



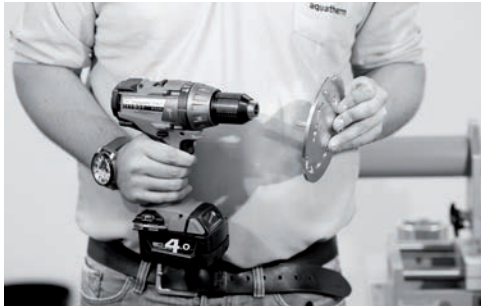
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## MANUAL FOR THE NEW AQUATHERM UNIVERSAL PEELING TOOLS

By using the aquatherm universal peeling tools the end pieces of the aquatherm OT (oxygen tight), UV (UV resistant) and MS (multilayer stabi) pipes can be peeled. By the uniform removal of the outer layer of the pipe any extension of the pipe system by electrofusion socket or fitting is possible. The universal peeling tools are available in the sizes  $\varnothing$  20-  $\varnothing$  125 mm (Art.-No. 50479 – 50488). The peeling process is done either mechanically or manually. For the mechanical processing two attachment plates for pipe sizes  $\varnothing$ 20-  $\varnothing$ 63 mm (Art.-No. 50499) and  $\varnothing$ 75-  $\varnothing$ 125 (Art.-No. 50500) mm are available. For the mechanically processing of the electrofusion sockets the peeler is extended by an attachment (Art.-No. 50489 – 50498). The power drill should have a high torque.

### 1. INSTRUCTIONS FOR THE MECHANICAL PEELING PROCESS

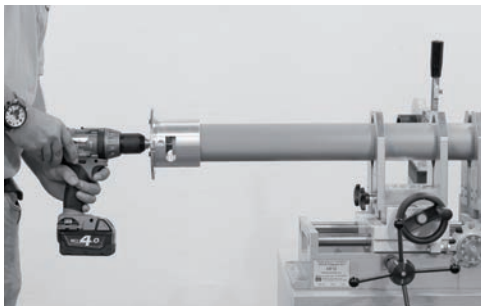
**1.1.** The attachment plate is clamped with the hexagon bolt in the power drill.



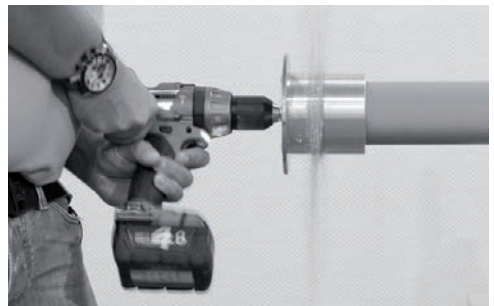
**1.2.** The peeler is fixed with its screws in the slot matching the diameter of the attachment plate and rotated clockwise so that the peeler adheres to the attachment plate.



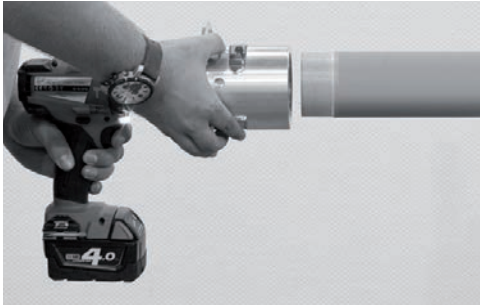
**1.3.** The peeling tool clamped on the chuck is set by the lead to the end of the pipe.



**1.4.** The peeling process starts with rotation of the peeling tool upon slight force in axial direction. The peeling operation is completed when the attachment plate strikes against the pipe end.



**1.5.** The pipe now can be welded by socket welding method.



## **2. INSTRUCTIONS FOR THE MECHANICAL PEELING PROCESS FOR ELECTROFUSION SOCKETS**

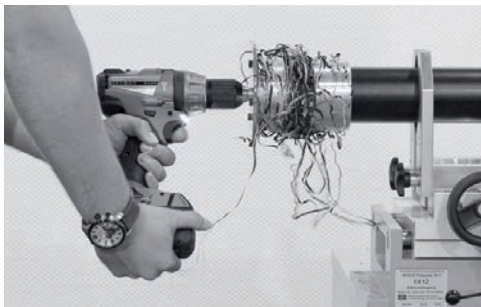
**2.1.** The extension is centered with the peeler through the superimposed chamfer fit and fastened with three Allen screws.



**2.2.** The attachment plate is clamped with the hexagon bolt in the power drill and connected with the peeling tool (see photo 1.2.).



**2.3.** The peeling process starts with rotation of the peeling tool upon slight force in axial direction. The peeling operation is completed when the carrier plate strikes against the pipe end.



**2.4.** The peeling tool is withdrawn from the pipe and the E-socket welding process can start.

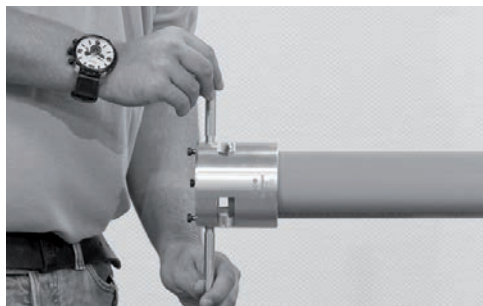


### 3. PEELING INSTRUCTIONS FOR MANUAL PEELING

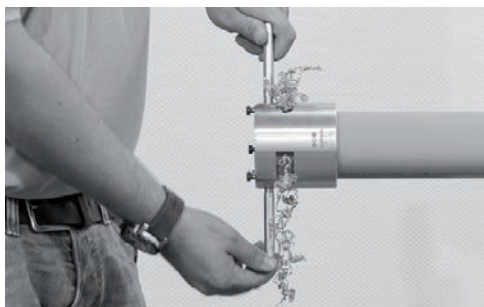
**3.1.** For the manual peeling two handles are mounted at the peeling tool.



**3.2.** The peeling tool is pushed onto the untreated pipe up to the stop.



**3.3.** The peeling tool is turned clockwise as long as the marked peeling depth (see table) is reached.



**3.4.** If the specified/marked peeling depth (see table) is reached, the peeling tool is removed and the socket welding process can start. If the electric socket can be used as a sliding sleeve, the peeling depth for the electric socket welding (see table) must be doubled.



**TABLE OF PEELING DEPTH:  
SOCKET AND ELECTRIC SOCKET WELDING**

Diameter	Peeling depth Socket welding	Peeling depth Electric socket welding
ø 20	16 mm	39 mm
ø 25	20 mm	43 mm
ø 32	22 mm	45 mm
ø 40	25 mm	50 mm
ø 50	28 mm	56 mm
ø 63	32 mm	65 mm
ø 75	34 mm	69 mm
ø 90	37 mm	77 mm
ø 110	42 mm	85 mm
ø 125	44 mm	90 mm

## RANGE OF UNIVERSAL PEELING TOOLS

Article-No.	Description
50479	Universal peeling tool 20mm
50489	Extension for universal peeling tool 20mm Art.-No. 50479
50480	Universal peeling tool 25mm
50490	Extension for universal peeling tool 25mm Art.-No. 50480
50481	Universal peeling tool 32mm
50491	Extension for universal peeling tool 32mm Art.-No. 50481
50482	Universal peeling tool 40mm
50492	Extension for universal peeling tool 40mm Art.-No. 50482
50483	Universal peeling tool 50mm
50493	Extension for universal peeling tool 50mm Art.-No. 50483
50484	Universal peeling tool 63mm
50494	Extension for universal peeling tool 63mm Art.-No. 50484
50485	Universal peeling tool 75mm
50495	Extension for universal peeling tool 75mm Art.-No. 50485
50486	Universal peeling tool 90mm
50496	Extension for universal peeling tool 90mm Art.-No. 50486
50487	Universal peeling tool 110mm
50497	Extension for universal peeling tool 110mm Art.-No. 50487
50488	Universal peeling tool 125mm
50498	Extension for universal peeling tool 125mm Art.-No. 50488
50499	Attachment plate for universal peeling tool 50479 – 50484
50500	Attachment plate for universal peeling tool 50485 – 50488



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