

ROTATOR

X-ROTATOR

1 ton

SAFETY INSTRUCTIONS FOR USE AND MAINTENANCE

DEVICE No W000277393 - W000277394



EDITION: EN
REVISION: D
DATE: 09-2019

Instructions for use

REF: **8695 6450**

Original instructions

Thank for the trust you have expressed by purchasing this equipment, which will give you full satisfaction if you follow its instructions for use and maintenance.

Its design, component specifications and workmanship comply with applicable European directives.

Please refer to the enclosed CE declaration to identify the directives applicable to it.

The manufacturer will not be held responsible where items not recommended by themselves are associated with this product.

For your safety,there follows a non-restrictive list of recommendations or requirements, many of which appear in the employment code.

Finally we would ask you kindly to inform your supplier of any error which you may find in this instruction manual.

CONTENTS

A - IDENTIFICATION	1
B - SAFETY INSTRUCTIONS.....	2
1 - AIRBORNE NOISE	2
2 - PARTICULAR SAFETY INSTRUCTIONS	2
C - DESCRIPTION	4
1 - CHARACTERISTICS	5
2 - DIMENSIONS AND SPACE REQUIREMENTS	6
3 - ROTATOR WITH OPTION LORRY	7
D - ASSEMBLY - INSTALLATION	9
1 - CONDITIONS OF INSTALLATION.....	9
2 - HANDLING THE X ROTATOR 1 TON.....	9
3 - INSTALLATION.....	10
E - MAINTENANCE.....	12
1 - SERVICING.....	12
2 - TROUBLESHOOTING	12
3 - SPARE PARTS	13
PERSONAL NOTES	16

REVISIONS

REVISION B

06/19

DESIGNATION	PAGE
To change logos	

REVISION C

07/19

DESIGNATION	PAGE
Update	

REVISION D

09/19

DESIGNATION	PAGE
Update	

A - IDENTIFICATION

Please enter the number of your equipment in the following box.

Quote this information in all correspondence.



B - SAFETY INSTRUCTIONS



1 - AIRBORNE NOISE

Refer to the special instructions "8695 7051" supplied with the equipment.

2 - PARTICULAR SAFETY INSTRUCTIONS



NEVER USE THE X ROTATOR ON ITS OWN; it must necessarily be used along with a stock or positioner.



Do not exceed the permissible loads, torques and tangential forces or the minimum and maximum diameters of shells.



Carry out a dry test run of the rotation movement.



Do not drop loads on the equipment.



Make sure that the working of the equipment is not hindered by tools and/or objects left close to the rotating part or by its appendages, which could strike fixed elements (ground, frame, posts).



Maintain the centre to centre distance of the rollers depending on the diameter of the shell (see section D).



No object is to be placed on the rolling tracks.



Before using the machine, make sure that all the guards are in place. All guard covers must be screwed in.



Clean the working area from time to time.



If the equipment is used for welding, make sure that the ground of the power source is connected to the piece before you start welding.



Never modify the machine.
The rotator **is not** designed for anchoring lifting equipment.



The use of Personal Protective Equipment (PPE) is **mandatory**.



Machine maintenance must be carried out **with all the energy supplies switched off.**
The disconnection and padlocking of all energy sources is **mandatory**.

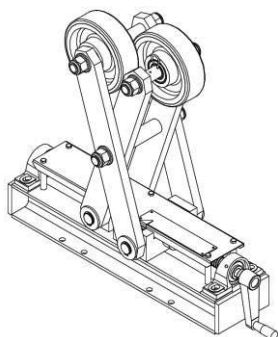
C - DESCRIPTION

The one-tonne X-rotator makes it possible to support shells or tubes with different diameters. The X arm system ensures that the height of the rotation axis is the same for all diameters. The rotator (generally under torque) must necessarily be associated with a stock or a positioner, and makes it possible to bear the load of the part; the part is only made to rotate by the rotation torque of the stock or positioner.

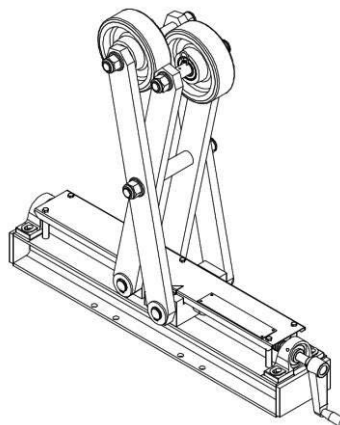
The setting of the roller distance is made manually with a crank. A slide makes sure the good setting of the roller distance according the diameter of the piece.

It exists 2 types of X-rotator 1 ton

Axis height 555mm W000277393



Axis height 750mm W000277394



These X-rotators can be mounted on idler lorry (W000274920) in order to facilitate the transversal movement.

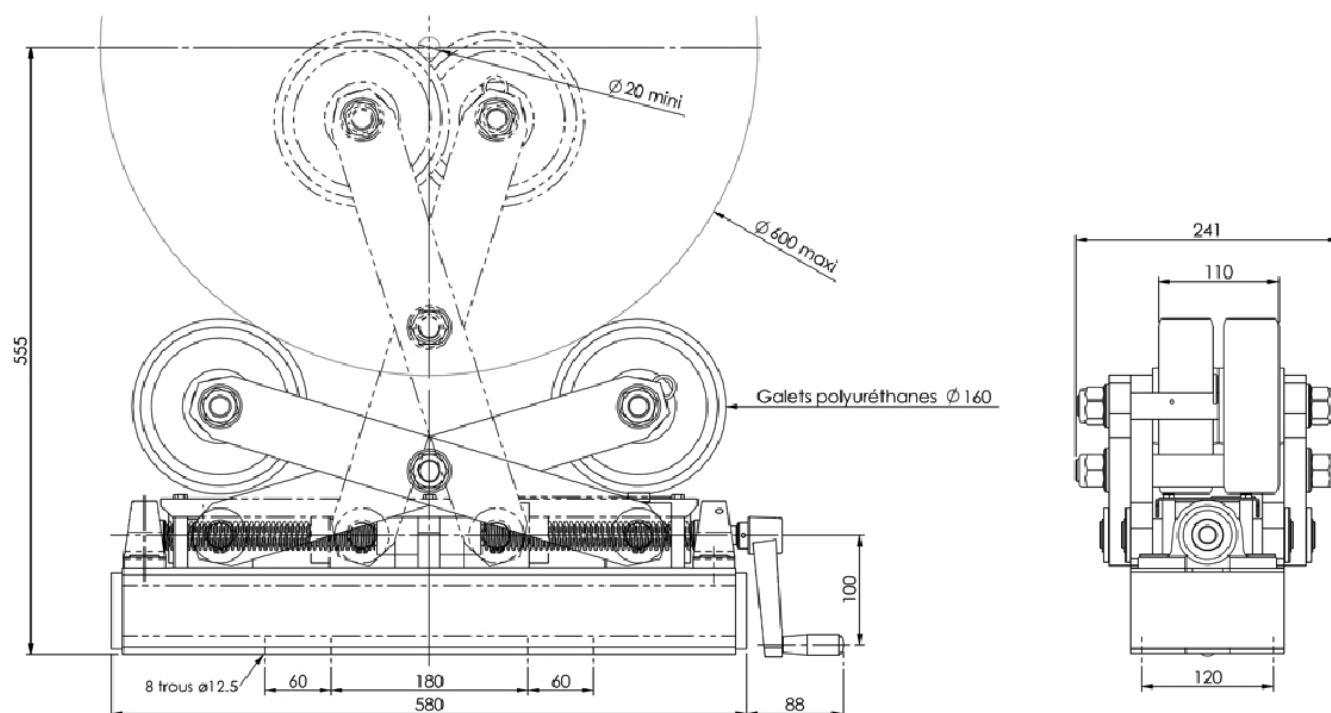
1 - CHARACTERISTICS

		X-ROTATOR 1 T – 20-600	X-ROTATOR 1 T – 60-1020
		W000277393	W000277394
Load capacity on 1 X-rotator :	-	1 ton	
Load capacity on a set of 2 X- rotators :	-	2 tons	
Minimum diameter of the piece :	mm	20	60
Maximum diameter of the piece :	mm	600	1020
Roller dimensions :	mm	Ø 160 x 50	
Roller material :	-	Polyurethane *	
Axis height :	mm	555	750
Setting of roller distance :	-	Manual with a slide	Manual with a slide
Weight :	Kg	70	100

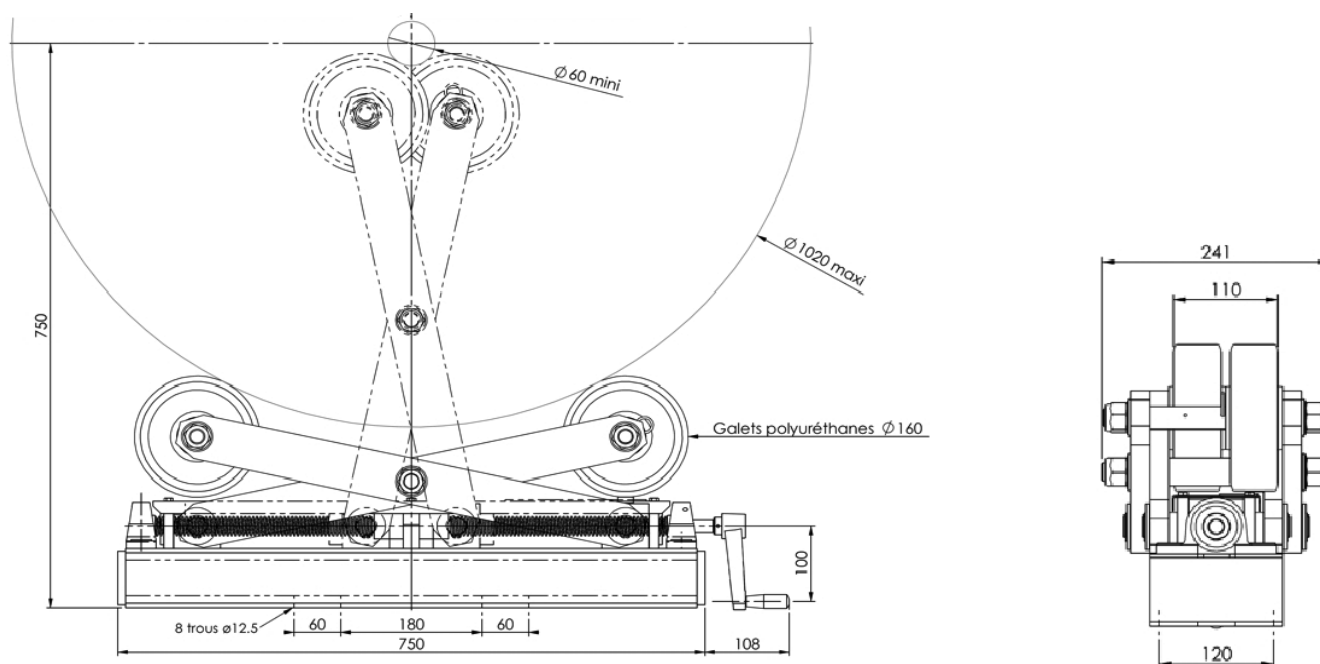
*possibility to have steel rollers in special

2 - DIMENSIONS AND SPACE REQUIREMENTS

X-rotator 1T – diameter : 20-600mm



x-rotator 1t – diameter : 60-1020mm



3 - ROTATOR WITH OPTION LORRY

The rotators can be also mounted on idler lorry (W000274920), then the distance rotation axis - ground is different according the type of X-rotator :

X-rotator 20-600 W000277393 555 mm	+	idler lorry W000274920 84 mm	+	LINCOLN ELECTRIC railway W000315250 oru W000315251 70 mm	=	709 mm
--	---	------------------------------------	---	---	---	---------------

X-rotator 60-1020 W000277394 750 mm	+	idler lorry W000274920 84 mm	+	LINCOLN ELECTRIC railway W000315250 or W000315251 70 mm	=	909 mm
---	---	------------------------------------	---	---	---	---------------



D - ASSEMBLY - INSTALLATION

The X-rotators are used in various applications. In particular, we use them for the welding or cutting of pipes, the piece supported by the X-Rotators and the rotation movement is made by the positioner.

The X-rotators can be put on the floor or on supports.

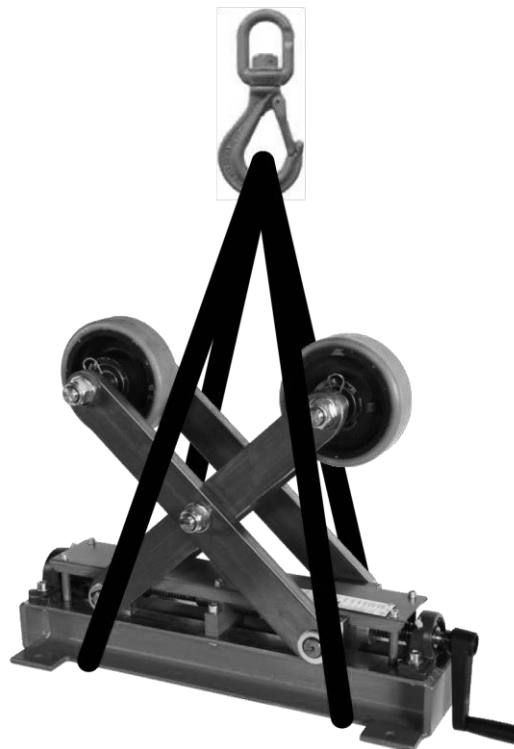
1 - CONDITIONS OF INSTALLATION

**THE LAYOUT OF THE INSTALLATION MUST COMPLY WITH
SAFETY STANDARD NF
EN 547 -1 -3 TO ASSURE PERSONAL PROTECTION.**

**THE FOLLOWING CONDITIONS MUST BE COMPLIED
WITH BEFORE INSTALLING THE EQUIPMENT**

2 - HANDLING THE X ROTATOR 1 TON

- Remove the X-ROTATOR 1 ton from its delivery packing
- Sling the X-ROTATOR 1 ton by using soft slings.



**Operator protection
Helmet - Gloves - Safety shoes**

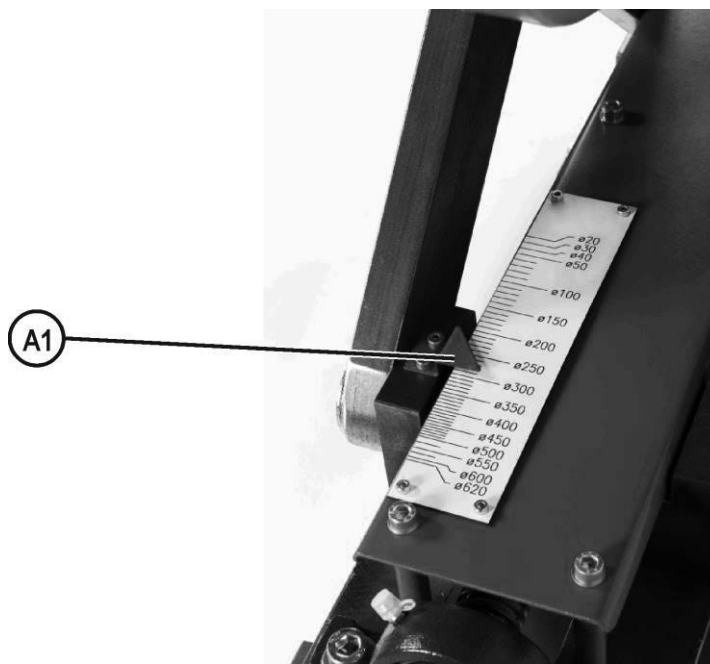
3 - INSTALLATION

- Bolt the X-ROTATOR 1 ton on the support (minimum 8 M10 bolts, class 8.8)



The X-ROTATOR must imperatively be fixed to its support (or the ground) to guarantee its stability.

- Adjust, without the piece, the shell diameter by using the graduated rule (A1)
- Set the piece



E - MAINTENANCE

1 - SERVICING

So that the machine continues to provide good service for as long as possible, a certain minimum of care and maintenance is necessary.

LUBRICATION

The screw have the be greased and blow the machine to remove the scoria.

CHECKING AND SAFETY

It is important to follow the indications given in these instructions, especially those relating to limits of use.

In addition, the main elements of the device must be checked every 3 months, paying particular attention to the screws and nuts of the roller closeness system.

TYRE SERVICING AND PROTECTION

For maximum length of use, it is important to comply with the following instructions:

- ⇒ **Do not overload them (avoid impacts when positioning the ring)**
- ⇒ **Do not leave the rollers for long under a heavy load which may distort the tyre irreversibly**
- ⇒ **Do not put hydrocarbons on the rollers. If so, clean them very quickly.**

During preheating, the temperature of the ring area in contact with the tyres should not exceed 60 to 70°C and the part must be kept moving.

2 - TROUBLESHOOTING

Possible symptoms	Probable causes	Possible remedies
The polyurethane roller doesn't turn	The roller axis is damaged	Dismount the roller and replace the faulty parts
The crank for roller distance adjustment doesn't turn	The nuts are blocked	Clean the nuts and the screw and grease them again

3 - SPARE PARTS

How to order

The photos or sketches identify nearly every part in a machine or an installation

The descriptive tables include 3 kinds of items:

- those normally held in stock: ✓
- articles not held in stock: ✕
- those available on request: no marks

(For these, we recommend that you send us a copy of the page with the list of parts duly completed. Please specify in the Order column the number of parts desired and indicate the type and the serial number of your equipment.)

For items noted on the photos or sketches but not in the tables, send a copy of the page concerned, highlighting the particular mark.

For example:

		✓	normally in stock
		✕	not in stock
			on request

Item	Ref.	Stock	Order	Designation
1	W000XXXXXX	✓		Machine interface board
2	W000XXXXXX	✕		Flowmeter
3	9357 XXXX			Silk-screen printed front panel

- For parts order, give the quantity required and put the number of your machine in the box below.

CE Type <input type="text"/> Matricule <input type="text"/>	TYPE:
	Number:

MECHANICAL PART

✓	normally in stock
✗	not in stock
	on request

Item	Ref.	Stock	Order	Designation
M1				Polyuretane roller
M2				Graduated rule
M3				Crank
M4				Nuts and screw
M5				Ball bearing

➤ For parts order, give the quantity required and put the number of your machine in the box below.

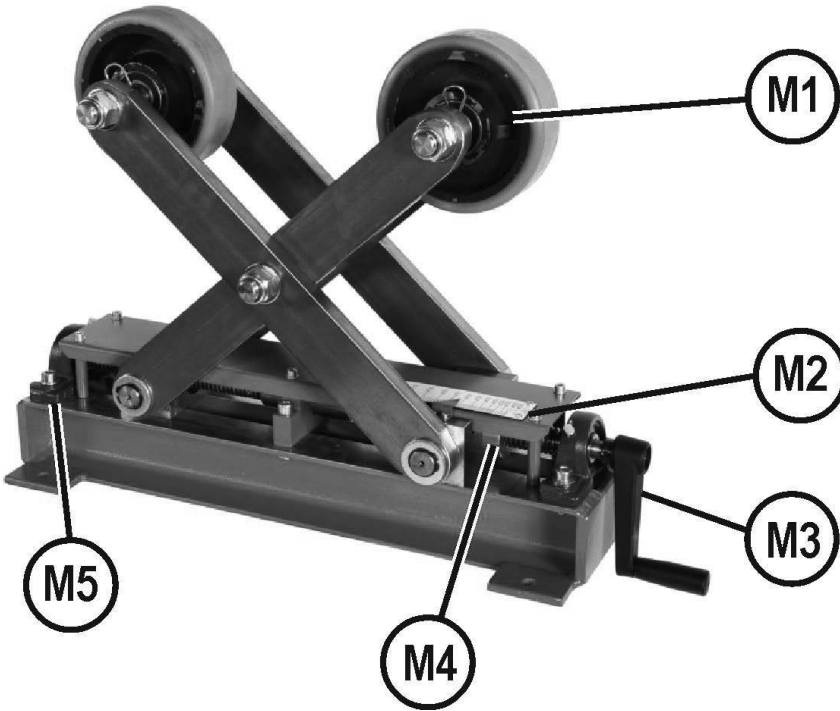
CE

Type

Matricule

TYPE:

Number:



OPTION LORRY (W000274920)

		<div><div><div><input checked="" type="checkbox"/></div><div><input checked="" type="checkbox"/></div><div><input type="checkbox"/></div></div><div><div>normally in stock</div><div>not in stock</div><div>on request</div></div></div>		
Item	Ref.	Stock	Order	Designation
L1				Travelling roller

➤ For parts order, give the quantity required and put the number of your machine in the box below.

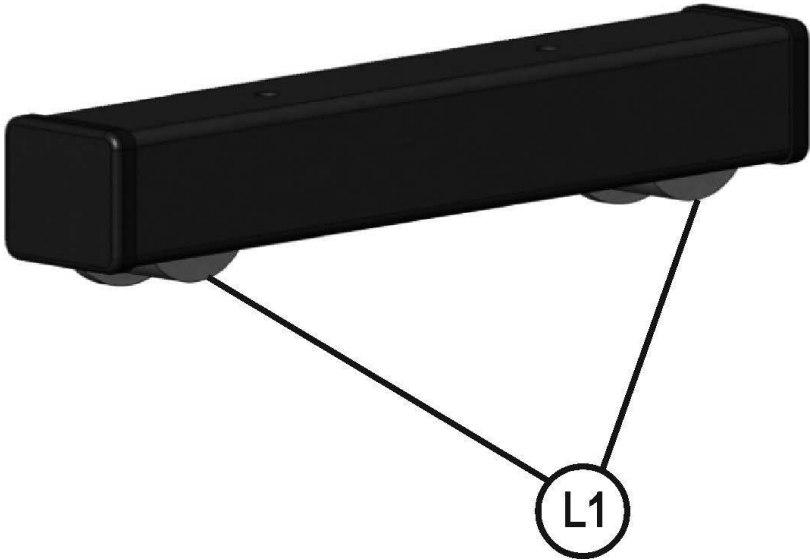
CE

Type

Matricule

TYPE:

Number:



[illegible]