Hy-Ram Engineering

User Manual, Operating Instructions and Specifications

AlignMaster Hydraulic Positioning Kit + 2 Pumps
Re-RoundMaster Hydraulic Re-Rounding Clamp + Pump

ELECTROFUSION

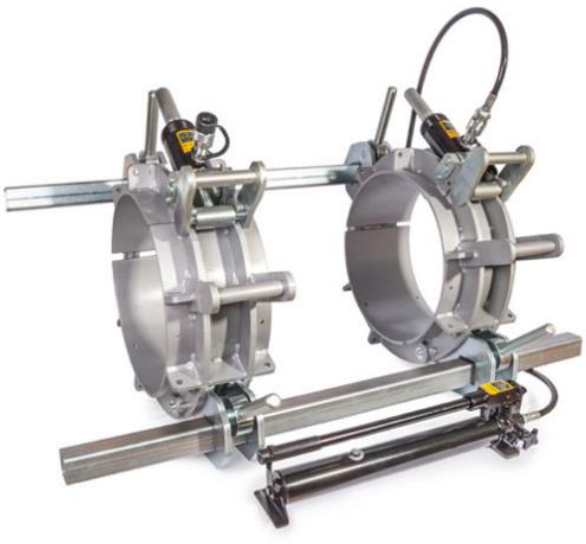
• INNOVATION • DESIGN • MANUFACTURE • SUPPLY

Hy-Ram Engineering

Pipe tool and equipment expertise

User Manual, Operating Instructions and Specifications

Description:	**AlignMaster Hydraulic Positioning Kit + 2 Pumps**	
Version:	**400mm (315 – 400mm)**	**Product Code: 089-000561**
	500mm (400 – 500mm)	**Product Code: 089-000562**
	630mm (500 – 630mm)	**Product Code: 089-000563**
	710mm (630 – 710mm)	**Product Code: 089-000564**
Description:	**Re-RoundMaster Hydraulic Re-Rounding Clamp + Pump**	
Version:	**400mm (315 – 400mm)**	**Product Code: 089-000547**
	500mm (400 – 500mm)	**Product Code: 089-000548**
	630mm (500 – 630mm)	**Product Code: 089-000549**
	710mm (630 – 710mm)	**Product Code: 089-000558**



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DESIGNED & MADE IN UK

Product Description

The Hy-Ram Hydraulic Re-Rounding Clamp Range is a range of hydraulically operated, 3-Segment Pipe Clamps to suit different PE Pipe diameters.
The intended use of the units is to remove ovality in PE Plastic Pipes before the Electro-Fusion welding process.
Re-Rounding the pipe makes insertion into the Electro-Fusion Fitting easier and gives a better all-round fit for the Electro-Fusion process.

The Hy-Ram Hydraulic Re-Rounding Clamp range comes complete with Hydraulic Handpumps and features a durable welded steel construction giving a robust design.
The clamps offer a wide contact area with the pipe (200mm width) and Reducing Shells are available to reduce the diameter for differing pipe diameters.

The range is designed for use on Polyethylene pipes with an outside diameter range of 315mm to 710mm with no restriction on wall thickness or SDR.

Models available:

AlignMaster Hydraulic Positioning Kit:

Product code	Description
089-000561	400mm Hydraulic Positioning Kit + 2 Pumps
089-000562	500mm Hydraulic Positioning Kit + 2 Pumps
089-000563	630mm Hydraulic Positioning Kit + 2 Pumps
089-000564	710mm Hydraulic Positioning Kit + 2 Pumps

Single re-rounding tools:

Product code	Description
089-000547	400mm Hydraulic Re-Rounding Clamp + Pump
089-000548	500mm Hydraulic Re-Rounding Clamp + Pump
089-000549	630mm Hydraulic Re-Rounding Clamp + Pump
089-000558	710mm Hydraulic Re-Rounding Clamp + Pump

Note:
No other uses are considered appropriate for this unit.
To use this unit for other purposes could lead to the unit being used for dangerous applications that may cause injury and could result in bad practice and poor-quality workmanship.
The information contained in these instructions is to assist with the safe installation, operation and maintenance of the equipment.
This information should be made available to all persons who are required to work with or on the equipment.
In the case of any doubt with any aspect of this equipment, including the application, safe use and instructions within this document; contact Hy-Ram Engineering Co. Ltd. for clarification and advice.

Introduction

This document explains about the machinery and how to use and maintain it. It is intended for users and should be made available to all persons who are likely to use or work on the machinery.

There are several Warning, Caution and Note statements and these notify of important points:

Warning: Informs of hazardous conditions which may cause bodily harm
Caution: Informs of conditions which may cause damage to the equipment
Note: Explains additional or helpful information

Health and Safety Notes

Hazards:

The Hydraulic Re-Rounding tools present dangers from trapping parts of the body between the moving / hinged parts. Particular dangers are when mounting the tool on the pipe and operating the Cam Handle.

The Hydraulic Re-Rounding tools often work within the trench. This can present dangers in terms of injury to fingers/hands if there is insufficient room or clearance around the whole circumference of the pipe.

Appropriate Personal protective Equipment (PPE) must be worn: Gloves, safety eyewear, safety headwear and safety footwear are mandatory.

Safety Instructions

Prior to use:
1. Read and understand the Operating Instructions and Specifications.
2. Ensure all component parts are present and in serviceable condition.

Only use the tool for the purpose of its design and on pipes within the specified diameters.

It is the responsibility of the operator of the tool to ensure that pipe is suitable for this kind of pipe preparation and that the tool will conform to the specified welding standard. In case of any doubt, contact the pipe manufacturer and/or the relevant controlling authority.

Always wear appropriate Personal Protective Equipment (PPE), see note in 'Hazards' above.

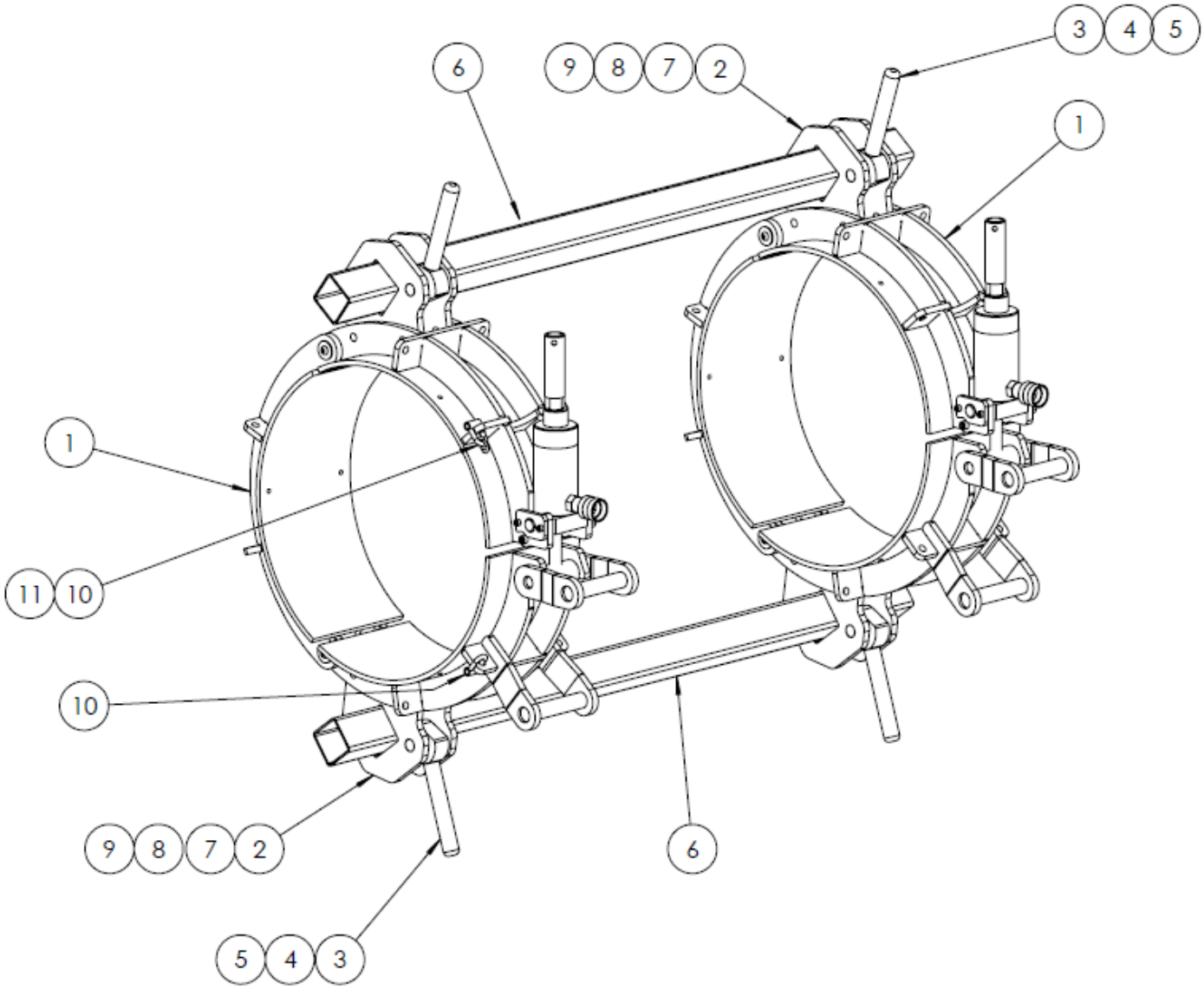
Take all possible precautions to avoid unexpected pipe movement whilst the tool is in use.

Photo gallery

AlignMaster Hydraulic Positioning Kit

Re-RoundMaster Hydraulic Re-Rounding Clamp

AlignMaster Hydraulic Positioning Kit Drawing Schematic:



Parts list and component part numbers

089-000561 400mm Hydraulic Positioning Kit + 2 Pumps

ITEM No:	QTY	PART No:	DESCRIPTION
1	2	141-089-000547	400mm HYDRAULIC RE-ROUNDER
2	8	111-645-000327	SUPPORT BAR PLATE, Dia 400mm
3	4	111-073-000004	CAM
4	4	111-171-000114	CAM HANDLE
5	4	111-740-000012	CAM TRUNNION
6	2	111-023-000298	ALIGNMENT BAR, 50x50x3
7	16	BOLT-M12x40mmHHBBZP	M12 x 40LG HEX HD BOLT, BZP
8	16	760-000094	M12 WASHER, BZP
9	16	NUTS-M12FNBZP	M12 NUT, BZP
10	2	703-000018	0.5 Ton EN13889 SCREW PIN DEE SHACKLE
11	1	079-000027	Ø4 SHORT LINK CHAIN DIN 5685 "A" - 400LG

089-000562 500mm Hydraulic Positioning Kit + 2 Pumps

ITEM No:	QTY	PART No:	DESCRIPTION
1	2	141-089-000548	500mm HYDRAULIC RE-ROUNDER
2	8	111-645-000326	SUPPORT BAR PLATE
3	4	111-073-000004	CAM
4	4	111-171-000114	CAM HANDLE
5	4	111-740-000012	CAM TRUNNION
6	2	111-023-000297	ALIGNMENT BAR
7	16	BOLT-M12x40mmHHBBZP	M12 x 40LG HEX HD BOLT, BZP
8	16	760-000094	M12 WASHER, BZP
9	16	NUTS-M12FNBZP	M12 NUT, BZP
10	2	703-000018	0.5 Ton EN13889 SCREW PIN DEE SHACKLE
11	1	079-000028	Ø4 SHORT LINK CHAIN DIN 5685 "A" - 500LG

089-000563 630mm Hydraulic Positioning Kit + 2 Pumps

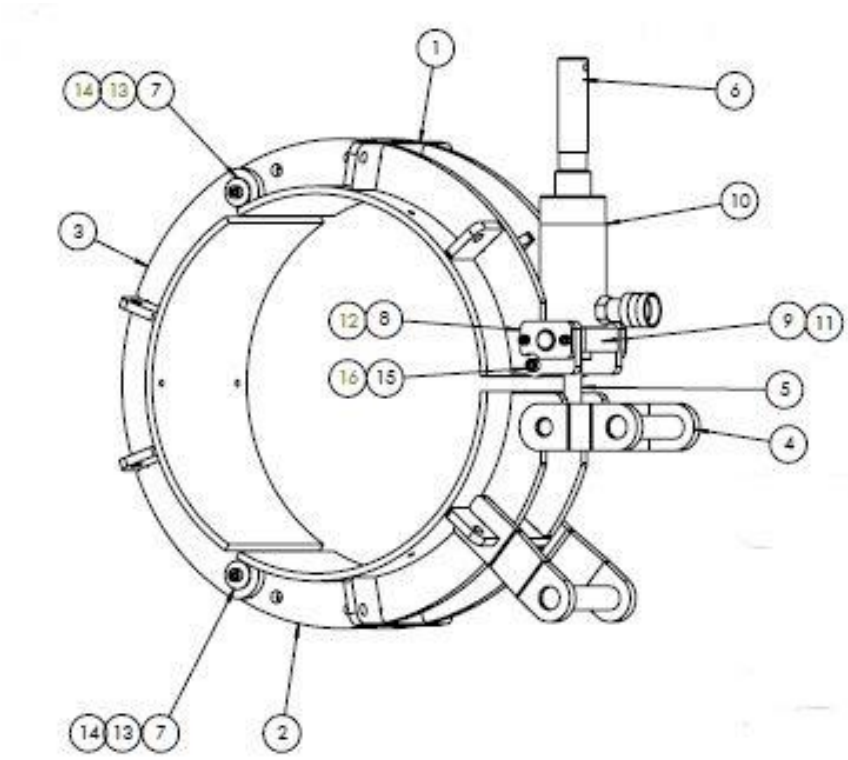
ITEM No:	QTY	PART No:	DESCRIPTION
1	2	141-089-000549	630mm HYDRAULIC RE-ROUNDER
2	8	111-645-000326	SUPPORT BAR PLATE
3	4	111-073-000004	CAM
4	4	111-171-000114	CAM HANDLE
5	4	111-740-000012	CAM TRUNNION
6	2	111-023-000297	ALIGNMENT BAR
7	16	BOLT-M12x40mmHHBBZP	M12 x 40LG HEX HD BOLT, BZP
8	16	760-000094	M12 WASHER, BZP
9	16	NUTS-M12FNBZP	M12 NUT, BZP
10	2	703-000018	0.5 Ton EN13889 SCREW PIN DEE SHACKLE
11	1	079-000029	Ø4 SHORT LINK CHAIN DIN 5685 "A" - 630LG

089-000564 710mm Hydraulic Positioning Kit + 2 Pumps

ITEM No:	QTY	PART No:	DESCRIPTION
1	2	141-089-000558	710mm HYDRAULIC RE-ROUNDER
2	8	111-645-000326	SUPPORT BAR PLATE
3	4	111-073-000004	CAM
4	4	111-171-000114	CAM HANDLE
5	4	111-740-000012	CAM TRUNNION
6	2	111-023-000297	ALIGNMENT BAR
7	16	BOLT-M12x40mmHHBBZP	M12 x 40LG HEX HD BOLT, BZP
8	16	760-000094	M12 WASHER, BZP
9	16	NUTS-M12FNBZP	M12 NUT, BZP
10	2	703-000018	0.5 Ton EN13889 SCREW PIN DEE SHACKLE
11	1	079-000030	Ø4 SHORT LINK CHAIN DIN 5685 "A" - 710LG

Product code	Description
089-000561	400mm Hydraulic Positioning Kit + 2 Pumps
604-000022	400-355mm Set of Reducing Shells (3 pieces)
604-000023	400-315mm Set of Reducing Shells (3 pieces)
089-000562	500mm Hydraulic Positioning Kit + 2 Pumps
604-000024	500-450mm Set of Reducing Shells (3 pieces)
604-000025	500-400mm Set of Reducing Shells (3 pieces)
089-000563	630mm Hydraulic Positioning Kit + 2 Pumps
604-000026	630-560mm Set of Reducing Shells (3 pieces)
604-000027	630-500mm Set of Reducing Shells (3 pieces)
089-000564	710mm Hydraulic Positioning Kit + 2 Pumps
604-000028	710-630mm Set of Reducing Shells (3 pieces)

Single Hydraulic Re-Rounding Clamp Drawing Schematic:



Parts list and component part numbers

089-000547 400 Re-rounding Clamp + Pump

ITEM No:	QTY	PART No:	DESCRIPTION
1	1	089-000583	RAM SEGMENT
2	1	089-000585	TRUNNION SEGMENT
3	1	089-000586	BOTTOM SEGMENT
4	1	171-000112	TRUNNION HANDLE
5	1	058-000035	STUD
6	1	171-000106	HANDLE
7	1	520-000099	PIVOT PIN
8	2	645-000325	KEEP PLATE
9	1	740-000007	TRUNNION for RAM
10	1	002-000057	RAM HES HI FORCE HHS102
11	2	SCRW-M8x40mmCAPBZP	M8 x 40LG HEX HD SKT SCREW
12	4	SCRW-M6x20mmCAPBZP	M6 x 20LG HEX HD SKT SCREW
13	4	760-000089	M8 REPAIR WASHER
14	4	SCRW-M8x25mmCAPBZP	M8 x 25LG HEX HD SKT SCREW
15	1	SCRW-M8x110mmCAPBZP	M8 x 110LG HEX HD SKT SCREW
16	1	NUTS-M8FNBZP	M8 HEX NUT
17	1	652-000044	HAND PUMP, HI FORCE Ref: HP110
18	1	359-000230	2m HYD HOSE, 700Bar, 3/8"NPT/QUICK CONNECTOR

089-000548 500 Re-rounding Clamp + Pump

ITEM No:	QTY	PART No:	DESCRIPTION
1	1	089-000587	RAM SEGMENT
2	1	089-000589	TRUNNION SEGMENT
3	1	089-000590	BOTTOM SEGMENT
4	1	171-000112	TRUNNION HANDLE
5	1	058-000035	STUD
6	1	171-000106	HANDLE
7	1	520-000099	PIVOT PIN
8	2	645-000325	KEEP PLATE
9	1	740-000007	TRUNNION for RAM
10	1	002-000057	RAM HES HI FORCE HHS102
11	2	SCRW-M8x40mmCAPBZP	M8 x 40LG HEX HD SKT SCREW
12	4	SCRW-M6x20mmCAPBZP	M6 x 20LG HEX HD SKT SCREW
13	4	760-000089	M8 REPAIR WASHER
14	4	SCRW-M8x25mmCAPBZP	M8 x 25LG HEX HD SKT SCREW
15	1	SCRW-M8x110mmCAPBZP	M8 x 110LG HEX HD SKT SCREW
16	1	NUTS-M8FNBZP	M8 HEX NUT
17	1	652-000044	HAND PUMP, HI FORCE Ref: HP110
18	1	359-000230	2m HYD HOSE, 700Bar, 3/8"NPT/QUICK CONNECTOR

089-000549 630 Re-rounding Clamp + Pump

ITEM No:	QTY	PART No:	DESCRIPTION
1	1	089-000591	RAM SEGMENT
2	1	089-000593	TRUNNION SEGMENT
3	1	089-000594	BOTTOM SEGMENT
4	1	171-000112	TRUNNION HANDLE
5	1	058-000035	STUD
6	1	171-000106	HANDLE
7	1	520-000099	PIVOT PIN
8	2	645-000325	KEEP PLATE
9	1	740-000007	TRUNNION for RAM
10	1	002-000057	RAM HES HI FORCE HHS102
11	2	SCRW-M8x40mmCAPBZP	M8 x 40LG HEX HD SKT SCREW
12	4	SCRW-M6x20mmCAPBZP	M6 x 20LG HEX HD SKT SCREW
13	4	760-000089	M8 REPAIR WASHER
14	4	SCRW-M8x25mmCAPBZP	M8 x 25LG HEX HD SKT SCREW
15	1	SCRW-M8x110mmCAPBZP	M8 x 110LG HEX HD SKT SCREW
16	1	NUTS-M8FNBZP	M8 HEX NUT
17	1	652-000044	HAND PUMP, HI FORCE Ref: HP110
18	1	359-000230	2m HYD HOSE, 700Bar, 3/8"NPT/QUICK CONNECTOR

089-000558 710 Re-rounding Clamp + Pump

ITEM No:	QTY	PART No:	DESCRIPTION
1	1	089-000595	RAM SEGMENT
2	1	089-000597	TRUNNION SEGMENT
3	1	089-000598	BOTTOM SEGMENT
4	1	171-000112	TRUNNION HANDLE
5	1	058-000035	STUD
6	1	171-000106	HANDLE
7	1	520-000099	PIVOT PIN
8	2	645-000325	KEEP PLATE
9	1	740-000007	TRUNNION for RAM
10	1	002-000057	RAM HES HI FORCE HHS102
11	2	SCRW-M8x40mmCAPBZP	M8 x 40LG HEX HD SKT SCREW
12	4	SCRW-M6x20mmCAPBZP	M6 x 20LG HEX HD SKT SCREW
13	4	760-000089	M8 REPAIR WASHER
14	4	SCRW-M8x25mmCAPBZP	M8 x 25LG HEX HD SKT SCREW
15	1	SCRW-M8x110mmCAPBZP	M8 x 110LG HEX HD SKT SCREW
16	1	NUTS-M8FNBZP	M8 HEX NUT
17	1	652-000044	HAND PUMP, HI FORCE Ref: HP110
18	1	359-000230	2m HYD HOSE, 700Bar, 3/8"NPT/QUICK CONNECTOR

Product code	Description
089-000547	400mm Hydraulic Re-Rounding Clamp + Pump
604-000022	400-355mm Set of Reducing Shells (3 pieces)
604-000023	400-315mm Set of Reducing Shells (3 pieces)
089-000548	500mm Hydraulic Re-Rounding Clamp + Pump
604-000024	500-450mm Set of Reducing Shells (3 pieces)
604-000025	500-400mm Set of Reducing Shells (3 pieces)
089-000549	630mm Hydraulic Re-Rounding Clamp + Pump
604-000026	630-560mm Set of Reducing Shells (3 pieces)
604-000027	630-500mm Set of Reducing Shells (3 pieces)
089-000558	710mm Hydraulic Re-Rounding Clamp + Pump
604-000028	710-630mm Set of Reducing Shells (3 pieces)

Specifications

Materials: Mild Steel – 070M20
Mild Steel – 080M40

Finishes: Powder Coat / Zinc Plate

Part No:	Description	Weight	Dimensions
089-000547	400mm Hydraulic Clamp + Pump	61.20Kg	H 630 x W 605 x L 200mm
089-000548	500mm Hydraulic Clamp + Pump	63.60Kg	H 730 x W 620 x L 200mm
089-000549	630mm Hydraulic Clamp + Pump	71.70Kg	H 870 x W 750 x L 200mm
089-000558	710mm Hydraulic Clamp + Pump	91.60Kg	H 950 x W 830 x L 200mm

Part No:	Description	Weight	Dimensions
089-000561	400mm Hydraulic Positioning Kit + 2 Pumps	132.00Kg	H 630 x W 605mm x L 1.25m
089-000562	500mm Hydraulic Positioning Kit + 2 Pumps	136.80Kg	H 730 x W 620mm x L 1.25m
089-000563	630mm Hydraulic Positioning Kit + 2 Pumps	169.60Kg	H 870 x W 750mmx L 1.25m
089-000564	710mm Hydraulic Positioning Kit + 2 Pumps	183.20Kg	H 950 x W 830mm x L 1.25m

Standards: The tool is designed and manufactured to meet the requirements of:

GIS/PL2-5: 2013
Specification for Polyethylene pipes and fittings for natural gas and suitable manufactured gas.
Part 5: Electrofusion ancillary tooling.

WIS 4-32-08: 2016
Specification for the fusion jointing of polyethylene pressure pipeline systems using PE80 and PE100 materials.

Note: Hy-Ram Engineering Co. Ltd. operate a policy of continual improvement and therefore reserves the right to modify product specifications without notice.

Operating Instructions - Single Hydraulic Re-Rounding Clamp

1. Check the pipe for any damage or abrasions that may be detrimental to the performance of the joint. Ensure the pipe ends to jointed are cut square to the axis and burrs removed. If required, wash down the pipe ends in excess of the area to be clamped so no debris will in the clamping area.

2. Using the Handle (6) rotate anticlockwise to take tension off the unit. Be careful the unit does not fall open.

3. Un-latch the unit by pulling the Trunnion Handle (4) down and up to lift open the segment.

4. Then lower the opposite side by using the Trunnion Segment Handle (2) and pass under the pipe carefully.

5. Once under the pipe, pull the unit around the pipe by pulling both the Trunnion Handle (4) and the Trunnion Segment Handle (2) together and hooking the Trunnion Handle (4) in position so the clamp is safely engaged around the pipe.

6. Rotating the Handle (6) clockwise, add pressure to the unit manually to take up any slack prior to using the Hydraulic Hand Pump (17).

7. With the clamp in position, measure the outside diameter of the pipe, north to south, east to west to find the ovality in the pipe with a measuring tape or a pair of callipers.

8. Once the area of ovality has been established, use the Hydraulic Hand Pump (17) to add pressure to the end of the pipe, while measuring the ovality every couple of pumps until the desired re-rounding effect has been reached.

9. Leave the clamp on the pipe under tension for the amount of time required to give the desired re-rounding effect prior to clamp being removed.

10. Once the re-rounding has taken place, remove the unit by releasing the pressure from the Hydraulic Hand Pump (17) and repeating steps 2-5.

11. Check that the fitting can easily be pushed in to position, if not then repeat the process. Do Not force the fitting on the pipe!

Operating Instructions - AlignMaster Hydraulic Positioning Kit

1) Use the alignment bars to join the 2 clamps

2) **IMPORTANT** Ensure the safety chain is connected to both sides (10) of the opening segments so assembly does not swing open unintentionally.

3) Refer to the above instructions 1 to 11 on how to operate a single clamp but do this for both clamps only remove safety chain when ready to place under pipe and re-attached chain when closing segments again around the pipe to stop unintentionally opening of segments.

Maintenance and storage

1. When the tools are not in use always store in a dry place.
2. Ensure the tools are stored in a clean condition free of dirt and mud.
3. Before storing, ensure the vent valve is closed on the Hydraulic Hand Pump.
4. Lubricate all moving parts on a periodic basis.

CE

EC DECLARATION OF CONFORMITY

We hereby declare that the following machinery complies with the essential health and safety requirements of the Machinery Directive 2006/42/EC enacted in the United Kingdom by The Supply of Machinery (Safety) Regulations 2008.

Product description: Re-RoundMaster Hydraulic Re-rounding Clamp, AlignMaster Hydraulic Positioning Kit

Make: Hy-Ram
Type: 400, 500, 630 & 710mm

Manufactured by: Hy-Ram Engineering Co Ltd.
Pelham Street
Mansfield
Nottinghamshire
NG18 2EY

This machinery has been designed and manufactured in accordance with the following transposed harmonised European standards.
The machinery complies with, or is designed and manufactured so far as is possible to comply with the relevant essential health and safety requirements, taking into account the state of threat.

Safety of Machinery
BS EN ISO 12100:2010 Safety of Machinery - General principles for design. Risk assessment and risk reduction.
and
Gas Industry Standard
GIS/PL2-5:2013 Electrofusion Ancillary Tooling

A technical construction file for this machinery is retained at the address of the manufacturer stated above.

Modifications to the equipment without prior written approval by the undersigned will render this declaration null and void.

For and on behalf of the manufacturer:
[Being a nominated person appointed by the manufacturer, and employed by Hy-Ram Engineering Co Ltd].

Signature: ……..

Name: ……..

Position: ……

Date: ……

Signature of this Declaration of Conformity authorises the manufacturer or his authorised representative to affix the CE mark to the equipment.

Certificate of calibration.

- These products have been designed, manufactured, inspected and tested in accordance with our LRQA approved ISO 9001: 2015 quality control systems and our LRQA approved ISO 14001: 2015 environmental procedures.

- These products have no calibration period and periodic safety inspections should be carried out by the operator. If in any doubt, please contact the manufacturer for further information

Decommissioning & Disposal Instructions

- If a Hy-Ram product has reached the end of its useful working life and cannot be refurbished it must be disposed of through a licensed scrap or waste disposal facility. Alternatively, a reverse engineering company could be used to strip the equipment for recycling purposes, or the product can be returned back to the manufacturer.

- Decommissioning and disposal is the responsibility of the customer. The product must be taken out of service safely and in compliance with essential Health and Safety requirements.

Warranty.

1. Extent of Warranty.

In the case that this product does not meet quality or performance expectations then Hy-Ram will replace the product to the customer's satisfaction. Hy-Ram will guarantee this product against breakage or defective workmanship for one year.
This guarantee is not valid in cases of abuse or exceptional damage beyond reasonable expectations or where incorrect use or care of the product has occurred as described in the user manual and instructions Additional the guarantee is not valid in cases of unauthorised modification, misuse or any use not in accordance with the operating manual and good industry practice, operation outside the products specifications, improper site preparation or maintenance or when using with faulty pipe or fittings.
Hy-Ram does not warrant the operation of any product to be uninterrupted or error free.

Any warranty or condition implied by law, shall be the replacement or parts, without charge, which are defective in material or workmanship and which have not been misused, carelessly handled, or mis-repaired by persons other than the manufacturer or an Authorised Service Centre.

Hy-Ram Engineering Co Ltd offer a 1 year from date of despatch warranty only against defects in workmanship and materials. This limited warranty does not apply to any refurbished or reconditioned equipment and is non-transferable and subject to the conditions and limitations set forth herein. The standard Terms and Conditions of trade form part of this warranty.
Hy-Ram Engineering Co Ltd will, at its option, repair or replace (with a new or reconditioned unit of like condition).

All warranty work will be carried out by Hy-Ram Engineering Co Ltd unless otherwise agreed or by authorised Hy-Ram Engineering Co Ltd service facilities.
If replacement parts are used in making repairs, these parts may be remanufactured or contain remanufactured materials.

In returning the product for repair, the product must be delivered in its original packaging or in packaging offering a sufficient degree of protection. The product must be accompanied by written evidence of the date of purchase (see also the form at the rear of this document). Hy-Ram will not be responsible for any loss or damage incurred in connection with the return of the product.

To the extent that this warranty statement is inconsistent with the law of the locality where the customer uses the product, this warranty statement shall be deemed modified by the minimum necessary to be consistent with such local law.
To the extent allowed by local law, the remedies provided in this warranty statement are the customer's sole and exclusive remedies.
This tool has been designed for the range of pipe and fittings commercially available at the time of its design and development. Hy-Ram Engineering Co Ltd can accept no liability for the unit's ability or otherwise to work with new or different fittings that are subsequently introduced to the market.

The foregoing limited warranty is Hy-Ram Engineering's only warranty with respect to the product and Hy-Ram makes no other warranty whatsoever, written or oral, express or implied, regarding the product, including without limitation any warranty of merchantability, fitness for a particular purpose or non-infringement. In no event will Hy-Ram or its authorised dealers be liable for any loss of profits or special, consequential or incidental damages even if such damages result from negligence or other fault.

Please complete this information and keep it safely with your proof of purchase receipt. You will require it for any warranty claim.

Name and location of seller .....

Date of purchase: .....

Name and address of purchaser: .....

.....

.....

Type of tool: .....

Serial number (if applicable): .....

<u>For service and repair please contact:</u>

Hy-Ram Engineering Co. Ltd.
Pelham Street
Mansfield
Nottinghamshire
NG18 2EY
Tel: +44 (0)1623 422982
www.hyram.com

Hy-Ram Engineering

For Sales, Hire and Repair support contact our admin team or scan the QR code for further details

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