3. This declaration is issued under the sole responsibility of the manufacturer.
4. The manufacture declares that the following machinery complies with the essential health and safety requirements of the Machinery Directive 2006/42/EC enacted in the United Kingdom by The Supply of Machinery (Safety) Regulations 2008.
5. This machinery has been designed and manufactured in accordance with the following transposed harmonised European standards or references to the other technical specifications in relation to which conformity is declared. The machinery complies with or is designed and manufactured so far as is possible to comply with the relevant essential health and safety requirements, taking into account the state of threat.

   - BS EN ISO 12100:2010 Safety of Machinery - General principles for design. Risk assessment and risk reduction.
   - BS EN ISO 13857:2008 Safety of Machinery – Safety distances to prevent hazard zones being reached by upper and lower limbs.
   - BS EN 349:1993+A1:2008 Safety of Machinery – Minimum gaps to avoid crushing of parts of the human body.
   - GIS/PL2-7:2026 Part 7: Squeeze-off tools and equipment.

6. A technical construction file for this machinery is retained at the address of the manufacturer stated above. Modifications to the equipment without prior written approval by the undersigned will render this declaration null and void.
7. The manufacturer applied the procedure for assessment of conformity with internal checks on manufacture. A conformity assessment body was not involved.
8. The technical documentation for the machinery is retained at the address of the manufacturer stated above.
9. Modifications to the equipment without prior written approval by the undersigned will render this declaration null and void.

For and on behalf of the manufacturer:
[Authorised representative of Hy-Ram Engineering Co Ltd].

Signature: *L Bullock-Jones*

Name: Lee Bullock Jones
Position: Technical Director
Date: 8th October 2026

Signature of this Declaration of Conformity authorises the manufacturer or his authorised representative to affix the CE mark to the equipment.

**UK DECLARATION OF CONFORMITY**

1. Product description: Squeeze Off Unit

   Make: Hy-Ram
   Type: SOU63HF

2. Manufactured by: Hy-Ram Engineering Co. Ltd., Pelham Street, Mansfield, Nottinghamshire, NG18 2EY.
3. This declaration is issued under the sole responsibility of the manufacturer.
4. The manufacture declares that the following machinery complies with the essential health and safety requirements of the Machinery Directive 2006/42/EC enacted in the United Kingdom by The Supply of Machinery (Safety) Regulations 2008.
5. This machinery has been designed and manufactured in accordance with the following transposed harmonised European standards or references to the other technical specifications in relation to which conformity is declared. The machinery complies with or is designed and manufactured so far as is possible to comply with the relevant essential health and safety requirements, taking into account the state of threat.

   - BS EN ISO 12100:2010 Safety of Machinery - General principles for design. Risk assessment and risk reduction.
   - BS EN ISO 13857:2008 Safety of Machinery – Safety distances to prevent hazard zones being reached by upper and lower limbs.
   - BS EN 349:1993+A1:2008 Safety of Machinery – Minimum gaps to avoid crushing of parts of the human body.
   - GIS/PL2-7:2026 Part 7: Squeeze-off tools and equipment.

6. A technical construction file for this machinery is retained at the address of the manufacturer stated above. Modifications to the equipment without prior written approval by the undersigned will render this declaration null and void.
7. The manufacturer applied the procedure for assessment of conformity with internal checks on manufacture. A conformity assessment body was not involved.
8. The technical documentation for the machinery is retained at the address of the manufacturer stated above.
9. Modifications to the equipment without prior written approval by the undersigned will render this declaration null and void.

For and on behalf of the manufacturer:
[Authorised representative of Hy-Ram Engineering Co Ltd].

Signature: *L Bullock-Jones*

Name: Lee Bullock Jones
Position: Technical Director
Date: 8th October 2026

Signature of this Declaration of Conformity authorises the manufacturer or his authorised representative to affix the CE mark to the equipment.

Hy-Ram Engineering

Pipe tool and equipment expertise

## Certificate of Conformity

This Certificate of Conformity certifies that the product detailed below has been designed, manufactured, inspected, and tested in accordance with our NQA approved:

Quality Management System ISO 9001:2015
Environmental Management System ISO 14001:2015
Occupational Health & Safety Management System ISO 45001: 2018

Product:
**SOU63HF**

The product conforms to the following standards:

**Safety of Machinery BS EN ISO 12100:2010 Safety of Machinery**
General principles for design. Risk assessment and risk reduction.

**GIS/PL2- 7:2026 Part 7: Squeeze-off tools and equipment**
This unit is design and manufactured to meet the requirements of National Grid Gas Industry Standards.

Date: **8th October 2026**

Note! This product has no calibration period and periodic safety inspections should be carried out by the operator.
For further information contact the manufacturer. www.hyram.com

*L Bullock-Jones*

Lee Bullock Jones
Technical Director

PRODUCT CONFORMITY Hy-Ram Engineering Mansfield, England U.K.

Hy-Ram Engineering Co. Ltd.
Pelham Street
Mansfield
Nottinghamshire
NG18 2EY

## Certificate of calibration

- This product has been designed, manufactured, inspected, and tested in accordance with our NQA ISO 9001:2015, NQA ISO 14001:2015 and ISO 45001:2018 systems.

## Decommissioning & Disposal Instructions

- If a Hy-Ram product has reached the end of its useful working life dispose through a licensed scrap or waste disposal facility.
- Decommissioning and disposal are the responsibility of the customer. Take the product out of service safely and in compliance with essential Health and Safety requirements.

## Warranty.

### Extent of Warranty.

In the case that this product does not meet quality or performance expectations then Hy-Ram will replace the product to the customer's satisfaction. Hy-Ram will guarantee this product against breakage or defective workmanship for one year.

This guarantee is not valid in cases of abuse or exceptional damage beyond reasonable expectations or where incorrect use, or care of the product has occurred as described in the user manual and instructions. Additionally, the guarantee is not valid in cases of unauthorised modification, misuse, or any use not in accordance with the operating manual and good industry practice, operation outside the products specifications, improper site preparation or maintenance or when using with faulty pipe or fittings. Hy-Ram does not warrant the operation of any product to be uninterrupted or error free.

Any warranty or condition implied by law, shall be the replacement or parts, without charge, which are defective in material or workmanship, and which have not been misused, carelessly handled, or mis-repaired by persons other than the manufacturer or an Authorised Service Centre.

Hy-Ram Engineering Co Ltd offer a 1 year from date of despatch warranty only against defects in workmanship and materials. This limited warranty does not apply to any refurbished or reconditioned equipment and is non-transferable and subject to the conditions and limitations set forth herein. The standard Terms and Conditions of trade form part of this warranty.

Hy-Ram Engineering Co Ltd will, at its option, repair or replace (with a new or reconditioned unit of like condition).

All warranty work will be by Hy-Ram Engineering Co Ltd unless otherwise agreed or by authorised Hy-Ram Engineering Co Ltd service facilities.

If replacement parts are used in making repairs, these parts may be remanufactured or contain remanufactured materials.

In returning the product for repair, send in its original packaging or in packaging offering a sufficient degree of protection. With the product must be evidence of the date of purchase (see also the form at the rear of this document). Hy-Ram will not be responsible for any loss or damage incurred in connection with the return of the product. To the extent that this warranty statement is inconsistent with the law of the locality where the customer uses the product, this warranty statement shall be deemed modified by the minimum necessary to be consistent with such local

law. To the extent allowed by local law, the remedies provided in this warranty statement are the customer's sole and exclusive remedies. This tool has been designed for the range of pipe and fittings commercially available at the time of its design and development. Hy-Ram Engineering Co Ltd can accept no liability for the unit's ability or otherwise to work with new or different fittings that are subsequently introduced to the market.
The foregoing limited warranty is Hy-Ram Engineering's only warranty with respect to the product and Hy-Ram makes no other warranty whatsoever, written, or oral, express, or implied, regarding the product, including without limitation any warranty of merchantability, fitness for a particular purpose or non-infringement. In no event will Hy-Ram or its authorised dealers be liable for any loss of profits or special, consequential, or incidental damages even if such damages result from negligence or other fault.

Upon purchase, please complete the original purchase record below and keep it safely with your proof of purchase receipt. You will require it for any warranty claim.

| **Product Record (for any warranty claim)** | |
|---|---|
| **Company name and location** | |
| **Date of purchase** | |
| **Name and address of purchaser** | |
| **Type of tool** | **SOU63HF** |
| **Serial number (if applicable)** | |

## Annex

Note: Hy-Ram Engineering Co. Ltd. operate a policy of continual improvement and therefore reserves the right to modify product specifications without notice.

## Revision Table

| Version | Details | Section / Page | Date |
|---|---|---|---|
| V1.26 | Original version | - | 8th October 2026 |
| | | | |
| | | | |

### Manual Handling

Please see the UK Health and Safety Executive for further guidelines regarding Manual Handling best practice.

- https://www.hse.gov.uk/msd/manual-handling/index.htm

## Contact Hy-Ram

For service and repair please contact:

**Hy-Ram Engineering Co. Ltd.**
**Pelham Street**
**Mansfield**
**Nottinghamshire**
**NG18 2EY**
**Tel: +44 (0)1623 422982**
**www.hyram.com**

Hy-Ram Engineering

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PE PIPE SQUEEZE OFF

For Sales, Hire and Repair support contact our admin team or scan the QR code for further details

**www.hyram.com**


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