

PETOL™ SlimGrip Tong

Operating Manual

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PETOL™ SlimGrip Tong Description

The PETOL™ SlimGrip Tongs were designed for making up and breaking out casing, drill pipe, down hole tools, and other tubular products with restricted gripping widths. The PETOL SlimGrip Tongs have the following specifications:

Model: SLG10

Diameter Range: 1 – 2 inches

Working Load: 1500 ft-lbs

Torque Arm Length: 18 1/4 - 18 7/8 inches

Gripping Width: 1 – 3/16 inches

Maximum Line Pull: 950 lbs

Model: SLG13

Diameter Range: 2-3/8 - 4 inches

Working Load: 5000 ft-lbs

Torque Arm Length: 32 - 34 inches

Gripping Width: 1 – 3/4 inches

Maximum Line Pull: 1760 lbs

Model: SLG15

Diameter Range: 3 3/4 - 6 1/2 inches

Working Load: 7500 ft-lbs

Torque Arm Length: 41 – 42 3/4 inches

Gripping Width: 1 – 1/4 inches

Maximum Line Pull: 2100 lbs

WARNING: Under no circumstances should the maximum working load be exceeded. Overloading may result in injury or death. Always use a load cell or other calibrated indicating device to monitor the line pull on the tong to avoid an overload.

The PETOL SlimGrip Tongs have the following features:

No adjustment needed.

Simple installation and removal of the tong from the pipe.

High strength alloy steels used throughout for long life with the toughest jobs.

Warranty

What Is Covered

GEARENCH™ tools are expressly warranted to you, the purchaser, to be free of defects in material and workmanship.

How Long Coverage Lasts

This express warranty lasts for the lifetime of the GEARENCH tool. Warranty coverage ends when the tool becomes unusable for reasons other than defects in workmanship or material.

How Can You Get Warranty Service

To obtain the benefit of this warranty, contact a GEARENCH sales representative in Clifton, Texas.
GEARENCH · 4450 South Highway 6 · P.O. Box 192 · Clifton, TX 76634

What Will We Do To Correct Problems

Warranted products will be repaired or replaced, at GEARENCH's option, and returned at no charge to you, the original purchaser; or, if after three attempts at repair or replacement during the warranty period, the product defect in material or workmanship persists, you can elect to receive a full refund of your original purchase price for the product.

What Is Not Covered

Defects, failures or conditions that are due to normal wear and tear, abuse or misuse, are not covered by this limited warranty. In addition, this limited warranty is in lieu of all other warranties, express or implied, verbal or written. To the maximum extent allowed by law GEARENCH disclaims all implied warranties, including implied warranties of merchantability and/or fitness for a particular purpose. GEARENCH also specifically denies any liability for any incidental damages and/or consequential damages, including but not limited to property damage to property other than the product itself, loss of sales profits, down time, costs or any other damages measurable in money, whether or not included in the foregoing enumeration.

Please be advised that some states do not allow the exclusion or limitation of incidental or consequential damages, so this limitation or exclusion may not apply to you. This warranty gives you specific rights, and you may also have other rights, which vary from state to state, province to province, or country to country.

Are Personal Injuries Covered

In the event you, someone working for you, or any other person sustain a personal injury as a result of using the GEARENCH tool, GEARENCH limits its potential liability for such a claim or injury to the fullest extent allowed by law, and disclaims and denies any liability for such personal injury.

Please be advised that some states do not allow the exclusion or limitation of liability for personal injuries, so the above limitation or exclusion may not apply to you, or the individual claiming injury.

No Other Express Warranty Applies

This GEARENCH LIMITED WARRANTY is the sole and exclusive warranty, express or implied for GEARENCH products. No employee, agent, dealer or other person is authorized to alter, modify, expand or reduce the terms of this warranty or to make any other warranty on behalf of GEARENCH.

Law Applicable

All matters related to the sale and/or use of the GEARENCH tool that is the subject of this limited warranty, along with the construction and enforcement of the terms of this limited warranty itself, shall be subject to the substantive and procedural laws of the state of Texas, not the conflicts of laws provisions of Texas, but rather the laws of Texas themselves.

Forum Selection Clause

Any dispute arising out of the sale and/or use of the GEARENCH tool that is the subject of this limited warranty shall be presented in the form of a claim or lawsuit to the offices of GEARENCH in Clifton, Bosque County, Texas. No claim or suit may be brought against GEARENCH, arising out of the sale and/or use of the tool, or arising out of the terms of this warranty, except in such forum. Purchase and/or use of the GEARENCH tool makes you subject to the benefits and limitations of this limited warranty. Accordingly, any writ, judgment or other enforcement, obtained from a jurisdiction, county, parish, state or federal court or other country, other than that from the forum identified above, shall be void and unenforceable against GEARENCH.

Arbitration Clause

In the event of dispute or claim arises out of the sale and/or use of the GEARENCH tool that is the subject of this limited warranty, or arises out of the interpretation or enforcement of the terms and conditions of this limited warranty, such dispute shall be submitted to binding arbitration pursuant to the rules of the American Arbitration Association. If required to accomplish the purpose of this Arbitration clause, the purchaser hereby expressly waives any right to demand trial by jury.

Complete Agreement

This express limited warranty contains the entire agreement regarding express or implied warranties related to the GEARENCH tool that is the subject of it. No writing or language contained in the purchase order or any other document of the purchaser, or invoice of GEARENCH or any intermediate seller, shall be construed as modifying, in any way, the rights and liabilities contained in this limited warranty. GEARENCH expressly disclaims any obligations expressed in any customer purchase order or document that are contrary to the terms and limitations of this warranty.

Severability

If any term or limitation contained in this limited warranty is deemed unenforceable by law, then the term shall be severed from the remaining portions of the limited warranty which shall remain enforceable.

All communications to GEARENCH regarding the use of the tool and any aspect of the sale of the tool of this limited warranty should be addressed to GEARENCH.

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Safe Practices and Procedures

Responsibility

"It is the responsibility of the employer to train the employee in the proper selection and usage of tools, chains, etc., and to ensure that they are selected and used in that manner. In many instances, injury results because it is assumed that anybody knows how to use common hand tools. Observations and the record show that this is not the case. A part of every job instruction program should therefore be detailed training in the proper use of hand tools (and of all other special tools and equipment needed to accomplish the job)." - (Source: National Safety Council)

"Employers are responsible for the safe condition of tools and equipment used by employees, including tools and equipment which may be furnished by employees." - (Source: OSHA 1910.242A)

Replacement Parts

Use only PETOL™ replacement parts - no other parts are of comparable strength, quality and interchangeability.

Safety

While we pride ourselves on the quality and dependability we build into GEARENCH™ tools and products, we caution users that it is only prudent to know and follow the simple rules of safety when using our products, or anyone else's.

Always follow safe practices and procedures in accordance with the recommendations of OSHA, The National Safety Council (NSC), The Hand Tools Institute (HTI), The National Association of Chain Manufacturers (NACM), The International Association of Drilling Contractors (IADC), Etc. All applicable Governmental rules, regulations or restrictions, now in effect or which may be promulgated, take precedence over the suggestions in this publication. The information in this publication is designed to supplement standard safe practices and procedures, not in lieu of, or replacement thereof.

Safe Practices

(Source: The National Safety Council)

Failure to observe one or more of the following five safe practices accounts for most hand and powered tool accidents:

1. ALWAYS WEAR SAFETY GOGGLES TO PROTECT EYES
2. SELECT THE RIGHT TOOL FOR THE JOB
3. KEEP TOOLS IN GOOD CONDITION
4. USE TOOLS CORRECTLY
5. KEEP TOOLS IN A SAFE PLACE

Safety Goggles must always be worn by persons in any area where hand and powered tools are being used.

Never apply excess leverage to a wrench or tool by means of a "Cheater Bar". Never strike wrenches and tools with hammers or other objects.

All tools should be kept clean, inspected on a regular basis, and replaced when they show signs of wear.

Be especially careful not to place yourself in a position that could result in bodily injury in the event of a failure. Brace yourself firmly and pull rather than push when wrenching. (If necessary to push, do so with the flat of the hand rather than gripping around the wrench.)

Never stand under or near loads being hoisted off the ground.

READ SAFE PRACTICES AND PROCEDURES MANUAL, CATALOG INFORMATION AND PRODUCT LABELING PRIOR TO OPERATION.

Spinning and drill pipe chain, cathead chain, and the PETOL™ Connecting Link attachment are designed for the specific purpose for which the name indicates. Chains and attachments that are to be used for any other purpose should be selected in accordance with the recommendations of ASTM, NACM, Rigger's Handbook, and the commercial chain manufacturer's technical manuals.

Safety Sources and Publications

In the interest of Safety the following sources of Safety information is furnished:

The Hand Tools Institute (HTI)
25 North Broadway
Tarrytown, New York 10591
(914) 332-0040
www.hti.org

The National Safety Council (NSC)
1121 Spring Lake Drive
Itasca, Illinois 60143-3201
(630) 285-1121
www.nsc.org

International Safety Council
1121 Spring Lake Drive
Itasca, Illinois 60143-3201
(630) 285-1121

Responsibility of Distributors

IT IS THE RESPONSIBILITY OF THE PURCHASERS OF GEARENCH PRODUCTS TO CONVEY THE INFORMATION IN THIS PUBLICATION AND ANY OTHER INFORMATION RELATING TO THE INDIVIDUAL PRODUCT, THROUGH THE CHANNELS OF DISTRIBUTION, DOWN TO AND INCLUDING THE INDIVIDUAL USING THE PRODUCT

NOTE:

In view of the fact that the actual use determines whether safety requirements have been met, the ultimate responsibility to comply rests with the end user.

The service life of leaf chains can be altered by a variety of adverse operating conditions. The following information discusses the most important of these conditions for consideration when operating or scheduling replacement of leaf chain systems.

Overloading / Shock Loads / Side Loading

Attempting to “inch loads which are beyond the rated capacity of the tool.

Striking the tool with a hammer or other object while force is being exerted in an attempt to loosen a “frozen” joint.

Side pull can be caused by pulling or pushing on the tong in a direction that is not along a perpendicular plane, unlevelled mounting of the tong, inadequate support of the part being broken out, and improper seating of the part being broken out in the ton. Improper seating will occur when the diameter of the part is not consistent within the width of the tong jaw.

Environmental Conditions

Tongs operate in widely varying environments, from wet outdoor conditions to mildly or highly corrosive industrial atmospheres. They can also be exposed to abrasives such as sand or grit.

The possible effects include:

Moisture - Corrosion and rust reduce strength by causing pitting and cracking.

Temperature - Very cold temperatures reduce strength by embrittlement.

Chemical Solutions or Vapors - Corrosive attack of components' grain structure and/or the mechanical connections between the components (crevice corrosion) may occur. Cracking often is microscopic. Propagation to complete failure can be eventual or sudden.

Abrasives - Accelerated wearing and scoring of the articulating members may occur, with a corresponding reduction in strength.

These conditions, when coupled with normal wear, can result in environmentally assisted failure. It is impossible to predict life under complex conditions, as the degree of hostility and its effects are dependent on many variables such as temperature, time of exposure, concentration of corrosive atmosphere or medium, degree of abrasive wear, etc. Establishing the degree and frequency of unpredictable dynamic loading is also difficult.

Safety Precautions

1. Always wear safety goggles to protect eyes.
2. Select the right tool for the job.
3. Keep tools in good condition.
4. Use tools correctly.
5. Keep tools in a safe place.
6. Wear protective clothing, gloves and safety shoes as appropriate.
7. Use lengths of assembled chain. Do not build lengths from individual components.
8. Do not attempt to rework damaged chain by replacing only the components obviously faulty. The entire chain may be compromised and should be discarded.
9. Never electroplate assembled leaf chains or components. Plating will result in failure from hydrogen embrittlement.
10. Do not weld any chain or component. Welding spatter should never be allowed to come into contact with chain or components.
11. Leaf chains are manufactured exclusively from heat-treated steels and therefore must not be annealed. If heating a chain with a cutting torch is absolutely necessary for removal, the chain should not be reused.
12. Inspect chains frequently and regularly for link plate cracking, pin turning, pin protrusion and corrosion.
13. Use only PETOL™ & TITAN™ replacement parts to ensure proper strength.

Operation

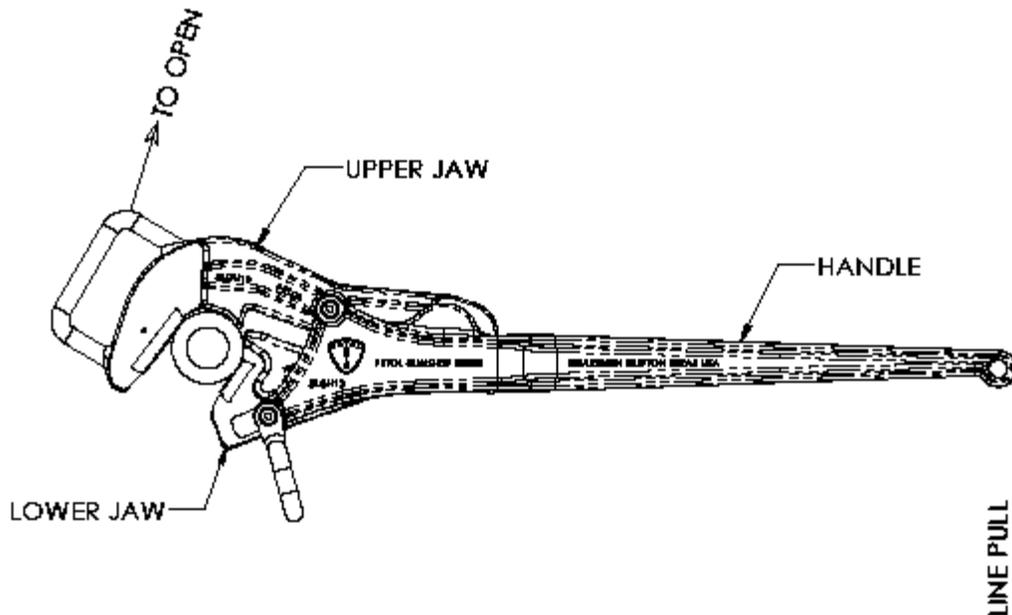
The PETOL™ SlimGrip Tong may be used in any orientation. Push the tong onto the pipe to latch. No adjustment is needed for various diameters. Position the tong with the pipe as far back on the jaws as possible.

The tong may be pulled by hand, hydraulic cylinder, overhead hoist, cable, or any other means provided that the load is monitored to prevent overloading.

WARNING: Never use a cheater or any other means to extend the handle length.

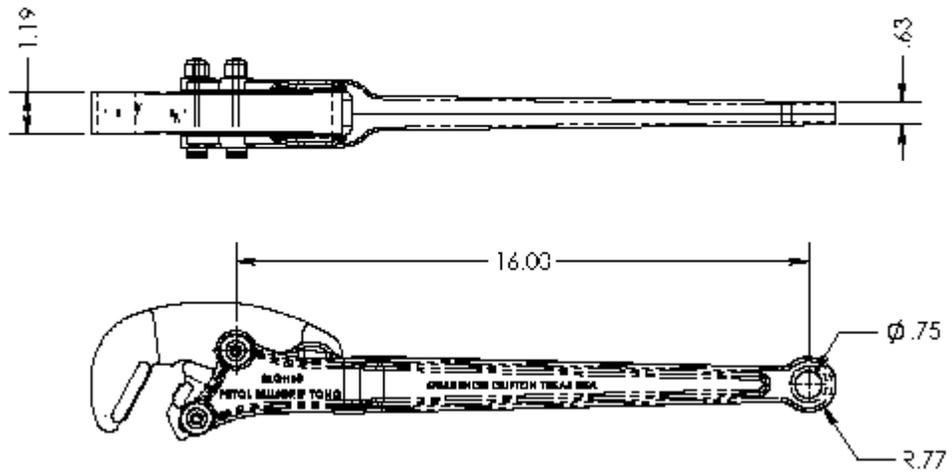
WARNING: Under no circumstances should the maximum working load be exceeded. Overloading may result in injury or death. Always use a load cell or other calibrated indicating device to monitor the line pull on the tong to avoid an overload.

The tong will exert torque in the direction shown. The tong will ratchet when moved in a direction opposite to the line pull. Ratcheting is used when the tong must be pulled more than once to completely makeup or breakout the connection.

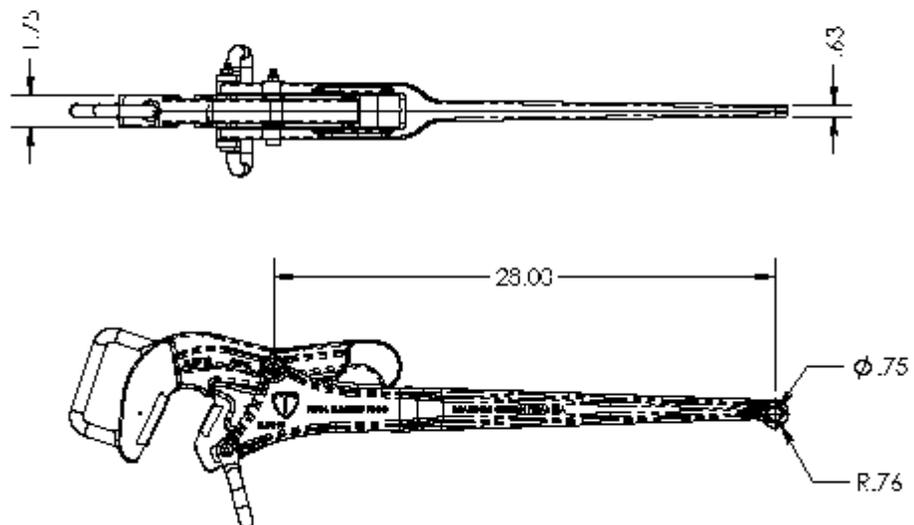


To remove the tong from the pipe, simply open the tong by pulling on the upper jaw as shown in the diagram above.

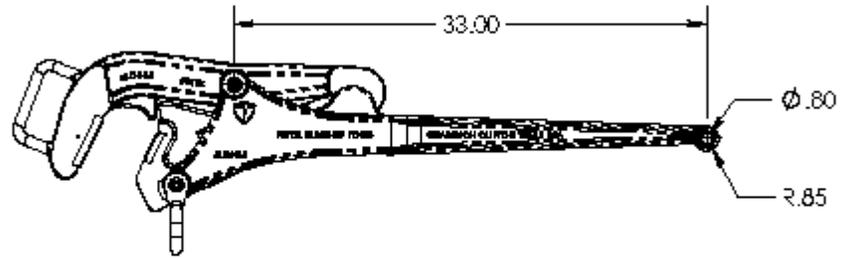
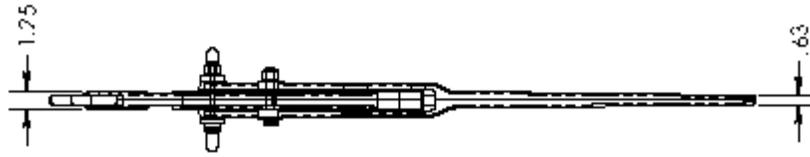
SLG10 Dimensions



SLG13 Dimensions



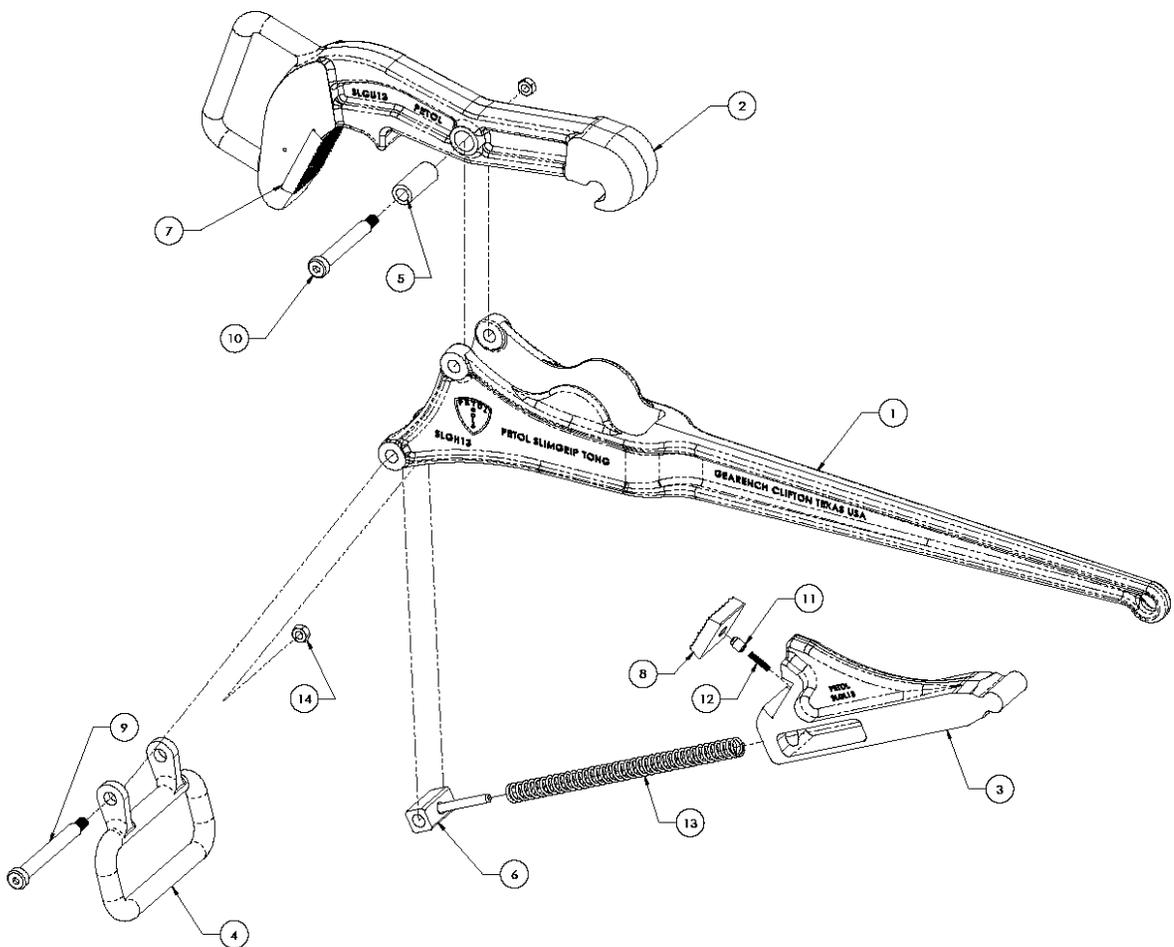
SLG15 Dimensions



Parts List

The following drawings, diagrams, and parts lists describe all parts, which may be needed as replacement items.

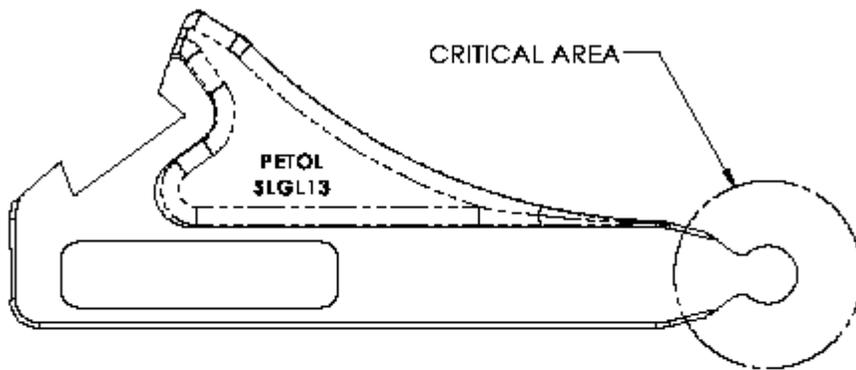
All tong components are manufactured only by GEARENCH™. DO NOT ATTEMPT TO SUBSTITUTE THESE COMPONENTS. The tong will not work properly unless these components are matched to the specific application. Consult our factory as your requirements change. Any non-GEARENCH substitutions of these components void all warranties and subject the user to assumption of liabilities resulting from subsequent use.



PARTS LIST					
ITEM	QTY.	DESCRIPTION	PART NUMBER		
			SLG10	SLG13	SLG15
1	1	Handle	SLGH10	SLGH13	SLGH15
2	1	Upper Jaw	SLGU10	SLGU13	SLGU15
3	1	Lower Jaw	SLGL10	SLGL13	SLGL15
4	1	Grip	N/A	SLGN13-F	SLGN15-F
5	1	Upper Bushing	HU21	HU13	HU15
6	1	Lower Bushing	HU22	HU14	HU16
7	1	Upper Insert	HI36D	HI32D	HI35D
8	1	Lower Insert	HI37D	HI33D	HI04D
9	1	Lower Bolt	HB68	HB15	HB43
10	1	Upper Bolt	HB68	HB16	HB34
11	2	insert Key	HXS073	HP902	HP902
12	2	Insert Key Spring	N/A	HS20SS	HS20SS
13	1	Lower Jaw Spring	HS10	HS36	HS35
14	2	Locking Nut	HSN010	HXN065	HXN069

Non-Destructive Evaluation

The figure below indicates the critical areas of the lower jaw. A critical area is defined as an area with no indications of a major dimension greater than 1/8" and no weld repairs are permitted. There are no critical areas on the handle and grip that meet these criteria. There are no non-critical areas on all other components.



Weld Repairs

This procedure is to be followed for minor repairs of indications in heat treated alloy steels. A weld repair shall be considered minor when the depth of the cavity does not exceed 50% of the actual wall thickness or 1 inch, whichever is smaller, or when the extent of the cavity does not exceed approximately 5 square inches. Major weld repairs must be performed by GEARENCH™ or an approved repair center using appropriate procedures followed by full heat treatment or by replacing the component.

Application:

This procedure applies to steel castings, forgings and, wrought with carbon content between 0.15% and 0.31%.

Weld preparation:

The crack indication is to be removed by carbon arc gouging, grinding, or machining until all indication is removed. Magnetic particle inspection shall be used to verify that the crack indication has been removed.

Filler material and process:

Repairs made with the FCAW process shall use a filler material of class E120T5-K4 or equivalent with CO₂ shielding gas. Repairs made with the SMAW process shall use a filler material of type E-12018-M. All welding is to be performed by a qualified welder.

Preheat:

Preheat the weld area to 300°F minimum.

Interpass temperature:

The interpass temperature is to be 600°F maximum. All weld slag to be removed prior to application of additional layers by chipping, grinding or wire brushing. Do not peen the weld repair.

Post weld heat treatment:

Do not allow weld to cool below 300°F before stress relief. Post heat immediately after welding to 1010 - 1040°F for 1 hour per inch of thickness, 2 hours minimum at temperature. Water quench after stress relief.

Weld blending and inspection:

The weld is to be ground flush with the adjacent parent material. The weld is to be inspected by magnetic particle to verify that the weld area is free of all crack indications.