

## INSTRUCTION MANUAL

**Link Peeler** for PE/PP-pipes 10-18" IPS &  
10-16" DIPS (250-450 mm)

Optional Extension: to 20" – 30" (500-800 mm)

For PE/PP-pipes 10-30" IPS / 10-24" DIPS (250-800 mm)

For PE/PP-pipes 10-36" IPS / 10-36" DIPS (250-1000 mm)



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# 1. Safety

For safe handling and a hassle-free operation of this product, requires understanding and following fundamental safety guidelines and safety regulations. This instruction manual contains important information on how to handle the device safely. Anyone working with this equipment shall read and understand these instructions. These instructions shall be read and implemented in accordance with the relevant standards, workplace health and safety legislation, installation instructions, Codes of Practice, and technical connection guideline in force in your country.

## 1.1 General safety guidelines for tools

- a) Read and make sure you understand all safety guidelines and instructions. Failure to follow the safety guidelines and instructions can lead to electric shock, fire and/or serious injury.
- b) Keep these safety guidelines and instructions for future use.

### 2) Safety in the work area

- a) Keep your work area clean and well lit. Working in cluttered or dark areas can easily lead to accidents. Prevent the tool from unintentional movement or dropping and assume a secure foothold.

### 3) Personal safety

- a) Stay alert! Watch what you are doing and use common sense when operating a tool.
- b) Use personal protective equipment and always wear eye protection. The use of protective equipment such as a dust mask, non-skid safety shoes, a hard hat or hearing protection, depending on the tool and its use will reduce personal injuries.
- c) Wear appropriate clothing. Do not wear loose clothing or jewelry. Keep your hair, clothing, and gloves away from moving parts. Loose clothes, jewelry or long hair can get caught by moving parts.

### 4) Tool usage and care

- a) Keep cutting tools sharp and clean. Properly maintained cutting tools with sharp and clean blades do not get stuck as easily and are easier to handle during operation.
- b) The blade is subject to wear. When not in use, always keep the Link Peeler clean and dry in the suitcase.
- c) Keep your tools clean. Follow the servicing instructions and the instructions for changing the tools. Keep oil and grease away from the handles.
- d) Care for your tools. Check for misalignment or binding of moving parts, breakage of parts and any other condition that may affect the operation of the tools. If damaged, have the tool repaired before use. Many accidents are caused by poorly maintained tools.
- e) Use the tool, accessories etc. in accordance with these instructions. Take the working conditions and the work to be performed into account. The use of the tool for applications differing from the application scope could result in a hazardous situation.
- f) The thickness of the peeling must be checked with a suitable measuring instrument on a regular basis.

### 5) Service

- a) Have your tool repaired only by a qualified technician with identical replacement parts. This will ensure that the safety of the tool is maintained.

## 1) Specific safety guidelines for the Link Peeler Personal safety

- a) The operator must have a safe foothold. Working overhead in areas not completely visible (e.g., under a pipe) is prohibited.
- b) Pipes and other workpieces must be firmly clamped or fixed. Poorly clamped or fixed workpieces may hurt you or affect your safe foothold.
- c) The blade is very sharp. This poses a risk of injury. Do not touch the blade.

## 1.2 Explanation of symbols

This instruction manual can make use of the following symbols:

### 1.2.1 General symbols



#### **This symbol indicates a general advice.**

This information describes recommended courses of action to enable the user to perform steps quicker and safer. The symbol can also underline certain required precondition or mean that the user must follow certain mandatory steps.

### 1.2.2 Mandatory symbols



#### **Observe the instructions!**

Read the provided documentation thoroughly to prevent applications errors and to work safer and according to the scope of application with the respective product. All users of the product must thoroughly read and understand the provided documentation prior to use.

**Reading the documentation thoroughly and completely helps in preventing accidents due to improper use and eases the work with the product.**

### 1.2.3 Prohibition symbols



#### **General prohibition symbol!**

There is a high risk of injury. Observe the detailed description of the prohibition.

**Failure to comply with this prohibition can lead to injury or damage to devices, machines, or tools.**

### 1.2.4 Warning symbols



#### **General warning symbol!**

This symbol warns of a potentially dangerous situation.

**Failure to comply with the warning and advice can lead to injury or damage to goods.**



#### **Warning: Sharp elements!**

This symbol warns of a potential risk of injury due to pointy and/or sharp items like needles or blades.

**Failure to comply with the warning and advice can lead to stabbing or cutting injuries to the hands or other body parts.**

## 2. Introduction

### 2.1 Scope of application

The Link Peeler 10"IPS – 18"IPS & 10"DIPS – 16"DIPS (250-450 mm), 10"IPS – 30"IPS (250-800 mm), and 10"IPS – 38"IPS (250-1000 mm) are solely meant for the removal of the oxide layer on polyethylene pipes as preparation for electrofusion (EF). Additionally, they are approved for usage on polypropylene (PP) and cross-linked polyethylene (PE-X) pipes.

The Peeler links can universally be used to scrape pipe ends (for welding fittings) and to scrape spots on pipes (for welding saddles).



#### **Intended Use**

It is not allowed to use the tool for any application not covered by the above stated terms. Modifying the tool without consulting the manufacturer is forbidden and shall be considered as improper use.

**The manufacturer is not liable for use of the Rotational Link Peeler Tool that falls outside its application scope!**

### 2.2 Maintenance and service

Should the tool fail despite the great care taken in manufacturing and testing it, the necessary repairs should only be carried out by an after-sales service center authorized by the manufacturer.

Please note that the product is a technically demanding machine for field application. In accordance to the applicable standards the tool is subject to periodical maintenance. The maintenance interval is 12 months, with heavy use shorter intervals are recommended.

During maintenance, the tool will be upgraded to the current technical standard of our devices, and you get a 3-month guarantee on function for the maintained tool.

The maintenance and the related checks are important for your safety and the continuous working reliability and safety of the tool. Therefore, the maintenance and all necessary repairs, must be carried out by the manufacturer or an authorized service point.

For further information about our after-sales service centers please contact:

**Integrity Fusion Products**  
**270 Parkade Ct.**  
**Peachtree City, GA 30269**

**PH: 770-632-7530**  
**[www.integrityfusion.com](http://www.integrityfusion.com)**

In all correspondence, please provide the serial number (S/N) as shown on the type-plate of the tool.

### 2.3 Handling and maintenance

To achieve optimum work results the tool must be handled with care and maintained frequently. Pollution by sand and dirt must be avoided or, if necessary, removed with a soft cloth or a Q-tip.

### 2.4 Disposal

The Link Peeler must be disposed of in an environmentally friendly way sorted by materials.

### 3. Scope of delivery

#### 3.1 Link Peeler 10'' – 18'' IPS & 10'' – 16'' DIPS (250-450 mm)

4_4200_007	Link Peeler 10'' – 18'' IPS & 10'' – 16'' DIPS (250-450 mm)		Enclosed
	1 x	Instruction manual	GB271
	1 x	Spare blade	2_4201_003
	1 x	Hex key screwdriver	1_2904_003
	1 x	Plastic suitcase	1_2800_013
	4 x	Roller wagon with link piece 55 mm	2_4200_001/3
	2 x	Roller wagon with link piece 85 mm	2_4200_001/2
	1 x	Hex screwdriver (long)	1_2904_004
	1 x	Biasing and scraping unit	2_4200_011

#### 3.1.1 Scope of delivery optional Extension 20'' – 30'' (500-800 mm)

4_4200_008	Extension 20'' – 30'' (500-800 mm) for Link Peeler 10'' – 18'' IPS & 10'' – 16'' DIPS (250-450 mm)		Enclosed
	1 x	Plastic toolbox with foam lining	1_2800_007
	2 x	Roller wagon with link piece 85 mm	2_4200_001/2

#### 3.2 Scope of delivery Link Peeler 10-30'' IPS / 10-24'' DIPS (250-800 mm)

4_4200_009	Link Peeler 10-30'' IPS / 10-24'' DIPS (250-800 mm)		Enclosed
	1 x	Instruction manual	GB271
	1 x	Spare blade	2_4201_003
	1 x	Hex key screwdriver	1_2904_003
	1 x	Plastic suitcase	1_2800_013
	4 x	Roller wagon with link piece 55 mm	2_4200_001/3
	4 x	Roller wagon with link piece 85 mm	2_4200_001/2
	1 x	Hex screwdriver (long)	1_2904_004
	1 x	Biasing and scraping unit	2_4200_011



### 3.3 Scope of delivery Link Peeler 10-36" IPS / 10-36" DIPS (250-1000 mm)

4_4200_029	Link Peeler 10-36" IPS / 10-36" DIPS (250-1000 mm)		Enclosed
	1 x	Instruction manual	GB271
	1 x	Spare blade	2_4201_003
	1 x	Hex key screwdriver	1_2904_003
	1 x	Plastic suitcase	1_2800_013
	6 x	Roller wagon with link piece 55 mm	2_4200_001/3
	5 x	Roller wagon with link piece 85 mm	2_4200_001/2
	1 x	Hex screwdriver (long)	1_2904_004
	1 x	Biasing and scraping unit	2_4200_011

## 4. Technical data

### 1.1 Link Peeler 10-36" IPS / 10-36" DIPS (250-1000 mm)

4_4200_007 Link Peeler 10-36" IPS / 10-36" DIPS (250- 1000 mm)		
<b>General</b>		
Suitable for pipes made of		PE, PE-HD, PE-X, PP
For pipe dimensions	[mm]	250-450
For pipe dimensions	IPS	10-18
For pipe dimensions	DIPS	10-16
Scraping depth	[mm]	0.3 (0.25 to 0.35)
<b>Dimensions, weights and packaging</b>		
Product dimensions L x W x H	[in./mm]	Depending on pipe dimension x 4" x 3.5" in.
Product weight	[lbs./ kg]	10 lbs. 9.3 oz (4.8 kg)
Packaging dimensions L x W x H	[ins./mm]	22.5" x 18.9" x 5.7" (570 x 480 x 145 mm )
Packaging material		Plastic
Packaging type		Suitcase
Packaging weight	[lbs./kg]	7 lbs. 11.5 oz. (3.5 kg)
Transport weight	[lbs./kg]	18 lbs. 4.8 oz. (8.3 kg)

The given technical information is valid for the standard setup of the tool. Depending on the ordered setup there may be variations.

### 1.1.1 Extension 20'' – 30'' (500-800 mm)

<b>4_4200_008      Extension 20'' – 30'' (500-800 mm) for Link Peeler 10'' – 18'' (250-450 mm)</b>		
<b>General</b>		
<b>Suitable for pipes made of</b>		PE, PE-HD, PE-X, PP
<b>For pipe dimensions</b>	<b>[mm]</b>	500-800
<b>For pipe dimensions</b>	<b>IPS</b>	20-30
<b>For pipe dimensions</b>	<b>DIPS</b>	18-24
<b>Dimensions, weights and packaging</b>		
<b>Product dimensions L x W x H</b>	<b>[mm]</b>	Depending on pipe dimension x 4'' x 3.5'' in.
<b>Product weight</b>	<b>[lbs./kg]</b>	2 lbs. 3.3 oz (1 kg)
<b>Packaging dimensions L x W x H</b>	<b>Lbs./ [mm]</b>	13'' x 7'' x 5.5'' (320 x 180 x 135)
<b>Packaging material</b>		Plastic
<b>Packaging type</b>		Box
<b>Packaging weight</b>	<b>[lbs./kg]</b>	1 lb. 1.6 oz (0.5 kg)
<b>Transport weight</b>	<b>[lbs./kg]</b>	33 lbs. 1.1 oz. (1.5 kg)

The given technical information is valid for the standard setup of the tool. Depending on the ordered setup there may be variations.

## 1.2 Link Peeler 10'' – 30'' (250-800 mm)

4_4200_009		Link Peeler 10'' – 30'' (250-800 mm''
<b>General</b>		
Suitable for pipes made of		PE, PE-HD, PE-X, PP
For pipe dimensions	[mm]	250-800
For pipe dimensions	IPS	10-30
For pipe dimensions	DIPS	10-24
Scraping depth	[mm]	0.3 (0.25 to 0.35)
<b>Dimensions, weights and packaging</b>		
Product dimensions L x W x H	[in./mm]	Depending on pipe dimension x 4'' x 3.5'' (100 x 85)
Product weight	[lbs./kg]	13lbs. 7.2oz. (6.1 kg)
Packaging dimensions L x W x H	[in./mm]	25'' x 19'' x 6'' (570 x 480 x 145)
Packaging material		Plastic
Packaging type		Suitcase
Packaging weight	[lbs./kg]	7 lbs. 13.5.5oz (3.5 kg)
Transport weight	[lbs./kg]	21 lbs. 2.6oz. (9.6 kg)

The given technical information is valid for the standard setup of the tool. Depending on the ordered setup there may be variations.

### 1.2.1 Extension 900-1000 mm

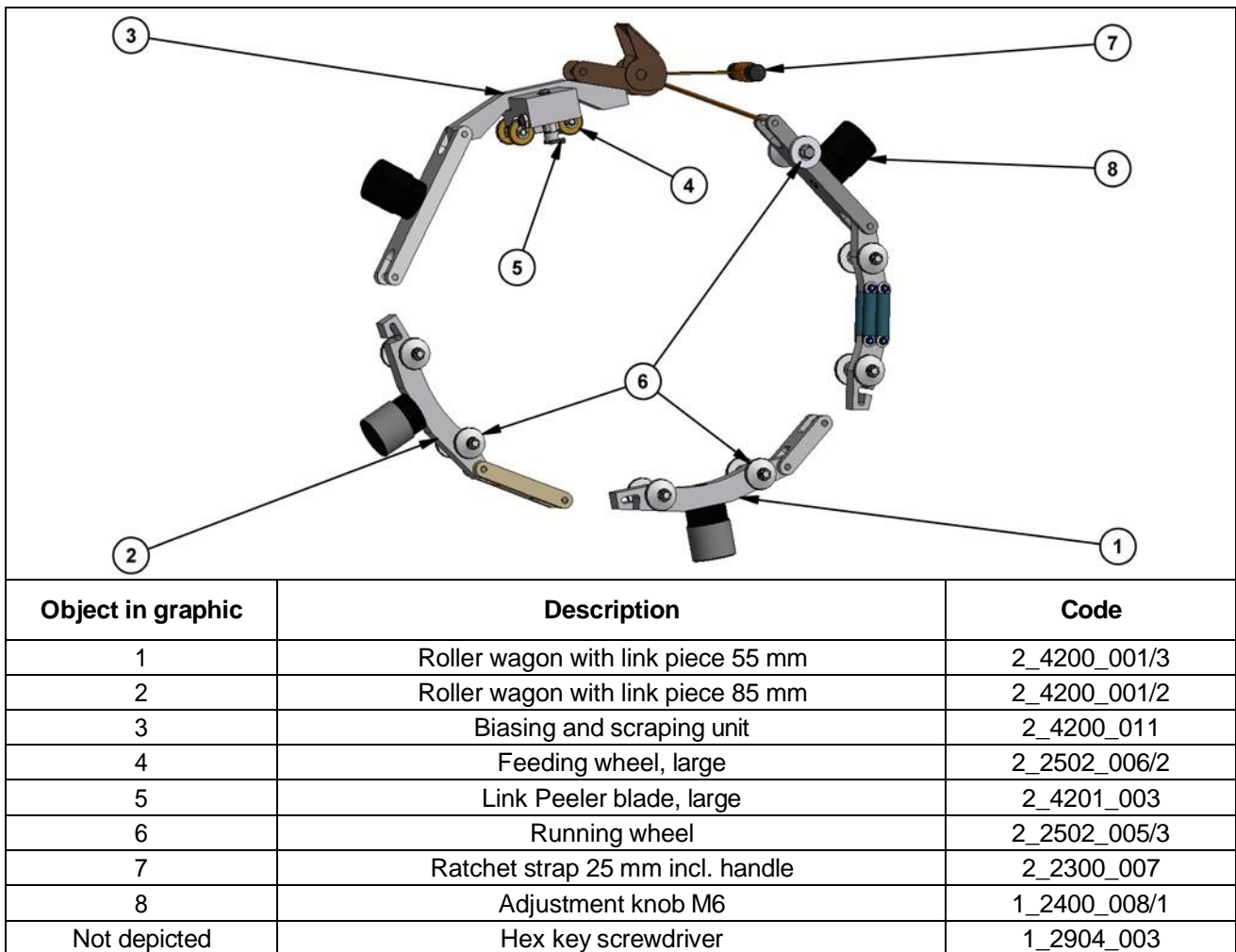
4_4200_010		Extension 900-1000 mm for Link Peeler 250-800 mm
<b>General</b>		
Suitable for pipes made of		PE, PE-HD, PE-X, PP
For pipe dimensions	[mm]	900-1000
For pipe dimensions	IPS	32-36
For pipe dimensions	DIPS	30-36
<b>Dimensions, weights and packaging</b>		
Product dimensions L x W x H	[in./mm]	Depending on pipe dimension x 4'' x 3.5'' (100 x 85)
Product weight	[kg]	3lbs. 4.9oz (1.5 kg)
Packaging dimensions L x W x H	[in./mm ]	320 x 180 x 135
Packaging material		Plastic
Packaging type		Box
Packaging weight	[lbs./kg]	1lbs. 1.6oz. (0.5 kg)
Transport weight	[lbs./kg]	4lbs. 6.5oz. (2 kg)

The given technical information is valid for the standard setup of the tool. Depending on the ordered setup there may be variations.

### 1.3 Link Peeler 10" – 38" (250-1000 mm)

4_4200_029		Link Peeler 10" – 38" (250-1000 mm)
<b>General</b>		
Suitable for pipes made of		PE, PE-HD, PE-X, PP
For pipe dimensions	[mm]	250-1000
For pipe dimensions	IPS	10-36
For pipe dimensions	DIPS	10-26
Scraping depth	[mm]	0.3 (0.25 to 0.35)
<b>Dimensions, weights and packaging</b>		
Product dimensions L x W x H	[ins./mm]	Depending on pipe dimension x 4" x 3.5" (100 x 85)
Product weight	[lbs./kg]	16lbs. 8.6oz. (7.5 kg)
Packaging dimensions L x W x H	[ins./mm]	25" x 19" x 6" (570 x 480 x 145)
Packaging material		Plastic
Packaging type		Suitcase
Packaging weight	[lbs./kg]	7 lbs. 13.5.5oz (3.5 kg)
Transport weight	[lbs./kg]	24lbs. 4oz. (11 kg)

## 2. Overview and spare parts



### 2.1 Special features

- Quick tensioning and adjustment to various pipe dimensions due to individual elements.
- Ovality compensation by spring action.
- Tilttable blade as well as tilttable blade wagon for optimum guidance of the Link Peeler blade on uneven or dented pipe surfaces.

### 3. Composition of the Link Peeler



**Danger of cutting injuries by Link Peeler blade!**

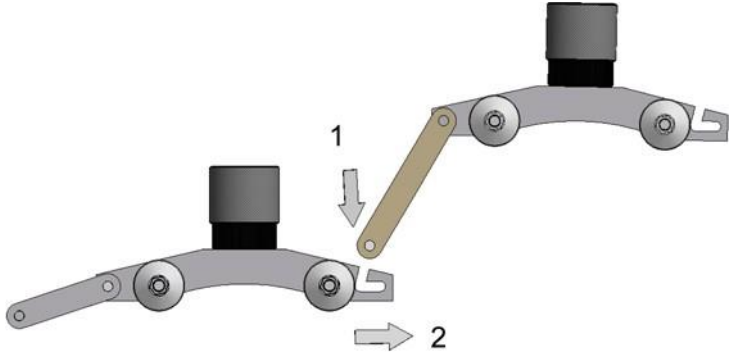
The blade is very sharp! Handling the spare blades involves a high risk of injury.

**Always wear cut-proof gloves as soon as you handle the peeling blades.**

Depending on the dimension of the pipe a different number of roller wagons and link pieces must to be used. A complete Link Peeler consists of a biasing and scraping unit and, depending on the ordered version (plus optional extension), a different number of roller wagons with link pieces. The table below gives an overview of the composition for different pipe diameters.

Pipe size			Number	Number	Number
mm	IPS	DIPS	Biasing and scraping unit	Roller wagon with link piece 55 mm	Roller wagon with link piece 85 mm
250	10"		1		1
280		10"	1		1
315	12"		1	1	1
355	14"	12"	1		2
		14"	1	3	
400	16"		1	2	1
450	18"	16"	1	4	
500	20"	18"	1		4
560	22"	20"	1	4	1
	24"		1	4	2
630	26"	24"	1	2	4
710	28"		1	3	4
800	30"		1	4	4
	32"	30"	1	3	5
900	34"		1	5	4
	36"		1	5	4
		36"	1	6	4
1000			1	6	5

### 3.1 Assembly of the Link Peeler

Step	Action
<p><b>1</b></p> <p><b>Connecting the roller wagons</b></p> <p>1.1</p>	<p>Like shown in the picture, the single roller wagons with link pieces can be easily attached to one another. Attaching the individual elements is only possible when inserting them at a certain angle. This prevents an unintentional falling apart of the assembled chain.</p> 

## 4. Scraping

### 4.1 Preparation: Cleaning and marking

Step	Action
<p><b>1</b></p> <p><b>Cleaning the pipe</b></p> <p>1.1</p>	<p>Use a clean cloth free of dirt and grease to remove mud, sand and dirt from the surface you want to scrape. If necessary additionally use certified pipe cleaner.</p>
<p><b>2</b></p> <p><b>Mark the area you want to scrape</b></p> <p>2.1</p>	<p>Mark the insertion depth of the fitting resp. the area of contact of the saddle according to the processing guidelines of the fitting manufacturer with a certified marker. The area to be scraped should be marked with wave-like markings.</p>

## 4.2 Mounting and tensioning the Link Peeler



### Attention!

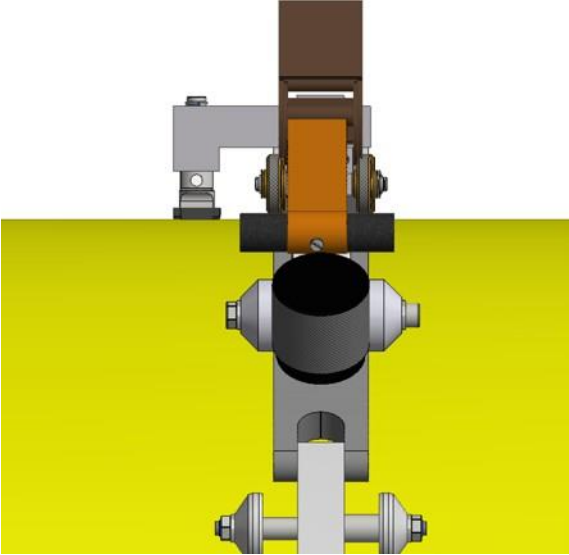
- The Link Peeler always runs ahead of the knife.
- When scraping pipe ends which have a smaller diameter than the rest of the pipe it can be necessary to loosen the Link Peeler and tighten it again. Due to the increasing diameter of the pipe the tensioning of the Link Peeler is sufficient for the smaller pipe end section but it can be too tight when you leave the smaller pipe section during the process of scraping.
- This results in a higher force needed for scraping. When you notice this loosen the Link Peeler and re-tighten it.

### 4.2.1 Case of application 1: Scraping pipe ends

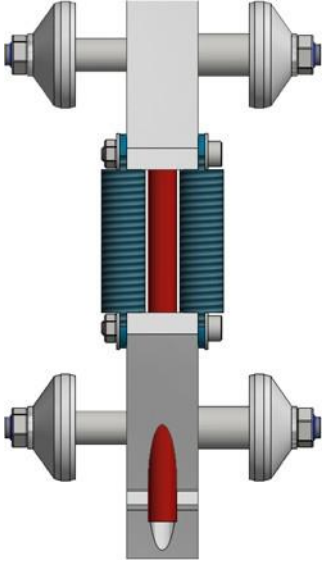
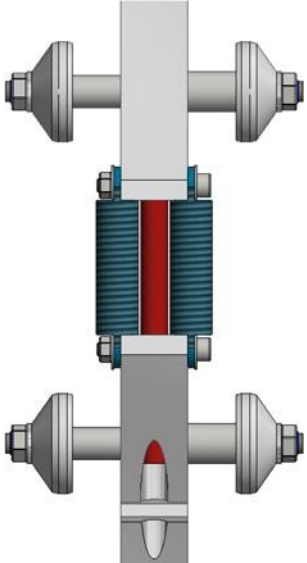
Step	Action
<b>1</b>	<b>Fully open the strap ratchet</b>
1.1	Fully open the strap ratchet to unlock the slotted spindle. The black rod prevents the strap from slipping out of the ratchet.
<b>2</b>	<b>Put the Link Peeler around the pipe</b>
2.1	Put the assembled Link Peeler around the pipe. If that is not possible, connect the ends of the Link Peeler after having put it around the pipe.
<b>3</b>	<b>Align the Link Peeler blade</b>
3.1	Put the assembled Link Peeler around the pipe. The blade must rest with about $\frac{1}{2}$ - $\frac{3}{4}$ of its width on the pipe end.
<b>3</b>	<b>Tensioning the chain</b>
3.1	Pull the strap using the black rod, so that the chain is tightens around the pipe. Make sure that the chain is perpendicular to the pipe.
3.1	Pull the black rod tight with one hand and hold/support it, using the black knob as support. Use the ratchet to tighten the Link Peeler around the pipe.



#### 4.2.2 Case of application 2: Peeling a saddle area

Step	Action
<p><b>1</b></p> <p>1.1</p>	<p><b>Fully open the strap ratchet</b></p> <p>Fully open the strap ratchet to unlock the slotted spindle. The black rod prevents the strap from slipping out of the ratchet.</p>
<p><b>2</b></p> <p>2.1</p>	<p><b>Put the Link Peeler around the pipe</b></p> <p>Put the assembled Link Peeler around the pipe. If that is not possible, connect the ends of the Link Peeler after having put it around the pipe.</p>
<p><b>3</b></p> <p>3.1</p>	<p><b>Align the Link Peeler blade</b></p> <p>Put the Link Peeler chain at the appropriate point around the pipe and close the chain. The blade should be set on the middle of the outer limit of the marking on the area of contact.</p> 
<p><b>3</b></p> <p>3.1</p> <p>3.1</p>	<p><b>Tensioning the chain</b></p> <p>Pull the strap using the black rod, so that the chain is tightens around the pipe. Make sure that the chain is perpendicular to the pipe.</p> <p>Pull the black rod tight with one hand and hold/support it, using the black knob as support. Use the ratchet to tighten the Link Peeler around the pipe.</p>

### 4.2.3 Note the indicators

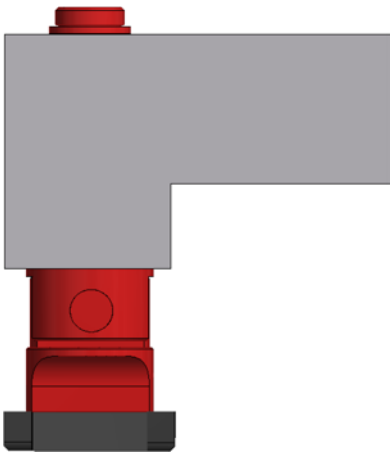
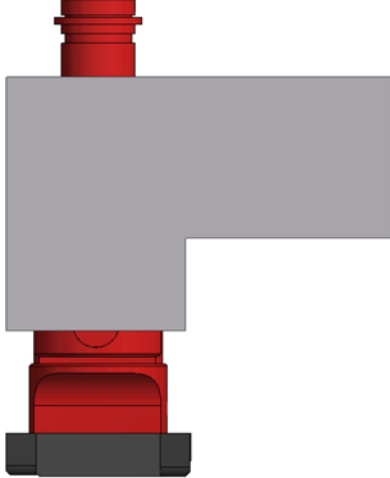
Step	Action
1 1.1	<p data-bbox="272 264 655 297"><b>Indicator on the spring wagon</b></p> <p data-bbox="272 315 1422 376">An indicator pin is located on the spring wagon. The Link Peeler is tightened sufficiently when the indicator pin is still visible.</p> <div data-bbox="389 416 711 976"></div> <p data-bbox="381 1025 735 1059"><b>Spring wagon not tightened</b></p> <div data-bbox="992 416 1299 976"></div> <p data-bbox="1007 1025 1313 1059"><b>Spring wagon tightened</b></p>



**Note**

The indicator pin gives you information about the tension in the Link Peeler. Depending on the pipe dimension, it can become necessary to apply lesser or more tension so the the indicator is retracted or protruded a little more.

Excessive tightening may damage the Link Peeler. If you tension the Link Peeler too much, the indicator pin can slip from its guidance bore and become lost.

Step	Action
<p data-bbox="188 210 209 239">2</p> <p data-bbox="188 277 225 306">2.1</p>	<p data-bbox="272 210 639 239"><b>Indicator on the blade holder</b></p> <p data-bbox="272 259 1362 320">The blade holder also features an indicator pin. When the tensioning force is increased it will protrude on the upper side.</p> <div style="display: flex; justify-content: space-around; align-items: center;"> <div style="text-align: center;">  <p data-bbox="379 969 732 999">Blade holder free of tension</p> </div> <div style="text-align: center;">  <p data-bbox="983 969 1329 999">Blade holder under tension</p> </div> </div>



**Note**

Always make sure that the blade holder is not fully compressed. Only then the spring in the blade holder will push the Link Peeler blade forcefully enough against the pipe surface to scrape flat spots.

### 4.3 Scraping the pipe

Step	Action
<p data-bbox="188 1361 209 1391">1</p> <p data-bbox="188 1413 225 1442">1.1</p>	<p data-bbox="272 1361 639 1391"><b>Clamping and fixing the pipe</b></p> <p data-bbox="272 1411 1362 1471">Fix or clamp the pipe before you begin scraping it to improve the scraping result and prevent accidents.</p>
<p data-bbox="188 1491 209 1520">2</p> <p data-bbox="188 1543 225 1572">2.1</p> <p data-bbox="188 1610 225 1639">2.2</p>	<p data-bbox="272 1491 691 1520"><b>Beginning the peeling procedure</b></p> <p data-bbox="272 1541 1414 1601">When you are finished with tensioning, after having checked both indicator pins while tensioning, you can begin with the scraping procedure.</p> <p data-bbox="272 1612 1445 1695">Begin scraping by pulling the Link Peeler around the pipe. The Link Peeler has its own feeding. Do not tilt the chain. Your position should ideally be 90° to the pipe so that no axial forces influence the set feed of the tool.</p>



When scraping, position yourself directly in front of the Link Peeler and pull on the handles. **If you stand to the side of the chain and pull it, a reliable and precise feed cannot be guaranteed.**

Step	Action
<b>3</b>	<b>Observe the peel width</b>
2.1	After the first rotation, check if the peel width measures about 2/3 max. of the blade width. If the peel width is larger or considerably smaller, the feed must be readjusted. See chapter 9 „Adjusting the feed“.
2.2	Pull the , chain around the pipe until the blade reaches the end of the marked area.



**Note**

In case of an insufficient scraping the feed has to be checked and readjusted or the blade has to be replaced. In consideration of the processing guidelines of the fitting manufacturer and the tolerances specified therein (max. gap between pipe and fitting) the pipe may be scraped a second time.

Link Peeler blades are subject to wear.

Use only on cleaned pipe surfaces.

Keep the Link Peeler clean and dry in the suitcase.

The thickness of the peel must be regularly checked with a suitable measuring device.

## 5. Dismounting the Link Peeler

Step	Action
<b>1</b>	<b>Releasing the tension</b>
1.1	To dismount the Link Peeler from the pipe the ratchet of the ratchet strap must be opened.
1.2	Do not use any extra tools to release the tension. Use the locking pawl on the strap ratchet to controllably release the tension.
<b>2</b>	<b>Dismounting the Link Peeler</b>
2.1	Disconnect the Link Peeler or take it off in one piece.
<b>3</b>	<b>Safely store the Link Peeler</b>
3.1	Disassemble the Link Peeler after using it and put its parts back into the transport container. This will keep the tool in a good condition.



**Note**

After removing the Link Peeler from the pipe, always make sure that you have completely scraped the marked area.

### 5.1 Additional notes

- In case of an insufficient scraping result the blade has to be replaced.
- In consideration of the processing guidelines of the fitting manufacturer and the tolerances specified therein (max. gap between pipe and fitting) the pipe may be scraped a second time.
- The Link Peeler blades are subject to wear.
- Use only on cleaned pipe surfaces.
- When not in use, always keep the Link Peeler clean and dry in the suitcase!
- The thickness of the peeling must be checked with a suitable measuring instrument on a regular basis.

## 6. Adjusting the feed

### 6.1 Increase the feed (widen peel width)

To increase the feed and the peel width, the feed wagon must be pivoted slightly more towards the non scraped area.



#### Note

The smaller the pipe dimension of the pipe to be scraped, the more feed is necessary to maintain a peel width of about 1/2 to 2/3 of the blade width.

Turn the adjustment screws only by 1/4 turn increments and afterwards scrape for 2 or 3 rotations so that the altered feed setting can take effect.

Step	Action
<b>1</b>	<b>Screw out the right adjustment screw</b>
1.1	Turn the right adjustment screw (1) for 1/4 turn (counter-clockwise).
<b>2</b>	<b>Screw in the left adjustment screw</b>
2.1	Turn the left adjustment screw (2) for 1/4 turn (clockwise).
<b>3</b>	<b>Check the feed</b>
3.1	After the adjustment make sure that the feed wagon is fixed again so that it does not move. Check the altered feed setting by scraping further.

## 6.2 Reducing the feed (reducing the peel width)

To reduce the feed and the peel width, the feed wagon must be pivoted slightly more towards the already scraped area.



### Note

The bigger the pipe dimension of the pipe to be scraped, the less feed is necessary to maintain a peel width of about 1/2 to 2/3 of the blade width.

Turn the adjustment screws only by 1/4 turn increments and afterwards scrape for 2 or 3 rotations so that the altered feed setting can take effect.

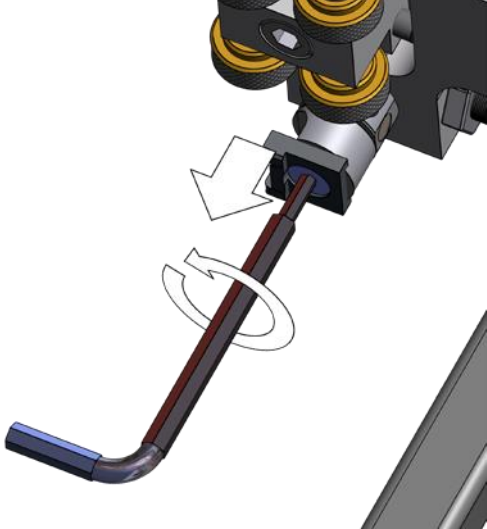
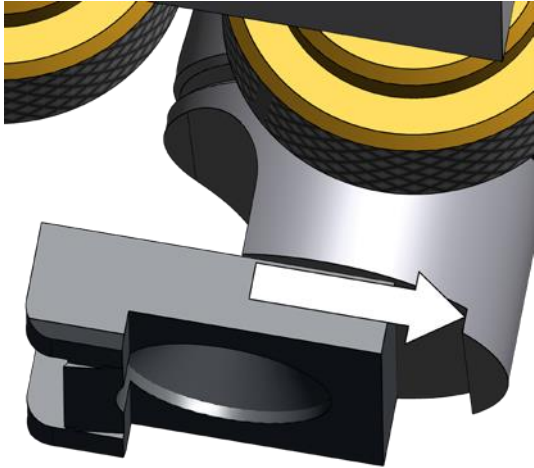
Step	Action
<b>1</b>	<b>Screw out the left adjustment screw</b>
1.1	Turn the left adjustment screw (1) for 1/4 turn (counter-clockwise).
<b>2</b>	<b>Screw in the right adjustment screw</b>
2.1	Turn the right adjustment screw (2) for 1/4 turn (clockwise).
<b>3</b>	<b>Check the feed</b>
3.1	After the adjustment make sure that the feed wagon is fixed again so that it does not move. Check the altered feed setting by scraping further.

## 7. Changing the Link Peeler blade



### Attention!

The blade is very sharp! Handling the spare blades involves a high risk of injury. Always wear cut-proof gloves as soon as you handle the scraping blades.

Step	Action
<p><b>1</b></p> <p><b>Loosen the screw</b></p> <p>1.1</p>	<p>Loosen the hexagon socket head screw (2.5 mm) that secures the Link Peeler blade on the blade holder with the enclosed key and remove the old Link Peeler blade.</p> 
<p><b>2</b></p> <p><b>Mount new Link Peeler blade</b></p> <p>2.1</p>	<p>Make sure that the Link Peeler blade lies flat on the blade holder and that it touches the stop with its backside.</p> 

Step	Action
<p data-bbox="188 215 209 244"><b>3</b></p> <p data-bbox="188 264 225 293">3.1</p>	<p data-bbox="272 215 644 244"><b>Fix the new Link Peeler blade</b></p> <p data-bbox="272 264 1422 324">Hold the Link Peeler blade in this position and screw the hexagon socket head screw (2.5 mm) in again with the enclosed key.</p> <div data-bbox="683 360 1059 898" style="text-align: center;"> </div>



**Note**

The spare blades are incompatible with the pipe end scrapers of PF-Schweisstechnologie GmbH, because these have a different edge.





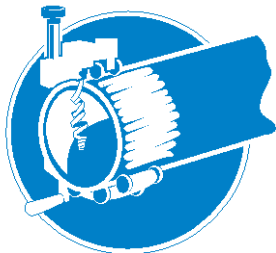






### General

Read complete manual!  
Observe fitting manufacturer's installation guide!  
Follow national and international directives!



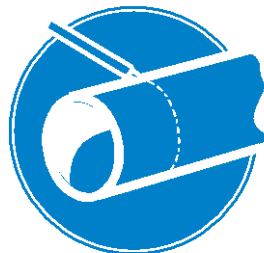
### Scraping

Remove dirt from the pipe!  
Mark welding area!  
Use rotational scraper tools only!



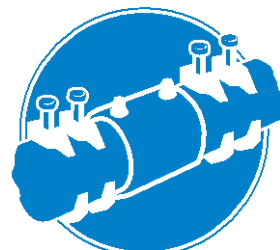
### Cleaning

Wipe around the pipe!  
Use approved cleaning agent!  
Use lint-free cloths!



### Marking

Do not touch the cleaned welding areas!  
Mark insertion depth of fitting!  
Use approved markers!



### Alignment

Use proper alignment tools!  
Avoid mechanical stress on pipes and fitting!  
Wait for cooling before pressurising!

## PF-SchweiBlechologieBmbH

Karl-Broger-StraBe 10  
DE-36304Alsfeld/Germany  
Phone +49 6631 9652-0  
E-Mail:info@pfs-gmbh.can  
www.pfs-gmbh.can