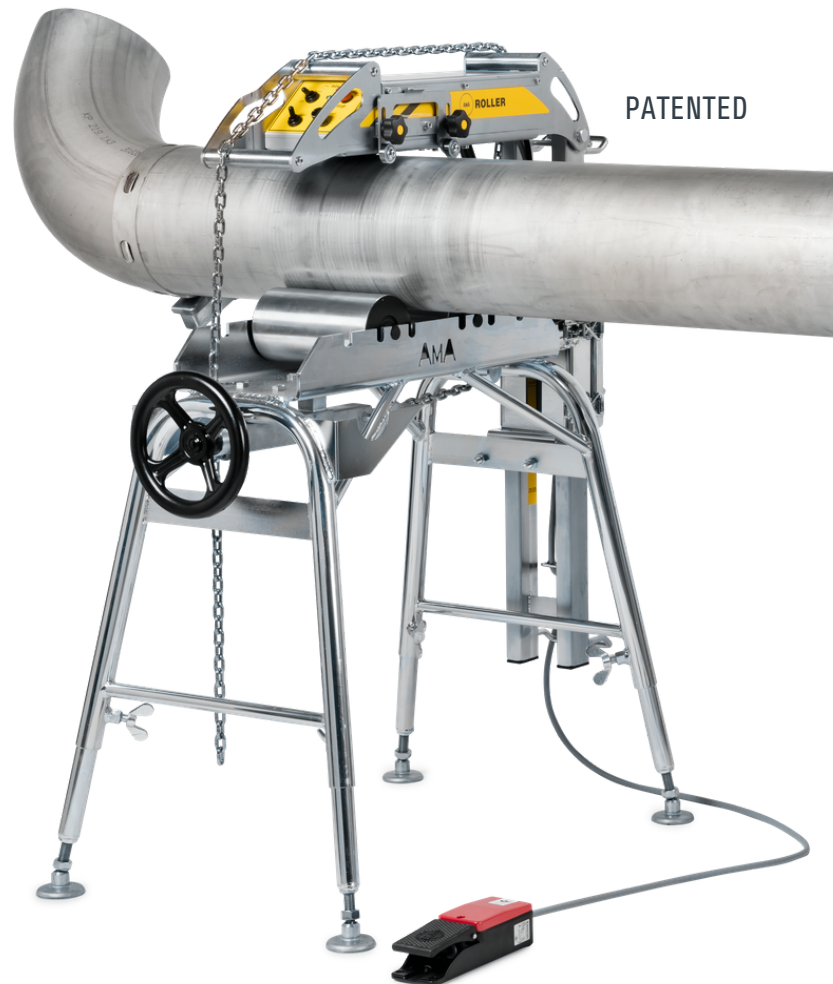




OPERATING INSTRUCTIONS AMA Roller®-PIPE ROTATOR



**READ THESE INSTRUCTIONS CAREFULLY BEFORE USING
THE PIPE ROTATOR.**



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MANUFACTURER:

Welner Oy

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1 DECLARATION OF CONFORMITY (Eu)

Manufacturer: Welner Oy www.welner.fi

Phone number: +358 400 600 942

email address: sales@welner.fi

Person authorized to compile the specification file:

Markku Impiö

Welner Oy declares that the following machine:

Device: Welner AMA Roller®

Model/Type: AMA Roller® 3-3

Other description: The device is designed to rotate pipes for preparatory installation and welding.

- conforms to the relevant regulations of machine directive 2006/42/EU.
- conforms to the relevant regulations of low voltage directive 2006/95/EU.
- conforms to the relevant regulations of EMC directive 2004/108/EU.

Last two numbers of the year when the CE marking was affixed: 16

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2 GENERAL

2.1 Description

The AMA Roller® pipe rotator is designed to rotate pipes for preparatory pipework installation and welding. The pipe rotator must not be used for anything other than what it is designed for. Fastening the pipe rotator to any stand other than the AMA A pipe stand is strictly forbidden.

2.2 Specifications

Weight (without the A pipe stand) [Kg]	23
Nominal voltage [V]	110
Current [A]	0.9
Frequency [Hz]	50/60
Power [W]	100
External diameter of the rotated pipe [mm]	30-500
Maximum rotation load [Nm]	30

Maximum rotation load 30 Nm

EXAMPLES OF MAXIMUM LOAD:

Maximum wall thickness per diameter of pipes/curves to be rotated with the AMA Roller® pipe rotator:

Example: Pipe length max 6 m+curve(curve radius = 1.5 x pipe diameter)

Pipe diameter	Maximum wall thickness
30-300 mm	10 mm
350 mm	8 mm
400 mm	6 mm
500 mm	4 mm

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3 SAFETY

3.1 Safety instructions

These safety instructions must be followed whenever the pipe rotator is being operated or serviced. Neglecting to follow these instructions may result in personal injury or damage to property.

- Do not connect the ground cable of the welding machine to the pipe rotator or the A pipe stand. The ground cable must be connected to the pipe being welded.
- The maximum temperature resistance of the drive wheel is 90 °C. Do not bring a hot welded seam near the drive wheel, as the wheel may melt.
- Be careful not to drop the pipe rotator on your feet when mounting it on the stand as it may fracture your foot. Wear protective shoes when mounting the pipe rotator.
- To prevent buckling when handling heavy or acentric pipes, the adjustable legs of the AMA A pipe stand must be fully retracted.
- Make sure there are no people or obstructions near the rotating pipe when operating the pipe rotator.
- Be careful not to pinch your fingers or hand between the pipe and the machine frame when installing or removing a pipe.
- Check the fastening of the pipe before operating the pipe rotator.
- Be careful not to put your fingers or hand between the roller and the pipe while rotating the pipe.
- Avoid using high rotating speeds when handling heavy pipes. The maximum rotation load is 30 Nm.
- The tightening chain must pass over every support tube on top of the machine and the chain must be locked to the chain slot of the AMA A pipe stand that is closest to the operator.



- The support rollers are meant to be used especially with pipes with a diameter of 150–250 mm. Tighten the support rollers only after tightening the chain.
- The pipe rotator must be operated and stored in dry conditions only.
- Spraying water or any other liquid on the pipe rotator is strictly forbidden. The pipe rotator may be damaged and the operator may get an electrical shock if moisture penetrates the electrical parts.
- The operating temperature of the pipe rotator is +5...+40 °C.
- Make sure the power cord is disconnected before opening the cover of the pipe rotator.
- Check the condition of the pipe rotator's electric wires regularly. Discontinue using the pipe rotator immediately if an electric wire is damaged.
- Fastening a pipe with an external diameter over 508 mm to the pipe rotator is strictly forbidden.
- Make sure the pipe rotator does not fall over when rotating very acentric pipes.

3.2 Safety equipment

The pipe rotator is equipped with the following safety equipment:

1. EMERGENCY STOP button

The pipe rotator's operation can be stopped immediately by depressing the EMERGENCY STOP button. The operator must be able to reach the EMERGENCY STOP button in all situations. The EMERGENCY STOP button is reset by lifting it and then turning the Power switch Off and On again.

3.3 Protective clothing

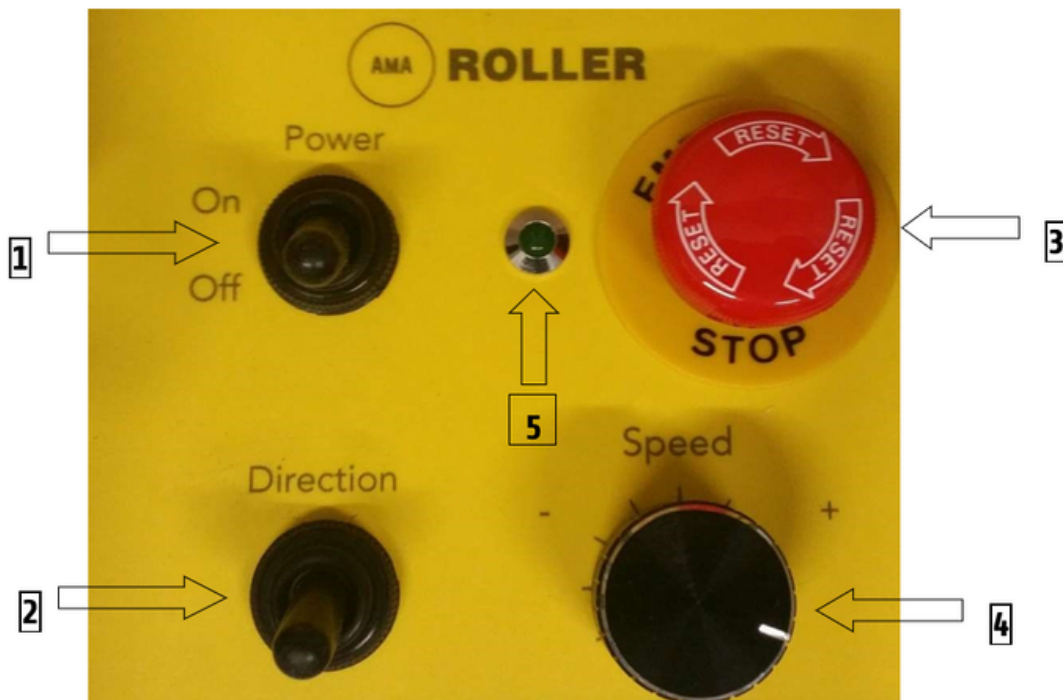
Always wear steel-tipped shoes, appropriate protective clothing, safety goggles, and protective gloves when operating the AMA Roller® pipe rotator.

4 OPERATION



The following section explains how to operate the pipe rotator safely. Read this section carefully.

4.1. 1.1 Description of the control panel



1. Power switch
2. Rotating Direction selector
3. EMERGENCY STOP button
4. Rotating Speed knob
5. Indicator lamp



4.1. Operating the pipe rotator

1. Place the pipe to be rotated on the rollers of the A pipe stand.
2. Loosen the thumb screws of the AMA Roller® pipe rotator's support rollers.
3. Lower the rotating device onto the pipe.
4. Pass the tightening chain of the rotating device over every support tube on top of the machine and lock the chain to the chain slot of the AMA A pipe stand that is closest to you.
5. Tighten the chain with the tensioning wheel of the A pipe stand. When the drive wheel at the bottom of the AMA Roller® pipe rotator touches the pipe to be rotated, further tighten the tensioning wheel 1½–2 turns.
6. If necessary, lower the support rollers onto the pipe and tighten the thumb screws.
7. Connect the power cord to a 220/230 V power supply.



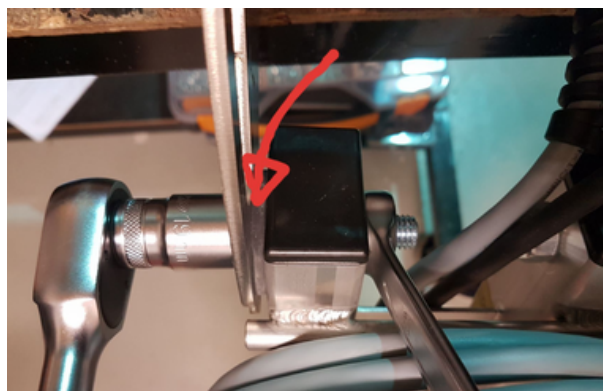
Before connecting the power cord make sure the Power switch is turned Off, the electric wires are not damaged, and the foot pedal is not activated.

8. Check that the EMERGENCY STOP switch is not depressed and turn the Power switch On.
9. Select the appropriate rotating direction with the Direction selector.
10. Select an appropriate rotating speed with the Speed knob.
11. Press the foot pedal. The pipe rotator operates only when the foot pedal is activated. The pipe rotator will stop immediately if the foot pedal is released.

5. MAINTENANCE, TROUBLESHOOTING

Troubleshooting

<p>The power does not go on</p>	<p>No electricity</p> <p>The EMERGENCY STOP button is depressed</p>	<p>Check the connections</p> <p>Lift the button and then turn the Power switch Off and On again</p>
<p>The drive wheel doesn't turn</p>	<p>The drive wheel chain is loose / dislocated / broken</p> <p>The motor or control circuit is faulty</p>	<p>Tighten / replace the chain</p> <p>Contact the device manufacturer</p>
<p>The top of the AMA Roller® doesn't stay up</p>	<p>If the bolt of the friction plate (red arrow) is too loose, Roller descends</p>	<p>Tighten the bolt, Roller will remain in the desired position</p>





6. PIPE ROTATOR DISPOSAL

When the AMA Roller® pipe rotator reaches the end of its service life, it should be disposed of in such a way that is not hazardous to the environment. Dismantle the device and sort the components for appropriate disposal.



7. WARRANTY

Welner Oy gives the AMA Roller® pipe rotator a 12-month warranty. Said warranty shall only cover faults caused by manufacturing errors. Said warranty shall not cover any faults caused by incorrect operation or overloading nor any accidents or damage caused by neglecting to follow these operating and safety instructions.

Said warranty shall not apply to a pipe roller that has been handled, operated, or modified in any way other than what is described in these operating instructions.

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