Operator's Manual

McELROY

www.mcelroy.com

6" IPS Pipe Preparation Machine

LineTamer®

Manual: LT0104 Revision: J 11/18
Original Language: English

WARNING Cancer and Reproductive Harm - www.P65warnings.ca.gov

8163361

This product and other products could be protected by patents or have patents pending. All the latest patent information is available at patent.mcelroy.com

Introduction

Thank you for purchasing this McElroy product.

The McElroy LineTamer® is designed to remove coil set and reround coiled pipe for easier fusion and to minimize the possibility of dangerous uncontrolled pipe recoil. The LineTamer consists of a straightening unit and a rerounding unit which prepares 3" to 6", high and medium density coiled polyethylene pipe for installation. With reasonable care and maintenance, this machine will give years of satisfactory service.

Before operating this machine, please read this manual thoroughly, and keep a copy with the machine for future reference. This manual is to be considered part of your machine.

PH03027-04-26-05

TX00569-7-19-95

McElroy University

For more than 30 years, McElroy has been the only pipe fusion machine manufacturer to continuously offer advanced training. Course offerings are meant to enhance your efficiency, productivity and safety in the proper use of McElroy machines. McElroy University classes are structured so that the skills learned and the machines used in each class closely match the machines found on pipelining jobsites. We offer training at our facility or yours. Our uniquely qualified McElroy University course instructors offer years of industry experience.

Tuition for each course includes lunches, course materials and a certificate of completion. Online registration, as well as up-to-date course offerings and dates, is available at **www.mcelroy.com/university**

This manual is intended as a guide only and does not take the place of proper training by qualified instructors. The information in this manual is not all inclusive and can not encompass all possible situations that can be encountered during various operations.

MU203-13-14

TX04659-03-24-14

Warranty

LIMITED WARRANTY

McElroy Manufacturing, Inc. (McElroy) warrants all products manufactured, sold and repaired by it to be free from defects in materials and workmanship, its obligation under this warranty being limited to repairing or replacing at its factory and new products, within **5 years** after shipment, with the exception of purchased items (such as electronic devices, pumps, switches, etc.), in which case that manufacturer's warranty applies. Warranty applies when returned freight is prepaid and which, upon examination, shall disclose to have been defective. This warranty does not apply to any product or component which has been repaired or altered by anyone other than McElroy or has become damaged due to misuse, negligence or casualty, or has not been operated or maintained according to McElroy's printed instructions and warnings. This warranty is expressly in lieu of all other warranties expressed or implied. The remedies of the Buyer are the exclusive and sole remedies available and Buyer shall not be entitled to receive any incidental or consequential damages. Buyer waives the benefit of any rule that disclaimer of warranty shall be construed against McElroy and agrees that such disclaimers herein shall be construed liberally in favor of McElroy.

RETURN OF GOODS

Buyer agrees not to return goods for any reason except upon the written consent of McElroy obtained in advance of such return, which consent, if given, shall specify the terms and conditions and charges upon which any such return may be made. Materials returned to McElroy, for warranty work, repair, etc., **must have a Return Material Authorization (RMA) number**, and be so noted on the package at time of shipment. For assistance, inquiry shall be directed to:

McElroy Manufacturing, Inc.
P.O. Box 580550
833 North Fulton Street Tulsa, Oklahoma 74158-0550

PHONE: (918) 836–8611, FAX: (918) 831–9285.
EMAIL: fusion@McElroy.com

Note: Certain repairs, warranty work, and inquiries may be directed, at McElroy's discretion, to an authorized service center or distributor.

DISCLAIMER OF LIABILITY

McElroy accepts no responsibility of liability for fusion joints. Operation and maintenance of the product is the responsibility of others. We recommend qualified joining procedures be followed when using McElroy fusion equipment.

McElroy makes no other warranty of any kind whatever, express or implied; and all implied warranties of merchantability and fitness for a particular purpose which exceed the aforestated obligation are hereby disclaimed by McElroy.

PRODUCT IMPROVEMENT

McElroy reserves the right to make any changes in or improvements on its products without incurring any liability or obligation to update or change previously sold machines and/or the accessories thereto.

INFORMATION DISCLOSED

No information of knowledge heretofore or hereafter disclosed to McElroy in the performance of or in connection with the terms hereof, shall be deemed to be confidential or proprietary, unless otherwise expressly agreed to in writing by McElroy and any such information or knowledge shall be free from restrictions, other than a claim for patent infringement, is part of the consideration hereof.

PROPRIETARY RIGHTS

All proprietary rights pertaining to the equipment or the components of the equipment to be delivered by McElroy hereunder, and all patent rights therein, arising prior to, or in the course of, or as a result of the design or fabrication of the said product, are exclusively the property of McElroy.

LAW APPLICABLE

All sales shall be governed by the Uniform Commercial Code of Oklahoma, U.S.A.

Register your product online to activate your warranty: www.McElroy.com/fusion

(Copy information listed on the machine nameplate here for your records).

Model No. _____

Serial No. _____

Date Received _____

Distributor _____

TX02486-11-4-13

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Equipment Safety

Safety Alerts

This hazard alert sign appears in this manual. When you see this sign, carefully read what it says. YOUR SAFETY IS AT STAKE.

You will see the hazard alert sign with these words: DANGER, WARNING, and CAUTION.

DANGER Indicates an imminently hazardous situation which, if not avoided, will result in death or serious injury.

WARNING Indicates a potentially hazardous situation which, if not avoided, could result in death or serious injury.

CAUTION Indicates a hazardous situation which, if not avoided, may result in minor or moderate injury.

In this manual you should look for two other words: **NOTICE** and **IMPORTANT**.

NOTICE: can keep you from doing something that might damage the machine or someone's property. It may also be used to alert against unsafe practices.

IMPORTANT: can help you do a better job or make your job easier in some way.

VR00051-11-30-92

TX00030-12-1-92

Read and Understand

Do not operate this equipment until you have carefully read, and understand all the sections of this manual, and all other equipment manuals that will be used with it.

Your safety and the safety of others depends upon care and judgment in the operation of this equipment.

Follow all applicable federal, state, local, and industry specific regulations.

McElroy Manufacturing, Inc. cannot anticipate every possible circumstance that might involve a potential hazard. The warnings in this manual and on the machine are therefore not all inclusive. You must satisfy yourself that a procedure, tool, work method, or operating technique is safe for you and others. You should also ensure that the machine will not be damaged or made unsafe by the method of operation or maintenance you choose.

VR00052-12-1-92

TX02946-4-15-09

Equipment Safety

General Safety

SAFE1ST-122-92

Safety is important. Report anything unusual that you notice during set up or operation.

LISTEN for thumps, bumps, rattles, squeals, air leaks, or unusual sounds.

SMELL odors like burning insulation, hot metal, burning rubber, hot oil, or natural gas.

FEEL any changes in the way the equipment operates.

SEE problems with wiring and cables, hydraulic connections, or other equipment.

REPORT anything you see, feel, smell, or hear that is different from what you expect, or that you think may be unsafe.

TX00114-4-22-93

Wear Safety Equipment

VR00053-122-92

Wear a hard hat, safety shoes, safety glasses, and other applicable personal protective equipment.

Remove jewelry and rings, and do not wear loose fitting clothing or long hair that could catch on controls or moving machinery.

TX000324793

Gas Powered Units

VR00080-4-12-93

⚠ DANGER Gasoline engines will cause explosions when operated in an explosive atmosphere. Do not operate gas powered machines in an explosive atmosphere.

Do not place flammable substances near the engine while it is operating.

A spark arrester is available as an optional part for this engine. It is illegal in some areas to operate an engine without a spark arrester. Check local laws and regulations before operating.

TX00955-06-12-14

Equipment Safety

Fuel Handling

⚠ DANGER Gasoline and diesel fuel are extremely flammable and their vapors will explode if ignited.

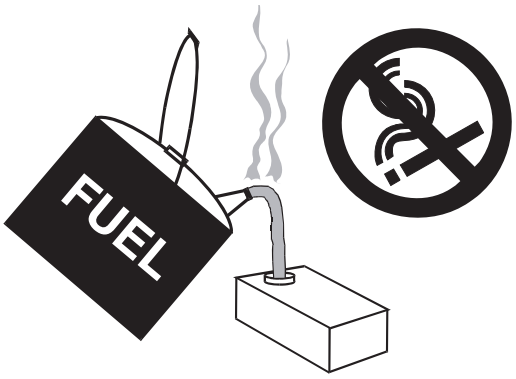
Do not fill the fuel tank while the engine is hot or running, as spilled fuel could ignite.

Refuel in a well ventilated area. Do not smoke or allow flames or sparks in the area where the engine is refueled, or where gasoline is stored.

Do not start the engine near spilled fuel. Wipe up spills immediately.

Maker sure the fuel tank cap is closed and properly secured.

NOTICE: Avoid repeated or prolonged contact with skin or breathing of vapor.



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Carbon Monoxide

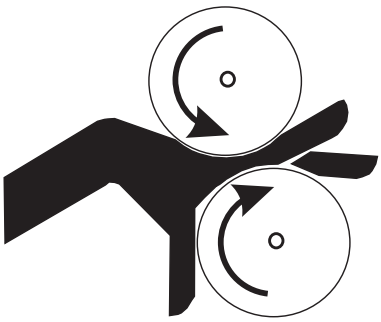
⚠ DANGER Engine exhaust gases contain poisonous carbon monoxide. Carbon monoxide can cause severe nausea, fainting and death. Avoid inhaling exhaust fumes and never run the engine in a closed or confined area.

WR00093-5-14-96

TX00954-5-14-96

Keep Personnel Away

⚠ WARNING The rollers in this machine are under hydraulic pressure and can cause severe bodily harm. All personnel must keep hands and body away from moving parts of machine.



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TX01601-10-12-98

Equipment Safety

Cutting Steel Bands

⚠WARNING Coiled pipe can uncoil with considerable force, causing extreme bodily injury if not properly contained. Do not cut the straps around the coil until the coil is contained in a suitable reel trailer or coil cage.

Leave plastic straps on coil. Do not cut.

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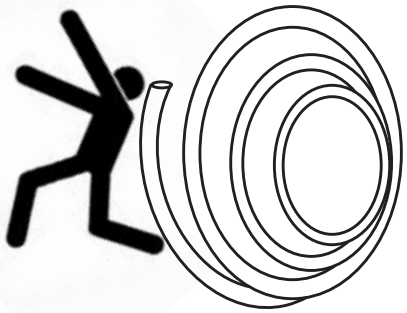

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Coiled Pipe Safety

When the tail end of the coil unwinds, or when the pipe is being cut, the ends can move suddenly in any direction with great force.

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⚠WARNING Loose ends of coiled pipe can move with great force in any direction. Keep personnel at least 15 feet away.

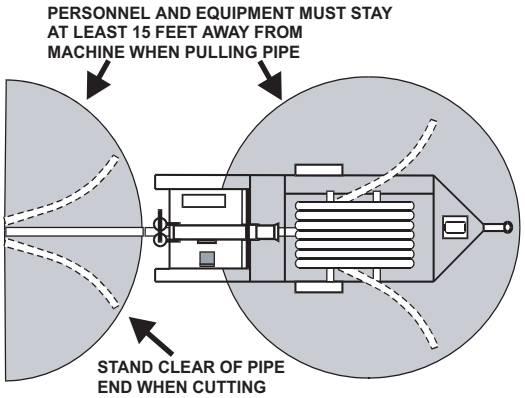
When pulling pipe through the LineTamer, personnel and equipment must stay at least 15 feet away from machine and pipe ends.

Cold Weather Conditions

The forceful movement of loose ends of pipe become more pronounced in cold weather and all personnel must be aware for their own safety.

There are practical limits to pulling pipe in cold weather. The ability of the pipe to be straightened and rerounded diminishes.

The LineTamer does not have enough power to properly straighten and reround pipe at lower temperatures. Operation below 32° F is not recommended.



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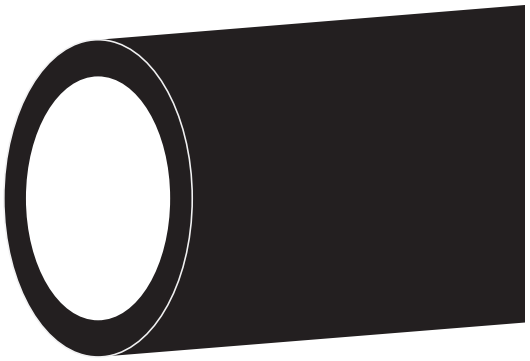
Equipment Safety

Pipe Handling Safety

⚠WARNING Do not position yourself under supported or raised pipe. Pipe is heavy and could result in serious injury or death.

⚠WARNING Pipe that is bent can store a great amount of energy. Do not bend and force the pipe into the machine. A bent pipe with stored energy could cause serious injury or death when that energy is released.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It is recommended that the pipe is always be held securely by either being clamped securely in the fusion machine jaws or attached to the lifting device.

Keep persons that are not involved in handling pipe away from handling operations. When the pipe and handling equipment are in motion, all persons involved in handling pipe should be able to see all other persons at all times. If any handling person is not in sight, immediately stop moving equipment and pipe and locate that person. Do not continue until all persons are accounted for and in sight.

NOTICE: Do not leave machine unattended while the Power Pack is running. When not operating the machine, turn off the Power Pack. This will prevent accidental or unintentional movement of the machine.

Never push, roll, dump or drop pipe lengths, bundles or coils off the truck, off handling equipment or into a trench. Always use appropriate equipment to lift, move and lower the pipe.

TX04586-4-17-13

Units With Hydraulics

Although the hydraulic pressures in this machine are low compared to some hydraulically operated equipment, it is important to remember that a sudden hydraulic oil leak can cause serious injury, or even be fatal if the pressure is high enough.

⚠WARNING Escaping fluid under pressure can penetrate the skin causing serious injury. Keep hands and body away from pinholes which eject fluid under pressure. Use a piece of cardboard or paper to search for leaks. If any fluid is injected into the skin, it must be immediately removed by a doctor familiar with this type of injury.


WR00078-4-8-93

NOTICE: Wear safety glasses, and keep face clear of area when bleeding air from hydraulic system to avoid spraying oil into eyes.

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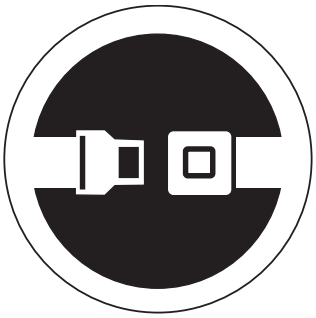
Operator's Seat

Always operate the machine from the control side with the operator in the control seat. Use the seat belt at all times.

Never stand on the LineTamer during operation.



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Overview

Usage Options

I: Pulling pipe from LineTamer and stringing the pipe on the ground for direct burial (in the trench) or relining an existing pipeline.

II: Pulling LineTamer behind vehicle with pipe reel or cage for stringing out straightened pipe along right of way.

III: Pulling LineTamer behind vehicle with plowing vehicle pulling pipe directly into the ground.

IV: Stationary: LineTamer connected to coil trailer with plowing vehicle pulling a pipe directly into the ground.

V: Stationary: LineTamer connected to coil trailer with pipe being pulled through existing pipe for relining.

VI: Stationary: LineTamer connected to coil trailer with directional boring unit pulling pipe directly into the ground.

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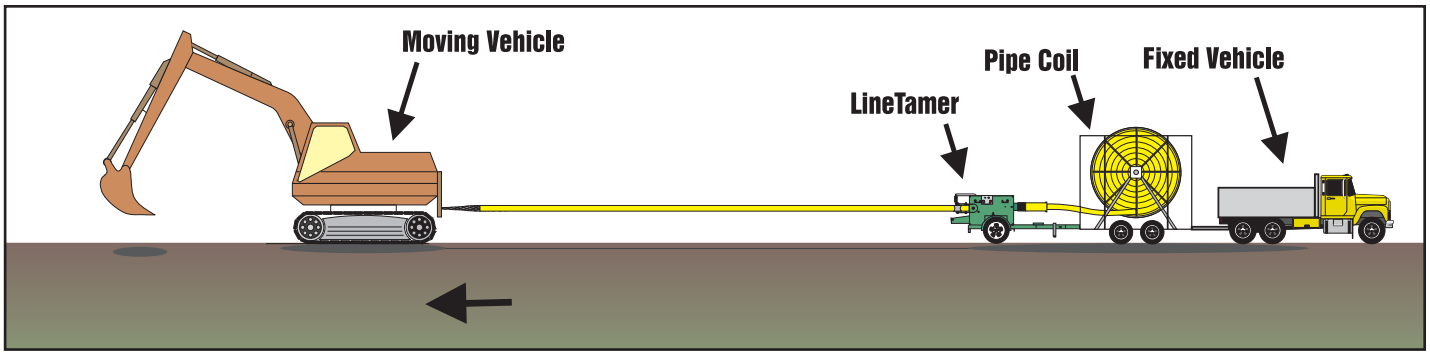
I: Stringing Pipe



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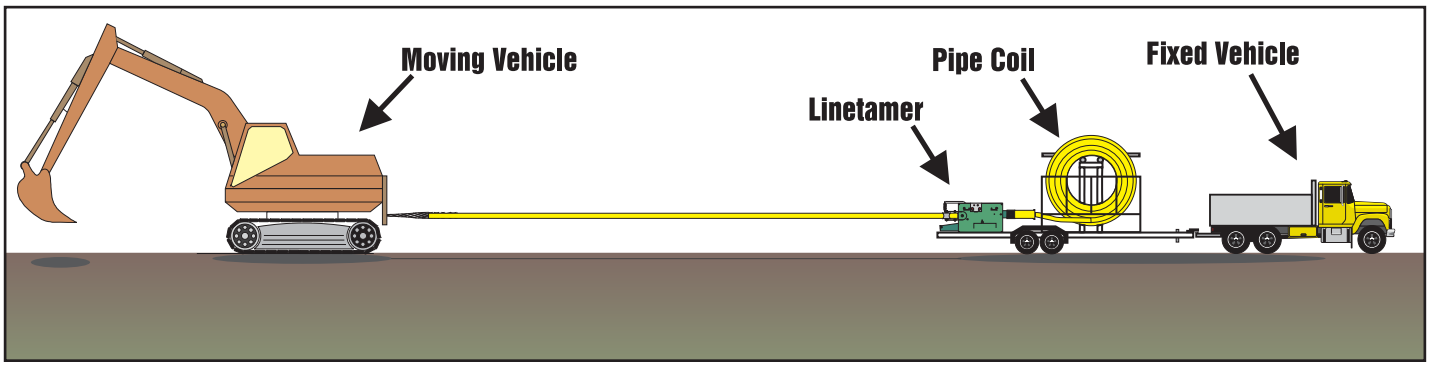
II: Stringing Pipe



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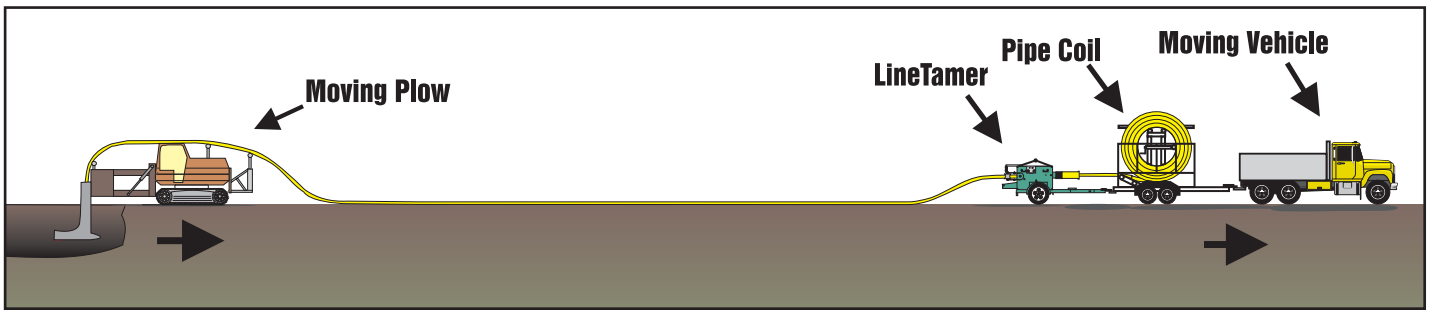
III: Stringing & Planting Pipe



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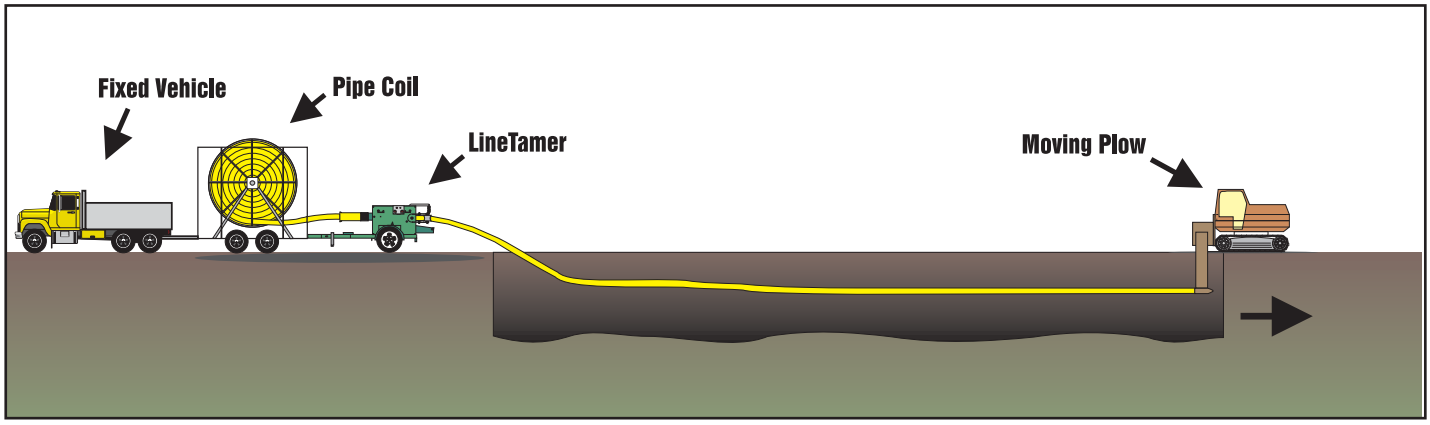
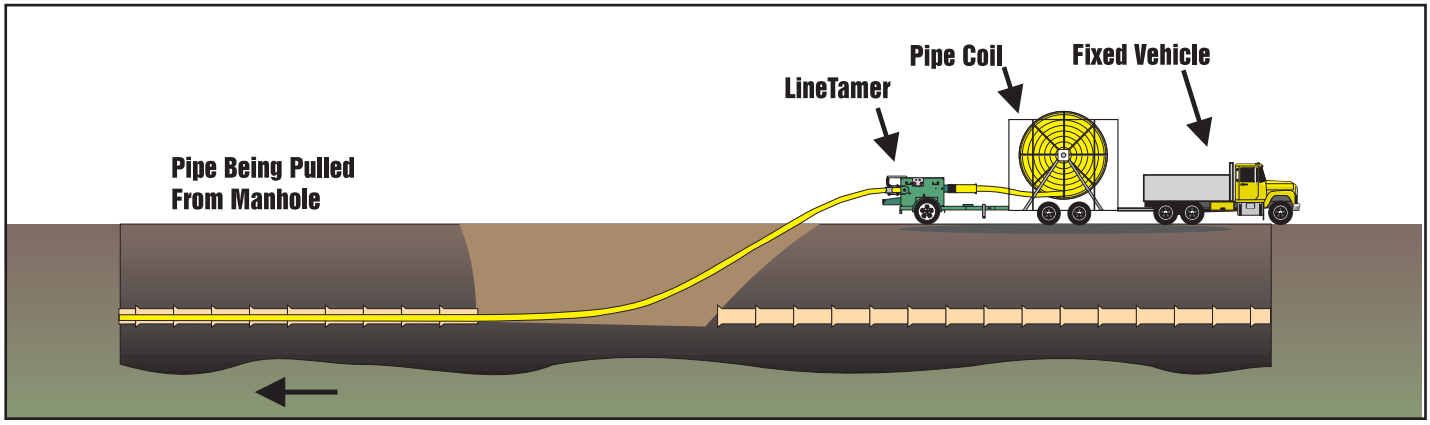
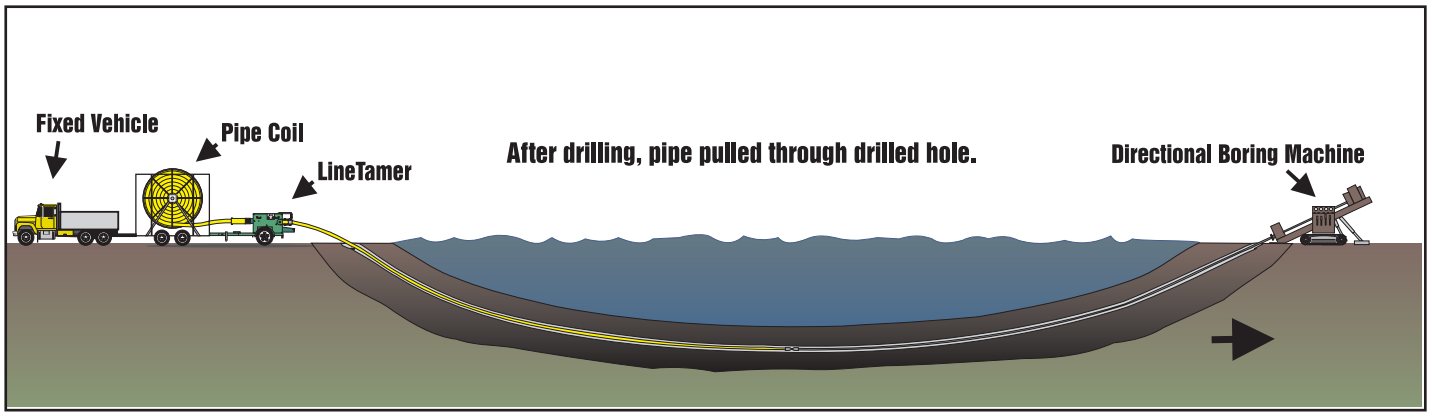
III: Stringing & Plowing Pipe



IV: Straightening Pipe for Relining



V: Straightening Pipe for Directional Boring



Hydraulic Power Unit

(A) Hydraulic fluid fill.

(B) Gasoline fill.

(C) Starter rope.

(D) Engine oil check and fill.

(E) System pressure gauge

The hydraulics are an open center flow system. The pressure relief valve is set at 2500 psi.

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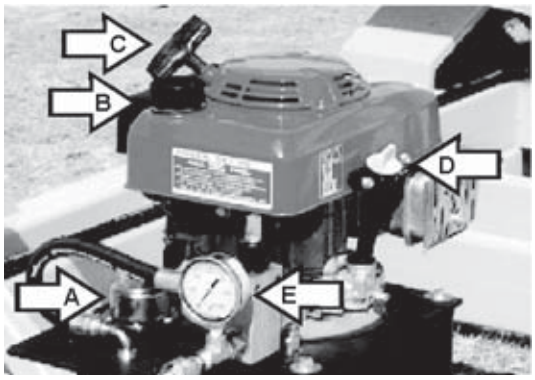

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Fuel Valve

The fuel valve should be turned off when transporting the equipment, or when not being used.

Turn the valve control in to turn off. Turn the control out to turn on.

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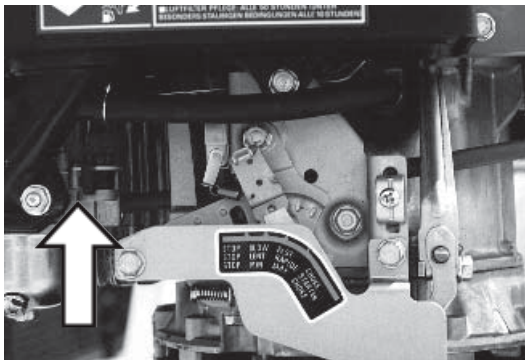

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Engine Control Lever

All the way back to the left, shuts the engine off. All the way forward to the right, is the choke position. Between these two positions, the desired engine speed can be set.

IMPORTANT: Do not use the choke if the engine is warm or the ambient temperature is high.

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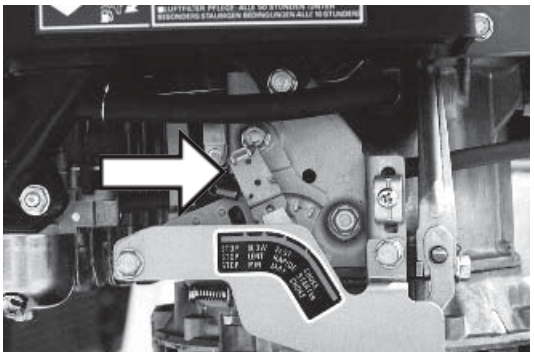

PH00823-4-26-96

Hydraulic Fluid

Check fluid level in reservoir. Proper level is indicated on the sight gauge. If level drops below this point, fill reservoir to the HIGH level on the sight gauge. Refer to the "Hydraulic Fluids" section of this manual for hydraulic oil recommendations.

Never allow dirt or other foreign matter to enter the open tank.

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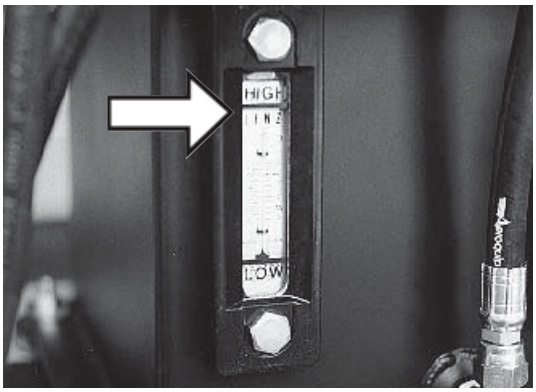

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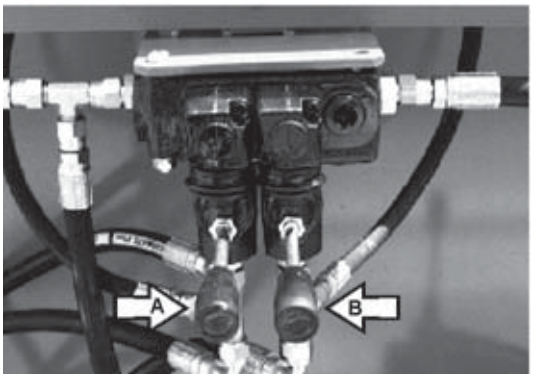
Hydraulic Controls

(A) Rerounder Pressure Control

(B) Straightener Pressure Control



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Pressure Gauges

The pressure gauge on the left indicates pressure on the rerounding rollers.

The pressure gauge on the right indicates pressure on the straightening rollers.

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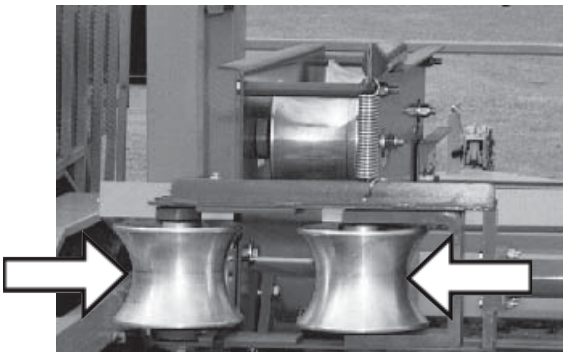
Rerounding Rollers

Pressure to the rerounding rollers is set by a manually operated control valve.



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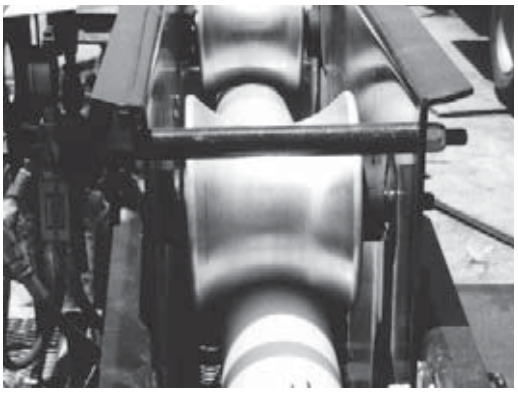
Straightening Rollers

Pressure to the straightening rollers is set by a manually operated control valve.



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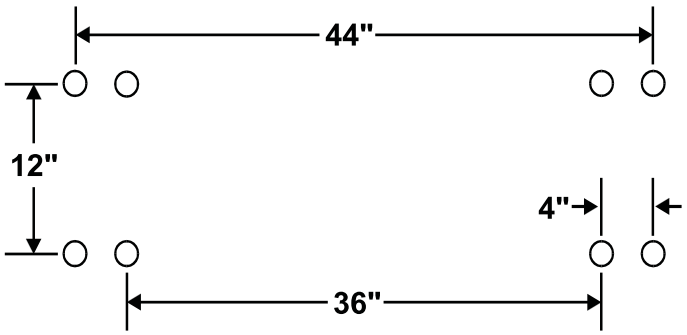
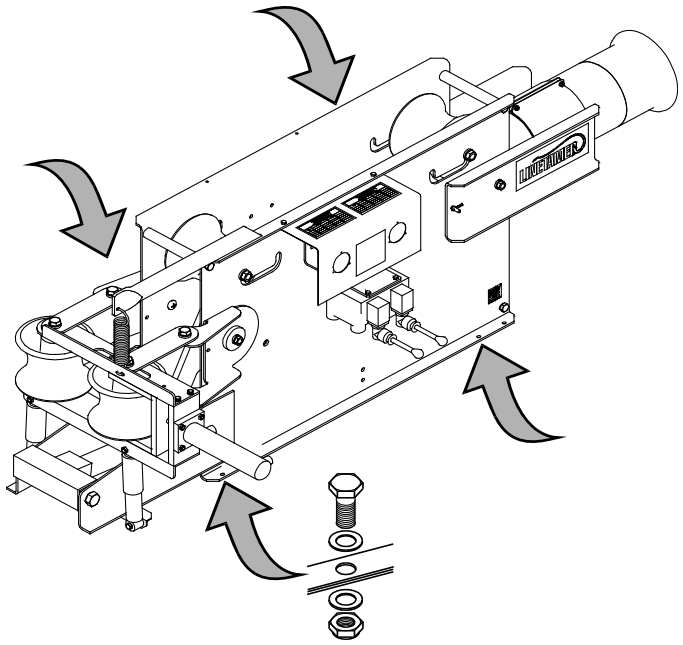
Installing LineTamer

A location should be selected of adequate construction to support the weight and forces involved with the operation of the LineTamer. Using the hole pattern dimensions as a guide, drill four 7/16" holes through the mounting surface.

Use 3/8"-16NC Hex Head Cap Screws of adequate length. Use 3/8" Type A Wide Flat Washers and 3/8"-16NC Finished Hex Nylon Lock Nuts.





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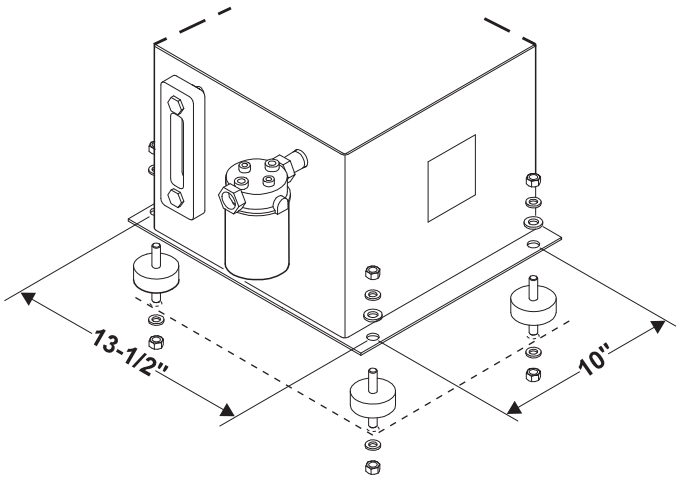
Installing Hydraulic Power Unit

Drill 7/16" holes at the dimensions shown, or use the four mounting holes on the HPU as a guide.

Shock mounts are provided to isolate the engine vibration from the mounting frame.

Install the Shock Mounts in the mounting surface and secure on the bottom with 3/8" Regular Split Lock Washers and 3/8"-16NC Finished Hex Nuts.

Position the HPU mounting holes over the shock mounts. Attach HPU with 3/8" Type A Wide Flat Washers, 3/8" Regular Split Lock Washers and 3/8"-16NC Finished Hex Nuts.



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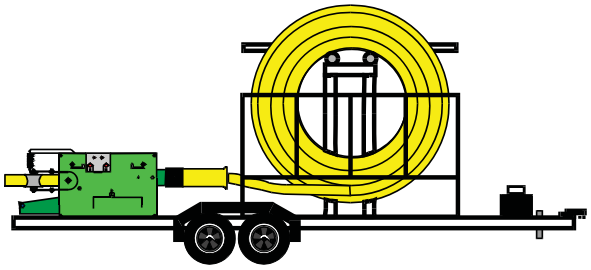
Transporting

Secure Pipe Before Transporting

The coil of pipe should be secured in the trailer before transporting. Use locking straps or similar means to secure the coil to itself as well as the trailer frame. This will prevent damage to the pipe and trailer from shifting loads at trailering speeds.

If the LineTamer is installed on the same trailer that holds the pipe coil, pipe from the coil can remain loaded in the Linetamer.



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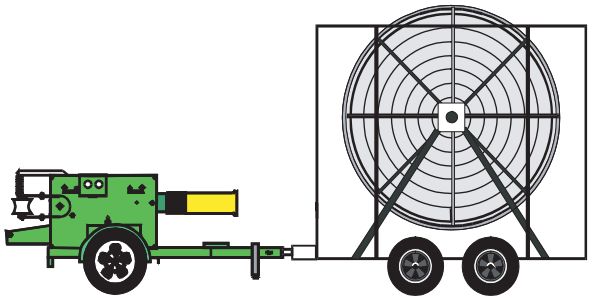
If the LineTamer is on a different trailer than the coil trailer, remove the pipe from the LineTamer before transporting.



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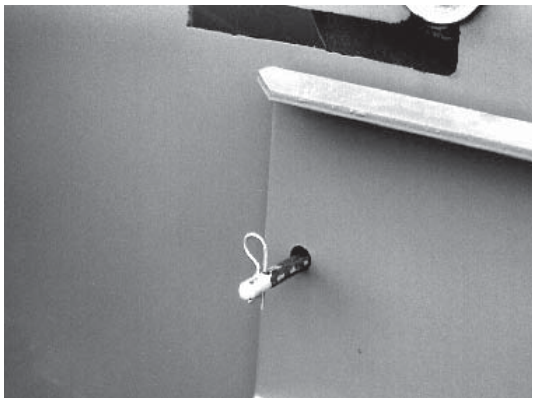
Lock Machine

Disconnect coil pipe from preparation machine.

Install the yellow-colored transport locking pin to prohibit movement of pipe guide.

Move seat to position inside trailer and lock into place.



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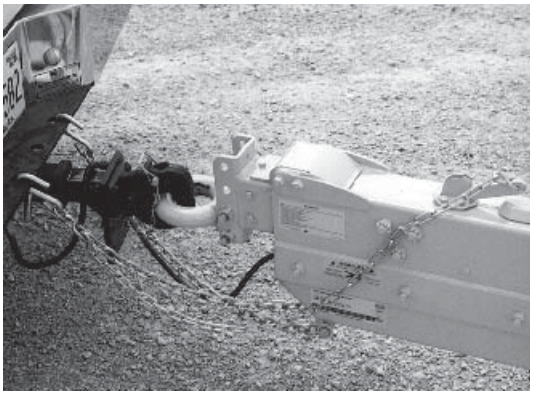
Transporting

Read Before Towing Trailer



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Never tow a trailer before you check to be sure of the following.

- Brake fluid is at the proper level.
- Coupler and hitch are the right size.
- Coupler and safety chains are safely secured to hitch.
- Trailer jack is in the raised position.
- Check all fasteners for proper tightness.
- Wheel lug nuts are properly tightened.
- Wheel bearings are properly adjusted and maintained.
- Load is within maximum load carrying capacity.
- Tires are properly inflated.
- All trailer lighting is working properly.

Follow all federal, state local and industry standards when towing a trailer.

TX00918-4-24-96

Preparation for Pulling

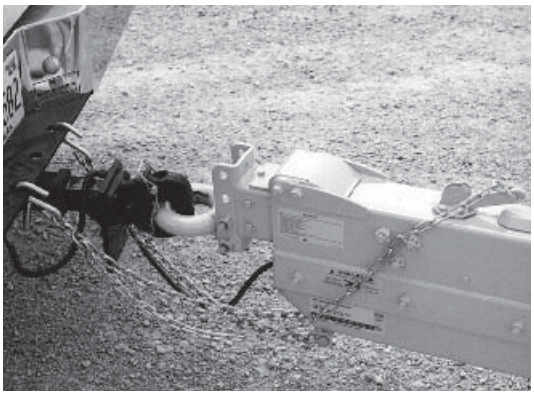
Connect Trailer

Connect trailer securely with the hitch and hook up safety chains.

⚠CAUTION Always use safety chains with proper hookup to trailer or vehicle.

With trailer secured to vehicle, raise jack up and secure.

TX01305-3-31-97



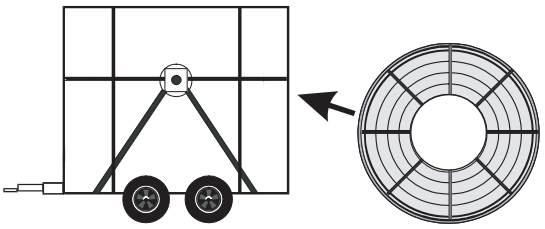
PH00808B-6-17-96

Load Coil

Load coil on reel, in a cage, on a truck, trailer, or stationary reel stand. Follow trailer manufacturer's instructions for loading and unloading coils.

⚠WARNING Coiled pipe can uncoil with considerable force, causing extreme bodily injury if not properly contained. Do not cut the steel straps around the coil until the coil is contained in a suitable reel trailer or coil cage.

TX01910-12-15-00



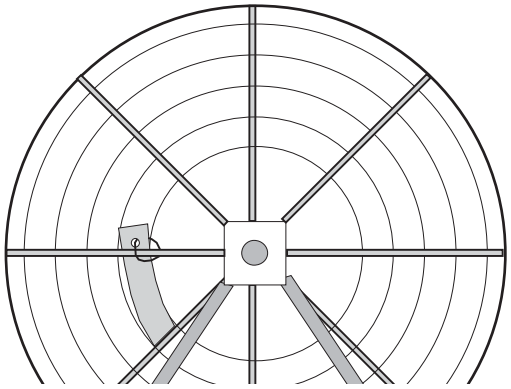
CD00371-12-15-00

Securing Pipe When Using a Reel

If the pipe coil is mounted on a reel, securing the inside loose end of the pipe with a rope will prevent the pipe from twisting before it can enter the pipe preparation machine.

Using a rope with a lower tensile strength than the pipe, secure the inside loose end of pipe to the reel (this will allow the rope to burst when the end of the coil is reached).

TX00619-8-31-95

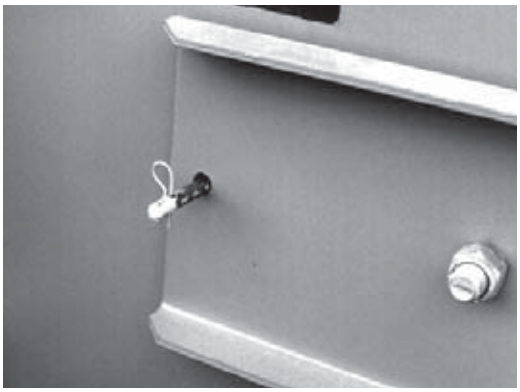


CD00164-8-31-95

Unlocking Machine

Remove the yellow-colored transport locking pin for free movement of roller system guide tube and rerounder system.

TX00584-8-10-95



PH00486-8-21-95

Preparation for Pulling

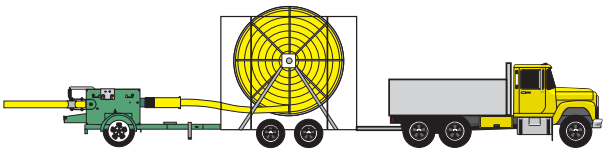
Positioning Pipe Payout

Make sure that the pipe payout from the reel or cage is lined up with the center of the pipe guide. The pipe preparation machine must be positioned directly in front of the payout from the coil.

IMPORTANT: The pipe may not be straightened or rerounded properly if the unit is not positioned correctly.

The pipe coil, LineTamer and pulling vehicle must be in alignment and make a straight pull during operation.

PH00493-8-28-95



CD00179-9-19-95

TX00583-8-10-95

Rerounder Rollers

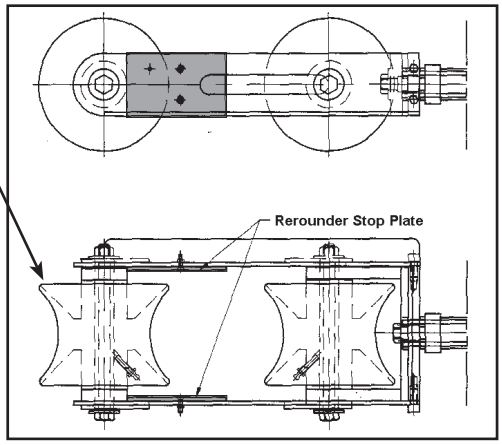
When changing rerounding rollers, the stop plates must be installed as shown. Ensure that the correct rollers and guide blocks are installed for pipe size being used.

A. 4" to 6" pipe configuration.

B. 4" to 3″ configuration.

4" to 6″ Roller

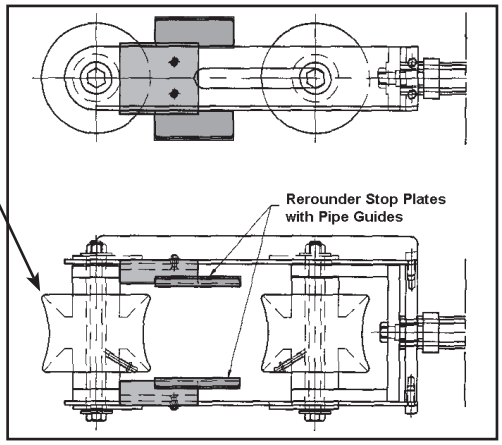
A



CD00174-9-13-95

4" to 3″ Roller

B



CD00173-9-13-95

TX00581-8-10-95

Preparation for Pulling

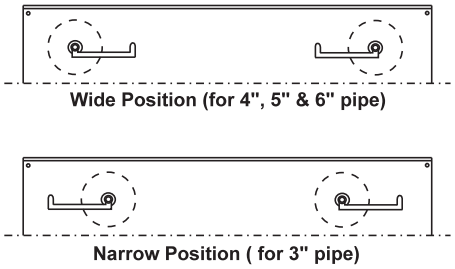
Straightening Roller

Confirm that the correct straightening roller position is set for pipe size to be used.

A. Wide roller setting for 4", 5" and 6" pipe.

B. Narrow roller setting for 3" pipe

TX00580-8-10-95



CD00156-8-21-95

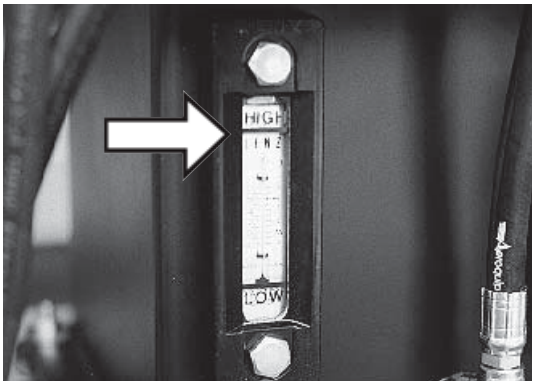
Check Hydraulic Fluid

Periodically check the hydraulic fluid level in reservoir. All hydraulic cylinders must be retracted before checking fluid to get an accurate level. Maintain fluid at HIGH Level.

Never allow dirt or foreign matter to enter the open tank.

Refer to the "Hydraulic Fluids" section of this manual for hydraulic oil recommendations.

TX00966-5-22-96



PH00825-5-2-96

Operation

Read and Understand

Do not operate this equipment until you have carefully read, and understand all the sections of this manual, and all other equipment manuals that will be used with it.

Your safety and the safety of others depends upon care and judgment in the operation of this equipment.

Follow all applicable federal, state, local, and industry specific regulations.

McElroy Manufacturing, Inc. cannot anticipate every possible circumstance that might involve a potential hazard. The warnings in this manual and on the machine are therefore not all inclusive. You must satisfy yourself that a procedure, tool, work method, or operating technique is safe for you and others. You should also ensure that the machine will not be damaged or made unsafe by the method of operation or maintenance you choose.

VR00052-12-1-92

TX02946-4-15-09

Pulling Force Limitations

When determining the amount of pulling force required through the LineTamer, consideration must be given to the amount of drag on the pipe. The amount of drag can be negligible or more than the safe pulling strength of the pipe, depending on the terrain and conditions at the job site.

Nominal pulling force through LineTamer.

3" pipe = 1,250 lbs

4" pipe = 1,800 lbs

5" pipe = 2,000 lbs

6" pipe = 2,400 lbs

Total Force = Nominal + Friction

NOTICE: Total pulling force should never exceed the pipe manufacturer's safe pulling strength. Exceeding these pulling forces can damage both pipe and equipment. It may be necessary to include a force monitoring device or a fusible link to ensure safe pulling forces are maintained. Slings and ropes should be of a load rating in excess of the loads noted above. Do not exceed the rated loads of any pulling assembly.

PH00494-9-1-95

PH02853-5-15-07

Operation

Before Starting Operation

Always ensure that the pipe and preparation machine are properly lined up in the pulling direction and that the feed height is equal to, or higher than the pipe guide.

Always ensure that roller stops are installed before pulling. Check that roller size is correct for pipe being used.

TX00588-8-10-95

STOP-1222-92

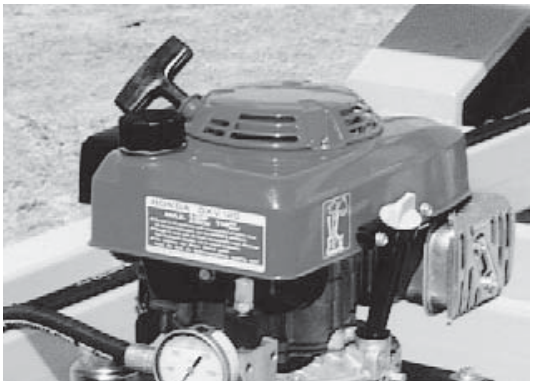
Start Engine

Turn the fuel valve to the ON position. Move the control lever to the CHOKE position. Pull the starter rope lightly until resistance is felt, then pull briskly.

NOTICE: Do not allow the starter grip to snap back against the engine. Return it gently to prevent damage to the starter.

When the engine warms up, move the control lever from the CHOKE position to the operating position.

TX00963-5-17-96



PH00843-5-17-95

Cutting Steel Bands

⚠WARNING Coiled pipe can uncoil with considerable force, causing extreme bodily injury if not properly contained. Do not cut the steel bands around the coil until the coil is contained in a suitable reel trailer or coil cage.

Do not cut plastic bands at this time.

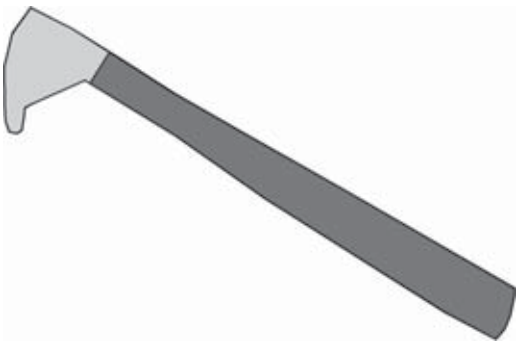
TX00590-8-10-95

PH00498-9-1-95

Cutting Plastic Bands

It may be necessary to cut the plastic bands on the coil during the pulling operation. These bands can slide together and "bunch up", posing a possible area for the pipe to kink. Use a long handled blunt nose cutter to avoid putting arms and hands inside the coil trailer/cage.

TX00620-9-1-95



PH01129-3-31-97

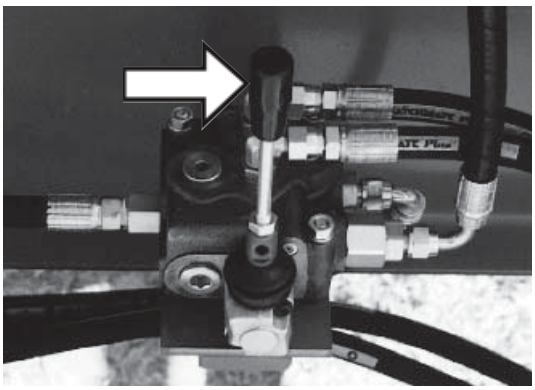
Pipe Threading Roller Valve

The pipe threading rollers equipped on some trailers can be used to help guide the starting end of the pipe into the LineTamer.

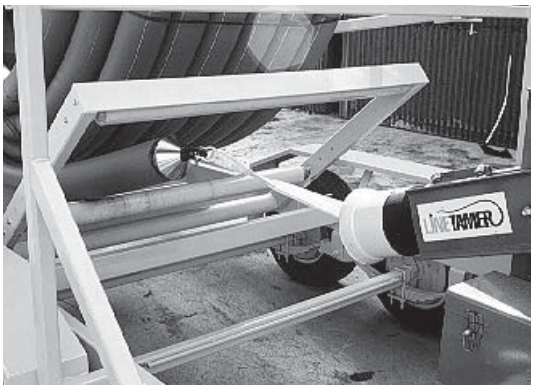
Use the rollers to pull the pipe down in alignment with the pipe guide on the LineTamer.

After the pipe is started, move the rollers up to help guide the coil.

TX00987-6-16-96



PH00844-5-17-96



PH00842-5-17-96

Loading Pipe into LineTamer

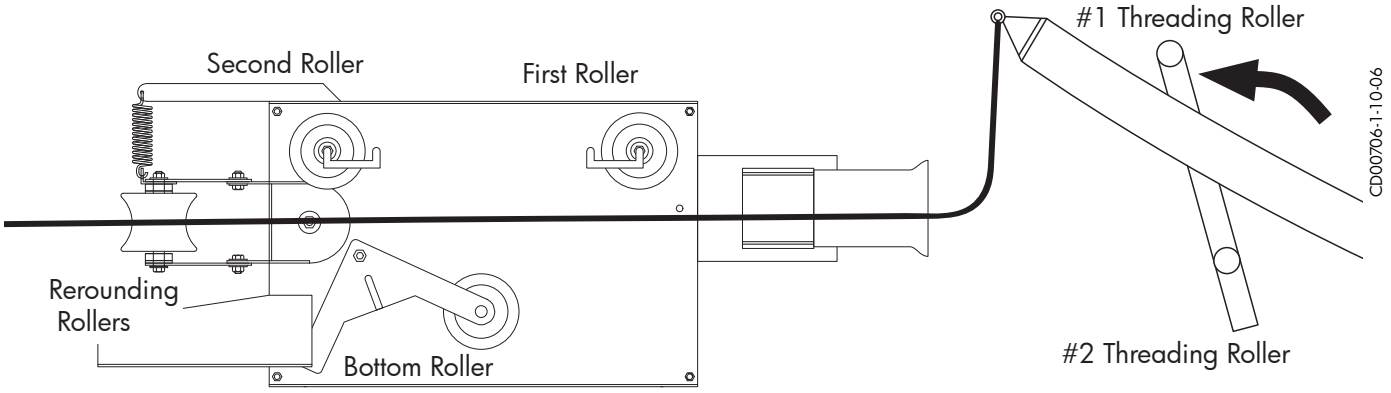
Install pulling head in pipe.

Raise threading rollers to highest position and manually roll pipe beneath #1 threading roller.

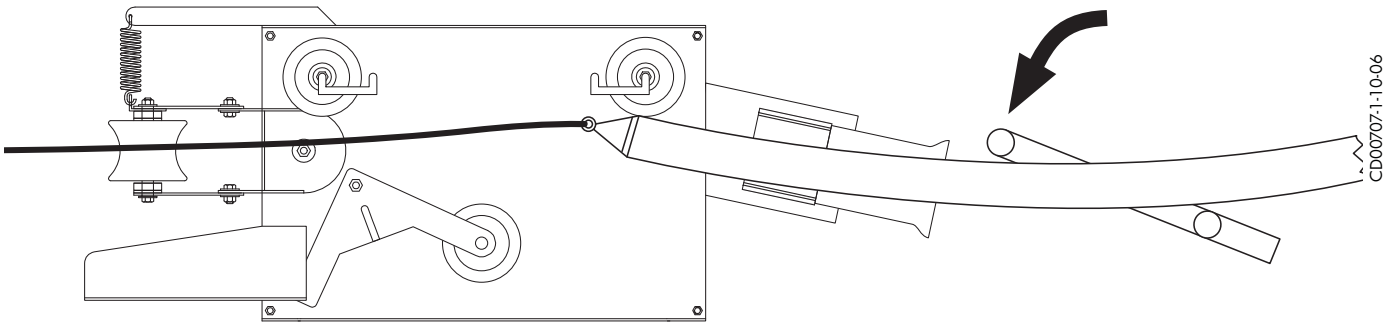
Attach pulling strap to pulling head.

NOTICE: Use only soft straps or rope to avoid any sharp edges which can damage rollers.

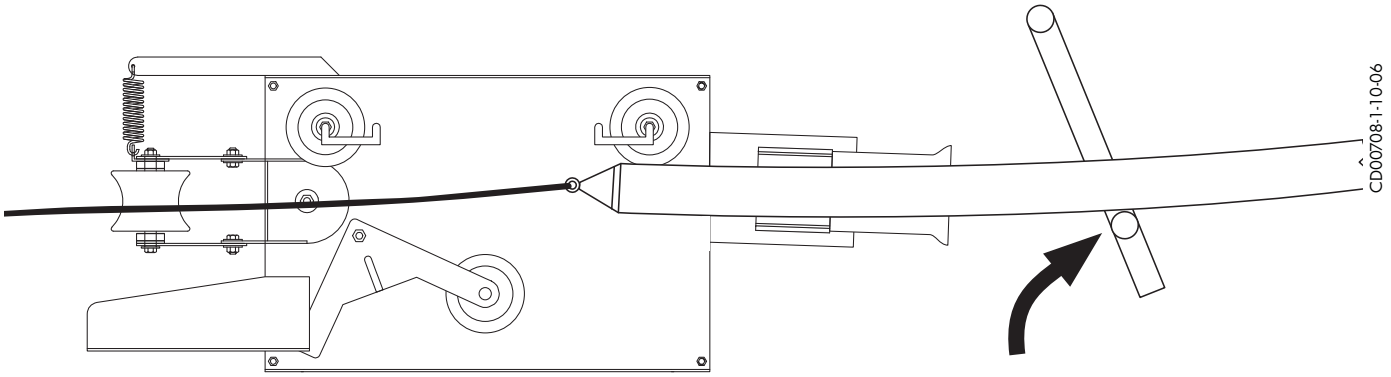
Lower threading roller #1 to align pipe with LineTamer pipe guide.



Pull pipe just past the first roller and stop.



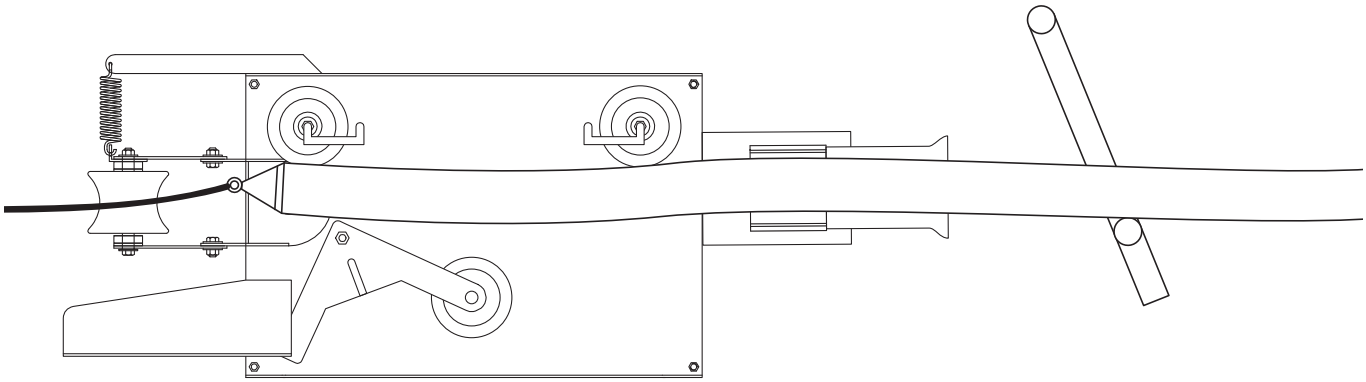
Raise threading roller #2 to align pipe with second roller.



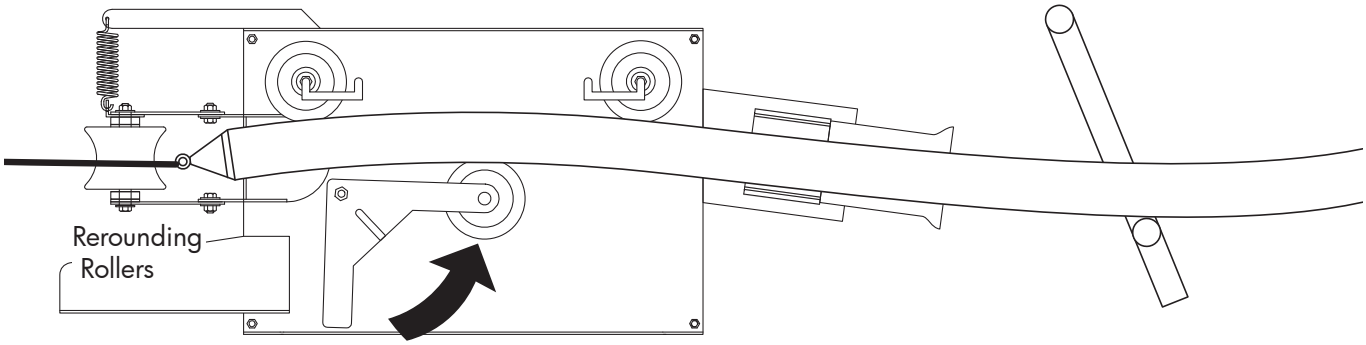
TX02580-1-10-06

Loading Pipe into LineTamer (continued)

Pull pipe just past the second roller and stop.



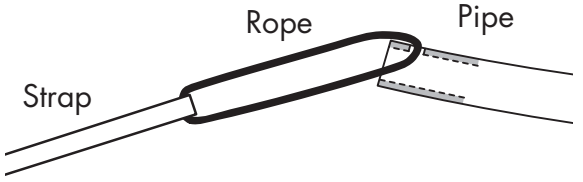
Raise bottom roller in LineTamer to align pipe with the re-rounding rollers and pull pipe through.



IMPORTANT: The use of a pulling head while loading pipe in the machine may pose a damage potential to the rollers. Many pulling heads have strap edges and hard metal surfaces that could collide with the rollers and cause damage.

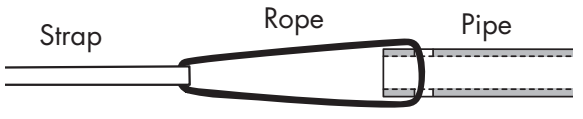
An alternative would be to use a strap and rope to pull and align the pipe in the machine.

To use the strap and rope to load the pipe in the machine, drill a hole about 2 to 3 inches from the end of the pipe. Thread the rope through the hole and attach to the strap (as shown). The strap and rope will pull the pipe downward and forward. This downward force makes it easier to pass each of the rollers in the LineTamer.



We recommend a pulling head to payout the coil of pipe as it provides positive means of attaching to the pipe.

If a pulling head is not available, you can use a similar arrangement of the strap and rope. Drill two holes inline about 2 to 3 inches from the end of the pipe. Thread the rope through both holes and attach the strap. Use the strap to pull the pipe to payout the coil.



TX02579-1-10-06

Pressure Settings

Charts show pressure settings for various pipe sizes and densities at different operating temperatures.

Always adjust pressure settings for both rerounder and straightener systems for changes in temperature. (Higher temperature = lower setting.)

The LineTamer does not have enough power to properly straighten and reround pipe at lower temperatures. Operation below 32° F is not recommended.

IMPORTANT: Charts on machine are range guidelines only for SDR 11 pipe, at speeds of 50 to 150 ft/min (less than 2 miles per hour).

- Lower speeds will require lower pressure settings.
- Thinner wall pipe will require lower pressure settings.
- Do not exceed 150 ft/min. pulling speed.

TX00592-8-10-95

Rerounder Pressure Chart
Gauge Pressure (psi)
Ambient Temperature (°F)

LT0040

Pipe Size	PE3408 / PE4710		PE2406 / PE2708	
	32° - 70°	71° - 110°	32° - 70°	71° - 110°
3"	300	250	250	200
4"	600	500	500	450
5"	900	850	850	800
6"	1250	1200	1200	1150

CD00635-7-16-18

Straightener Pressure Chart
Gauge Pressure (psi)
Ambient Temperature (°F)

LT0041

Pipe Size	PE3408 / PE4710		PE2406 / PE2708	
	32° - 70°	71° - 110°	32° - 70°	71° - 110°
3"	250	250	250	200
4"	500	450	450	400
5"	750	700	700	650
6"	1550	1500	1500	1400

CD00636-17-16-18

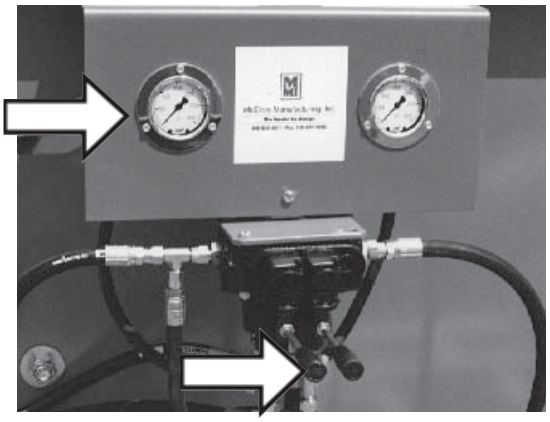
Rerounder Pressure

Select rerounder pressure control valve and set appropriate pressure value, based on pipe size and material. Refer to rerounder pressure chart.

NOTICE: Pressure gauge will indicate a lower pressure than your initial setting if pull is stopped, but will return to original setting when the pull begins again. If you adjust the setting while the pull is stopped, the setting will be higher than necessary when the pull starts again.

Rerounder pressure setting can be maintained during short stops, but should be reduced during stops of 10 minutes or more.

TX00988-6-18-96



JPH00850B-6-18-96

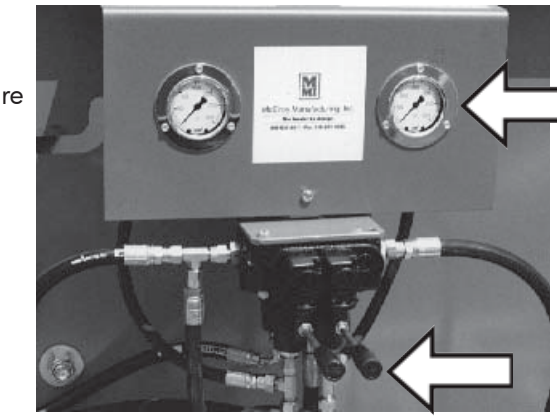
Straightener Pressure

Select straightener pressure control valve and start pulling pipe slowly while applying pressure to straightener system. Set appropriate pressure value, based on pipe size and material. Refer to straightener pressure chart.

IMPORTANT: Always reduce the pressure on the straightener system whenever the pipe pull is discontinued. If the pipe pull stops, the straightener system can kink the pipe when under pressure.

Re-engage when pull is continued, to the initial pressure setting on straightener gauge.

TX00989-6-18-96



JPH00850 8-96

Monitor Pressure

Due to variations in temperature and pulling speed, adjustments may have to be made to pressure settings for the straightener and rerounder systems to obtain the best results.

IMPORTANT: Final ovality measurements are only reliable after two hours, due to slow relaxation of pipe.

TX00594-8-10-95

PH00855-6-16-96

Precautions

Do not operate this equipment until you have carefully read, and understand all the sections of this manual, and all other equipment manuals that will be used with it.

Do not stand in front or behind preparation machine during pulling process.

Always operate machine from control-side of unit.

Operator should always be in radio contact with driver of pulling vehicle.

Never stand on preparation machine during operation.

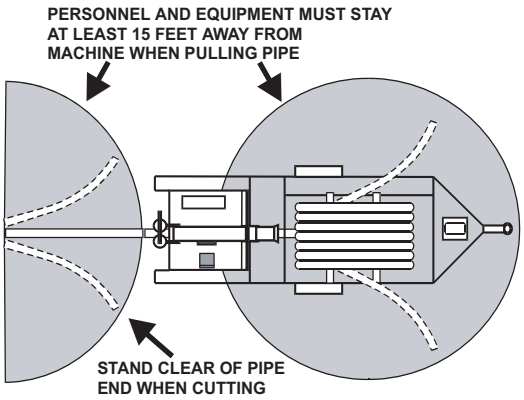
Keep hands and legs away from machine during operation.

Do not sit or step on pipe during pull.

All non-participating personnel should be at least 15 feet away from pipe coil and machine during pull.

TX00586-8-10-95

SAFE1ST-1222-95

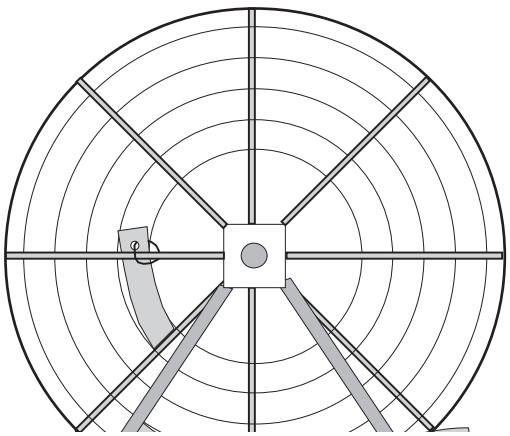


CD00342-1217-96

End of Coil with Pipe Secured

If the pipe coil was mounted on a reel and the inside end tied off, continue the pull until the pipe has reached the end of the coil. Do not stop the pull when the rope securing the end of the pipe is reached. Let the pulling load break the rope. This keeps the pipe from twisting until the last few feet get to the pipe preparation machine.
If the pipe twists, it may not be straightened or rerounded properly.

TX00621-9-5-95



CD00164-8-31-95

Maintenance

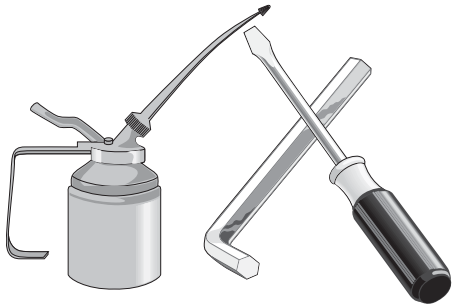
Preventative Maintenance

To insure optimum performance, the machine must be kept clean and well maintained.

With reasonable care, this machine will give years of service. Therefore, it is important that a regular schedule of preventive maintenance be kept.

Store machine inside, out of the weather, whenever possible.

TX00428-8-10-95



CD00142-11-2-94

Washing the Machine

The machine should be cleaned, as needed with a soap and water wash.

Do not pressure wash.

TX00429-04-28-14

CD00178-9-15-95

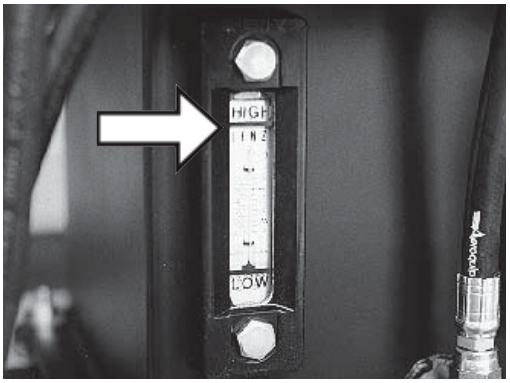
Check Hydraulic Fluid

Periodically check the hydraulic fluid level in reservoir. All hydraulic cylinders must be retracted before checking fluid to get an accurate level. Maintain fluid at HIGH Level.

Never allow dirt or foreign matter to enter the open tank.

Refer to the "Hydraulic Fluids" section of this manual for hydraulic oil recommendations.

TX00966-5-22-96

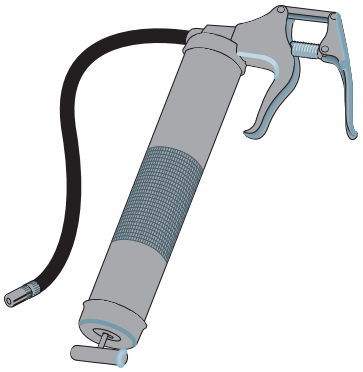


PH00825-6-16-96

Grease Bearings and Sleeves

Periodically grease all fittings for bearings and sleeves.

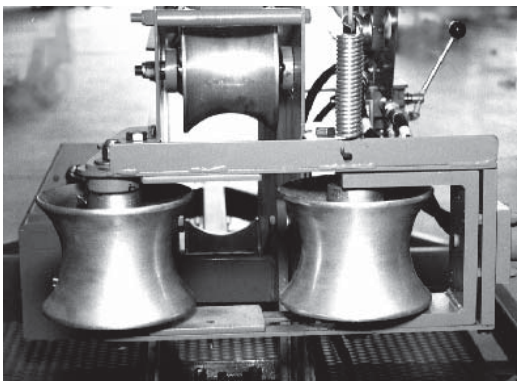
TX00990-6-18-96



CD00183-11-6-95

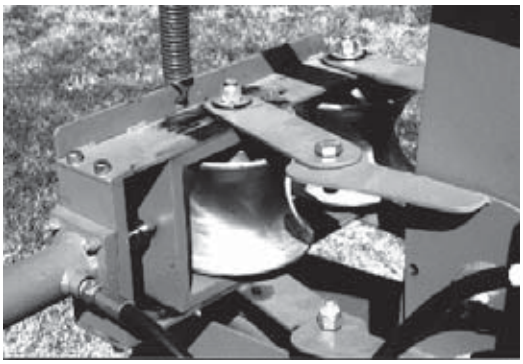
Grease Moving Parts

All moving parts should be greased periodically. All pipe rollers have fittings for lubricating the bearings. Grease the fittings once a month, or as required.



PH00502-9-5-95

Grease sliding linkage of rerounder system.



PH00503-9-5-95

TX01306-3-31-97

Hydraulic Fluids

The use of proper hydraulic fluid is mandatory to achieve maximum performance and machine life. Use a clean, high quality, anti-wear hydraulic fluid with a viscosity index (VI) of 135 minimum. It should have a maximum viscosity of 500 cSt (2000 SSU) at startup (ambient temperature) and a minimum viscosity of 13 cSt (65 SSU) at the maximum fluid temperature (generally 80°F above ambient). Using hydraulic fluids that do not meet these criteria may cause poor operation and/or damage to the hydraulic components.

The following table specifies the fluid temperature at various viscosities. Temperature rise of the hydraulic fluid can vary from 30° F to about 80° F over the ambient temperature depending on the pressure setting, age of the pump, wind, etc. Mobil Univis N46 hydraulic fluid is installed at our factory. The advantage of this fluid is a wider temperature range, however, this fluid should not be used for continuous operation below 24°F.

TX03082-04-18-16

Hydraulic Fluids Characteristics

Manufacturer	Fluid Name	cSt 100F	cSt 210F	V.I.	-20F	-10F	0F	10F	30F	50F	70F	90F	110F	130F	150F	Range °F	Range °C
Mobil	DTE 10 Excel 15	15.8	4.1	168	***	********	********	********	********	********	********	********				-16 - 113	-27 - 45
	DTE 10 Excel 32	32.7	6.6	164				********	********	********	********	********	********	********	*	12 - 154	-11 - 68
	DTE 10 Excel 46	45.6	8.5	164				***	********	********	********	********	********	**********	****	23-173	-5 - 78
	DTE 10 Excel 68	68.4	11.2	156					*****	********	********	********	********	**********	*******	37-196	3 - 91
	Univis N-32	34.9	6.9	164				********	********	********	********	********	********	*******		12-150	-11 - 66
	Univis N-46	46	8.5	163				***	********	********	********	********	********	*********	***	24-166	-4 - 74
	Univis N-68	73.8	12.1	160					***	********	********	********	********	**********	*******	39-193	4 - 89

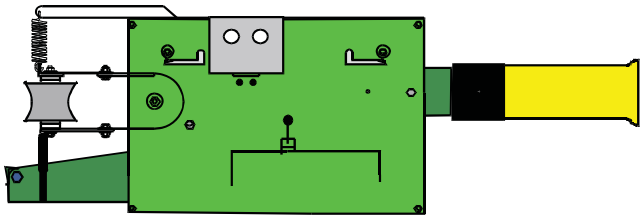
NOTE: This chart is based on pump manufacturer recommendations of 13 to 500 cSt.

NOTE: Temperatures shown are fluid temperatures. – NOT ambient temperatures.

Specifications

LineTamer

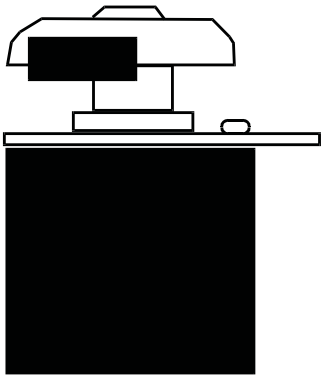
Dimensions: 50'' H x 46" W x 96" L (LineTamer only)
Weight: 730 lbs.
Pipe Capacity: 3", 4", 5" & 6" IPS pipe
4", 5" & 6" Pipe Rollers Standard
(3" & 4" Pipe Rollers Optional)



CD00302-3-31-97

Hydraulic Power Unit

Fluid: Mobil DTE 15M or equivalent
Reservoir Capacity: 5 gallons
Maximum Pressure: 2500 psi
Flow: 2.0 GPM @ 2000 psi



CD00304-5-20-96

Engine: Honda 5 HP OHV vertical-shaft engine with electronic ignition
Starting System: Pull Start
Fuel Type: Unleaded
Fuel Tank Capacity: 1.16 QT

TX00964-5-26-05

About this manual . . .

McElroy Manufacturing continually strives to give customers the best quality products available. This manual is printed with materials made for durable applications and harsh environments.

This manual is waterproof, tear resistant, grease resistant, abrasion resistant and the bonding quality of the printing ensures a readable, durable product.

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