



McELROY

HDPE/MDPE QUICK GUIDE

MANUAL FUSION



SAFETY ALERTS

Do not operate this equipment until you have carefully read and understood all sections of the machine manual and all other equipment manuals that will be used with it. Please be sure you are familiar with the standard to which you will be fusing. 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 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.

GENERAL SAFETY

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.

WEAR SAFETY EQUIPMENT

Wear a hard hat, safety shoes, safety glasses and other applicable personal protective equipment. Remove jewelry and rings, do not wear loose-fitting clothing and tie back long hair that could catch on controls or moving machinery.



WARNING FACER BLADES ARE SHARP & CAN CUT

Never attempt to remove shavings while the facer is running, or is in the facing position between the jaws. Use care when operating the facer and when handling the unit.



NOTICE: Turn machine off, disconnect machine power, and remove the facer blades before attempting any maintenance or adjustment. Never extend the facer blades beyond the inner or outer circumference of the facer.



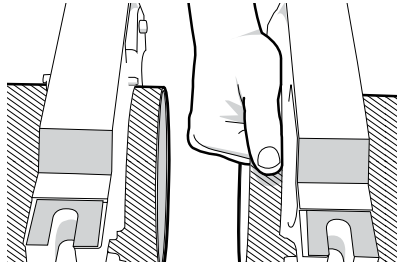
CAUTION HEATER IS HOT & CAN BURN

The heater can burn skin and clothing. Keep the heater in its insulated heater frame or stand when not in use and use care when heating the pipe.



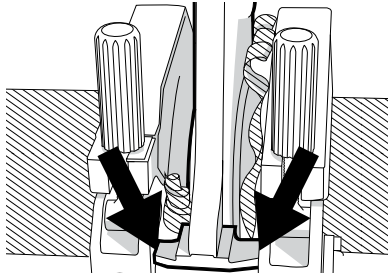
NOTICE: Use only a clean, dry, lint-free, non-synthetic cloth to clean the heater butt plates.

1 INSPECT, CLEAN & INSTALL PIPE



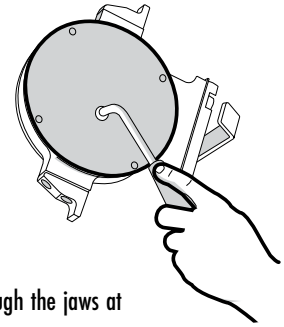
- INSPECT machine and pipe.
- Review HEAT SOAK time, BEAD SIZE, OPEN/CLOSE time, and COOLING time.
- CLEAN inserts and pipe.
- Install and clamp pipe. If pipe ends are fairly even, check ALIGNMENT.

2 PREPARE PIPE ENDS



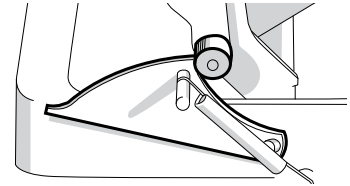
- Close the carriage with the minimal force necessary to FACE the pipe ends.
- Continue facing until the jaws come into contact with both mechanical stops and have produced a minimum of one complete ribbon.
- CLEAN fusion area after facing.
- At FACING force, check ALIGNMENT of the pipe ends and check for GAPS.

3 PREPARE HEATER



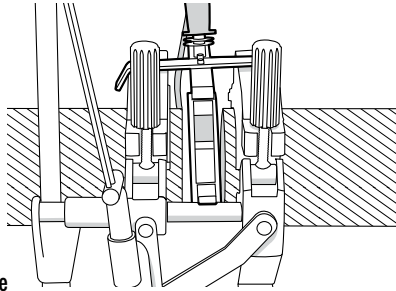
- Review FUSING parameters.
- Ensure the pipe does not slip through the jaws at FUSING force.
- Check the heater TEMPERATURE and CLEAN heater surfaces.
- Set the heater into the machine between the pipe ends.

4 HEAT SOAK



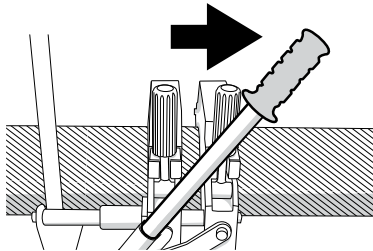
- To close, SNAP the pipe ends sharply against the heater to ensure full contact.
- At this point, RELAX the force without breaking contact with the heater.
- Engage the LOCKING CAM. (Except when using a 2CU.)
- Maintain contact of pipe ends against the heater with NO FORCE during the entire HEAT SOAK time.

5 HEATER REMOVAL & PIPE INSPECTION



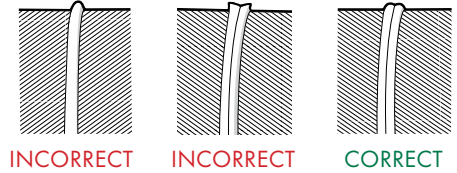
- When appropriate bead size is observed, open the carriage and REMOVE the heater.
- Leave the LOCKING CAM engaged during heater removal.
- INSPECT the pipe ends for condition of the melt.

6 FUSE & COOL



- Close the carriage quickly and smoothly with enough FUSING force to roll both melt beads over so that they touch the piping component OD surfaces.
- Hold FUSING force for 10 SECONDS, then the LOCKING CAM will hold that jaw position. (For the 2CU, hold FUSING force for the entire COOLING time.)
- Leave the LOCKING CAM engaged until COOLING time is complete.

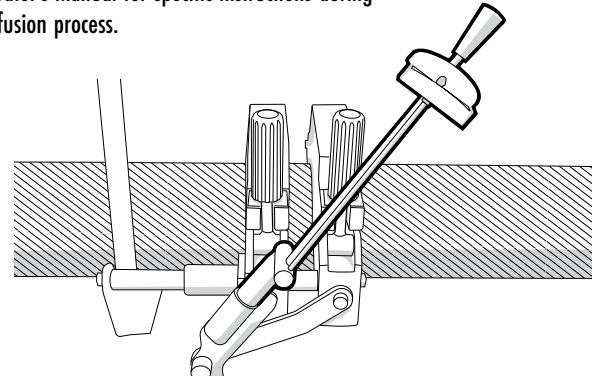
7 OPEN JAWS & INSPECT FUSION



- Disengage the LOCKING CAM.
- Loosen the jaws, open the carriage, and INSPECT the fusion.

TORQUE WRENCH

If using a TORQUE WRENCH and TORQUE WRENCH ADAPTER, refer to the machine Operator's Manual for specific instructions during the fusion process.





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DISQKGD0118