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# Calderprep Plus Rotary Scraping Tool 20-63mm


Model: 01-07-330

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## Operating Instructions

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REVISION: 01



# Helping you make the right connections.

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# 01. Introduction

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## General Description

Calderprep tools are designed for scraping small diameter pipes primarily for electrofusion purposes. The Calderprep tool is lightweight, strong and durable. It removes ovality from pipe before scraping 100% of the scraped area every time and produces consistent results over hand scraping. It is designed to fit pipe sizes from 20mm through to 63mm.

The tool has mandrel inserts to allow for different sizes and wall thicknesses of pipes allowing quick and easy changing of size.

The tool is designed to remove a thin layer of the pipe wall to prepare the pipe (new, weathered or previously installed) and provide a fusible surface for electrofusion purposes in accordance with Gas Industry Standards GIS/PL2-5 Part 5 Electrofusion Ancillary Tools.

This product (Calderprep Plus) has been manufactured, inspected and tested in accordance with the ISO9001 quality control systems and procedures in place at Caldervale Technology Ltd, Dewsbury.

## Before Using

It is important to ensure all component parts are present and in serviceable condition.

The condition of the tool should be inspected thoroughly prior to use, attention should be paid to the cutting tip, if this is damaged or worn the quality of scrape can be severely limited.

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**Note: These tools are designed only to work with pipe size specified, are not interchangeable and will not work on another size of pipe. For example, a 63mm Calderprep will not scrape a 50mm pipe.**

## 02. Safety Instructions

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1. Read and understand the whole booklet before using the tool.
2. Never attempt to operate on pipes that are not within the specified dimensions.
3. Operatives should wear eye protection, gloves, safety headwear & footwear when using the equipment.



### **Important!**

This tool should be used in accordance with the pipe manufacturers' recommendations and in line with local codes of practice.

This manual outlines the operation of the pipe preparation tool for PE pipe and forms a part of the product to which it relates. It should be kept for the life of the product. Any amendments issued by Caldervale Technology Ltd should be incorporated in the text. The manual should be passed to any subsequent holder or user of this product.

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

## 03. Mandrel Heads

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There are a number of mandrels readily available for the calderprep line of rotary scraping tools. A different mandrel insert will allow the Calderprep Plus to work on different pipe diameter as well as different wall thicknesses of pipe to be scraped.

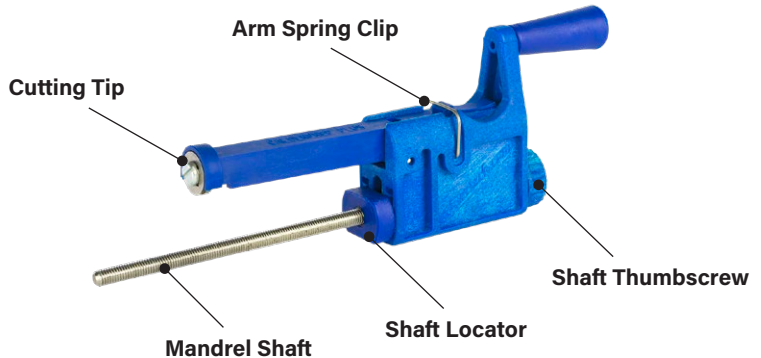
Mandrel heads are available for pipe sizes 20, 25, 32, 40, 50 and 63mm and a range of wall thicknesses and SDR ratings are available. Special sizes are available upon request.

Our mandrel heads can be found at [www.caldertech.com](http://www.caldertech.com)



## 04. Operation

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### Instructions for Use

1. Check the pipe size and SDR in order to select the correct Mandrel.
2. Unscrew the shaft thumbscrew by turning anticlockwise. It is not necessary to fully remove this from the tool.
3. Use the shaft locator to locate the shaft at the correct position for the pipe being used by lining up the line on the side of the shaft locator with the size markings on the body of the tool then tighten the shaft thumbscrew clockwise.
4. Ensure the arm spring clip is keeping the arm of the tool in its uppermost position. If it is not, press on the rear of the arm with the thumb and move the clip to keep the arm in its uppermost position.
5. Insert the mandrel shaft into the selected mandrel.
6. Insert the mandrel fully into the pipe to be scraped.
7. Turn the whole tool clockwise until the cutting tip is over the edge of the pipe. Ensure it is on the edge to ensure there are no areas of un-scraped pipe.
8. Push down on the rear of the arm and release the spring clip to allow the cutting tip to rest on the pipe.

9. Begin to turn the whole tool clockwise using the crank handle. As the tool is turned it will automatically advance the scrape down the pipe.
10. It may be necessary to pause scraping to remove excess peel.

## Removal

1. When the scrape is complete push down once again on the rear of the arm and put the arm spring clip in place to keep the arm raised away from the pipe.
2. Remove the mandrel head from the pipe. If there is difficulty removing it, turn (the mandrel only), anticlockwise to remove.



## Storage

### **IMPORTANT! When not in use always:**

1. Ensure the tool is clean and dry before storage.
2. Always store in the tool case provided.

## Routine Maintenance

1. Check for correct movement and operation and lubricate moving parts at regular intervals before using.
2. It is important to ensure all component parts are present and in serviceable condition.



## 05. Specifications

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<b>Materials:</b>	Mild Steel / Stainless Steel / Aluminum / Plastic / Brass
<b>Finish:</b>	Natural / Zinc passivate (Steel) / Blue (Plastic)
<b>Dimensions:</b>	L. 300mm x W. 80mm x H. 280mm
<b>Weight:</b>	0.5kg
<b>Min Pipe Diameter:</b>	20mm
<b>Max Pipe Diameter:</b>	63mm
<b>SDR:</b>	All (With correct Mandrel Head)
<b>Product Code:</b>	01-07-330

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

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

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**It is the responsibility of the operator to ensure that the PE pipe is suitable for this clamping system if in doubt contact the PE pipe manufacturer for confirmation.**

## 06. Warranty Information

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### 1. Extent of Warranty

- a) Subject to clauses 2 and 3, Caldervale Technology Ltd warrants to the end-user customer that its products will be free from defects in materials and workmanship, for six months after the date of purchase by the end-user customer, subject to providing proof of purchase.
- b) If Caldervale Technology Ltd receives, during the warranty period, notice of a defect in product which is covered by this warranty; Caldervale Technology Ltd shall either repair or replace the product, at its option. Any replacement product may be either new or like-new, provided that it has functionality at least equal to that of the product being replaced.
- c) All warranty work will be carried out by Caldervale Technology Ltd unless otherwise agreed. On-site warranty and repair or replacement services are available from authorised Caldervale Technology Ltd service facilities world-wide.
- d) Customers shall prepay shipping charges for products returned to Caldervale Technology Ltd for warranty service, and Caldervale Technology Ltd will charge for return of the products back to the customer.
- e) This warranty statement gives the customer specific legal rights. The customer may also have other rights which vary from country to country in the world.

### 2. Pre-conditions for Warranty Application

Caldervale Technology Ltd's warranty covers only those defects which arise as a result of normal use of the product, and this warranty shall only apply in the following circumstances:

- a) All the instructions contained in the operating manual have been complied with; and
- b) None of the following apply:
  - i) Improper or inadequate maintenance;
  - ii) Physical abuse;
  - iii) Unauthorised modification, misuse or any use not in accordance with the operating manual and good industry practice;

- iv) Operation outside the products specifications;
- v) Improper site preparation or maintenance;
- vi) Faulty pipes.

### 3. Limitations of Warranty

- a) Caldervale Technology Ltd does not warrant the operation of any product to be uninterrupted or error free.
- b) Caldervale Technology Ltd makes no other warranty of any kind, whether express or implied, with respect to its products. Caldervale Technology Ltd specifically disclaims the implied warranties of satisfactory quality and fitness for a particular purpose.
- c) 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.
- d) To the extent allowed by local law, the remedies provided in this warranty statement are the customer's sole and exclusive remedies.
- e) This tool has been designed for the range of pipes available at the time of its design and development. Caldervale Technology Ltd can accept NO liability for the unit's ability or otherwise to work with new or different pipes that subsequently appear in the market place.

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

Where purchased: \_\_\_\_\_

Date of purchase: \_\_\_\_\_

Name of purchaser: \_\_\_\_\_

Address of purchaser: \_\_\_\_\_

\_\_\_\_\_  
\_\_\_\_\_

Type of tool: \_\_\_\_\_

Serial number: \_\_\_\_\_

## 07. Service and Repair

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This product has no specific calibration period, however periodic safety inspections should be carried out by the operator as specified in this manual, if in any doubt please contact the manufacturer for further information.

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## 08. Decommissioning and Disposal

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These give the instructions for decommissioning and disposal of the equipment and confirm how it is to be taken out of service safely, in respect of the Essential Environmental, Health and Safety Requirements.

- If a Caldertech Calderprep Plus has reached the end of its useful working life and cannot be refurbished it must be sent to a licensed recycling facility for treatment. That will ensure the waste hierarchy requirements are met.
- End of life treatment is the responsibility of the Customer. This can also be achieved by returning the product back to the manufacturer if required.



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## Certificate of Conformity

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This document certifies that the product detailed below fully conforms to the following standard without derogation.

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**GIS/PL2-5:2018 Electrofusion Ancillary Tools**

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**Product: Calderprep Plus  
Rotary Scraping Tool**

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**MARCH 2019**



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**I. Smith**  
Managing Director



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