



## INSTRUCTION MANUAL

### Pipe End Peelers

for PE pipes 3" - 6"  
for PE pipes 8" - 16"

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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. The safety guidelines must be acknowledged and observed by everyone working with the device.

## 1.1 General Safety Guidelines

Read all safety guidelines and instructions. Failure to follow the safety guidelines and instructions can lead to electric shock, fire and/or serious injury.

Keep these safety guidelines and instructions for future use.

### 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.

### Personal safety

- a) 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.
- b) Avoid an unnatural posture. Always make sure that you have a safe foothold and stay in balance. This ensures optimum control of the tool in unexpected situations.
- 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.

### 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) Pipe End Peeler blades are subject to wear. Keep the Peeler clean and dry in the transport case.
- c) Keep oil and grease away from the handles, and check for misalignment or binding in the moving parts. Worn or broken parts may affect the proper operation of the Peeler.

### Service

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

## 1.2 Specific Safety Guidelines for the Pipe End Peeler

### 1) 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 restrained. Poorly clamped or restrained workpieces may hurt you or affect your safe foothold.
- c) The Pipe End Peeler blades have a very sharp edge. This poses a risk of injury.

## 2. Introduction

### 2.1 Scope of Application


The Pipe End Peelers are solely meant for the removal of the oxide layer on polyethylene pipes as preparation for electrofusion (EF) fitting installation. The Pipe End Peeler can be used for pipe ends, spigot fittings and outlets.

Pipe End Peelers can be used on polypropylene (PP) and cross-linked polyethylene (PE-X) pipes.

It is not allowed to use the device for any application not covered by the above stated terms.

#### **ATTENTION**

The manufacturer is not liable for the use of the device out of the scope of the intended use.



### 2.2 Maintenance and Service

Should the device 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.

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

**Integrity Fusion Products**  
**270 Parkade Court**  
**Peachtree City, GA 30269**

**PH: 888.770.6330**  
**[www.integrityfusion.com](http://www.integrityfusion.com)**

### 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

A regular check of the Link Peeler, depending on the frequency of application, should be performed every 6 to 12 months by an authorized service station.

### 2.4 Disposal

The Pipe End Peeler must be disposed of in an environmentally friendly way, sorted by materials.

## 3. Range of Fitting Dimensions

The Pipe Peeler is to be used on PE pipe, depending on the size range capability of the tool being used. 3' to 6", or 8" to 16".

## 4. Scope of Delivery

### 4.1 Pipe End Peeler 3" - 6"

	Pipe End Peeler 3" • 6"		Enclosed
	1 x	Instruction manual	GB269
	1 x	Plastic Suitcase	1_2800_024
	1 x	Hex key screwdriver	1_2904_003
	1 x	Spare blade (blue container)	2_4201_005

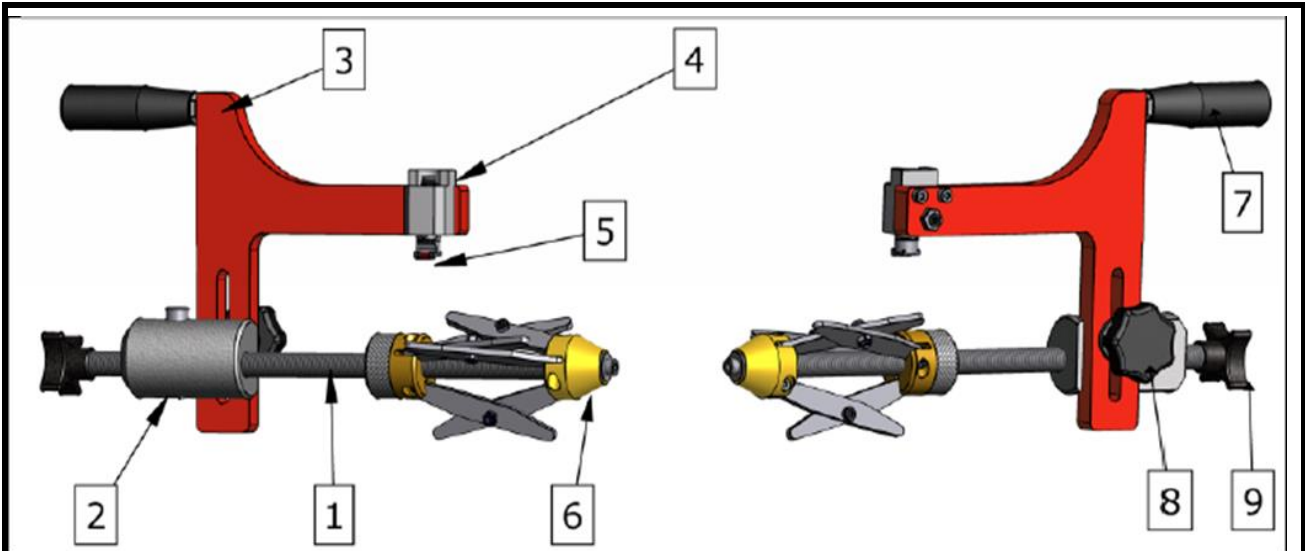
### 4.2 Pipe End Peeler 8" - 16"

	Pipe End Peeler 8" • 16"		Enclosed
	1 x	Instruction manual	GB269
	1 x	Plastic Suitcase	1_2800_025
	1 x	Hex key screwdriver	1_2904_003
	1 x	Spare blade (red container)	2_4201_008

## 5. Technical Data

### 5.1 Overview and Spare Parts for 3" - 6" Pipe End Peeler

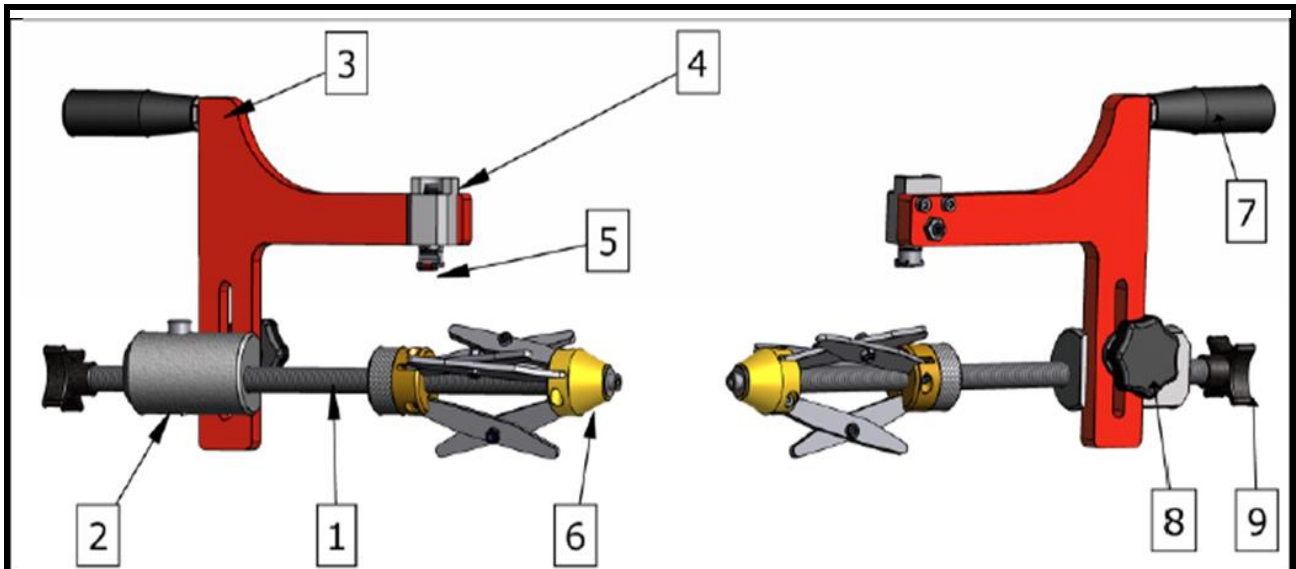
Pipe End Peeler 3" - 6"		
General		
Suitable for pipes made of		PE, PE-HD, PE-X, PP
For pipe dimensions	[in]	3" - 6"
Scraping depth	[mm]	0.3 (0.25 to 0.35)
Length of peeling at max. insertion depth	[in]	Approx. 5"
Dimensions, Weights, and Packaging		
Product dimensions L x W x H	[in]	16.73" x 14.6" x 5.5"
Product weight	[lbs.]	6lbs. 2.8 oz
Packaging dimensions L x W x H	[in]	17.7 "x10.4"x18.5" (580 • 265 • 470)
Packaging material		Plastic
Packaging type		Suitcase
Packaging weight	[lbs.]	3 lbs. 49oz
Transport weight	[lbs.]	9 lbs. 7.7 oz.



Object in graphic	Description	Code
1	Threaded spindle with cross handle	2_4200_027
2	Catch for length setting 2.5" – 7.1"	2_4200_023
3	Piloting arm incl. cylindrical handle	2_4200_029
4	Blade holder (complete incl. blade)	2_4200_031
5	Peeler blade	2_4201_005
6	Tensioning head 2.5" -7.1" (complete)	2_4200_025/1
7	Cylindrical handle	1_2400_023
8	Star knob	1_2400_013/1
9	Cross handle	1_2400_024

## 5.2 Overview and Spare Parts for 8" - 16" Pipe End Peeler

Pipe End Peeler 8" - 16"		
General		
Suitable for pipes made of		PE, PE-HD, PE-X, PP
For pipe dimensions	[in.]	8" • 16"
Scraping depth	[mm]	0.3 (0.25 to 0.35)
Length of peeling at max. insertion depth	[in]	Approx. 6.7"
Dimensions, Weights, and Packaging		
Product dimensions L x W x H	[ins.]	20.86" x 4" x 6"
Product weight	[lbs.]	15 lbs. 14 oz.
Packaging dimensions L x W x H	[ins.]	23.6" x 16.5" x 6"
Packaging material		Plastic
Packaging type		Suitcase
Packaging weight	[lbs./kg]	5 lbs. .11.7 oz
Transport weight	[lbs./kg]	21 lbs. 9.8 oz



Object in graphic	Description	Code
1	Threaded spindle with cross handle	2_4200_028
2	Catch for length setting 2.5" – 7.1"	2_4200_033
3	Piloting arm incl. cylindrical handle	2_4200_030
4	Blade holder (complete incl. blade)	2_4200_032
5	Peeler blade	2_4201_008
6	Tensioning head 2.5" -7.1" (complete)	2_4200_026/1
7	Cylindrical handle	1_2400_023
8	Star knob	1_2400_013
9	Cross handle	1_2400_024

## 6. Operation of Pipe End Peeler 3" – 6"

### ATTENTION

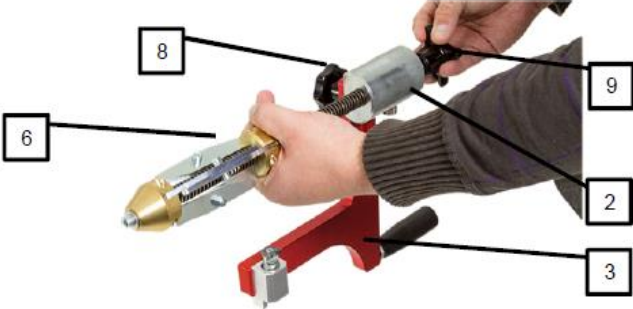
The numbers in brackets refer to the respective overview in section 5.1 "Overview and Spare Parts".

### 6.1 Preparation for Peeling



Step	Action
1	<b>Cleaning the pipe</b>
1.1	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.
2	<b>Mark the area you want to peel</b>
2.1	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.

## 6.2 Mounting the Pipe End Peeler

Step	Action
1	<b>Preparation of the Pipe End Peeler</b>
1.1	Loosen the star knob (8) by turning it counterclockwise.
1.2	Move the piloting arm (3) to its upper stop and fix it in place by turning the star knob (8) clockwise.
1.3	Press and hold the button on the catch for the length setting (2) and pull it in direction of the cross handle (9) close to it.
1.4	Hold the rear tensioning head with one hand. Then use the other hand to turn the cross handle (9) until you have sufficiently opened the scissor mechanism of the tensioning head (6).



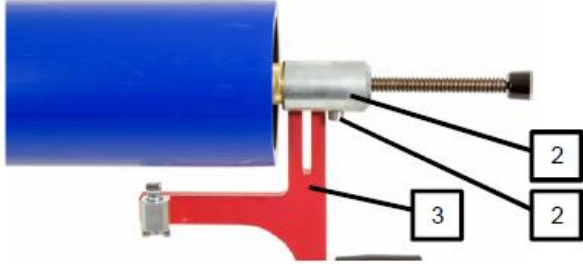
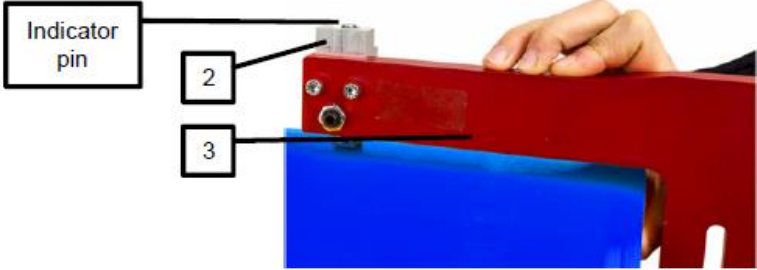
Step	Action
2	<b>Insert the Pipe End Peeler into the pipe end</b>
2.1	Insert the tensioning head (6) into the pipe end.
3	<b>Set the Pipe End Peeler in the pipe end</b>
3.1	The tips of the scissors must come in contact with the inner pipe wall to give the tool sufficient grip. Fix the tool in the pipe by further turning the cross handle (9). Hold onto the rear tension head so that it cannot rotate. Finger-tight tensioning of the Pipe End Peeler is completely sufficient.
3.2	Do not insert the Pipe End Peeler so deep into the pipe end that the piloting arm (3) does not come into contact with it. Otherwise, it might not be possible to unlock the piloting arm.



**CAUTION**

Tensioning the tool too much can damage the tool and its mechanics. Only tension the Pipe End Peeler finger-tight to the pipe so that it has enough grip to stay in place.

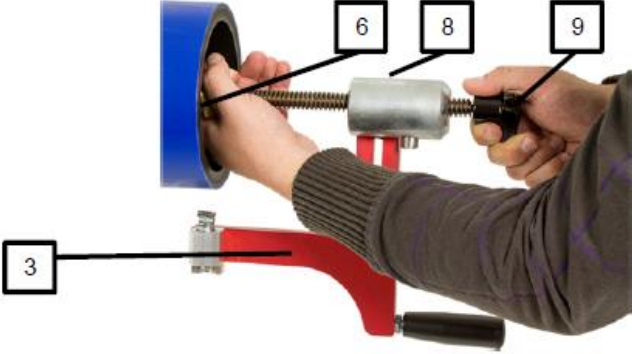
Step	Action
<p><b>4 Bring the Peeler arm into position</b></p> <p>4.1 Unlock the catch for the length setting (2) by pressing the button on it.</p> <p>4.2 Then move the piloting arm in the direction of the pipe so that the peeler head with the blade reaches the rear end of the area to be scraped resp. the rear tensioning head. The piloting arm should have sufficient space to face of the pipe.</p>	
<p><b>5 Bring the Peeler arm down</b></p> <p>5.2 Loosen the star knob (8) by turning it counterclockwise and lower the piloting arm (3) to the pipe surface so that the peeler blade contacts it.</p>	
<p><b>6 Press the Peeler arm down</b></p> <p>6.1 Then press the piloting arm with one hand against the pipe surface until the indicator pin is flush with the upper end of the peeler blade holder (4).</p>	
<p>6.2 Turn the star knob (8) clockwise to lock the piloting arm (3) in this position.</p>	

### 6.3 Pipe end Peeling

Step	Action
<p><b>1 Pipe End Peeling</b></p> <p>1.1 Position yourself in front of the tool and grab the cylindrical handle (7) with one hand and continuously rotate the piloting arm (3) clockwise around the pipe. Do not apply an axial pulling or pushing force.</p> <p>1.2 Pay attention to the scraping process and continue rotating until you have peeled the whole surface of the pipe end.</p>	

## 6.4 Removing the Pipe End Peeler

Step	Action
<b>1</b>	<b>Bring the piloting arm in the upper position</b>
1.1	Loosen the star knob (8) by turning it counterclockwise and bring the piloting arm (3) to its upper position again. Then turn the star knob (8) clockwise to fix the piloting arm (3) in place.
1.2	Grab hold of the brass part of the rear tensioning head (6) and turn the cross handle (9) counterclockwise to loosen the scissor mechanism enough to be able to remove the tool from the pipe end.



### ATTENTION

After peeling the surface of the pipe, it is mandatory to check that the marked area has been scraped completely.

## 7. Operation of 8” – 16” Pipe End Peeler

### ATTENTION

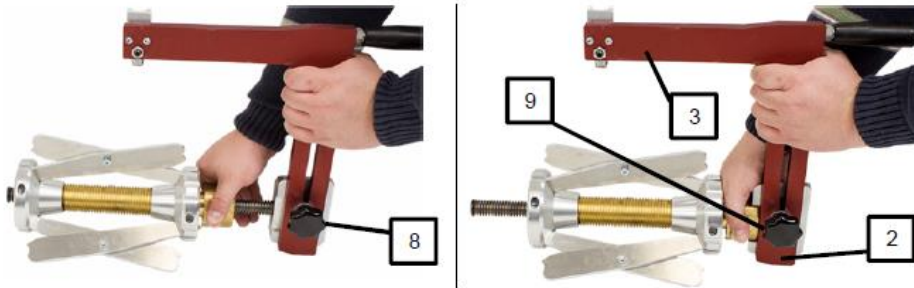
The numbers in brackets refer to the respective overview in section 5.1 “Overview and Spare Parts”.

### 7.1 Preparation for Peeling

Step	Action
<b>1</b>	<b>Cleaning the pipe</b>
1.1	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.
<b>2</b>	<b>Mark the area you want to peel</b>
2.1	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.

## 7.2 Mounting the Pipe End Peeler

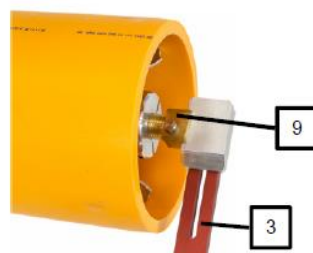
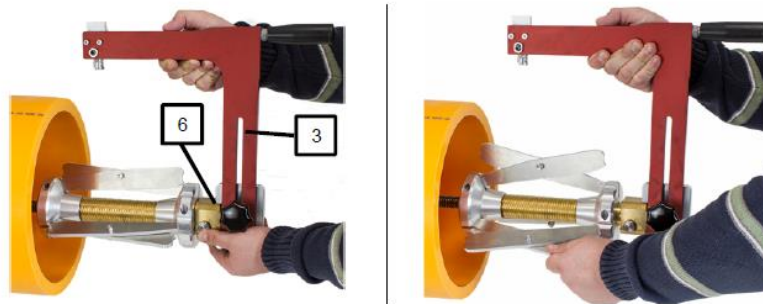
Step	Action
<b>1</b>	<b>Preparation of the Pipe End Peeler</b>
1.1	Loosen the star knob (8) by turning it counterclockwise.
1.2	Move the piloting arm (3) to its upper stop and fix it in place by turning the star knob (8) clockwise.
1.3	Press and hold the button on the catch for the length setting (9) and move the carrier for the piloting arm (2) into the recess of the catch for the length setting (9).



### ATTENTION

At the beginning it is possible that a little force is needed to turn the tension head.

Step	Action
<b>2</b>	<b>Insert the Pipe End Peeler into the pipe end</b>
2.1	Hold the piloting arm (3) and turn the tensioning head (6) counterclockwise until the scissor mechanism is opened enough to still be able to insert it into the pipe end.
2.2	Insert the tensioning head (6) into the pipe end.
2.3	Do not insert the Pipe End Peeler so deep into the pipe end that the piloting arm (3) does not come into contact with it. Otherwise, it might not be possible to unlock the piloting arm.



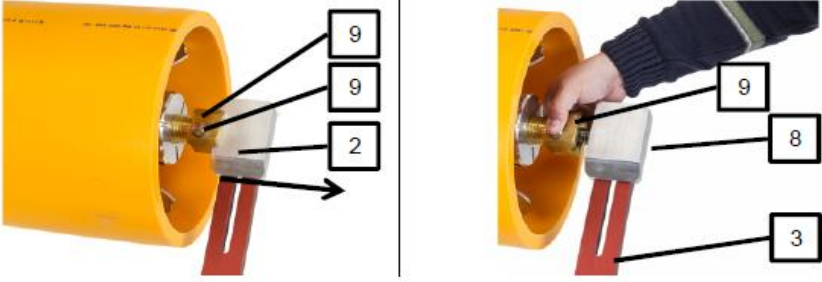

**ATTENTION**

To ensure proper functioning of the tool you should insert the tool deep enough into the pipe end that at least half of the length of the expander rails are inserted into the pipe.

Step	Action
<b>3</b>	<b>Set the Pipe End Peeler in the pipe end</b>
<b>3.1</b>	Then turn the piloting arm (3) together with the catch for the length setting (9) clockwise around the pipe to extend the scissor mechanism. That way you can fix the Pipe End Peeler with the rails in the pipe. Make sure that the tensioning head does not turn as well.

**CAUTION**

Tensioning the tool too much can damage the tool and its mechanics. Only tension the pipe end peeler finger-tight to the pipe so that it has enough grip to stay in place.

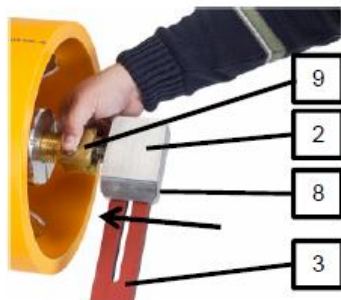
Step	Action
<b>4</b>	<b>Bring the Peeler arm into position</b>
<b>4.1</b>	Check that the tensioning head sits tight.
<b>4.2</b>	Then press the button on the catch for the length setting (9) and pull the carrier for the piloting arm (2) from the recess of the catch for the length setting (9).
	
<b>4.3</b>	This unlocks the carrier for the piloting arm (2) so that it can be turned clockwise without interfering with the tensioning head. Bring the piloting arm (3) with the peeler blade over the area you want to scrape.
<b>5</b>	<b>Bring the Peeler arm down</b>
<b>5.1</b>	Loosen the star knob (8) by turning it counterclockwise and lower the piloting arm (3) to the pipe surface so that the peeler blade contacts it.
<b>6</b>	<b>Press the Peeler arm down</b>
<b>6.1</b>	Then press the piloting arm with one hand against the pipe surface until the indicator pin is flush with the upper end of the peeler blade holder (4).
	
<b>6.2</b>	Turn the star knob (8) clockwise to lock the piloting arm (3) in this position.

## 7.3 Pipe End Peeling

Step	Action
<b>1</b>	<b>Pipe End Peeling</b>
1.1	Position yourself in front of the tool and grab the cylindrical handle (7) with one hand. Turn the piloting arm clockwise using the cylindrical handle (7). Do not apply an axial pulling or pushing force. Continue rotating the piloting arm until you have scraped the whole pipe end.
1.2	Pay attention to the scraping process and continue rotating until you have peeled the whole surface of the pipe end.

## 7.4 Removing the Pipe End Peeler

Step	Action
<b>1</b>	<b>Bring the piloting arm in the upper position</b>
1.1	Loosen the star knob (8) by turning it counterclockwise and bring the piloting arm (3) to its upper position again. Then turn the star knob (8) clockwise to fix the piloting arm (3) in place.
1.2	Press and hold the button on the catch for the length setting (9) and move the carrier for the piloting arm into the recess of the catch for the length setting (9).
1.3	To remove the tool, turn the piloting arm (3) together with the catch for the length setting (9) counterclockwise around the pipe. By doing so you can retract the scissor mechanism to a degree which enables you to remove the tool from the pipe.



### ATTENTION

After scraping it is mandatory to check that the marked area has been scraped completely.

## 8. 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 Peeler blades are subject to wear
- Use only on cleaned pipe surfaces.
- Keep the Pipe End Peeler clean and dry in the suitcase!
- The thickness of the peel must be regularly checked with a suitable measuring device.

## 9. Changing the Peeler blade

Loosen the hexagon socket head screw (2.5 mm) that fixes the blade on the blade holder and remove the old blade. Put the new blade on the blade holder and insert the hexagon socket head screw. While tightening the screw the blade must be pressed against the stop at the blade holder.

### **CAUTION**

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.

### **ATTENTION**

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

### 9.1 Peeler blade for 3" – 6" Pipe End Peeler



### 9.2 Peeler blade for 8" – 16" Pipe End Peeler

