



Mechanical Re-Rounding Clamps **Sizes 20mm - 400mm**

Operating Instructions



Helping you make the right connections.

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01. Introduction



Important!

This manual outlines the operation of various diameter pipe re-rounding clamps.

This manual forms a part of the product to which it relates. It should be kept for the life of the product. Any amendments issued by Caldervale Technology Ltd should be incorporated in the text. The manual should be passed to any subsequent holder or user of this product.

These products are not suitable for re-rounding pipe which has previously been squeezed off, other products are available for this.

General Description of Use

These products are suitable for use on P.E. pipe from 20mm to 450mm (dependant on model) prior to jointing by the electrofusion process and have been designed to comply with U.K. Gas Industry Standards GIS/ PL2-5:2006 Part 5 Electrofusion ancilliary tooling.

Some units have been manufactured so that inserts can be fitted and used on various pipe dimensions.

Before Using

It is important to ensure all component parts are present and in serviceable condition. Check all threaded parts for damage. Ensure the reducing inserts (when required) are fitted with the correct screws.

02. Safety Instructions

1. Read BEFORE USING procedure before using the tool.
2. It is imperative that all possible precautions are made to avoid unexpected movement of the tool during use.
3. Never use the re-rounder on PE pipe which is not suitable for re-rounding. If in doubt contact the pipe manufacturer
4. The clamps vary in weight between 1.5Kg through to 90Kg dependant on model care should be taken when in use.
5. To avoid injury the re-rounder should be closed and secured and if safety chains are fitted they should be latched in position.
6. Lifting must be by 2 persons for above 25 kilograms
7. Operatives should wear eye protection, gloves, safety headwear & footwear when using the equipment.

03. Re-Rounding Clamps Range



**Re-Rounder Nut Cracker
20-55mm**



**Re-Rounder Hinged Collar
63-75mm**



**Re-Rounder Hinged Collar
110-180mm**



**Re-Rounder Split Collar
200-250mm**



**Re-Rounder Split Collar
280-400mm**

04. Parts List and Product Codes

| Code | Product description |
|-----------|---|
| 01-08-001 | Nutcracker type 20mm |
| 01-08-002 | Nutcracker type 25mm |
| 01-08-003 | Nutcracker type 32mm |
| 01-08-004 | Nutcracker type 40mm |
| 01-08-005 | Nutcracker type 50mm |
| 01-08-006 | Hinged collar type 63mm |
| 01-08-007 | Hinged collar type 75mm |
| 01-08-008 | Hinged collar type 90mm |
| 01-08-009 | Hinged collar type 110mm |
| 01-08-010 | Hinged collar type 125mm |
| 01-08-011 | Hinged collar type 140mm |
| 01-08-012 | Hinged collar type 160mm |
| 01-08-013 | Hinged collar type 180mm |
| 01-08-014 | Split collar with ratchet 200mm |
| 01-08-015 | Split collar with ratchet 225mm |
| 01-08-016 | Split collar with ratchet 250mm |
| 01-08-028 | Segmented collar 280mm with ratchet |
| 01-08-020 | Segmented collar 315mm with ratchet |
| 01-08-021 | Segmented collar 355mm with ratchet |
| 01-08-022 | Segmented collar 400mm with ratchet |
| 01-08-026 | Set of reducing liners 400-355mm (2 pieces) |
| 01-08-027 | Set of reducing liners 400-315mm (2 pieces) |

05. Operation

Instructions for use

1. The tools are designed to be clamped around a section of pipe prior to it being fitted into an electrofusion collar. Most pipes have some out of roundness caused in the production and storage process, to avoid problems caused in joint assembly it is necessary to remove this out of roundness by applying a circular clamp to the pipe end, the re-rounding action of the clamp temporarily allows for the pipe to be scraped and the joint assembled before the natural memory of the pipe material returns the pipe to its out of round shape.
2. The tool should be opened and fixed round the pipe, then closed and locked in position, it is not necessary to fully tighten the clamp until both free halves come together, the clamp is designed for the pipe cavity not to be a complete circle, this allows for use with pipe at the upper size of its tolerance range.

Tightening both halves of the clamp until they meet will exceed the correct roundness of the pipe and then start to compress the pipe and damage the clamp.

3. Tightening should be finished when the pipe reaches its roundest point.
4. It is recommended that the re-rounding process be applied for a minimum of 10 minutes before releasing the tool.
5. On completion of the re rounding process, release the clamp and slide back down the pipe sufficient to scrape the pipe using a mechanical scraping tool using normal scraping procedure.
6. On completion of scraping bring the re rounding clamp forward to the end of the scraped area and retighten to maintain pipe roundness while the joint is assembled.

06. Removal After Pipe Re-Rounding

Care must be taken on removing the clamp to ensure injury to operatives is avoided.

Transport and Storage

1. Care should be taken not to cause damage to the already re-rounded pipe end.



Storage

IMPORTANT! When not in use always:

1. Store the tool in an upright position.
2. Clean the equipment.
3. Store in a clean damp free environment
4. Make sure the store is not subject to extreme temperature changes.

Routine Maintenance

1. Grease and check screw threads at regular intervals.
2. Inspect and replace damaged security chains.
3. Inspect and lubricate all moving components if necessary.

07. Warranty Information

1. Extent of Warranty

- a) Subject to clauses 2 and 3, Caldervale Technology Ltd warrants to the end-user customer that its products will be free from defects in materials and workmanship, for twelve months after the date of purchase by the end-user customer, subject to providing proof of purchase.
- b) If Caldervale Technology Ltd receives, during the warranty period, notice of a defect in product which is covered by this warranty; Caldervale Technology Ltd shall either repair or replace the product, at its option. Any replacement product may be either new or like-new, provided that it has functionality at least equal to that of the product being replaced.
- c) All warranty work will be carried out by Caldervale Technology Ltd unless otherwise agreed. On-site warranty and repair or replacement services are available from authorised Caldervale Technology Ltd service facilities world-wide.
- d) Customers shall prepay shipping charges for products returned to Caldervale Technology Ltd for warranty service, and Caldervale Technology Ltd will charge for return of the products back to the customer.
- e) This warranty statement gives the customer specific legal rights. The customer may also have other rights which vary from country to country in the world.

2. Pre-conditions for Warranty Application

Caldervale Technology Ltd's warranty covers only those defects which arise as a result of normal use of the product, and this warranty shall only apply in the following circumstances:

- a) All the instructions contained in the operating manual have been complied with; and
- b) None of the following apply:
 - i) Improper or inadequate maintenance;
 - ii) Physical abuse;
 - iii) Unauthorised modification, misuse or any use not in accordance with the operating manual and good industry practice;

- iv) Operation outside the products specifications;
- v) Improper site preparation or maintenance;
- vi) Faulty pipes.

3. Limitations of Warranty

- a) Caldervale Technology Ltd does not warrant the operation of any product to be uninterrupted or error free.
- b) Caldervale Technology Ltd makes no other warranty of any kind, whether express or implied, with respect to its products. Caldervale Technology Ltd specifically disclaims the implied warranties of satisfactory quality and fitness for a particular purpose.
- c) 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.
- d) To the extent allowed by local law, the remedies provided in this warranty statement are the customer's sole and exclusive remedies.
- e) This tool has been designed for the range of pipes available at the time of its design and development. Caldervale Technology Ltd can accept NO liability for the unit's ability or otherwise to work with new or different pipes that subsequently appear in the market place.

Please complete this information and keep it safely with your proof of purchase receipt. You will require it for any warranty claim.

Where purchased: _____

Date of purchase: _____

Name of purchaser: _____

Address of purchaser: _____

Type of tool: _____

Serial number: _____

08. Certificate of Calibration

- This product has been inspected and tested in accordance with the ISO9001 quality control systems and procedures in place at Caldervale Technology Ltd, Dewsbury.
- This product has no calibration period, periodic, safety inspections should be carried out by the operator if in any doubt please contact the manufacturer for further information.

09. Service and Repair

For service and repair please contact:

Caldertech Europe

Bretfield Court, Dewsbury,
West Yorkshire WF12 9DG, UK

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Malaga WA 6090, Australia

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10. Decommissioning and Disposal

These give the instructions for decommissioning and disposal of the equipment and confirm how it is to be taken out of service safely, in respect of the Essential Health and Safety Requirements.

- If a Maxifuse™ Re-rounding tool has reached the end of its useful working life and cannot be refurbished it must be disposed of through a licensed scrap or waste disposal facility. Alternatively, a reverse engineering company could be used to strip the equipment for recycling purposes.
- Disposal is the responsibility of the Customer this can also be achieved by returning the product back to the manufacturer.



EU Declaration of Conformity

SUPPLIER: Caldervale Technology Limited
SUPPLIER'S ADDRESS: Bretfield Court, Dewsbury,
West Yorkshire WF12 9BG, United Kingdom

Declares that the goods described below:

- Make: CTL
- Product: Maxifuse™ Re- rounding clamps
- Type:
- Reference No:

Conforms to the following directives:

- 98/37/EC Machinery (Safety) Regulations (as amended)

Meets the following standards:

Safety of Machinery

- BS EN 12100: 2003, BS EN 982: 1996

Gas Industry Standard

- GIS/PL2-5: 2006 Part 5 Electrofusion ancillary tooling

Complies with, or is designed and constructed so far as it is possible to comply with the relevant health and safety requirements, taking into account the state of the art.

Modifications to the equipment without prior approval by the undersigned will render this Declaration null and void.

For and on behalf of the Manufacturer:

G L Lilley

Gordon Lilley

Position: Managing Director (CE Responsible Person)

Signed at: Dewsbury, West Yorkshire, United Kingdom

Date: 5th February 2007

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

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