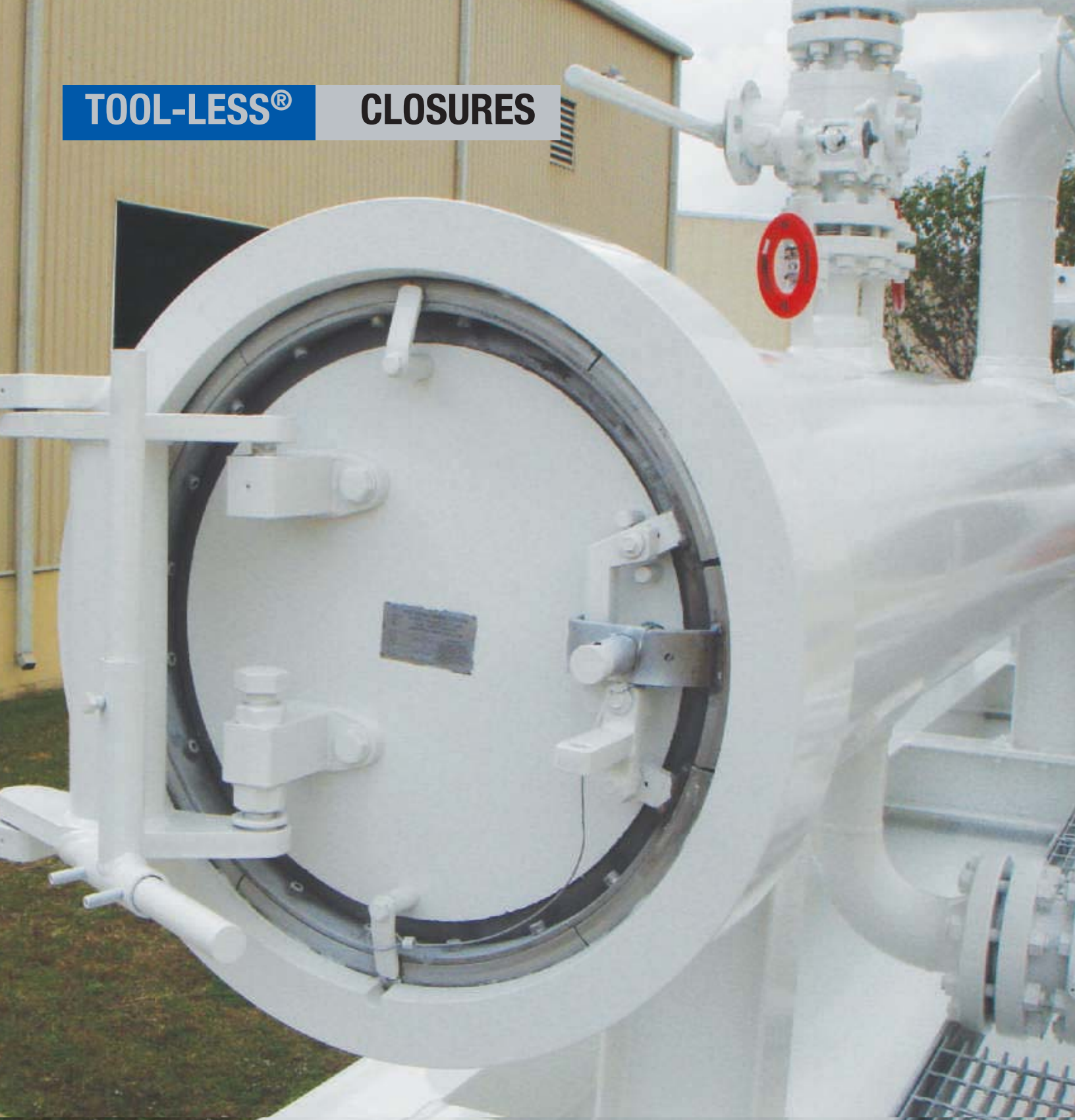


**TOOL-LESS®**

**CLOSURES**



For Blanking Off  
Pipeline Ends,  
Tank and  
Vessel Openings



**SYPRIS®**  
TECHNOLOGIES  
Tube Turns Division

## HISTORY

Tube Turns was founded in 1927 in Louisville, Kentucky, USA. We were the first American manufacturer of forged seamless pipe elbows and returns. Over the years, our products have evolved to exceed the ever changing market demands of the industries that we serve.

In 1959, we developed Yoke Style Hinged Closures. We then added T-Bolt Closures, Threaded Closures and Tool-less® Closures in order to satisfy customer requirements.

Applications include scraper traps, filters, strainers, separators/ coalescers, terminal manifolds, meter provers, distillation towers, storage tanks or any pressure vessel requiring frequent access.



## DESIGN

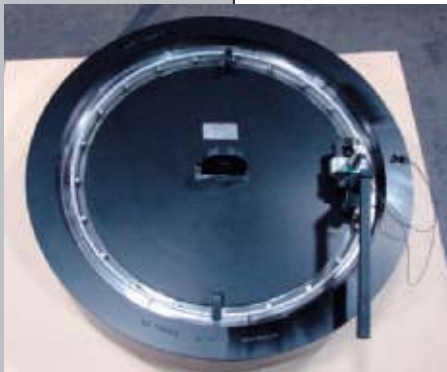
The Tool-less® Closure satisfies design requirements in ASME B31.3, B31.4, B31.8, and Section VIII, Div. 1. The entire design has been verified through proven stress calculations, the latest finite element analysis (FEA) software, and strain gage testing, establishing a high level of confidence in the structural integrity of the Tool-less® Closure. In addition, fatigue analysis based on severe field condition data has been successfully conducted on all closure sizes and classes.

### FAST, EASY OPERATION

Tool-less® operation is smooth and direct and even the largest unit can be opened or closed in a matter of seconds by one person. Complete Installation, Operation and Maintenance Instructions are furnished with each Tool-less® Closure.

### SAFETY

Our Pressure Warning Screw (PWS) assures both pressure warning and mechanical interlocking of the closure prior to commencement of operation. Additionally the PWS serves the purpose of alerting the operator to any residual pressure inside the vessel should the operator inadvertently attempt to open the closure before all pressure has been relieved. Tool-less® Closure safety system meets the requirements of UG-35 of ASME Section VIII Division 1. The Tool-less® Closure can also be easily fitted with key interlock systems.



### CONFIGURATION

Tool-less® Closure is available in horizontal and vertical configurations. Horizontal closures are available in left (standard) or right hand hinging and include a robust double pivot adjustable hinge. Vertical closures can be offered with a davit or lifting lug depending on customer preference.



# TOOL-LESS® CLOSURES

## MATERIALS OF CONSTRUCTION

We maintain an inventory of ASME compliant components in carbon and stainless steel including low temperature and high yield materials to accommodate quick delivery. Materials conforming to the latest NACE requirement standard MR0175/ISO 15156, duplex stainless steel, and other specialty alloys are available upon request.

## CORROSION RESISTANT WELD OVERLAY

Weld overlay of the sealing and wetted surfaces can be provided in a variety of corrosion resistant alloys.

## ALLOWABLE WORKING PRESSURES (RATINGS)

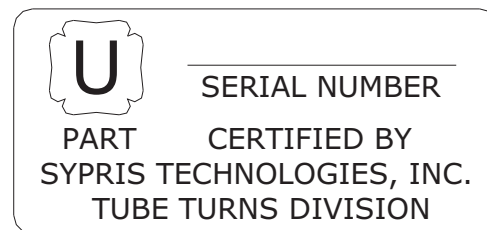
In general, the pressure classes established for Tube Turns Tool-less® Closures refer to ASME/ANSI B16.5 ratings used in normal piping terminology. This is done as a matter of convenience to give the engineer the exact Tool-less® Closure design required for a particular application. Maximum allowable working pressures for carbon steel Tube Turns Tool-less® Closures are:

ASME/ANSI Pressure Class	Closure Service to 250°F (121°C) PSI (bar)
150	285 (19.65)
300	740 (51.02)
600	1480 (102.04)
900	2220 (153.06)
1500	3705 (255.45)



## ASME CODE STAMPED CLOSURES

Code stamping of Tube Turns Tool-less® Closures is available on request at a nominal fee. This includes (1) the furnishing of a Partial Data Report (Form U-2A) verifying shop inspection of the unit by a commissioned inspector of the National Board of Boiler and Pressure Vessel Inspectors, and (2) the affixing of the ASME stamp.



## MANUFACTURER'S STATEMENT OF CODE COMPLIANCE

In the event that shop inspection and stamping in accordance with Section VIII of the ASME Boiler and Pressure Vessel Code is not required, Tube Turns can furnish a Manufacturer's Statement of Code Compliance at no charge. This document affirms that the Tool-less® Closure is manufactured in accordance with the applicable requirements of the Code.

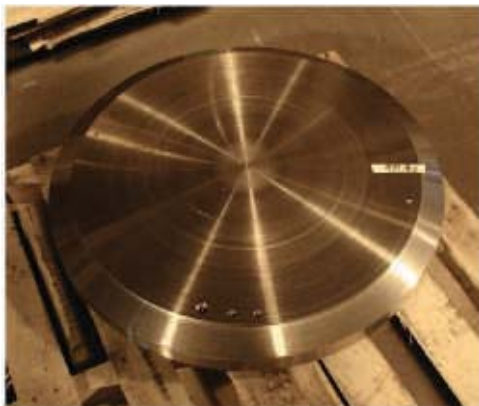
# TOOL-LESS® CLOSURES



## ORDERING DATA

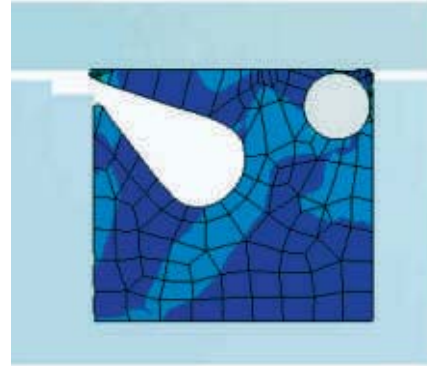
When inquiring and/or purchasing Tube Turns Tool-less® Closures, please specify the following:

1. Quantity
2. Size
3. Materials of construction
4. Design conditions - both pressure and temperature
5. Minimum design metal temperature (MDMT)
6. Application - horizontal (opens like a car door) or vertical (opens like a car hood)
7. Bore or wall thickness
8. ASME code stamp and partial data reports
9. Seal material
10. Corrosion allowance, if applicable.
11. Design Codes and/or specifications, if applicable.



## LIP SEAL

The Tool-less® Closure lip seal was developed using FEA. This allowed for the behavior and the stresses of the seal to be examined before physical testing. We have analyzed the seal at the worst case scenarios to ensure that the seal will successfully perform in the closure.



Designed for long life, each Tool-less® Closure is furnished with a fully molded self energized lip seal with an integral stainless steel backing ring located in the closure door. Standard lip seal material is Buna-N; optional seal materials available include FKM (commonly called Viton), HNBR, Ethylene Propylene, and Explosive Decompression Resistant FKM. Special compounds are available for low temperature applications.

Common materials used for seals are discussed below. Technical information as to properties and usages of lip seal material are based on data and recommendations of the manufacturers of the materials.

Buna-N is used for general service. It is resistant to petroleum-base hydraulic and lubricating oils, animal and vegetable oils, gases such as butane, propane, acetylene, and natural gas, aromatic and non-aromatic fuels such as gasoline, kerosene, diesel fuel and fuel oils, anhydrous ammonia, and water. Operating temperature limits are -40°F to 250°F (-40°C to 121°C).

FKM is generally used for high-temperature services. It is resistant to synthetic lubricants, petroleum-base products, some chlorinated solvents, benzene, toluene, and many acids and alkalis. Operating temperature limits are -40°F to 400°F (-40°C to 204°C).

**Note: Determination of the compatibility of the seal is the responsibility of the purchaser.**

# DESIGN VALIDATION

## FEA AND STRAIN GAGE TESTING

The Tool-less® Closure product line has been designed in accordance with ASME Section VIII, Division 1, B31.3, B31.4, and B31.8 using FEA. All pressure retaining components are designed for long life and verified through fatigue analysis.

Furthermore, strain gage testing was performed for various sizes and classes. The results obtained through strain gage testing were compared to FEA for theoretical agreement and meet the allowable stresses prescribed in the ASME Section VIII Division 1. All strain gage testing was witnessed by an independent authorized inspection agency.

## PRESSURE FATIGUE TESTING

A 36" Class 600 Tool-Less® Closure was subjected to hydrostatic pressure fatigue test and showed no signs of leaking, deforming, or yielding.



## ADVANTAGES

### Simple and Quick Operation

Operation of closure requires no tools and can be opened and closed in a matter of seconds by one person reducing costly downtime.

### Low Maintenance

Designed to be durable and to minimize spare parts.

### Actuation

Robust and fatigue resistant actuation for ease of use and long life.

### Segmented Locking Ring

Locking ring segments rigidly attached to a spring band allow for smooth operation and prevent binding. Heavy duty locking ring provides maximum safety.

### Safety

Positive mechanical locking prevents inadvertent opening under pressure. Complete with pressure warning screw in accordance with UG-35 of ASME Section VIII Div 1.

### Economical and Readily Available

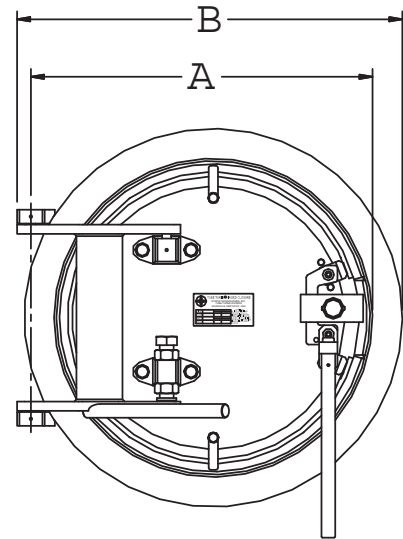
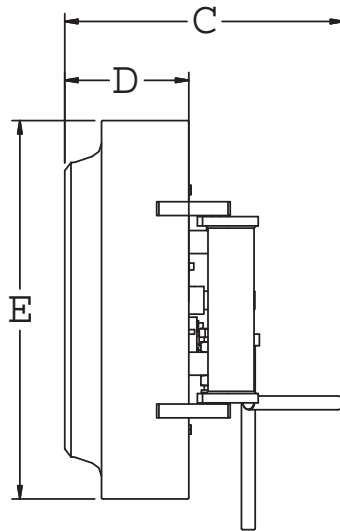
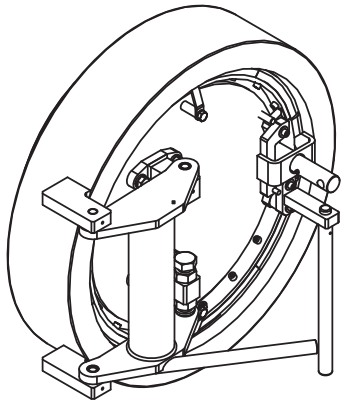
Competitive pricing and best in class lead times driven by inventoried materials.

### Fully Molded Seal

Eliminates need for splicing resulting in higher strength and longer life. Ensures optimal performance under the most stringent design requirements.

### Integrated Backing Spring

One piece seal construction simplifies installation and reduces spare parts required.

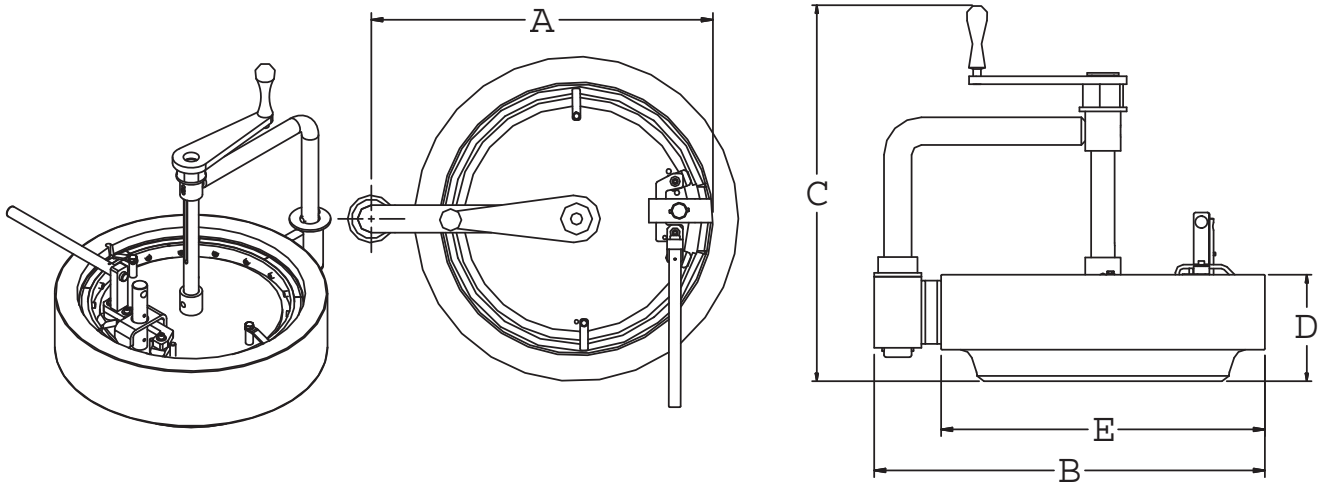


	Nominal Size		Swing Radius A		Over-all Width B		Over-all Height C		Hub Length D		Hub OD E		Approx. Weight	
	In.	(Dn)	In.	(cm)	In.	(cm)	In.	(cm)	In.	(cm)	In.	(cm)	lbs	(Kg)
CLASS 150-H & 300-H	8	(200)	10 13/16	(27.46)	12 11/16	(32.23)	11 3/8	(28.89)	5 1/16	(12.86)	12 1/16	(30.64)	100	(45)
	10	(250)	12 13/16	(32.54)	14 15/16	(37.94)	11 3/8	(28.89)	5 1/4	(13.34)	14 1/2	(36.83)	140	(64)
	12	(300)	15 3/16	(38.58)	17 1/2	(44.45)	13	(33.02)	5 7/8	(14.92)	16 7/8	(42.86)	220	(100)
	14	(350)	15 15/16	(40.48)	17 7/8	(45.40)	14 5/16	(36.35)	5 7/16	(13.81)	17 7/16	(44.29)	200	(91)
	16	(400)	17 7/8	(45.40)	19 7/8	(50.48)	14 11/16	(37.31)	5 7/8	(14.92)	19 9/16	(49.69)	260	(118)
	18	(450)	19 13/16	(50.32)	21 7/8	(55.56)	14 7/8	(37.78)	6 1/8	(15.56)	21 3/4	(55.25)	320	(145)
	20	(500)	22 3/16	(56.36)	24 13/16	(63.02)	17 3/16	(43.66)	7	(17.78)	24 3/8	(61.91)	480	(218)
	22	(550)	24 1/16	(61.12)	26 3/4	(67.95)	17 1/4	(43.82)	7 1/8	(18.10)	26 1/2	(67.31)	570	(259)
	24	(600)	25 3/4	(65.41)	28 1/2	(72.39)	17 11/16	(44.93)	7 5/8	(19.37)	28 3/8	(72.07)	680	(308)
	26	(650)	27 7/8	(70.80)	30 7/8	(78.42)	20 5/8	(52.39)	8 1/16	(20.48)	30 9/16	(77.63)	850	(386)
	28	(700)	29 3/4	(75.57)	32 13/16	(83.34)	20 13/16	(52.86)	8 5/16	(21.11)	32 11/16	(83.03)	1000	(454)
	30	(750)	31 11/16	(80.49)	34 7/8	(88.58)	21 3/16	(53.82)	8 11/16	(22.07)	34 7/8	(88.58)	1180	(535)
	32	(800)	33 7/8	(86.04)	37 5/8	(95.57)	29 3/4	(75.57)	9 5/8	(24.45)	37 9/16	(95.41)	1550	(703)
	34	(850)	35 3/4	(90.81)	39 1/2	(100.33)	30 1/8	(76.52)	9 7/8	(25.08)	39 11/16	(100.81)	1780	(807)
	36	(900)	37 11/16	(95.73)	41 1/2	(105.41)	30 1/4	(76.84)	10 1/8	(25.72)	41 7/8	(106.36)	2030	(921)
	38	(950)	39 15/16	(101.44)	44 3/16	(112.24)	31 13/16	(80.80)	10 3/4	(27.31)	44 3/16	(112.24)	2430	(1102)
	40	(1000)	41 3/8	(105.09)	45 11/16	(116.05)	32 5/8	(82.87)	11 5/8	(29.53)	45 13/16	(116.36)	2710	(1229)
	42	(1050)	42 13/16	(108.74)	47 3/16	(119.86)	32 11/16	(83.03)	11 11/16	(29.69)	47 7/16	(120.49)	2970	(1347)
	44	(1100)	45	(114.30)	49 3/4	(126.37)	38 15/16	(98.90)	12 1/8	(30.80)	49 3/4	(126.37)	3480	(1579)
	46	(1150)	46 15/16	(119.22)	51 3/4	(131.45)	39 1/4	(99.70)	12 5/16	(31.27)	51 15/16	(131.92)	3850	(1746)
48	(1200)	49	(124.46)	54	(137.16)	39 3/8	(100.01)	13 1/16	(33.18)	54 7/16	(138.27)	4450	(2018)	
50	(1250)	51 1/4	(130.18)	56 5/8	(143.83)	40 11/16	(103.35)	13 5/16	(33.81)	56 5/8	(143.83)	4990	(2263)	
52	(1300)	52 11/16	(133.83)	58 1/16	(147.48)	41 15/16	(106.52)	13 15/16	(35.40)	58 1/4	(147.96)	5410	(2454)	
54	(1350)	54 5/8	(138.75)	60 1/16	(152.56)	42 3/8	(107.63)	14 3/16	(36.04)	60 7/16	(153.51)	5940	(2694)	

See notes on Page 7.

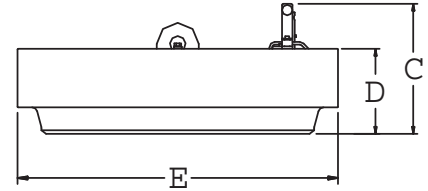
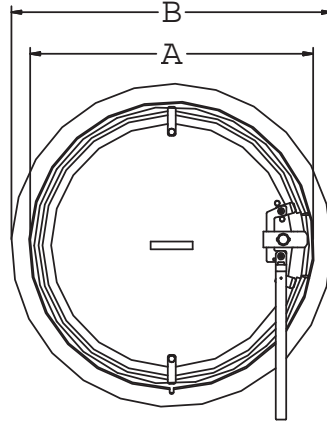
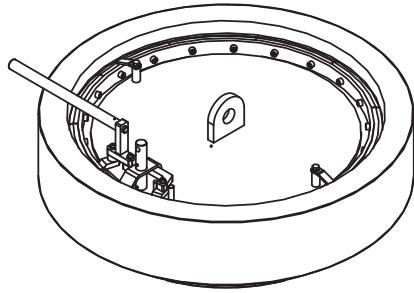
	Nominal Size	Swing Radius A		Over-all Width B		Over-all Height C		Hub Length D		Hub OD E		Approx. Weight	
	In. (Dn)	In.	(cm)	In.	(cm)	In.	(cm)	In.	(cm)	In.	(cm)	lbs	(Kg)
CLASS 600-H	8 (200)	10 13/16	(27.46)	12 11/16	(32.23)	11 3/8	(28.89)	5 1/16	(12.86)	12 1/16	(30.64)	100	(45)
	10 (250)	12 13/16	(32.54)	14 15/16	(37.94)	11 3/8	(28.89)	5 1/4	(13.34)	14 1/2	(36.83)	140	(64)
	12 (300)	15 3/16	(38.58)	17 1/2	(44.45)	13	(33.02)	5 7/8	(14.92)	16 7/8	(42.86)	220	(100)
	14 (350)	16 7/16	(41.75)	18 3/4	(47.63)	14 15/16	(37.94)	6 3/8	(16.19)	18 1/4	(46.36)	270	(122)
	16 (400)	18 7/16	(46.83)	20 15/16	(53.18)	15 3/16	(38.58)	6 3/4	(17.15)	20 9/16	(52.23)	350	(159)
	18 (450)	20 7/16	(51.91)	23 1/16	(58.58)	15 5/8	(39.69)	7 5/16	(18.57)	22 13/16	(57.94)	550	(249)
	20 (500)	26 1/8	(66.36)	22 15/16	(58.26)	18 1/8	(46.04)	8 1/16	(20.48)	25 9/16	(64.93)	660	(299)
	22 (550)	25	(63.50)	28 3/8	(72.07)	18 7/16	(46.83)	8 9/16	(21.75)	28	(71.12)	820	(372)
	24 (600)	26 11/16	(67.79)	30 3/16	(76.68)	19 1/8	(48.58)	9 5/16	(23.65)	29 15/16	(76.04)	1000	(454)
	26 (650)	28 7/8	(73.34)	32 3/4	(83.19)	21 13/16	(55.40)	9 15/16	(25.24)	32 1/4	(81.92)	1250	(567)
	28 (700)	30 15/16	(78.58)	35	(88.90)	21 15/16	(55.72)	10 3/16	(25.88)	34 11/16	(88.11)	1490	(676)
	30 (750)	32 15/16	(83.66)	37 1/8	(94.30)	22 3/16	(56.36)	10 9/16	(26.83)	36 15/16	(93.82)	1750	(794)
	32 (800)	35 1/8	(89.22)	39 13/16	(101.12)	23	(58.42)	11 15/16	(30.32)	39 9/16	(100.49)	2280	(1034)
	34 (850)	37 1/8	(94.30)	42 1/16	(106.84)	23 3/16	(58.90)	12 5/16	(31.27)	42	(106.68)	2640	(1197)
	36 (900)	39 1/8	(99.38)	44 1/4	(112.40)	23 15/16	(60.80)	13 1/4	(33.66)	44 5/16	(112.55)	3120	(1415)
	38 (950)	41 9/16	(105.57)	47 3/16	(119.86)	25 1/8	(63.82)	13 13/16	(35.08)	46 7/8	(119.06)	3710	(1683)
	40 (1000)	43 1/16	(109.38)	48 3/4	(123.83)	25 5/16	(64.29)	14 1/8	(35.88)	48 9/16	(123.35)	4030	(1828)
	42 (1050)	44 9/16	(113.19)	50 3/8	(127.95)	26 5/8	(67.63)	15 1/2	(39.37)	50 5/16	(127.79)	4630	(2100)
	44 (1100)	46 13/16	(118.90)	53 1/16	(134.78)	30 9/16	(77.63)	15 15/16	(40.48)	52 3/4	(133.99)	5330	(2418)
	46 (1150)	48 13/16	(123.98)	55 3/16	(140.18)	30 3/4	(78.11)	16 1/4	(41.28)	55	(139.70)	5910	(2681)
48 (1200)	51 7/16	(130.65)	57 3/4	(146.69)	30 3/4	(78.11)	16 1/2	(41.91)	57 13/16	(146.84)	6870	(3116)	
50 (1250)	53 3/8	(135.57)	60 1/2	(153.67)	31 1/4	(79.38)	17 1/2	(44.45)	60 1/8	(152.72)	7660	(3475)	
52 (1300)	54 7/8	(139.38)	62 1/16	(157.64)	32 9/16	(82.71)	18 7/8	(47.94)	61 13/16	(157.00)	8540	(3874)	
54 (1350)	56 7/8	(144.46)	64 3/16	(163.04)	32 11/16	(83.03)	19 1/16	(48.42)	64 1/8	(162.88)	9350	(4241)	
CLASS 900-H	8 (200)	11 1/4	(28.58)	13 1/4	(33.66)	12 1/16	(30.64)	6	(15.24)	12 9/16	(31.91)	130	(59)
	10 (250)	13 1/4	(33.66)	15 1/2	(39.37)	13 9/16	(34.45)	6 7/16	(16.35)	15 1/16	(38.26)	190	(86)
	12 (300)	15 3/4	(40.01)	18 1/4	(46.36)	13 13/16	(35.08)	6 15/16	(17.62)	17 9/16	(44.61)	280	(127)
	14 (350)	17 1/16	(43.34)	19 11/16	(50.01)	15 15/16	(40.48)	7 3/4	(19.69)	19 1/16	(48.42)	360	(163)
	16 (400)	19 9/16	(49.69)	22 9/16	(57.31)	16 11/16	(42.39)	9 3/16	(23.34)	22 1/16	(56.04)	560	(254)
	18 (450)	21 7/16	(54.45)	24 7/8	(63.18)	19 9/16	(49.69)	9 7/8	(25.08)	24 7/16	(62.07)	740	(336)
	20 (500)	23 9/16	(59.85)	27 3/16	(69.06)	20	(50.80)	10 1/2	(26.67)	26 15/16	(68.42)	940	(426)
	22 (550)	25 11/16	(65.25)	29 3/4	(75.57)	21 11/16	(55.09)	11 3/16	(28.42)	29 5/16	(74.45)	1190	(540)
24 (600)	27 11/16	(70.33)	32	(81.28)	22 3/8	(56.83)	12 1/8	(30.80)	31 9/16	(80.17)	1470	(667)	

Note: Horizontal Tool-less® Closures are normally installed with hinge at the left (left hand hinge) when viewed facing the closure. If right hand hinge is required, this information needs to be made available at time of order. Otherwise, closure will not operate properly when installed. For Pressure-Temperature, see Page 3.



	Nominal Size		Swing Radius A		Over-all Width B		Over-all Height C		Hub Length D		Hub OD E		Approx. Weight	
	In.	(Dn)	In.	(cm)	In.	(cm)	In.	(cm)	In.	(cm)	In.	(cm)	lbs	(Kg)
CLASS 150-V & 300-V	8	(200)	13 1/16	(33.18)	15 15/16	(40.48)	18 3/4	(47.63)	5 1/16	(12.86)	12 1/16	(30.64)	100	(45)
	10	(250)	15 5/16	(38.89)	17 1/2	(44.45)	19 13/16	(50.32)	5 1/4	(13.34)	14 1/2	(36.83)	150	(68)
	12	(300)	17 7/16	(44.29)	19 7/8	(50.48)	20 5/8	(52.39)	5 7/8	(14.92)	16 7/8	(42.86)	220	(100)
	14	(350)	18 7/16	(46.83)	20 15/16	(53.18)	20 7/16	(51.91)	5 7/16	(13.81)	17 7/16	(44.29)	210	(95)
	16	(400)	20 1/2	(52.07)	23 1/16	(58.58)	20 3/4	(52.71)	5 7/8	(14.92)	19 9/16	(49.69)	250	(113)
	18	(450)	23 1/4	(59.06)	26	(66.04)	23 3/8	(59.37)	6 1/8	(15.56)	21 3/4	(55.25)	330	(150)
	20	(500)	25 5/8	(65.09)	28 5/8	(72.71)	24 1/2	(62.23)	7	(17.78)	24 3/8	(61.91)	480	(218)
	22	(550)	28 3/16	(71.60)	31 1/2	(80.01)	24 5/8	(62.55)	7 1/8	(18.10)	26 1/2	(67.31)	570	(259)
24	(600)	30 1/16	(76.36)	33 3/8	(84.77)	25 1/8	(63.82)	7 5/8	(19.37)	28 3/8	(72.07)	680	(308)	
CLASS 600-V	8	(200)	13 1/16	(33.18)	15 15/16	(40.48)	18 3/4	(47.63)	5 1/16	(12.86)	12 1/16	(30.64)	100	(45)
	10	(250)	15 5/16	(38.89)	17 1/2	(44.45)	19 13/16	(50.32)	5 1/4	(13.34)	14 1/2	(36.83)	150	(68)
	12	(300)	17 7/16	(44.29)	19 7/8	(50.48)	20 5/8	(52.39)	5 7/8	(14.92)	16 7/8	(42.86)	220	(100)
	14	(350)	18 3/8	(46.67)	20 15/16	(53.18)	21 1/4	(53.98)	6 3/8	(16.19)	18 1/4	(46.36)	270	(122)
	16	(400)	21 9/16	(54.77)	24 13/16	(63.02)	23 9/16	(59.85)	6 3/4	(17.15)	20 9/16	(52.23)	350	(159)
	18	(450)	23 5/16	(59.21)	26 13/16	(68.10)	24	(60.96)	7 5/16	(18.57)	22 13/16	(57.94)	550	(249)
	20	(500)	27	(68.58)	30 9/16	(77.63)	24 15/16	(63.34)	8 1/16	(20.48)	25 9/16	(64.93)	650	(295)
	22	(550)	28 15/16	(73.50)	32 11/16	(83.03)	25 5/16	(64.29)	8 9/16	(21.75)	28	(71.12)	820	(372)
24	(600)	30 11/16	(77.95)	34 15/16	(88.74)	26 5/8	(67.63)	9 5/16	(23.65)	29 15/16	(76.04)	1020	(463)	
CLASS 900-V	8	(200)	13 9/16	(34.45)	15 9/16	(39.53)	20 9/16	(52.23)	6	(15.24)	12 9/16	(31.91)	130	(59)
	10	(250)	15 9/16	(39.53)	18 1/16	(45.88)	21 1/16	(53.50)	6 7/16	(16.35)	15 1/16	(38.26)	190	(86)
	12	(300)	17 13/16	(45.24)	20 9/16	(52.23)	21 11/16	(55.09)	6 15/16	(17.62)	17 9/16	(44.61)	280	(127)
	14	(350)	19 3/16	(48.74)	22 1/16	(56.04)	22 11/16	(57.63)	7 3/4	(19.69)	19 1/16	(48.42)	360	(163)
	16	(400)	22 3/8	(56.83)	26 5/16	(66.83)	24 3/4	(62.87)	9 3/16	(23.34)	22 1/16	(56.04)	560	(254)
	18	(450)	24 3/4	(62.87)	29 1/8	(73.98)	25 9/16	(64.93)	9 7/8	(25.08)	24 7/16	(62.07)	740	(336)
	20	(500)	27 3/4	(70.49)	31 15/16	(81.12)	28	(71.12)	10 1/2	(26.67)	26 15/16	(68.42)	940	(426)
	22	(550)	29 15/16	(76.04)	34 5/16	(87.15)	28 1/4	(71.76)	11 3/16	(28.42)	29 5/16	(74.45)	1190	(540)
24	(600)	31 15/16	(81.12)	36 9/16	(92.87)	29 3/8	(74.61)	12 1/8	(30.80)	31 9/16	(80.17)	1470	(667)	

Vertical Tool-less® Closures are furnished with a davit or lifting eye. For sizes 8" through 24", the davit is standard. For sizes larger than 24", the lifting eye is standard. For Pressure-Temperature, see page 3.



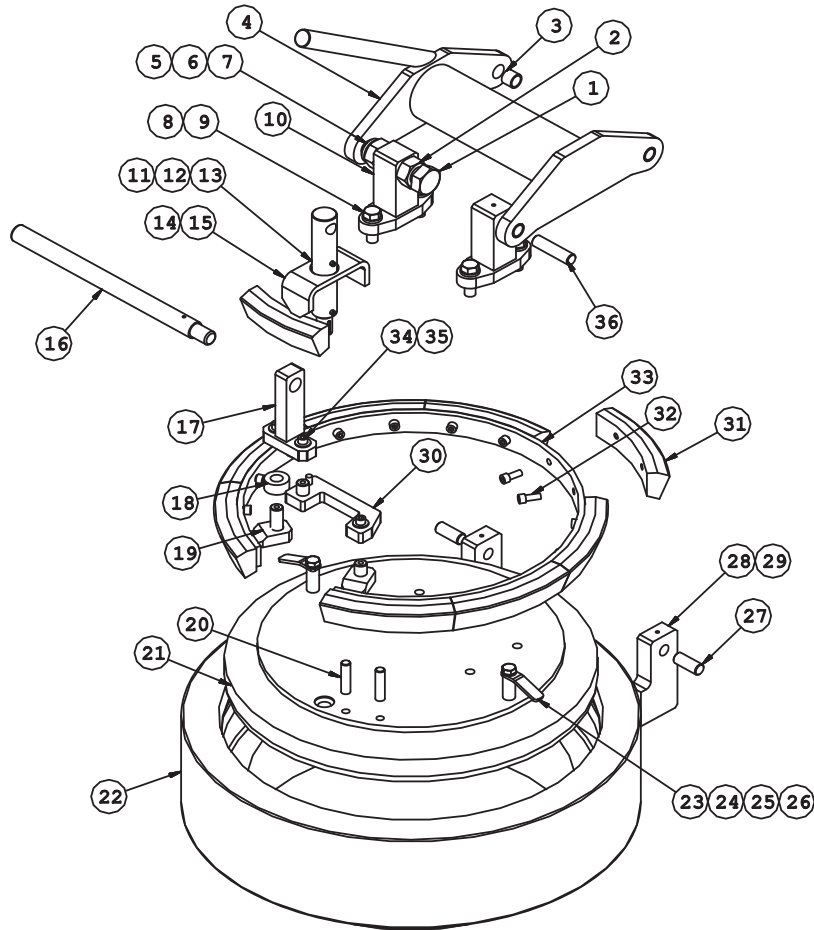
	Nominal Size		Swing Radius A		Over-all Width B		Over-all Height C		Hub Length D		Hub OD E		Approx. Weight	
	In.	(Dn)	In.	(cm)	In.	(cm)	In.	(cm)	In.	(cm)	In.	(cm)	lbs	(Kg)
CLASS 150-V & 300-V	26	(650)	26 11/16	(67.79)	30 9/16	(77.63)	12 5/16	(31.27)	8 1/16	(20.48)	30 9/16	(77.63)	790	(358)
	28	(700)	28 11/16	(72.87)	32 11/16	(83.03)	12 11/16	(32.23)	8 5/16	(21.11)	32 11/16	(83.03)	940	(426)
	30	(750)	30 3/4	(78.11)	34 7/8	(88.58)	13 1/16	(33.18)	8 11/16	(22.07)	34 7/8	(88.58)	1120	(508)
	32	(800)	32 3/4	(83.19)	37 9/16	(95.41)	14 1/2	(36.83)	9 5/8	(24.45)	37 9/16	(95.41)	1430	(649)
	34	(850)	34 3/4	(88.27)	39 11/16	(100.81)	14 3/4	(37.47)	9 7/8	(25.08)	39 11/16	(100.81)	1660	(753)
	36	(900)	36 13/16	(93.50)	41 7/8	(106.36)	14 15/16	(37.94)	10 1/8	(25.72)	41 7/8	(106.36)	1900	(862)
	38	(950)	38 13/16	(98.58)	44 3/16	(112.24)	15 11/16	(39.85)	10 3/4	(27.31)	44 3/16	(112.24)	2260	(1025)
	40	(1000)	40 3/8	(102.55)	45 13/16	(116.36)	16 9/16	(42.07)	11 5/8	(29.53)	45 13/16	(116.36)	2530	(1148)
	42	(1050)	41 7/8	(106.36)	47 7/16	(120.49)	16 5/8	(42.23)	11 11/16	(29.69)	47 7/16	(120.49)	2790	(1266)
	44	(1100)	43 15/16	(111.60)	49 3/4	(126.37)	16 15/16	(43.02)	12 1/8	(30.80)	49 3/4	(126.37)	3190	(1447)
	46	(1150)	45 15/16	(116.68)	51 15/16	(131.92)	17 1/16	(43.34)	12 5/16	(31.27)	51 15/16	(131.92)	3560	(1615)
	48	(1200)	48	(121.92)	54 7/16	(138.27)	17 7/16	(44.29)	13 1/16	(33.18)	54 7/16	(138.27)	4150	(1882)
	50	(1250)	50 1/16	(127.16)	56 5/8	(143.83)	18 1/8	(46.04)	13 5/16	(33.81)	56 5/8	(143.83)	4610	(2091)
	52	(1300)	51 9/16	(130.97)	58 1/4	(147.96)	18 11/16	(47.47)	13 15/16	(35.40)	58 1/4	(147.96)	5040	(2286)
54	(1350)	53 5/8	(136.21)	60 7/16	(153.51)	18 7/8	(47.94)	14 3/16	(36.04)	60 7/16	(153.51)	5550	(2517)	
CLASS 600-V	26	(200)	26 11/16	(67.79)	32 1/4	(81.92)	13 3/4	(34.93)	9 15/16	(25.24)	32 1/4	(81.92)	1190	(540)
	28	(201)	28 11/16	(72.87)	34 11/16	(88.11)	13 7/8	(35.24)	10 3/16	(25.88)	34 11/16	(88.11)	1440	(653)
	30	(202)	30 3/4	(78.11)	36 15/16	(93.82)	14 3/16	(36.04)	10 9/16	(26.83)	36 15/16	(93.82)	1690	(767)
	32	(203)	32 3/4	(83.19)	39 9/16	(100.49)	16 1/4	(41.28)	11 15/16	(30.32)	39 9/16	(100.49)	2160	(980)
	34	(204)	34 3/4	(88.27)	42	(106.68)	16 9/16	(42.07)	12 5/16	(31.27)	42	(106.68)	2520	(1143)
	36	(205)	36 13/16	(93.50)	44 5/16	(112.55)	17 3/8	(44.13)	13 1/4	(33.66)	44 5/16	(112.55)	2990	(1356)
	38	(206)	38 13/16	(98.58)	46 7/8	(119.06)	17 7/8	(45.40)	13 13/16	(35.08)	46 7/8	(119.06)	3540	(1606)
	40	(207)	40 3/8	(102.55)	48 9/16	(123.35)	18 1/8	(46.04)	14 1/8	(35.88)	48 9/16	(123.35)	3850	(1746)
	42	(208)	41 7/8	(106.36)	50 5/16	(127.79)	19 1/2	(49.53)	15 1/2	(39.37)	50 5/16	(127.79)	4460	(2023)
	44	(209)	43 15/16	(111.60)	52 3/4	(133.99)	19 3/4	(50.17)	15 15/16	(40.48)	52 3/4	(133.99)	5050	(2291)
	46	(210)	45 15/16	(116.68)	55	(139.70)	20 1/8	(51.12)	16 1/4	(41.28)	55	(139.70)	5620	(2549)
	48	(211)	48	(121.92)	57 13/16	(146.84)	20 7/8	(53.02)	16 1/2	(41.91)	57 13/16	(146.84)	6570	(2980)
	50	(212)	50 1/16	(127.16)	60 1/8	(152.72)	21 3/16	(53.82)	17 1/2	(44.45)	60 1/8	(152.72)	7280	(3302)
	52	(213)	51 9/16	(130.97)	61 13/16	(157.00)	22 1/2	(57.15)	18 7/8	(47.94)	61 13/16	(157.00)	8160	(3701)
54	(214)	53 5/8	(136.21)	64 1/8	(162.88)	24 5/16	(61.75)	19 1/16	(48.42)	64 1/8	(162.88)	8960	(4064)	

Vertical Tool-less® Closures are furnished with a davit or lifting eye. For sizes 8" through 24", the davit is standard. For sizes larger than 24", the lifting eye is standard. For Pressure-Temperature, see page 3.



### 12" - 72" Type "H" Tool-less® Closure Parts List

1. Hinge Bolt	11. Pressure Warning Screw	21. Door	31. Locking Segment
2. Hinge Bolt Jam Nut	12. PWS Spring Pin	22. Hub	32. Ring Segment Screw
3. Hinge Plain Bushing	13. PWS O-Ring	23. Holding Clip	33. Connecting Band
4. Hinge Beam	14. Safety Interlock Segment	24. Holding Clip Spacer	34. Actuator Screw
5. Hinge Bolt Hex Nut	15. PWS Connecting Arm	25. Holding Clip Screw	35. Actuator Screw
6. Hinge Bolt Thrust Washer	16. Crank Handle	26. Holding Clip Washer	36. Head Hinge Pin
7. Hinge Thrust Bushing	17. Crank	27. Hub Hinge Pin	37. Door Seal (Not Shown)
8. Head Hinge Arm Screw	18. Crank Spacer	28. Hub Hinge Arm	
9. Head Hinge Arm Washer	19. Actuator Ear	29. Hinge Pin Set Screw	
10. Hinge Arm	20. Ear Stop Stud	30. Actuator U-Plate	



### Spare Parts – It is suggested that the following spare parts be stocked for each closure:

Start-Up & Commissioning requires the following spares:

- 3) One\* door seal per closure.....Part No. 37
- 4) Two\* pressure warning screw O-rings per closure.....Part No. 13

Operation:

- 3) Two\* door seals per closure.....Part No. 37
- 4) Four\* pressure warning screw O-rings per closure.....Part No. 13

\*These recommendations are for normal service; spare quantities may require adjustment based on service and operating conditions.

For Spare Parts Orders, supply the following information:

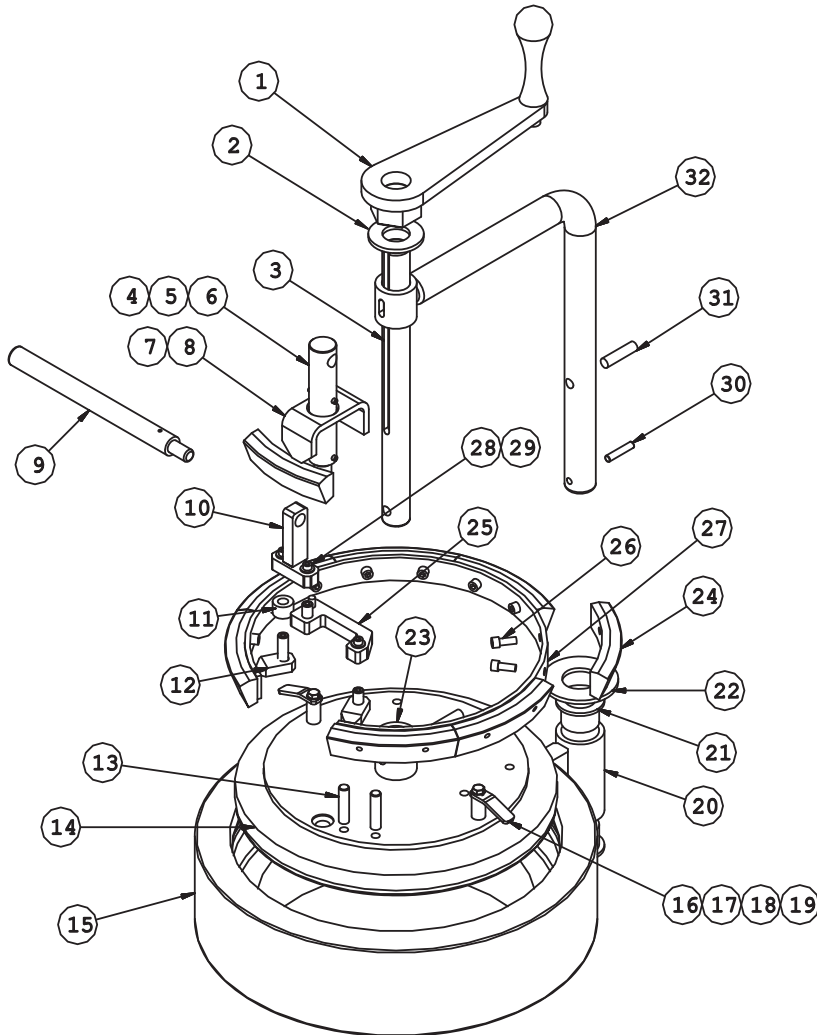
- 6) Quantity required
- 7) Description
- 8) Part number
- 9) Size and pressure class
- 10) Closure serial number

Example:

Qty: 1  
 Material: Buna-N Door Seal  
 Part No.: 37  
 Size & Class: 54" CL600  
 Serial No.: TL00273

### 8" - 24" Type "V" Tool-less® Closure Parts List

1. Wrench Handle	11. Crank Spacer	21. Davit Arm Flange Bushing	31. Davit Post Support Pin
2. Wrench Handle Washer	12. Actuator Ear	22. Davit Post Washer	32. Davit Arm
3. Davit Post	13. Ear Stop Stud	23. Davit Post Mount	33. Door Seal (Not Shown)
4. Pressure Warning Screw	14. Door	24. Locking Segment	
5. PWS Spring Pin	15. Hub	25. Actuator U-Plate	
6. PWS O-Ring	16. Holding Clip	26. Ring Segment Screw	
7. Safety Interlock Segment	17. Holding Clip Spacer	27. Connecting Band	
8. PWS Connecting Arm	18. Holding Clip Screw	28. Actuator Screw	
9. Crank Handle	19. Holding Clip Washer	29. Actuator Washer	
10. Crank	20. Davit Arm Mount	30. Davit Post Holding Pin	



Spare Parts - It is suggested that the following spare parts be stocked for each closure:

Start-Up & Commissioning requires the following spares:

- 5) One\* door seal per closure.....Part No. 33
- 6) Two\* pressure warning screw O-rings per closure.....Part No. 6

Operation:

- 5) Two\* door seals per closure.....Part No. 33
- 6) Four\* pressure warning screw O-rings per closure.....Part No. 6

\*These recommendations are for normal service; spare quantities may require adjustment based on service and operating conditions.

For Spare Parts Orders, supply the following information:

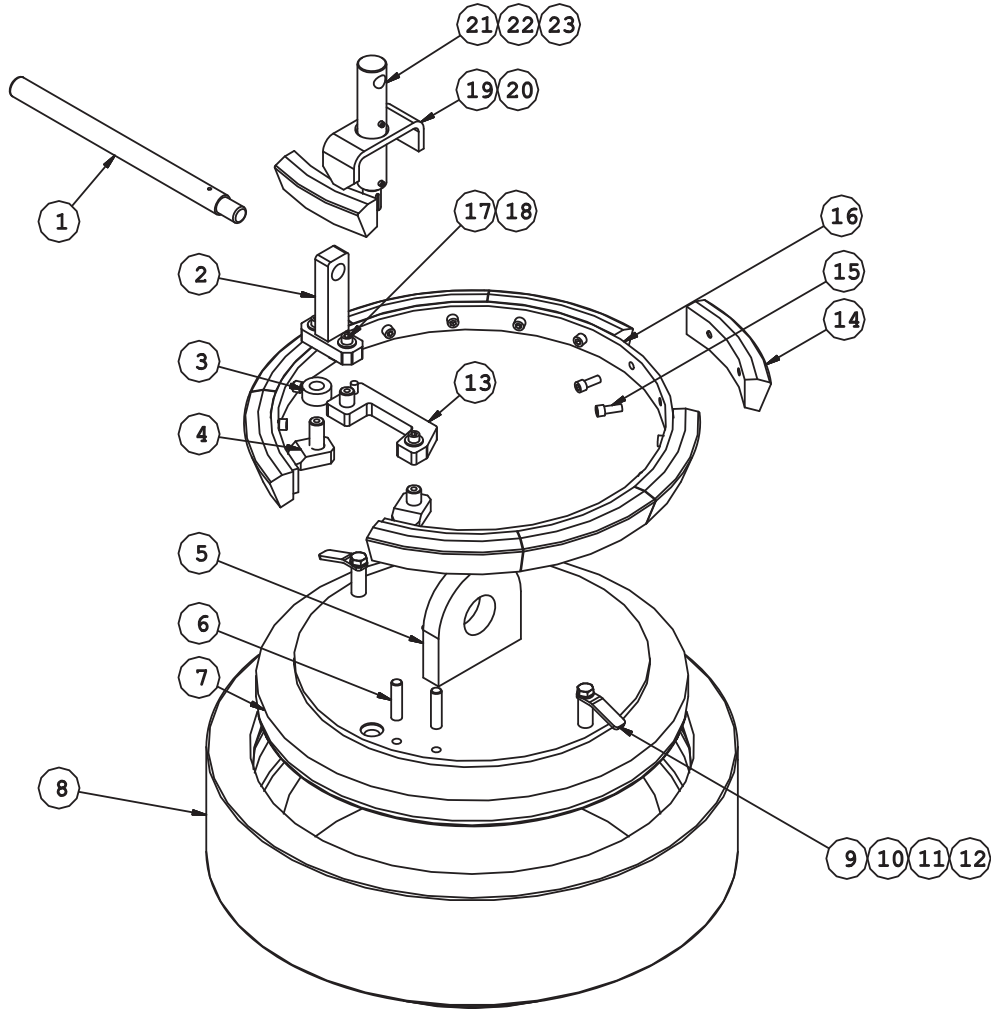
- 11) Quantity required
- 12) Description
- 13) Part number
- 14) Size and pressure class
- 15) Closure serial number

Example:

Qty: 22  
 Material: Buna-N Door Seal  
 Part No.: 33  
 Size & Class: 8" CL600  
 Serial No.: TL04025

26" - 72" Type "V" Tool-less® Closure Parts List

1. Crank Handle	11. Holding Clip Screw	21. Pressure Warning Screw
2. Crank	12. Holding Clip Washer	22. PWS O-Ring
3. Crank Spacer	13. Actuator U-Plate	23. PWS Spring Pin
4. Actuator Ear	14. Locking Segment	24. Door Seal (Not Shown)
5. Lifting Lug	15. Locking Segment Screw	
6. Ear Stop Stud	16. Connecting Band	
7. Door	17. Actuator Screw	
8. Hub	18. Actuator Washer	
9. Holding Clip	19. Safety Interlock Segment	
10. Holding Clip Spacer	20. PWS Connecting Arm	



Spares Parts - It is suggested that the following spare parts be stocked for each closure:

Start-Up & Commissioning requires the following spares:

7) One* door seal per closure.....Part No. 24	Operation:	7) Two* door seals per closure.....Part No. 24
8) Two* pressure warning screw O-rings per closure.....Part No. 22		8) Four* pressure warning screw O-rings per closure.....Part No. 22

\*These recommendations are for normal service; spare quantities may require adjustment based on service and operating conditions.

For Spare Parts Orders, supply the following information:

- 16) Quantity required
- 17) Description
- 18) Part number
- 19) Size and pressure class
- 20) Closure serial number

Example:  
 Qty: 14  
 Material: Buna-N Door Seal  
 Part No.: 24  
 Size & Class: 36" CL600  
 Serial No.: TL21890

# QUALITY CONTROL

The Tool-less® Closure is manufactured in Louisville, Kentucky, USA. The Tube Turns Division quality system meets the ASME Section VIII, Division 1, Appendix 10 standard. The quality system is audited by an independent authorized inspection agency.

The quality system controls order analysis, calibration, drawings, documents, materials, processes, welding, nondestructive examination and inspection.

Raw materials are inspected for dimensional acceptability and proper heat code identification. Mill test reports are checked to ensure proper physical and chemical properties of all pressure retaining components. Certified material test reports are shipped with each closure.

A serial number is assigned to each Tool-less® Closure at order entry and is permanently stamped on the closure.

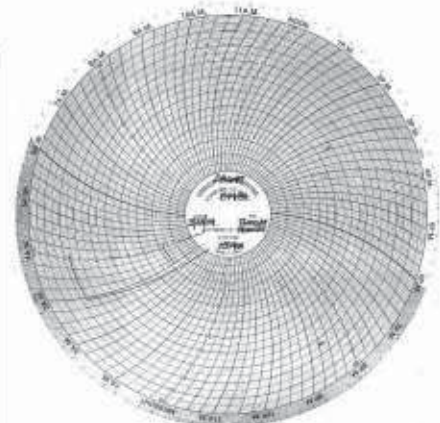
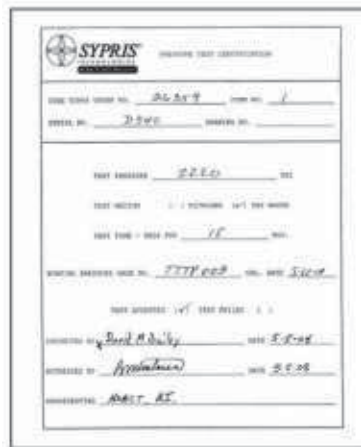
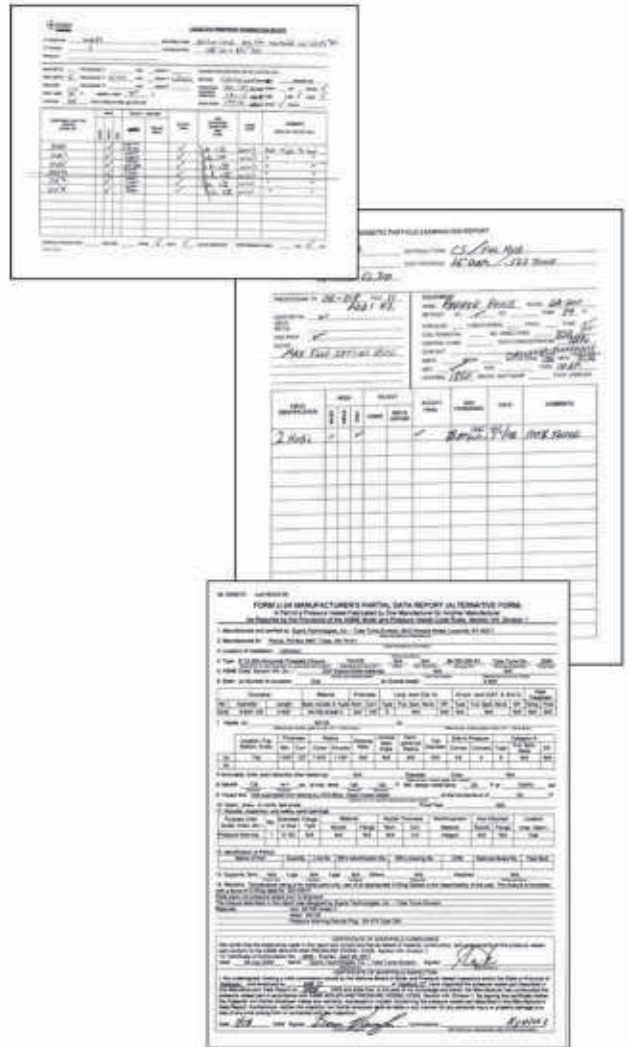
The actual heats of material used for the individual closures are permanently recorded and stamped on all pressure retaining components. This provides traceability to the material test reports for every closure.

The Tube Turns Division can meet the most stringent quality system, customer material and testing requirements. Special customer requirements are evaluated by the engineering department.

The Tube Turns Division offers optional hydrotest and helium leak test. Nondestructive examination per ASME Section V is available in-house and includes radiography, ultrasound, magnetic particle, and liquid penetrant.

When specified, the following documents are furnished for each closure

- ❖ Hydrostatic test certification
- ❖ Nondestructive test reports
- ❖ ASME code stamping available upon request



# TERMS AND CONDITIONS

1. Seller offers to sell to Buyer, or accepts Buyer's offer to purchase, on the condition that Buyer assents to the terms contained herein. Buyer's failure to provide seller with notification of any objection to these terms within a period of five days after receipt of this instrument or Buyer's acceptance of any product shipped hereunder constitutes assent by the Buyer to these terms. Seller's acceptance of Buyer's offer to purchase, or Buyer's acceptance hereof, is limited and restricted to these terms. Seller objects to and refuses to be bound by any terms additional to or different from those contained herein.

2. Prices are subject to change without notice, and all orders are to be invoiced at Seller's prices prevailing at time of shipment.

3. Any taxes which Seller may be required to pay or collect under existing or future law upon or with respect to the sale, purchase, delivery, transportation, storage, processing, use, or consumption of any of the products or services covered hereby, including all taxes upon or measured by receipts from sales or services, shall be for the account of Buyer, who shall promptly pay the amount thereof to Seller upon demand.

4. All accounts are payable in United States funds, free of exchange, collection or other charges. If Buyer fails to fulfill the terms of payment or if Seller shall have any doubt at any time as to Buyer's financial responsibility, Seller may suspend production and decline to make shipment or delivery except upon receipt of cash or security satisfactory to Seller.

5. Unless otherwise specifically provided herein, delivery will be made f.o.b. point of shipment, all risk of loss shall pass to Buyer upon delivery to carrier, and Buyer shall be responsible for obtaining insurance if desired. The method and agency of transportation and the routing, unless specified on the face hereof, will be selected by Seller, and Seller reserves the right to ship freight collect. Shipping dates are approximate and are based on prompt receipt of all necessary information.

6. Seller shall not be liable for any delay in performance due to fire, explosion, casualty, strike or other labor difficulties, shortage of material, utility, facility or labor, delay in transportation, breakdown or accident, compliance with or other action taken to carry out the intent or purpose of any law or regulation, or any cause whether similar or dissimilar beyond Seller's reasonable control, and Seller shall have such additional time for performance as may reasonably necessary under the circumstances and the right to apportion its production among its customers in any manner it sees fit.

7. Any claims for shortages, damaged products, or non-conformance of products with the order must be made in writing within ten (10) days after receipt of shipment, and Seller must be afforded an opportunity to investigate.

8. Cancellation or alteration of an order or

return of any product by Buyer may not be made without advance written consent by Seller and, at Seller's option, shall be subject to a cancellation, alteration or return charge acceptable to Seller.

9. Seller warrants that its products are free from defects in material and workmanship.

10. In the event of breach of any warranty hereunder, Seller's sole and exclusive liability shall be at its option either to repair or replace, f.o.b. point of shipment, any defective product, or to accept return, transportation prepaid, of such product and refund the purchase price; in either case provided that such product within 12 months from date of shipment to Buyer is found by Seller to have been defective at the time of such shipment, that the product has been installed and operated in accordance with generally approved practice and in accordance with Seller's instructions, that no repairs, alterations or replacements have been made by others without Seller's written approval, and that Buyer notifies Seller in writing within 15 days after the defect becomes apparent and promptly furnishes full particulars in connection therewith; and provided further that in no event shall the aggregate liability of Seller in connection with breach of any warranty or warranties exceed the purchase price paid for the products purchased hereunder. Seller, may, at its option, require the return of any product, transportation and duties prepaid, to establish any claim of defect made by Buyer. EXCEPT AS EXPRESSLY STATED IN THIS INSTRUMENT, SELLER MAKES NO WARRANTIES, EXPRESS OR IMPLIED, AND DOES NOT WARRANT THAT THE PRODUCTS SOLD HEREUNDER ARE MERCHANTABILITY OR FIT FOR ANY PARTICULAR PURPOSE.

11. Seller will defend at its own expense any suit or legal proceeding instituted against Buyer, and will pay any damages and costs awarded therein against Buyer, insofar as the same are based on a claim that any product furnished hereunder, except as excluded below, in itself constitutes an infringement of any United States patent, provided Buyer gives Seller prompt written notice of such infringement claim and of the institution of such suit or proceeding and also gives Seller all necessary authority, information and reasonable assistance to enable Seller, at Seller's option, to settle or defend the same. In case any said product is held in such suit to constitute an infringement and its use is enjoined, Seller at its own expense will either procure for Buyer the right to continue using said product, or modify same so that it becomes non-infringing, or replace it with a non-infringing product, or remove the product and refund the purchase price paid therefor by Buyer. The foregoing provisions state Seller's entire obligation and liability for patent infringement; and it is understood and agreed that there shall be excluded from the operation of said provisions any and all products

furnished in accordance with particular designs, specifications or instructions furnished or expressly or impliedly prescribed by Buyer and not customarily followed by Seller in the course of its general business, and Buyer will indemnify and hold harmless Seller from and against all loss, cost, expense, damage and liability of any nature or kind for or on account of any patented or unpatented invention or trade secret which in compliance with any such designs, specifications or instructions is embodied in any product furnished hereunder.

12. Seller shall not, except as set forth above, be otherwise liable to Buyer or to any person who shall purchase from Buyer, or use, any products supplied hereunder for damages of any kind, including, but not limited to, direct, indirect, special or consequential damages or loss of production or loss of profits resulting from any cause whatsoever, including, but not limited to, any delay, act, error or omission of Seller.

13. Technical information, recommendations and advice as to properties and usages of materials, design, installation and use of products, engineering and other matters are provided as an accommodation and are intended only as suggestions. Although they are believed to be accurate, based on Seller's best knowledge and experience, Seller assumes no obligation or liability for any results obtained in their use or application, and they are not to be construed as establishing any warranty, express or implied.

14. This agreement shall inure to the benefit of and be binding upon the successors and assigns of the parties hereto.





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For general inquiry please contact us: [tubeturns@SyprisTechnologies.com](mailto:tubeturns@SyprisTechnologies.com)



**12" Class 300H Tool-less® Closure with Pipe Extension and Weld Neck Flange**

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