



SUPERTRONIC® 2000

SUPERTRONIC® 2000

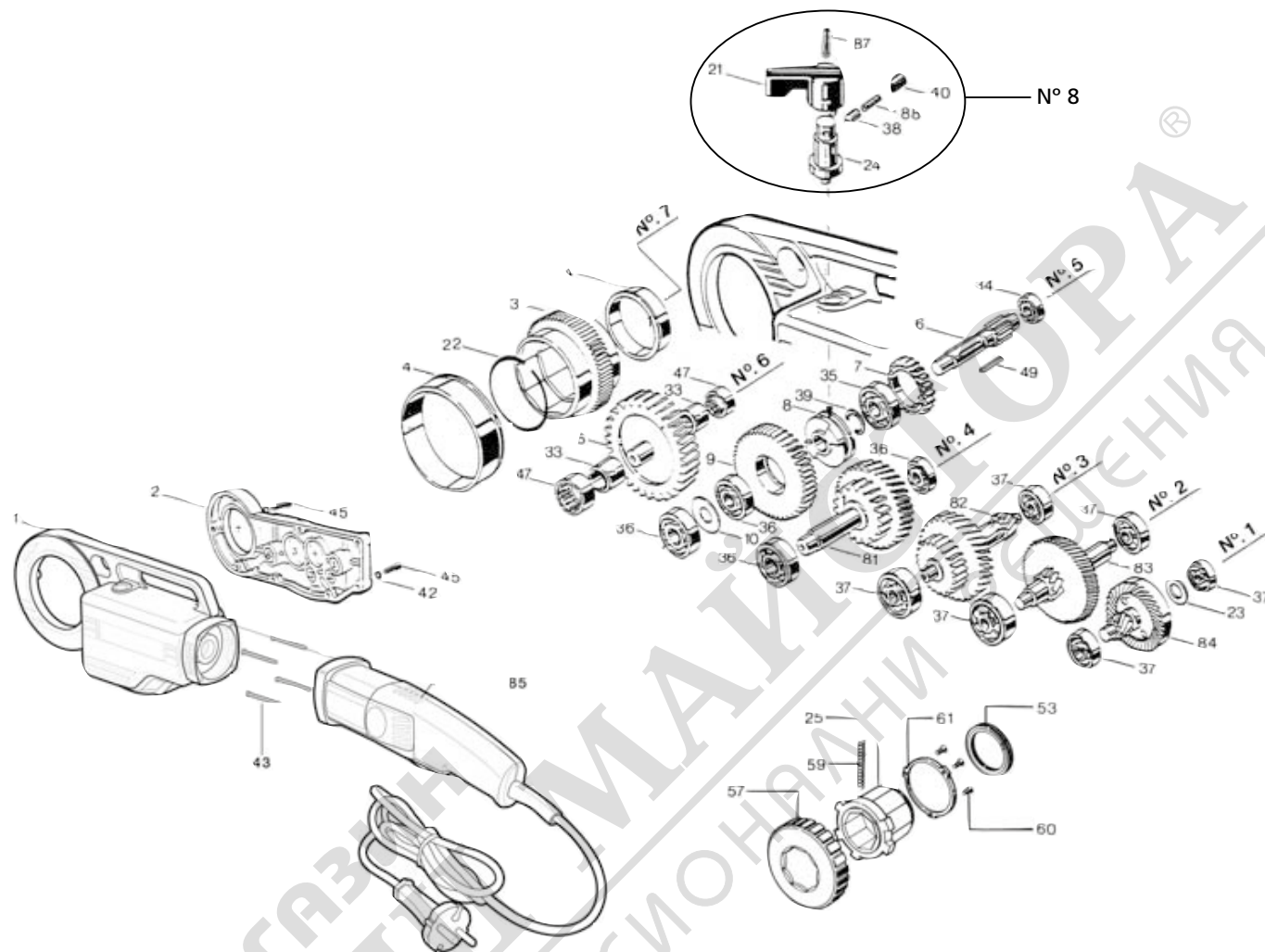


Bedienungsanleitung
Operating instructions
Instructions de service
Manual de instrucciones
Istruzione d'uso
Manual de instruções
Gebruikshandleiding
Brugsanvisning
Användningsinstruktioner



www.rothenberger.com

A Spare parts

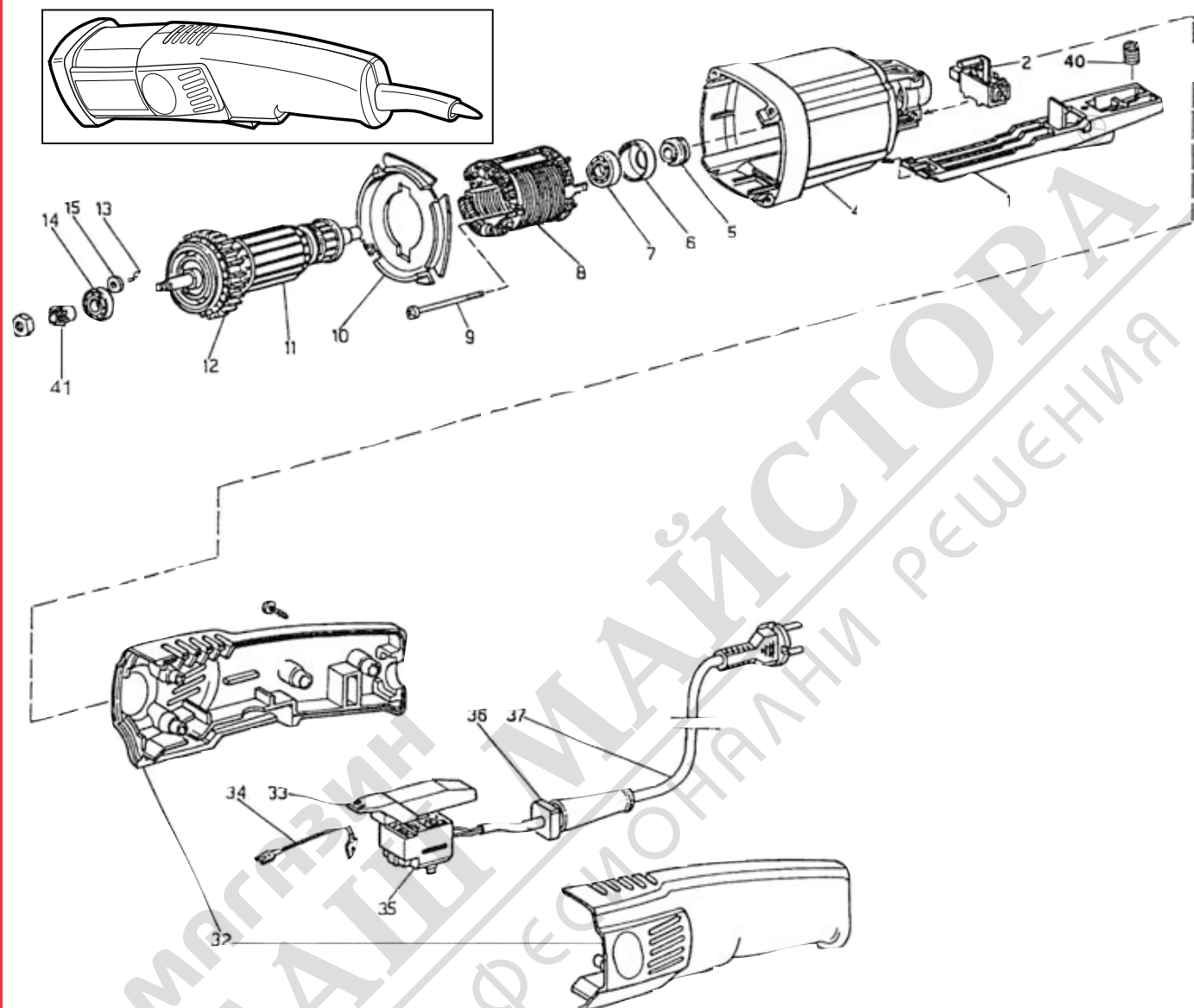


ITEM	CODE
1	8640001
2	8640002
3	8640003 (2")
3	8630003 (1.1/4")
4	8620004
5	8640005
6	8640006
7	8620007
8	8620008
9	8620009
10	8620010
21	8620021
22	8620022 (2")
22	6000008 (1.1/4")
23	8620023
24	8620024
25	8620025
33	8620033

ITEM	CODE
34	8620034
35	8620035
36	8620036
37	8620037
38	8620038
39	8620039
40	8620040
42	8620042
43	8640043
45	8620045
47	8620047
49	8620049
53	8620053
57	8620057
59	8620059
60	8620060
61	8620061
81	8620081

ITEM	CODE
82	8620082
83	8620083
84	8620084
85	8640085 (230 V)
85	8640088 (110 V)
87	1021014
88	8620063
90	8620327
91	8620096
N° 1	8620064
N° 2	8620065
N° 3	8620066
N° 4	8620067
N° 5	8640075
N° 6	8640068
N° 7	8640069
N° 8	8620078

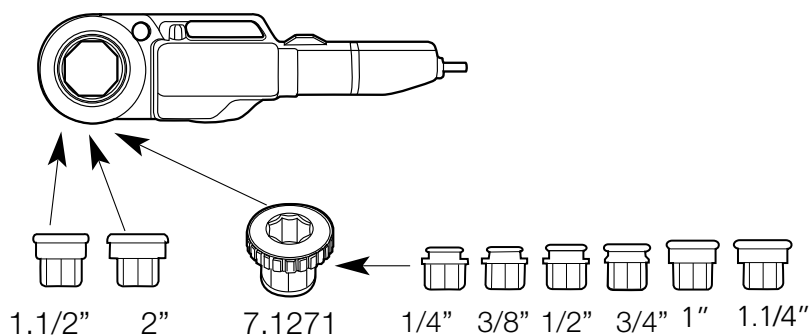
B Spare parts



ITEM	CODE
1	A257180
2	A387080 (230 V)
2	A387081 (110 V)
4	A211321
6	A481073
7	A483159
8	A123110 (230 V)
8	A121080 (110 V)
9	A617101
10	A246491
11	A113181 (230 V)
11	A111109 (110 V)
12	A286084

ITEM	CODE
13	8620048
14	A483101
15	8620079
32	A216190
34	A182282
34	A182300
35	A311225
36	A235179
37	A381079
37	A381095
40	A447110
41	A422045

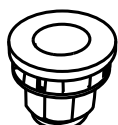
C Accessories



ITEM	CODE
1/4"-2"	7.1272



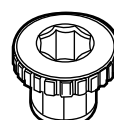
1.1/2"	7.1007
--------	--------



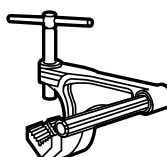
	Ø	CODE
BSPT	1/4"	7.0821X
	3/8"	7.0822X
	1/2"	7.0823X
	3/4"	7.0824X
	1"	7.0825X
	1.1/4"	7.0826X
	1.1/2"	7.0842X
	2"	7.0843X



1/4"-1.1/4"	7.1273
-------------	--------



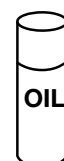
1/4"-1.1/4"	7.1271
-------------	--------



	7.1280
--	--------



mineral 5 l.	6.5010
synthetic 5 l.	6.5015



mineral 600 cc.	6.5008
synthetic 600 cc.	6.5013

Intro

CE-KONFORMITÄTSEKTLÄRUNG

Wir erklären in alleiniger Verantwortung, dass dieses Produkt mit den angegebenen Normen und Richtlinien übereinstimmt.

EC-DECLARATION OF CONFORMITY

We declare on our sole accountability that this product conforms to the standards and guidelines stated.

DECLARATION CE DE CONFORMITÉ

Nous déclarons sous notre propre responsabilité que ce produit est conforme aux normes et directives indiquées.

DECLARACIÓN DE CONFORMIDAD CE

Declaramos, bajo nuestra responsabilidad exclusiva, que este producto cumple con las normas y directivas mencionadas.

DICHARAZIONE DI CONFORMITÀ CE

Dichiriamo su nostra unica responsabilità, che questo prodotto è conforme alle norme ed alle direttive indicate.

EC-VERKLARING VAN OVEREENSTEMMING

Wij verklaren in eigen verantwoordelijkheid dat dit product overeenstemt met de van toepassing zijnde normen en richtlijnen.

DECLARAÇÃO DE CONFORMIDADE CE

Declaramos, sob responsabilidade exclusiva, que o presente produto está conforme com as Normas e Directivas indicadas.

CE-KONFORMITETSEKTLÆRING

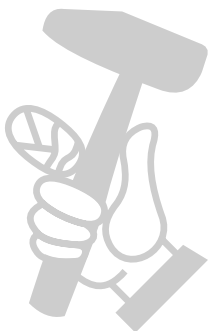
Vi erklærer som eneansvaring, at dette produkt er i overensstemmelse med anførte standarder, retningslinjer og direktiver.

CE.FÖRSÄKRAN

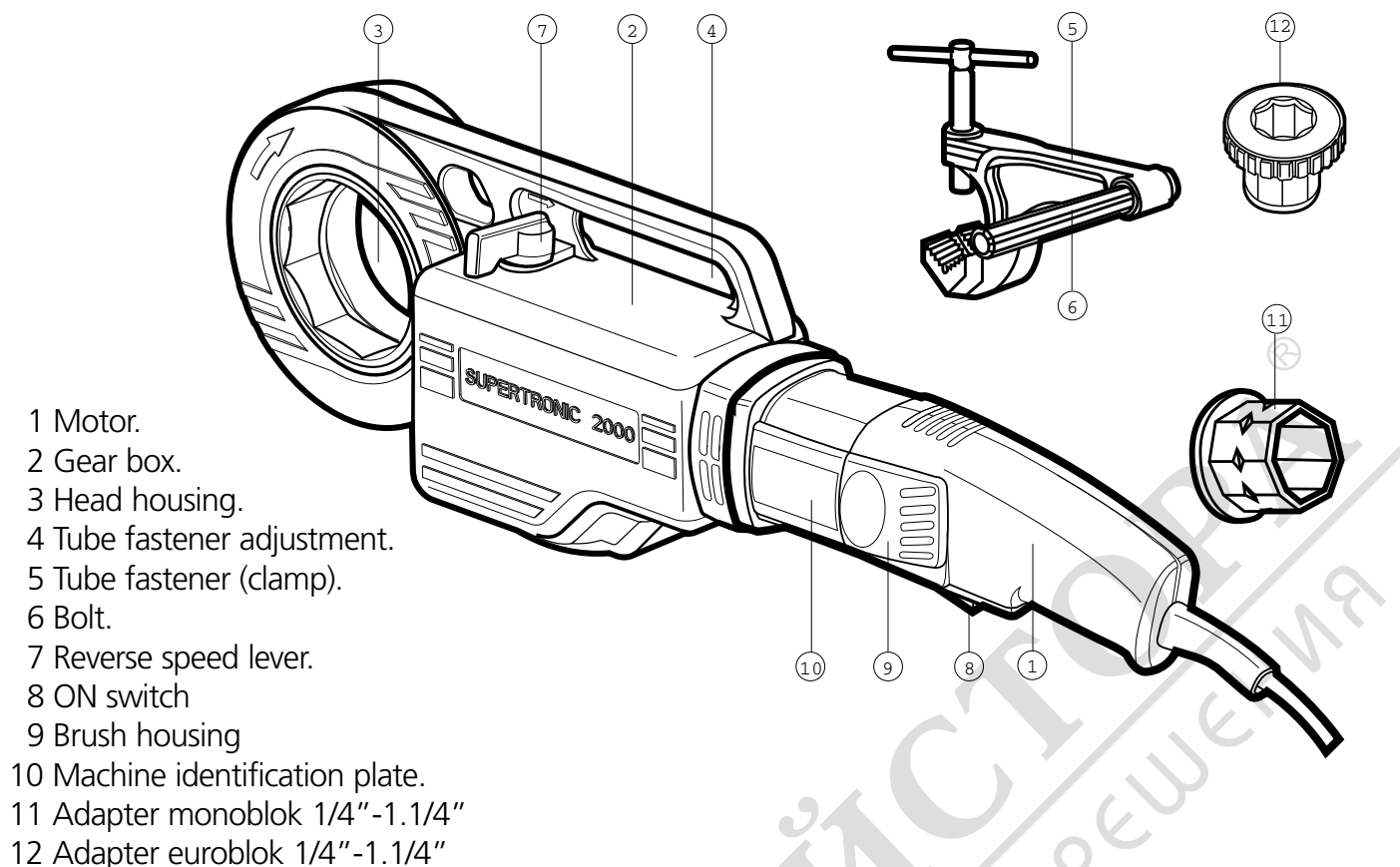
Vi försäkar på eget ansvar att denna produkt uppfyller de angivna normerna och riktlinjerna.



89392 EEC
91368 EEC
73/23 EEC
89/336 EEC
EN 50144.2.9



José Iganacio Pikaza
Hersteller / Name und
rechtsverbindliche Unterschrift
Manufacturer / authorized
representative signature



TECHNICAL CHARACTERISTICS

Threading capacity:	1/4" to 2"	1/4" to 1.1/4"
Type of thread:	BSPT (Right, Left) NPT	BSPT (Right, Left) NPT
Thread taper:	1/16	1/16
Threading speed:	25 to 15 /min.	25 to 15 /min.
Fast reverse speed:	58 /min.	58 /min.
Electric current:	230 V (110 V optional) 50/60 Hz	230 V (110 V optional) 50/60 Hz
Absorbed power:	1.010 W (900 W)	1.010 W (900 W)
ON switch:	non-blocking	non-blocking
Machine weight:	6 Kgs	6 Kgs
Machine size:	580 x 95 x 140 mm	580 x 95 x 140 mm
Tube fastener weight:	1,6 Kgs	1,6 Kgs
Weight complete set:	17 Kgs	16,4 Kgs
Size of Box:	600 x 390 x 140 mm	630 x 250 x 130 mm
Lw	100 dBA	100 dBA
Lp	87 dBA	87 dBA
Vibratio level	<2,5 m/s ²	<2,5 m/s ²
R (DIN 2999, BSPT), NPT/API, G (DIN ISO 228, DIN 259, BSPP) NPSM, Pg, M, BSW, UNC		

APPROVALS

89392 EEC, 91368 EEC, 73/23 EEC, 89/336 EEC, EN 50144.2.9



General safety instructions

Attention! When using electrical tools, please observe the following basic safety rules in order to reduce the risk of electric shock, injury and fire.

Read and follow all of these instructions before using the threading machine.

Wear adequate safety clothing:

Do not wear loose clothing or jewellery. They could be caught by moving parts of the machine. For outdoor work, rubber gloves and nonskid shoes must be worn.

Work in a correct position.

Avoid working in a tiring position. Stand up firmly and maintain a good balance at all times.

Keep your work area clear.

Do not allow other people to touch the machine or cable. Keep children out of reach.

Keep your work area tidy.

An untidy and dirty work area can lead to accidents. Do not leave electrical tools out in the rain. They should not be used in a humid or wet environment nor near inflammable liquids or gases.

Do not overwork the machine.

Use the machine only for those jobs for which it has been designed, do not force it. Stop the machine if it is not working correctly.

Protect the power cable.

Before starting up the machine, check that the electric cable and switch are in optimum condition. Do not carry the machine by the cable nor pull it to disconnect it from the plug. Protect it from heat, oil and sharp edges.

Disconnecting the electric cable.

Before carrying out any maintenance work or change of accessories, disconnect the machine from the mains.

Keep your machine clean.

For safe operation, keep the machine and threading heads free of swarf. Keep the handles dry and free from oil and grease. Protect your machine against blows and do not leave it in dusty or muddy areas. At the end of the day, lock it with its accessories in a dry place, out of the reach of children.

Check the machine when idle.

Familiarize yourself with the machine's operation. Lubricate the machine before

executing any threading operation.

Working with a generator.

Check that there is a minimum output power of 2.8 Kwa.

Attention!

The use of accessories other than those indicated in the instruction manual could lead risk of personal injury.

Preparation for start up

1 Do not thread without using the tube clamp.

The tube clamp should be used even when threading the smallest sizes.

2 Check that the tube clamp is perfectly mounted.

If the tube is not fastened correctly, the machine would rotate on the threading head, with the consequent risk of injury to the operator. The tube fastening bolt is left loose inside the case cover and should be screwed into its corresponding hole.

3 Check condition of ON switch.

When released of pressure, check that the ON switch unblocks automatically.

4 Use of extension cables.

Check that the cable is as thick and as short as possible. The extension cable should be for more than 15 Amp and not longer than 30 metres.

5 Do not thread without abundant and continuous lubrication.

Good lubrication will prolong the life of your machine and threading heads. It will also improve threading quality.

6 Always thread at working speed.

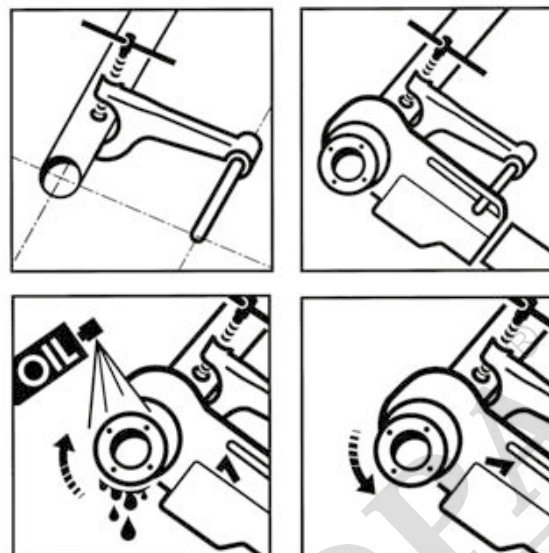
Threading from right to left should be done at the working speed indicated on the reversing gear lever in the direction of the arrow. Fast speed will only be used to unscrew the threading head from the tube. For left thread, insert the threading head at the opposite end of the machine and maintain rotation in work direction.

7 Do not change speeds during the threading operation.

When the threading operation has been completed, stop the machine and change gears to initiate reverse movement and free the tube.

Start up

- 1** Before carrying out any operations with the machine, first read the general safety instructions and preparations for start up.
- 2** Fasten the tube clamp securely and check that the machine's anchor bolt is parallel to the tube to be threaded. The bolt should extend over the end of the tube by approximately 1 or 1.5 cm.
- 3** Choose the threading head according to your needs and mount it in the octagonal coupling of the machine. Fit the adapter first, when using a 1.1/4" head. For right thread, insert the threading head at the front of the machine. For left thread, insert the threading head at opposite end of the machine.
- 4** When using the adapter, this should be directly inserted in the octagonal coupling of the machine on the same in which the threading head has been inserted (right thread: front side; left thread: opposite side) and secured by its threaded cap.
- 5** To insert the head into the adapter, move the mobile part of the latter counter-clockwise until it is completely inserted. This will spring back securing the head. To remove it, proceed in likewise manner.
- 6** Next insert the machine in the tube and make sure that it is securely guided into its housing by the tube clamp bolt.
- 7** Check that the reverse gear lever is correctly in place (arrow in working direction). Press the electric switch with your right hand. Rotation will start immediately. Now the head should be moved towards the tube to start the threading process by pressing on the machine.
- 8** As soon as threading has begun, the head should be constantly and abundantly lubricated with threading oil Rothenberger.
- 9** Once the appropriate threading length has been achieved (the tube of the threading head should never overhang in a normal thread), stop the motor. Change the position of the reverse gear lever and start the motor. The machine will begin to unscrew the head and the tube will become free.



ATTENTION!

Fast speed must only be used to unscrew the head. Never thread on fast speed.

Care and maintenance

Before carrying out any job on the machine, disconnect the plug from the mains outlet.

- 1** Cable and plug.
Both the cable and plug should be in optimum condition. Check them at regular intervals.
- 2** ON switch.
Check that the machine switch unblocks automatically when finger pressure is released. In case of any anomaly, replace immediately with a new one.
- 3** Brushes.
Check frequently for brush wear and perfect contact with rotor. Change brushes when their length is 1/3 of original length. Use original Rothenberger brushes.
- 4** Motor and rotor.
The carbon dust accumulated in the motor and brush housing should be removed every 100 hours. The motor's rotor should be permanently clean with a uniform surface (light bronze colour).
- 5** Threading heads.
Check that there are no damaged teeth on the head to be used, as thread quality could be seriously deteriorated. Keep clean of swarf to achieve top quality threading and longer life.

6 Gear box.

Change grease every 500 operating hours. After dismantling the machine, oil all mechanisms to eliminate old grease. Remove parts with dry compressed air and apply new grease with clean hands. Do not use antdissolvents. Approximately 300 grs. of grease is needed for a correct lubrication. An excessive amount of grease is not recommended as it can increase the temperature of the machine. Grease type: LGMT2 by SKF or similar. We recommend that this operation be carried out by an authorized after-sales service.

7 Dismounting the gear box.

Before dismantling the cover of the gear box, never introduce sharp objects such as tips, screwdrivers, etc. between the body and cover's connecting faces. The correct procedure is to tap the front of the octagon gently with a plastic hammer.

8 Tube fastener (clamp).

Check that the tube fastener clamp is in good condition. Replace when tube displacement occurs.

9 Machine maintenance and repair should be done by a specialist.

All repairs should be carried out by a specialist and only original parts should be used.


– Check operating condition of threading heads.

– Apply plenty and continuous lubrication to threading heads.

– Make sure that the tube can be screwed.

B Off-centre threading.

– Check position of tube fastener (shaft parallel to tube).

– Check condition and quality of tube. 

C Insufficient thread length.

– Check correct positioning of tube fastener.

– Make sure that there is no obstruction between the machine and the tube fastener.

D Poor thread quality.

– Check condition of teeth.

– Check that there is continuous and abundant lubrication.

– Check quality of tube.

– Check quality of threading oil (use Rothenberger oil).

E Incorrect adjustment of threading head.

– Use the adapter for appropriate sizes (ut to 1.1/4").

– Check that the appropriate threading head is being used (Rothenberger, serie 600 or equivalent).

F Locked Shift lever.

– Move the machine slightly upwards and downwards.

Diagnosis of faults

Before carrying out any job on the machine, disconnect the plug from the mains outlet.

ATTENTION! If any additional service is needed other than those indicated below, please contact the nearest technical service station.

A Insufficient power.

– Make sure that extension cable is not too long or that it does not have insufficient section.

– Make sure that the right working speed is being used.

– Tube clamp must be well secured (bolt parallel to tube).