

Flexalen® PB EVOH Scraper

Scraper set for preparing Flexalen® PB EVOH service pipes for welding process



Set Content

Hand scraper
Plastic Hammer
Screwdriver
Caliber 25-90
Stroke tool
Caliber disassembly tool



Required Tools

Cleaner
Tissues
Marker
Plastic hand scraper

Application Instruction

Application conditions and pipe preparation

- Ambient temperature: +5 to +40°C
- Service pipe is cut straight and without damage; service pipe is free from dirt and condensation
- Scraper set is without damage and free from dirt and moisture



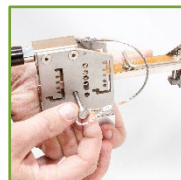
01. Clean PB service pipe and mark the correct length to scrape with a non-greasy marker pen.

For electrofusion connections mark the insertion depth on the pipe and scrape pipe until the mark is reached.

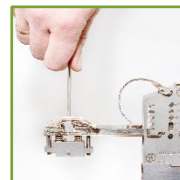


02. Place the caliber of the correct size in the PB service pipe as far as possible. Make sure the service pipe is stable.

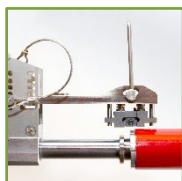
For PB25mm and PB32mm only use the plastic hammer (with cautious-ness) to fix the caliber. From PB40mm up to PB90mm use the stroke tool.



03. Set the correct service pipe diameter on the scraper: remove the pin, slide the scraper arm to the diameter to be scrapped and plug the pin back in.



04. Lift the knife holder and slide the hand scraper on the caliber towards the PB service pipe.



05. Position the knife holder in such a way that the knife does not yet touch the PB service pipe. Lower the knife block. The first guide block should "rest" on the PB service pipe.



06. Scrape clockwise by gently turning the hand scraper. Do not push! Make sure that the removed EVOH layer does not get between the knife block and the service pipe to be scraped.



07. When the mark is reached, lift the knife holder and remove the hand scraper from the caliber.



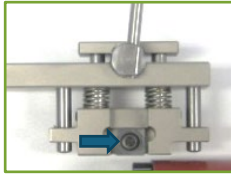
08. Remove the caliber by hand or by using the stroke and caliber disassembly tool.

Note: If there is still EVOH layer left, residual EVOH layer must be removed with a plastic hand scraper.

Disclaimer

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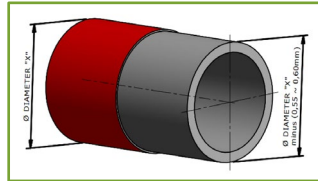
Service & Maintenance



01.

Blunt Knife

If the scraping result is not satisfying anymore, mostly the knife is no longer sharp. The knife has 4 blades on each long side and can be turned 4 times. Remove with the included screwdriver and turn 90°.



02.

Checking tolerances of the scraper

Measure the diameter before and after scraping with:

- a) a circumference tape
- b) a caliper (on two marked positions, marked on the cross-section area) and use the average value.

The difference before and after scraping must be between 0.55 – 0.60 mm (thickness of oxygen barrier = max. 0.3 mm)



03.

Spare part kit

We advise to replace the O-rings of the calibers and knife latest after 1.5 years. You can order the spare part kit at your local Thermaflex partner with the following product code: 1881-000000-004. including O-rings for all dimensions and one knife.

Important information:

- If the scraper removes too much material (see point 02. checking tolerances) or it felt down, etc., then be sure to send it to our factory for service.
- In case of manipulation of the scraper, we do not guarantee the scraper quality.
- We advise to send the scraper in one-year intervals for service to our factory. Please contact your local Thermaflex partner for processing.

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