

OPERATING INSTRUCTIONS

Scraper Tool

FWSG 63

for Pipes from ½" to 2" IPS



Scraper Tool FWSG 63 for Pipes from 1/2" to 2" IPS



KEY COMPONENTS

- | | |
|-------------------------|-----------------------------------|
| 1. Handle (collapsible) | 6. Guide Rollers |
| 2. Twist Grip Knob | 7. Feed/Locking Device |
| 3. Scraper Blade | 8. Setting Mark for Pipe Diameter |
| 4. Housing | 9. Guide Skid |
| 5. Support Rollers | |

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Picture 2



Picture 3



Picture 4

1. Clean any heavy deposits of dirt etc. from the surface to be scraped (e.g. with a clean cloth, which is free of grease).
2. Determine length of area to be scraped (= depth of insertion of coupling/molded part + 0.2) and mark with IPEX Marker.
3. Mark this surface with wavy lines (IPEX Marker).
4. Release the feed lock (7) and set the required pipe diameter (8) by pressing on the tensioning/guide rollers in the direction of the arrow up to the stop. The upper and lower line marking on the side selected must be in alignment with each other (Picture 2). Lock again.
5. Guide the tool over the pipe (Picture 3) until the support rollers are resting on the pipe (Picture 4) and are flush with its edge.
6. Turn the twist grip knob (2) clockwise by hand until the support rollers (5), tensioning rollers (6) and the scraper blade (3) are pressing against the pipe. If the pipe is oval this process should be carried out on the smallest available outside diameter of the pipe.
7. Turn the tool clockwise around the end of the pipe. Rotate it steadily until the pipe surface is scraped up to the mark (Picture 5). Do not push the tool in the direction of the axis of the pipe while scraping.



Picture 5

8. Release the tool by turning the twist grip knob (2) anti-clockwise. It can now be pulled off the pipe.
9. Remove the scrapings. Inspect the scraping result. If the marker lines are not completely removed, the scraping process should be repeated from point 4.



ATTENTION!

Scrape twice at a maximum, otherwise the tolerances of fitting/pipe would be exceeded. In this case a regular fusion can not be guaranteed.

10. If a perfect result is still not achieved even after scraping twice
 - a. Check the feed setting at the markings
 - b. Check the scraper blade (3) and if necessary replace it (See point on "Replacing the scraper blade").
11. Chamfer the end of the pipe with a hand scraper, of about 0.08 – 0.12.
12. After scraping and before fusing, the pipe should be cleaned with a PE cleaner – and an absorbent, non-fibrous, undyed paper.



ATTENTION!

The scraper tool must be kept clean and dry and always stored in its transporting case. The blade should be covered for protection. Danger of injury!

With heavy use the scraper blade will be subject to a certain amount of wear, so you should make a regular check on the thickness of the swarf removed using a sliding caliper gauge. The thickness of the swarf should be between 0.15 and 0.25 mm. The wear limit for the scraper blade is a swarf thickness of 0.12.

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WARNING!

Risk of injury on the scraper blade.

PROCEDURE

- Release the TORX screw with the TORX spanner supplied
- Remove the blade and clean the mating surface carefully
- Insert a new blade
- Tighten the TORX screw with the TORX wrench

Please note when replacing the blade that only blades dyed green may be used.

Replacement Blade Set	Order No
FWSGE 4	T-613 323

Table for Setting the Various Pipe Sizes

Setting Mark on Tool	5/8" – 1-1/4" IPS				1-1/2" – 2" IPS	
Pipe Size	1/2"	3/4"	1"	1-1/4"	1-1/2"	2"

WARRANTY

The Warranty period is twelve months, except for scraper blades or parts which have worn prematurely due to the environment (sand, earth etc.). The tool must be protected from dirt.

OPERATIONAL SAFETY

The scraper tool FWSG 63 is based on quality management according to DIN ISO 9002 and was checked with operational safety in mind before dispatch. It is recommended to test it annually for its operational safety. Please contact our service and Technical Equipment department.