

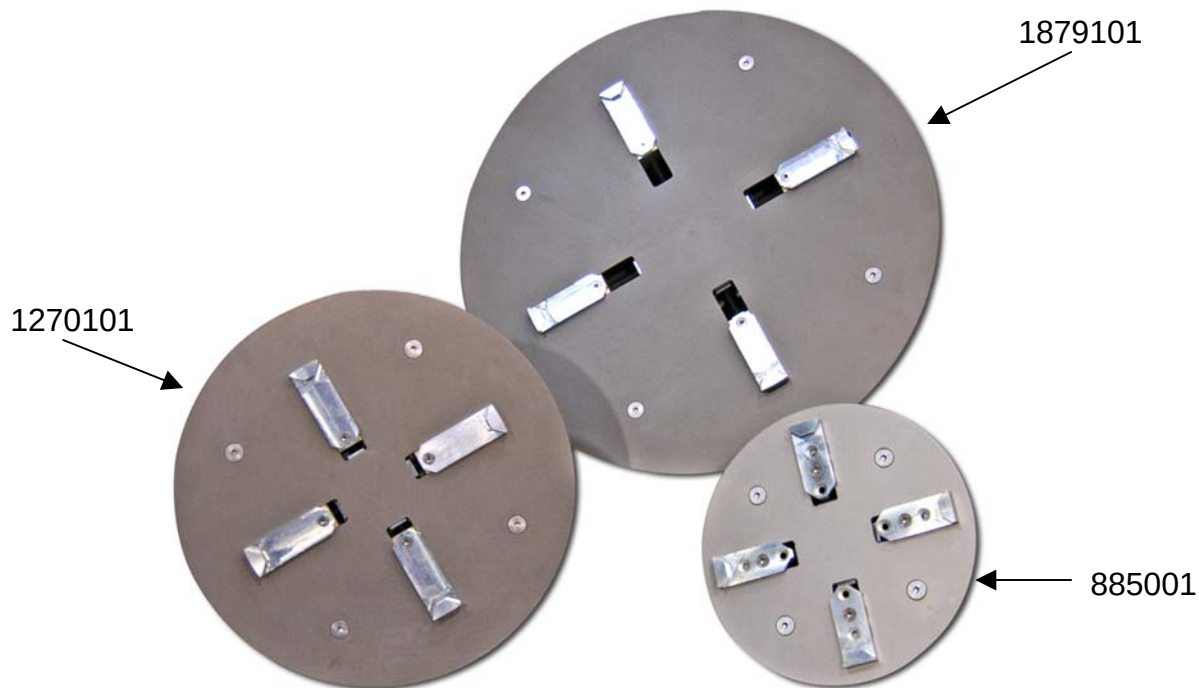


INSTRUCTION SHEET

Stub End Holders

Overview

The stub end holder is used when fusing stub ends on thermoplastic pipe using a McElroy fusion machine. The stub end holder is a self centering chuck that is held in the jaw of the fusion machine and in turn, grips the OD or ID of the stub end.



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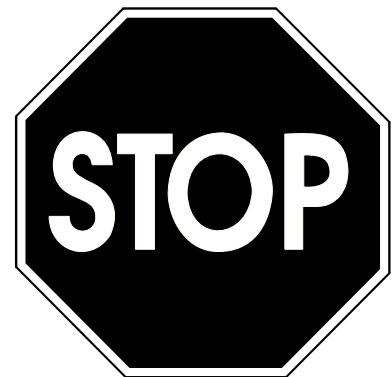
Fusion Procedures

Read Before Operating

Before operating the fusion machine, please read the fusion machine manual thoroughly and keep a copy available for future reference.

Before using the stub end holder, please read this instruction sheet thoroughly.

Use this instruction sheet with the operator's manual to complete the fusion procedures.



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INSTRUCTION SHEET

Stub End Holders

Prepare Heater



DANGER Heater Is Not Explosion Proof. Operation of heater in a hazardous environment without necessary safety precautions will result in explosion and death.

If operating in a hazardous environment, heater should be brought up to temperature in a safe environment, then unplugged before entering the hazardous atmosphere for fusion.

Install butt fusion heater plates.

Remove the heater stripper bar.

NOTICE: The heater should never be used without butt fusion heater plates installed. Refer to the "Maintenance" section of the fusion manual for installation procedure.

Plug heater into a proper power source.

Allow heater to warm-up to operating temperature.

Refer to the "Maintenance" section of the manual for instructions on how to adjust heater temperature.



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Loading the Pipe

Clean the inside and outside of pipe ends that are to be fused.

Open the upper jaws and insert pipe into the jaws of the fusion machine with applicable inserts installed. Let the pipe end protrude past the face of the jaw.



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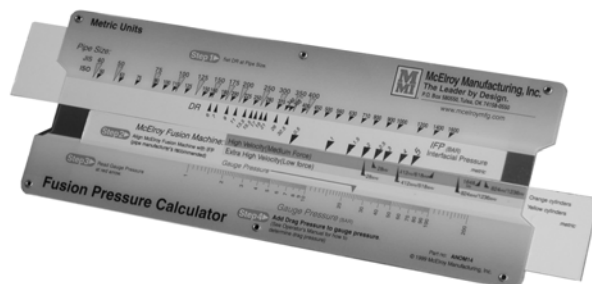


INSTRUCTION SHEET

Stub End Holders

Check Hydraulic Pressure

Refer to the fusion machine's operator's manual for procedures on setting the hydraulic fusion pressures.



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Facing the Pipe

IMPORTANT: It may be necessary to remove the facer from the pivot shaft in order to face the ends of the pipe. Refer to the operator's manual for procedures on removing the facer.

Open the carriage.

Move facer into place.

Open the ball valve on the facer motor.

Move the carriage control valve to the close position.

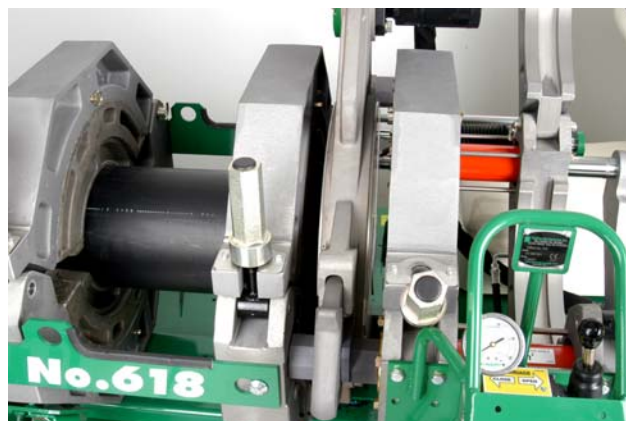
If the facer begins to stall, adjust the facing pressure so the facer continues to cut.

IMPORTANT: When drag pressure exceeds 300 psi it is necessary to move the carriage to the left bringing the pipe ends into contact with the facer before opening the facer valve.

Let the carriage bottom out on facer stops. Turn the facer off by closing the ball valve. Open the carriage so the facer can be removed.



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INSTRUCTION SHEET

Stub End Holders

Installing Stub End Holder

Push jaw detent pins back so that it is flush with the face of the jaw.

Open the inner jaw.

Place the stub end holder into the lower jaw.

Close the upper jaw and tighten the clamp knob.

Check to assure that the stub end holder is parallel to the jaw face.



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Loading Stub End

Rotate the handle on the back of the stub end holder to position the jaws of the holder according to the size adapter or stub end to be used.

Place the adapter or stub end onto the stub end holder.

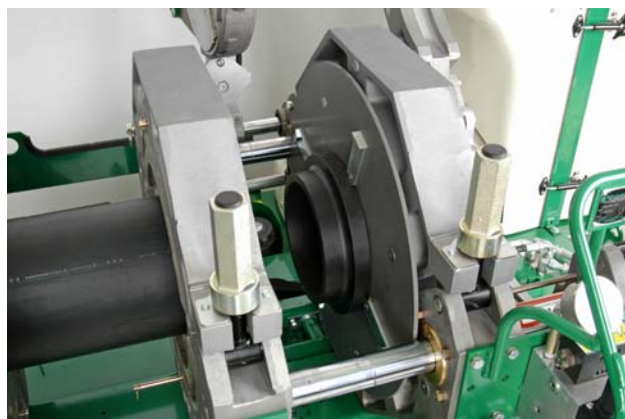
Rotate the handle on the back of the stub end holder to tighten the jaws against the adapter or stub end.

Assembly 885001 may require the jaws to be moved to a different mounting location. This is done with a 5/32" hex key.

Assemblies 1270101 and 1879101 have two serrated surfaces on the jaws for OD clamping and one serrated surface that may be used for gripping large stub ends on the ID. It is recommended to grip the OD of the stub end whenever possible.



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INSTRUCTION SHEET

Stub End Holders

Facing the Stub End

Move facer into place.

Open the ball valve on the facer motor.

Move the carriage control valve to the close position. Let the facer take off one ribbon of material.

Use just enough carriage pressure to make the facer cut.

IMPORTANT: When drag pressure exceeds 300 psi it is necessary to move the carriage to the left bringing the pipe ends into contact with the facer before opening the facer valve.

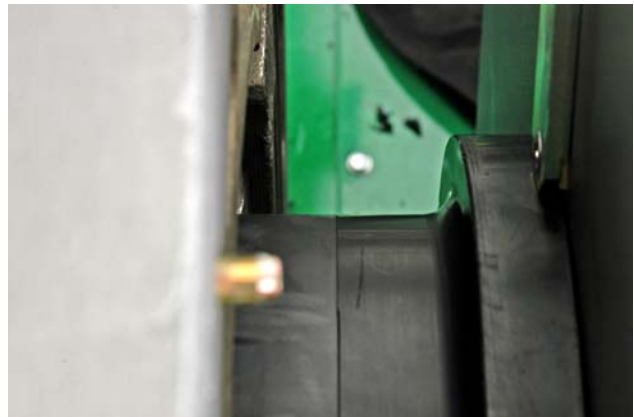
After the facer has made on full revolution of uninterrupted cut, shift the carriage into neutral and let the facer run until it stops cutting.

After the facer stops cutting, turn the facer off by closing the ball valve. Open the carriage so the facer can be removed.

Bring the carriage together and check the pipe for proper alignment. If pipe is not lined up with stub end, tighten the jaw of the pipe if the pipe is higher than stub end. Ensure there is no unacceptable gap between the ends.



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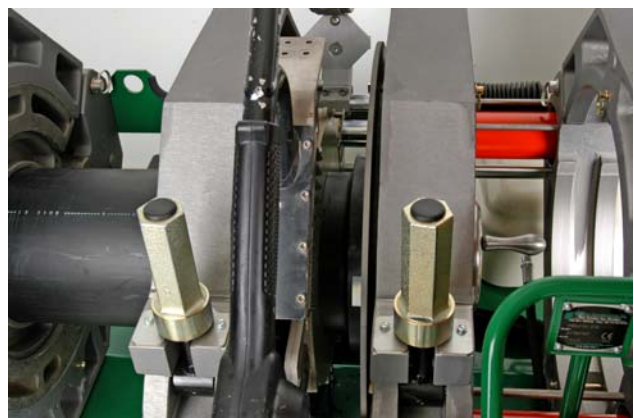
Heating the Pipe

Check heater for proper temperature.

Use a clean non-synthetic cloth to clean the butt fusion heater plate surfaces.

Open the carriage and insert the heater. Close the carriage bringing the heater into contact with both pipe ends. Ensure both ends are in full contact with the heater.

Move the selector valve to the center position.



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INSTRUCTION SHEET

Stub End Holders

Fusing the Pipe



Failure to follow pipe manufacturer's fusion procedures or appropriate joining standard may result in a bad joint.

After following the pipe manufacturer's procedures or appropriate joining standard.

Shift the carriage control valve to neutral position, if it is not already in that position.

Shift the selector valve down to fusion position.

Shift carriage control valve to the open position and allow the carriage to open up enough to remove the heater.

Quickly remove the heater.

Quickly close the carriage bringing the pipe ends together under the pipe manufacturer's procedures or appropriate joining standard.

Allow joint to cool under pressure according to pipe manufacturer's procedures or joining standard.



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Opening Jaws

Using the handle on the back of the stub end holder, rotate the handle to release the end of the fused pipe from the jaws.

Open the jaws.

Remove the fused pipe.

Open the inner jaw and remove the stub end holder.

If other adapters or stub ends are to be fused, repeat the step from this instruction sheet and steps in the fusion machine's operator's manual.



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