



Issued by Department

Revision

Page

FRFRA/IA

A

1/ 10

Customer

Plant

ABB Contract No.

Customer Contract No.

## MANUAL AND MAINTENANCE INSTRUCTION

### LIPS for PIG

### 4" SCH10AC



A	14/09/2020	First issue	A. CAILLOT	C. PIERCE	Th. DELECLUSE	
Rev. Etat/ Status	Date	Objet de la révision / Description of the modification	ABB PI Cellier Etabli par / Written by	ABB PI Cellier Vérifié par / Checked by Date/Visa	ABB PI Cellier Approuvé par / Approved by Date/Visa	Client/Customer Approuvé par / Approved by Date/Visa

Ce document est la propriété exclusive de ABB France Division Process Automation Activité Cellier. Il est interdit d'en faire usage ou de le communiquer sans autorisation préalable.  
This document belongs to ABB France Division Process Automation Activity Cellier. It is prohibited to use or transmit it without our prior consent.



Issued by Department

Revision

Page

FRFRA/IA

A

2/ 10

Customer


Plant

ABB Contract No.

Customer Contract No.

1	A								60										119									
2	A								61										120									
3	A								62										121									
4	A								63										122									
5	A								64										123									
6	A								65										124									
7	A								66										125									
8	A								67										126									
9	A								68										127									
10	A								69										128									
11									70										129									
12									71										130									
13									72										131									
14									73										132									
15									74										133									
16									75										134									
17									76										135									
18									77										136									
19									78										137									
20									79										138									
21									80										139									
22									81										140									
23									82										141									
24									83										142									
25									84										143									
26									85										144									
27									86										145									
28									87										146									
29									88										147									
30									89										148									
31									90										149									
32									91										150									
33									92										151									
34									93										152									
35									94										153									
36									95										154									
37									96										155									
38									97										156									
39									98										157									
40									99										158									
41									100										159									
42									101										160									
43									102										161									
44									103										162									
45									104										163									
46									105										164									
47									106										165									
48									107										166									
49									108										167									
50									109										168									
51									110										169									
52									111										170									
53									112										171									
54									113										172									
55									114										173									
56									115										174									
57									116										175									
58									117										176									
59									118										177									

☐ Seules les pages révisées font l'objet de l'émission de référence. Only the revised pages are sent with the last issue to date.

	<b>ABB France Division Industrial Automation Cellier Activity</b>	<b>4JFR000001A0024</b>	
Issued by Department	Revision	Page	
<b>FRFRA/IA</b>	<b>A</b>	<b>3/ 10</b>	
Customer	Plant	ABB Contract No.	Customer Contract No.

## **CONTENTS**

<b>1.</b>	<b>FOREWORD .....</b>	<b>4</b>
1.1	CONFORMITY.....	4
<b>2.</b>	<b>AFTER-SALES SERVICE .....</b>	<b>4</b>
2.1	PRODUCTS HANDLED BY THE EQUIPMENT .....	4
2.2	PIGGED LINES .....	5
2.3	GUARANTEE .....	5
<b>3.</b>	<b>TECHNICAL DATA.....</b>	<b>5</b>
<b>4.</b>	<b>MAINTENANCE.....</b>	<b>6</b>
<b>5.</b>	<b>PIG SIZE .....</b>	<b>6</b>
<b>6.</b>	<b>PIG DAMAGE .....</b>	<b>6</b>
<b>7.</b>	<b>PIG STORAGE .....</b>	<b>7</b>
<b>8.</b>	<b>AIR PRESSURES.....</b>	<b>7</b>
<b>9.</b>	<b>TYPICAL PROBLEMS WITH THE BUILD OF A PIGGED LINE .....</b>	<b>7</b>
9.1	INTERNAL WELDS NOT SMOOTHED .....	7
9.2	PIPE JOINING.....	7
9.3	ROUGH INTERNAL PIPE FINISH .....	8
9.4	FLANGES NOT PROPERLY LINED UP .....	8
9.5	PIPE SUPPORTS.....	8
<b>10.</b>	<b>REFERENCE DOCUMENTS .....</b>	<b>8</b>
<b>11.</b>	<b>DATASHEET PIG .....</b>	<b>9</b>
<b>12.</b>	<b>PIG INSPECTION SHEET .....</b>	<b>10</b>

<b>ABB</b>	<b>ABB France Division Industrial Automation Cellier Activity</b>	<b>4JFR000001A0024</b>	
Issued by Department <b>FRFRA/IA</b>		Revision <b>A</b>	Page <b>4/ 10</b>
Customer	Plant	ABB Contract No.	Customer Contract No.

## 1. FOREWORD

### 1.1 CONFORMITY

You have purchased an ABB France I.A. Cellier Activity product.

This operating manual provides the operator with appropriate instructions for safe and correct operation and to facilitate the maintenance. This manual must have been read and understood by every individual given the task of transporting, installing, commissioning, maintaining operating and repairing the equipment and be available to the operating personal at all times.

## 2. AFTER-SALES SERVICE

Our after-sales service will provide you with all technical information on ABB France I.A. Cellier Activity products and their applications. Should you have any questions regarding our products, please contact :

**ABB France**  
**Division Industrial Automation– Cellier Activity**  
**Service Après-Vente produits**  
**Parc d'Activités des Combaruches**  
**73100 Aix Les Bains**  
**Email : fr-aix\_sp@abb.com**  
**Tel : +33 (0) 479350565**  
**Fax : +33 (0) 479883771**

### 2.1 PRODUCTS HANDLED BY THE EQUIPMENT


The equipment has been designed to handle certain products. Typically these products are :

- Petroleum oils and additives.
- Paints.
- Water.



The transfer of any products other than those defined above can be harmful to users or to the equipment (solvent with a low flash point, overheated products, aggressive/corrosive products etc....)

In case of doubt, contact ABB France I.A. Cellier Activity.

	<b>ABB France Division Industrial Automation Cellier Activity</b>	<b>4JFR000001A0024</b>	
Issued by Department <b>FRFRA/IA</b>	Revision <b>A</b>	Page <b>5/ 10</b>	
Customer	Plant	ABB Contract No.	Customer Contract No.

## 2.2 PIGGED LINES

The equipment has been designed for ABB pigged lines.



The equipment can be used in other makes of pigged line **but the following items must be carefully checked :**

- The internal diameter of the pigged line,
- The pigged lancer/receiver and pigged valves used on the pigged line,
- The instrumentation of the pigged line,
- The construction method of the pigged line (no penetrating welds and no internal sharp edges),
- The assembly method of the pigged line and the pipe (flange and pipe connections perfectly aligned),
- The piping and equipment supports,
- The pig detection method and equipment.

## 2.3 GUARANTEE

ABB Cellier assume no liability for damage or malfunctions resulting from failure to comply with the installation, operating or maintenance instructions.

Parts subject to wear are not guaranteed.

Guarantee claims must be made by quoting ABB Cellier order number immediately on detecting the defect and within the scope of warranty obligations mentioned in the purchase contract.

The guarantee does not cover damage resulting directly or indirectly from :

- Inappropriate use.
- Non-compliance with our storage instructions.
- Faulty equipment or facilities connected to the product.
- Vibrations generated by external units (sample : pumps) and transmitted to the product.
- Incorrect cables and wiring.
- Use of non-genuine spare parts and accessories from ABB France I.A. Cellier Activity.
- Modification of our product without prior written approval from ABB France I.A. Cellier Activity.

## 3. TECHNICAL DATA

These operating instructions concern the following ranges of pig :

- Either monobloc, requiring in this case the complete replacement of the pig (mainly 2"),
- Dismountable, requiring the replacement of only the lips after the dismantling of the pig.

General technical data regarding the pig can be found in the following attached documents :

- Data sheet n° C48003763.

<b>ABB</b>	<b>ABB France Division Industrial Automation Cellier Activity</b>	<b>4JFR000001A0024</b>	
Issued by Department <b>FRFRA/IA</b>	Revision <b>A</b>	Page <b>6/ 10</b>	
Customer	Plant	ABB Contract No.	Customer Contract No.

## 4. MAINTENANCE

In all cases preventive maintenance is necessary with the pig replacement. It will be more difficult to replace a damaged or too worn pig than a normally worn pig. The pig lifetime is specific to each installation. The pig replacement periodicity can be defined after a few months operation by frequently checking during this period (say once every two weeks) the state of wear of the pig lips. The attached sheet can be used to record the findings line by line.

It is also possible to observe signs which indicate that a pig is worn such as :

- Pig detections in launching/receiving stations are not stable during product pumping. ABB Cellier programmed control systems give warnings if this happens during an automatic sequence.
- Pigs can be sucked out of the launching station by the product. ABB Cellier programmed control systems give warnings if this happens during an automatic sequence.
- Demisters become full of product more quickly. This can also be observed by regularly monitoring the levels in the demisters and noting the frequency with which the emptying is necessary.
- Pig sequences take longer. ABB Cellier programmed control systems give warnings if the pigging operation is too long.


## 5. PIG SIZE

The following table can be used to determine if a worn pig can be re-used or if the pig / lips need to be replaced.

ABB reference / Item code	Nominal pipe size		Nominal internal pipe diameter (mm)	Minimum recommended external lip diameter (mm)
4JFR000001A0023	4"	<b>SCH10AC</b>	107,1	108,6

## 6. PIG DAMAGE

A normally worn pig lip will show even signs of wear on the whole circumference and the tip of the lip will be point and not flat as for a brand new pig lip. However if the lips is cut, split or has lumps missing then this is a sign that something is wrong with the build of the line (if the pigs are always in this condition when changed) or that an incident has happened during the pig operation which has led to the lips being damaged.

	<b>ABB France Division Industrial Automation Cellier Activity</b>	<b>4JFR000001A0024</b>	
Issued by Department <b>FRFRA/IA</b>		Revision <b>A</b>	Page <b>7/ 10</b>
Customer	Plant	ABB Contract No.	Customer Contract No.

## 7. PIG STORAGE

The mechanical characteristics of pig material (lips and bodies) can be adversely affected if stored for a long time (more than 6 months) in humid conditions

Storage under the following conditions will help to eliminate such effects and the resulting reduction in their working life :

- Stored in sealed, opaque bags, anti UV with humidity absorber.
- Labelled with the delivery date.
- Temperature between 15°C and 35°C.
- Out of direct light.
- Inside.

## 8. AIR PRESSURES

The air pressure used for pigging can sometimes be the cause of damage if it is set too high. The pressure is set using a manual pressure regulator on the air supply line to each launching and receiving station. It can be necessary to increase the pressure in case a pig becomes blocked but the pressure must always be reduced to a suitable operating pressure. The actual required pressure depends greatly on the line configuration and the products pigged. If the pressure is set too high then the pigs will travel very fast in an empty line condition (pig positioning or at the end of transfers for example). A high pressure will also increase the compressed air consumption and increase may result in increased cycle times as the decompression time will be longer.

Normal operating pressures are between 2 to 4 bars.


## 9. TYPICAL PROBLEMS WITH THE BUILD OF A PIGGED LINE

### 9.1 INTERNAL WELDS NOT SMOOTHED

After welding a flange onto the pipe it is necessary to grind the internal weld bead to a smooth finish at the same internal diameter as the pipe. This will prevent pig lip damage as the pig passes over the weld. This cause is usually found immediately after construction during the commissioning phase and is not a cause of sudden damage after a period of satisfactory operation.

### 9.2 PIPE JOINING

Pipe joining is done using the sleeve junction method with no penetration welding, to ensure that the pipe junction will not cause damage to the pigs. If the internal edges of the pipes at the cut end are not deburred and rounded off then the pig lips will be damaged. If the pipes are not spot welded face to face but with a gap then this could also cause the pig lips to be damaged. If the internal pipe diameter tolerances are not tight enough then two adjacent lengths of pipe could have different internal diameters meaning that a smooth transition from one pipe to another is not possible and consequently the lips will be damaged. This cause is usually found immediately after construction during the commissioning phase and is not a cause of sudden damage after a period of satisfactory operation.

	<b>ABB France Division Industrial Automation Cellier Activity</b>	<b>4JFR000001A0024</b>	
Issued by Department	Revision	Page	
<b>FRFRA/IA</b>	<b>A</b>	<b>8/ 10</b>	
Customer	Plant	ABB Contract No.	Customer Contract No.

### 9.3 ROUGH INTERNAL PIPE FINISH

Not all pipe specifications require the same smooth internal finish as used for pigged lines. The use of such pipes could lead to abnormally fast wearing out of pig lips. The same is true if the pipes have been poorly protected during the storage/construction phase. The pipes delivered must come with protective end caps and are internally oiled before packing. They should be kept in this condition up until the moment they are required for construction and as far as possible stored in a covered/protected area.

### 9.4 FLANGES NOT PROPERLY LINED UP

When making flanged connections on a pigged line two (2" & 3" lines) or four (4" & 6" lines) centering pins are installed. These pins ensure that the flange bores are lined up so that the pig passage is smooth and it does not come up against a shoulder. Flange connections are used when installing pig stations or valves in a pigged line. Depending on the installation method the centering pins could have been removed and replaced by normal bolts. If this is the case then it is necessary to make sure that M16 bolts have been used for 2", 3" & 4" lines and M20 bolts have been used for 6" lines, to check the flange to flange line up and to check that the bolts are tight. Periodic flange tightness checks should be performed (every two to three months).

### 9.5 PIPE SUPPORTS

Due to the pigging process and the vibrations caused by the movement of pigs, especially through the bends, it is important that the pipe supports are frequent enough and correctly installed. If this is not the case then the shocks resulting from pig movement and loose pipes could cause the flange connections to come loose and, in extreme circumstances, the pipes to be damaged. A damaged pipe, with a dent for example could cause the pig lip to be damaged. Periodic support fixing checks should be performed (every two to three months).

## 10. REFERENCE DOCUMENTS

- C48003763 : Datasheet Pig
- Pig Inspection Sheet.





## 11. DATASHEET PIG

1	2	3	4	5	6	7	8																																																																																																																																																										
				<table border="1"><thead><tr><th>NPS</th><th>ND / DN</th><th>PIPE / TUBE</th><th>SCH</th><th>ØA</th><th>B</th><th>C</th><th>D</th><th>Weight / Poids Kg</th></tr></thead><tbody><tr><td>2"</td><td>50</td><td>STEEL / ACIER</td><td>10</td><td>57</td><td>74</td><td>51</td><td>5</td><td>0,180</td></tr><tr><td>2"</td><td>50</td><td>STEEL / ACIER</td><td>40</td><td>55</td><td>74</td><td>51</td><td>5</td><td>0,180</td></tr><tr><td>2"</td><td>50</td><td>S.S. / INOX</td><td>10</td><td>57</td><td>74</td><td>51</td><td>5</td><td>0,180</td></tr><tr><td>3"</td><td>80</td><td>STEEL / ACIER</td><td>10</td><td>87</td><td>105</td><td>69</td><td>7</td><td>0,600</td></tr><tr><td>3"</td><td>80</td><td>STEEL / ACIER</td><td>40</td><td>82</td><td>105</td><td>69</td><td>7</td><td>0,600</td></tr><tr><td>3"</td><td>80</td><td>S.S. / INOX</td><td>10</td><td>87</td><td>105</td><td>69</td><td>7</td><td>0,600</td></tr><tr><td>4"</td><td>100</td><td>STEEL / ACIER</td><td>10</td><td>112</td><td>140</td><td>90</td><td>8</td><td>1,200</td></tr><tr><td>4"</td><td>100</td><td>STEEL / ACIER</td><td>40</td><td>107</td><td>140</td><td>90</td><td>8</td><td>1,200</td></tr><tr><td>4"</td><td>100</td><td>S.S. / INOX</td><td>10</td><td>113</td><td>140</td><td>90</td><td>8</td><td>1,200</td></tr><tr><td>5"</td><td>125</td><td>STEEL / ACIER</td><td>10</td><td>137</td><td>200</td><td>115</td><td>12</td><td>3,000</td></tr><tr><td>5"</td><td>125</td><td>STEEL / ACIER</td><td>40</td><td>133</td><td>200</td><td>115</td><td>12</td><td>3,000</td></tr><tr><td>5"</td><td>125</td><td>S.S. / INOX</td><td>10</td><td>140</td><td>200</td><td>115</td><td>12</td><td>3,000</td></tr><tr><td>6"</td><td>150</td><td>STEEL / ACIER</td><td>10</td><td>165</td><td>210</td><td>126</td><td>12</td><td>4,140</td></tr><tr><td>6"</td><td>150</td><td>STEEL / ACIER</td><td>40</td><td>160</td><td>210</td><td>126</td><td>12</td><td>4,140</td></tr><tr><td>6"</td><td>150</td><td>S.S. / INOX</td><td>10</td><td>167,5</td><td>210</td><td>126</td><td>12</td><td>4,140</td></tr></tbody></table>				NPS	ND / DN	PIPE / TUBE	SCH	ØA	B	C	D	Weight / Poids Kg	2"	50	STEEL / ACIER	10	57	74	51	5	0,180	2"	50	STEEL / ACIER	40	55	74	51	5	0,180	2"	50	S.S. / INOX	10	57	74	51	5	0,180	3"	80	STEEL / ACIER	10	87	105	69	7	0,600	3"	80	STEEL / ACIER	40	82	105	69	7	0,600	3"	80	S.S. / INOX	10	87	105	69	7	0,600	4"	100	STEEL / ACIER	10	112	140	90	8	1,200	4"	100	STEEL / ACIER	40	107	140	90	8	1,200	4"	100	S.S. / INOX	10	113	140	90	8	1,200	5"	125	STEEL / ACIER	10	137	200	115	12	3,000	5"	125	STEEL / ACIER	40	133	200	115	12	3,000	5"	125	S.S. / INOX	10	140	200	115	12	3,000	6"	150	STEEL / ACIER	10	165	210	126	12	4,140	6"	150	STEEL / ACIER	40	160	210	126	12	4,140	6"	150	S.S. / INOX	10	167,5	210	126	12	4,140										
				NPS	ND / DN	PIPE / TUBE	SCH	ØA	B	C	D	Weight / Poids Kg																																																																																																																																																					
2"	50	STEEL / ACIER	10	57	74	51	5	0,180																																																																																																																																																									
2"	50	STEEL / ACIER	40	55	74	51	5	0,180																																																																																																																																																									
2"	50	S.S. / INOX	10	57	74	51	5	0,180																																																																																																																																																									
3"	80	STEEL / ACIER	10	87	105	69	7	0,600																																																																																																																																																									
3"	80	STEEL / ACIER	40	82	105	69	7	0,600																																																																																																																																																									
3"	80	S.S. / INOX	10	87	105	69	7	0,600																																																																																																																																																									
4"	100	STEEL / ACIER	10	112	140	90	8	1,200																																																																																																																																																									
4"	100	STEEL / ACIER	40	107	140	90	8	1,200																																																																																																																																																									
4"	100	S.S. / INOX	10	113	140	90	8	1,200																																																																																																																																																									
5"	125	STEEL / ACIER	10	137	200	115	12	3,000																																																																																																																																																									
5"	125	STEEL / ACIER	40	133	200	115	12	3,000																																																																																																																																																									
5"	125	S.S. / INOX	10	140	200	115	12	3,000																																																																																																																																																									
6"	150	STEEL / ACIER	10	165	210	126	12	4,140																																																																																																																																																									
6"	150	STEEL / ACIER	40	160	210	126	12	4,140																																																																																																																																																									
6"	150	S.S. / INOX	10	167,5	210	126	12	4,140																																																																																																																																																									
				<table border="1"><thead><tr><th colspan="3">B 150410</th><th colspan="2">UPDATED / MISE A JOUR</th><th colspan="2">R.DEPLANTE</th><th colspan="2">Th. DELECLUSE</th><th colspan="2">C.PIERCE</th></tr><tr><th>A</th><th>280108</th><th>PROJET</th><th colspan="2">Première Emission</th><th colspan="2">TOURNER</th><th colspan="2">PIERCE</th><th colspan="2">T.DELECLUSE</th></tr><tr><th>REV</th><th>DATE</th><th>STATUS FOR</th><th colspan="3">DESIGNATION</th><th colspan="2">DRAWN BY:</th><th colspan="2">CHECKED BY</th><th colspan="2">APPROVED BY:</th></tr></thead><tbody><tr><td colspan="3">ABB France</td><td colspan="3">CUSTOMER :</td><td colspan="2"></td><td colspan="2"></td><td colspan="2"></td></tr><tr><td colspan="3">Division Process Automation</td><td colspan="3">PLANT :</td><td colspan="2"></td><td colspan="2"></td><td colspan="2"></td></tr><tr><td colspan="3">Activité CELLIER</td><td colspan="3"></td><td colspan="2"></td><td colspan="2"></td><td colspan="2"></td></tr><tr><td colspan="3">PARC D'ACTIVITES DES COMBAROUCHES</td><td colspan="3"></td><td colspan="2"></td><td colspan="2"></td><td colspan="2"></td></tr><tr><td colspan="3">73100 AIX LES BAINS - FRANCE</td><td colspan="3"></td><td colspan="2"></td><td colspan="2"></td><td colspan="2"></td></tr><tr><td colspan="3">Tél : (33) 04.79.35.95.65 - Fax : (33) 04.79.88.37.71</td><td colspan="3"></td><td colspan="2"></td><td colspan="2"></td><td colspan="2"></td></tr><tr><td colspan="12">Ce document est la propriété exclusive de ABB France - Activité Cellier. Il est interdit d'en faire usage ou de le communiquer sans autorisation. This data belongs exclusively to ABB France - Activité Cellier. It is forbidden to use it or to transmit it without ABB France's permission.</td></tr><tr><td colspan="12">DATA SHEET PIG / RACLEUR</td></tr><tr><td colspan="2">SCALE</td><td colspan="2">SIZE</td><td colspan="2">CUSTOMER N° Plan / Drawing Number</td><td colspan="2">ABB France N° Plan / Drawing Number</td><td colspan="2">REV.</td><td colspan="2"></td></tr><tr><td colspan="2"></td><td colspan="2">A3</td><td colspan="2"></td><td colspan="2">C48003763</td><td colspan="2"></td><td colspan="2">B</td></tr></tbody></table>				B 150410			UPDATED / MISE A JOUR		R.DEPLANTE		Th. DELECLUSE		C.PIERCE		A	280108	PROJET	Première Emission		TOURNER		PIERCE		T.DELECLUSE		REV	DATE	STATUS FOR	DESIGNATION			DRAWN BY:		CHECKED BY		APPROVED BY:		ABB France			CUSTOMER :									Division Process Automation			PLANT :									Activité CELLIER												PARC D'ACTIVITES DES COMBAROUCHES												73100 AIX LES BAINS - FRANCE												Tél : (33) 04.79.35.95.65 - Fax : (33) 04.79.88.37.71												Ce document est la propriété exclusive de ABB France - Activité Cellier. Il est interdit d'en faire usage ou de le communiquer sans autorisation. This data belongs exclusively to ABB France - Activité Cellier. It is forbidden to use it or to transmit it without ABB France's permission.												DATA SHEET PIG / RACLEUR												SCALE		SIZE		CUSTOMER N° Plan / Drawing Number		ABB France N° Plan / Drawing Number		REV.						A3				C48003763				B	
				B 150410			UPDATED / MISE A JOUR		R.DEPLANTE		Th. DELECLUSE		C.PIERCE																																																																																																																																																				
A	280108	PROJET	Première Emission		TOURNER		PIERCE		T.DELECLUSE																																																																																																																																																								
REV	DATE	STATUS FOR	DESIGNATION			DRAWN BY:		CHECKED BY		APPROVED BY:																																																																																																																																																							
ABB France			CUSTOMER :																																																																																																																																																														
Division Process Automation			PLANT :																																																																																																																																																														
Activité CELLIER																																																																																																																																																																	
PARC D'ACTIVITES DES COMBAROUCHES																																																																																																																																																																	
73100 AIX LES BAINS - FRANCE																																																																																																																																																																	
Tél : (33) 04.79.35.95.65 - Fax : (33) 04.79.88.37.71																																																																																																																																																																	
Ce document est la propriété exclusive de ABB France - Activité Cellier. Il est interdit d'en faire usage ou de le communiquer sans autorisation. This data belongs exclusively to ABB France - Activité Cellier. It is forbidden to use it or to transmit it without ABB France's permission.																																																																																																																																																																	
DATA SHEET PIG / RACLEUR																																																																																																																																																																	
SCALE		SIZE		CUSTOMER N° Plan / Drawing Number		ABB France N° Plan / Drawing Number		REV.																																																																																																																																																									
		A3				C48003763				B																																																																																																																																																							



## 12. PIG INSPECTION SHEET

Pig Line Diameter : .....

Pig Line Reference : .....

Pig Line Length : .....

	Inspection date .....	Inspection date .....	Inspection date .....	Inspection date .....
Reason for pig inspection				
Time since last inspection or since new				
Number of cycles performed and/or distance covered				
External pig lip diameter				
Condition of pig lips				
Condition of pigs ends				
Pig ends correctly screwed and not loose				
Condition of centre body				
Other remarks				
Decision : - Re-use as is : - Replace damaged parts : - Destruction :				

Date : .....

Signature : .....