



## **OPERATING INSTRUCTIONS FOR Re-rounding Clamps 315mm to 400mm**

- 1. Machine to be operated by trained personnel.**
- 2. Instructions to be read before use.**

Hy-Ram Mansfield  
Pelham Street  
Mansfield  
Nottinghamshire  
NG18 2EY

Hy-Ram Bury  
9 Portland  
Industrial Estate  
Portland Street  
Bury  
Lancashire  
BL9 6EY

Hy-Ram Enfield  
Unit 2, Riverwalk  
Business Park  
Riverwalk Road  
Enfield  
EN3 7QN

Hy-Ram Livingston  
18 Napier Square  
Houstoun Road  
Trading Estate  
Livingston  
West Lothian  
EH54 5DG

Tel: 01623 422982  
Fax: 01623 661022

Tel: 0161 7641721  
Fax: 0161 7620577

Tel: 0208 805 8010  
Fax: 0208 805 6010

TEL: 01506 440233  
Fax: 01506 440266

This unit is design and manufactured to meet the requirements of National Grid Gas Industry Standards GIS/PL2-5:2006 Part 5 Electrofusion ancillary tooling.

Hy-Ram Engineering Co Ltd has a policy of continuous improvement in product quality and design. Hy-Ram Engineering Co Ltd therefore reserves the right to change the specification of its models at any time, without prior notice.

### **General description.**

The equipment has been designed to re-round the P.E. pipe prior to carrying out the electrofusion jointing process on SDR11 and SDR17 pipe work in accordance with Gas Industry Standards GIS/PL2-5:2006 Part 5 Electrofusion ancillary tooling.

***These clamps will not cure flattening in previously squeezed off pipe, where the clamp comes into contact with scraped pipe, the area must be re-scraped before fitting into the electrofusion coupler***

### **Safety Instructions**

1. Operatives should wear eye protection, gloves, safety headwear & footwear when using the equipment.

### **Pipe Re-rounding prior to clamping and electrofusion cycle.**

*If the pipe is found to be out of round it will be necessary to re-round the pipe before electrofusing the joint. It is recommended that the re-rounding clamp be left in situ for at least 10 minutes then the pipe regarded as ready for use.*

### **Instructions for use.**

1. The tool should be positioned onto the pipe end.
2. When the tool is correctly positioned tightened down the clamping mechanism using the ratchet tool provided.
3. Close the two halves together and initiate the re rounding effect.
4. Allow sufficient time for the re-rounding effect to take place prior to releasing the clamp.