

## Working Instructions Translation WIDOS Outside debader

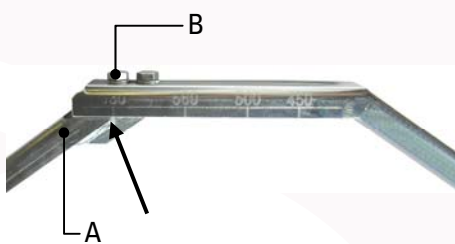
The WIDOS **Outside debader** is an ultra-light and solid device for the safe, simple and power-saving removal of the external beads after butt welding.

Due to the compact construction, it is an ideal device for working on clamped pieces, e.g. after expiration of 20-30 % of the cooling time, without time-consuming removal of the clamping devices.

Size 1	∅ = 110 – 160 for WIDOS 4400	0.8 kg
Size 2	∅ = 140 – 250 for WIDOS 4600	1.0 kg
Size 3	∅ = 180 – 315 for WIDOS 4900	1.3 kg
Size 4	∅ = 280 – 450 for WIDOS 5100	2.0 kg
Size 6	∅ = 450 – 630 for WIDOS 6100	9.3 kg
Size 8	∅ = 630 – 1000 for WIDOS 10000	20.0 kg
Size 9	∅ = 800 – 1200 for WIDOS 12000	23,5 kg



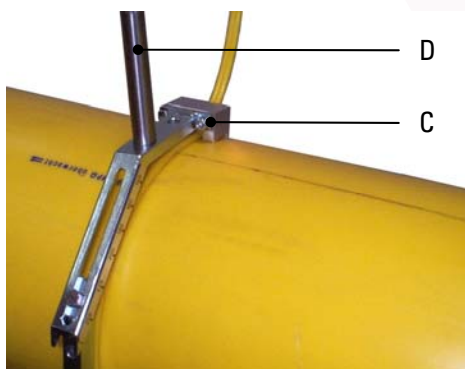
The pipes to be welded have to be clamped in such a way that the outside debader will fit in between the clamping devices after completion of the welding process.



Adjust the outside debader by means of the scale according to the pipe dimension.

The edge <A> shows you the diameter range at the scale (arrow).

Tighten the screw <B> with low force.



The best time for removing the bead is after expiration of 20-30 % of the cooling time.

Put the outside debader with the cutting head <C> onto the bead and turn it.

Due to the rotation, the knife penetrates the bead.

Insert the knurled grips <D> into the prepared holes and rotate the device around the pipe.



### Danger of injury at the cutting knife !



Rotate the outside debader completely around the pipe, if necessary change-over the knurled grips.



Check the sharpness of the knife regularly, if necessary exchange the knife.

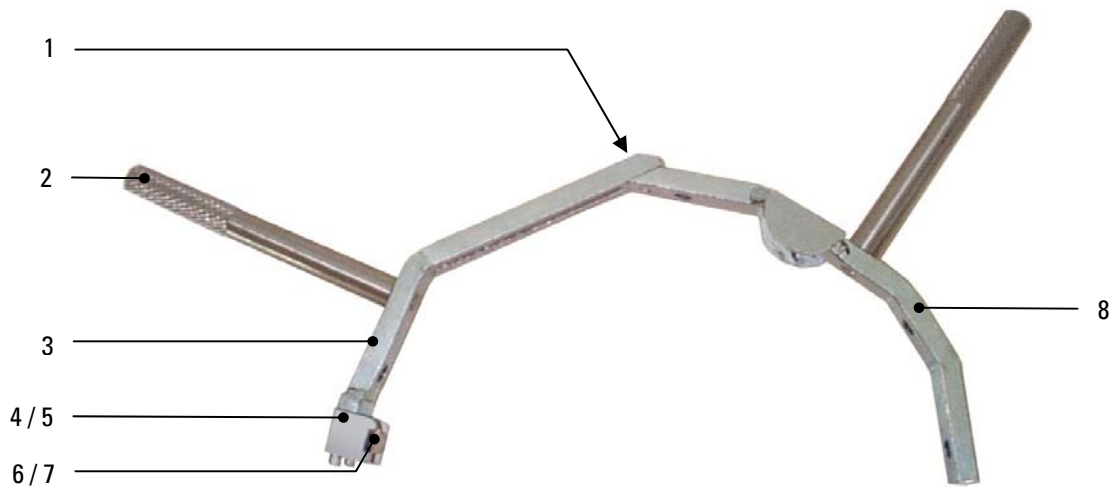
## Accessories

Following equipment is part of the first delivery:

<i>Units</i>	<i>Denomination</i>
1	Allan key, tilted, size 4

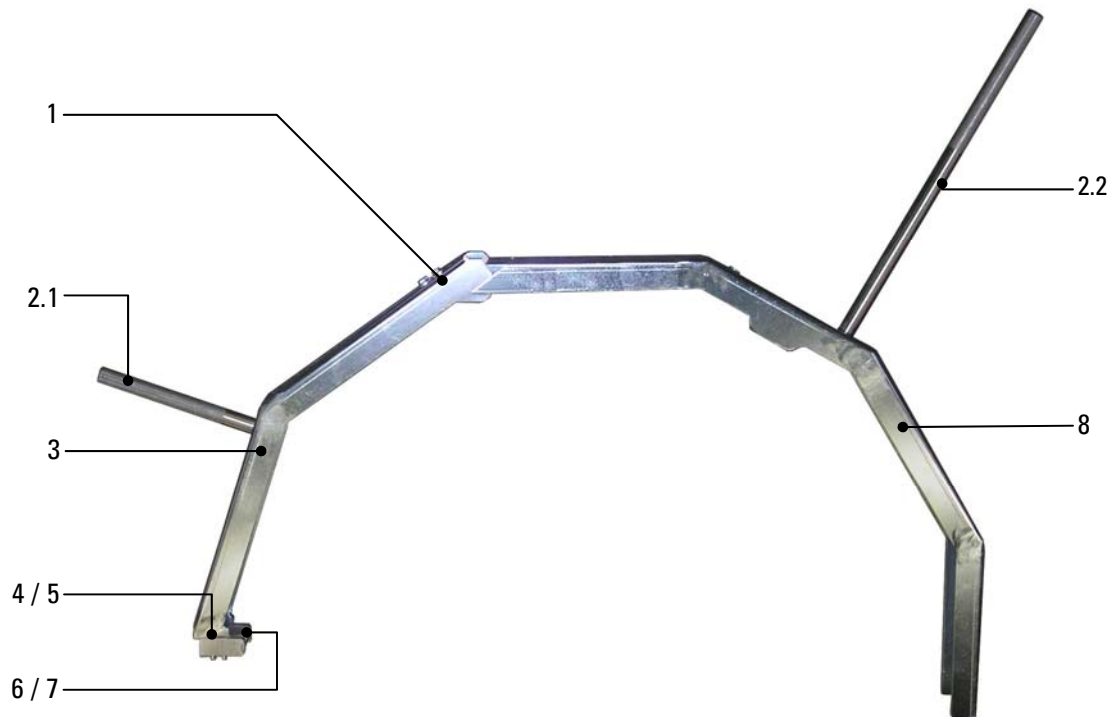
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## Spare parts list for size 1 - 4



Outside Debeader Size 1				Outside Debeader Size 2			
Pos.	Name	Pieces	Art. No.	Pos.	Name	Pieces	Art. No.
1	Flat-head screw M6x12 DIN 7991	1	7991F012	1	Flat-head screw M6x12 DIN 7991	1	7991F012
2	Knurled grip	2	565206	2	Knurled grip	2	565206
3	Guide rail	1	565103	3	Guide rail	1	565203
4	Cutting head	1	565101	4	Cutting head	1	565201
5	Pan-head screw M4x25 DIN 912	2	0912D025	5	Pan-head screw M5x30 DIN 912	2	0912E030
6	Knife	1	MES285	6	Knife	1	MES039
7	Flat-head screw M3x8 DIN 965	2	0965C008	7	Flat-head screw M3x8 DIN 965	2	0965C008
8	Guiding	1	565104	8	Guiding	1	565204
--	Allan key angled size 4	1	ZIG04	--	Allan key angled size 4	1	ZIG04
<b>Outside Debeader Size 3</b>				<b>Outside Debeader Size 4</b>			
Pos.	Name	Pieces	Art. No.	Pos.	Name	Pieces	Art. No.
1	Flat-head screw M3x8 DIN 7991	1	7991F012	1	Flat-head screw M6x12 DIN 7991	1	7991F012
2	Knurled grip	2	565206	2	Knurled grip	2	565206
3	Guide rail	1	565303	3	Guide rail	1	565403
4	Cutting head	1	565201	4	Cutting head	1	565401
5	Pan-head screw M5x30 DIN 912	2	0912E030	5	Pan-head screw M5x30 DIN 912	2	0912E030
6	Knife	1	MES039	6	Knife	1	MES052
7	Flat-head screw M3x8 DIN 965	2	0965C008	7	Flat-head screw M3x8 DIN 965	2	0965C008
8	Guiding	1	565304	8	Guiding	1	565404
--	Allan key angled size 4	1	ZIG04	--	Allan key angled size 4	1	ZIG04

## Spare parts list for size 6 - 9



Outside Debeader Size 6				Outside Debeader Size 8			
Pos.	Name	Pieces	Art. No.	Pos.	Name	Pieces	Art. No.
1	Hexagon head screw M10x20 DIN 933	1	7991F020	1	Hexagon head screw M10x20 DIN 933	1	7991F020
to 1	Washer M10 DIN 9021	2	9021J	to 1	Washer M10 DIN 9021	2	9021J
2.1	Knurled grip, short	2	565606	2.1	Knurled grip, short	1	565606
3	Guide rail	1	565603	2.2	Knurled grip, long	1	565807
4	Cutting head reinforced	1	5656011	3	Guide rail	1	565803
5	Pan-head screw M6x30 DIN 912	2	0912F030	4	Cutting head	1	5658011
6	Knife	1	MES071	5	Pan-head screw M5x30 DIN 912	2	0912E030
7	Flat-head screw M5x12 DIN 7991	2	7991E012	6	Knife	1	MES071
8	Guiding	1	565604	7	Flat-head screw M4x12 DIN 965	2	0965D012
--	Allan key angled size 4	1	ZIG04	8	Guiding	1	565804
				--	Allan key angled size 4	1	ZIG04
<b>Outside Debeader Size 9</b>							
Pos.	Name	Pieces	Art. No.				
1	Hexagon head screw M10x20 DIN 933	1	7991F020				
to 1	Washer M10 DIN 9021	2	9021J				
2.1	Knurled grip, short	1	565606				
2.2	Knurled grip, long	1	565807				
3	Guide rail	1	565903				
4	Cutting head	1	5658011				
5	Pan-head screw M5x30 DIN 912	2	0912E030				
6	Knife	1	MES071				
7	Flat-head screw M4x12 DIN 965	2	0965D012				
8	Guiding	1	565904				
--	Allan key angled size 4	1	ZIG04				