

DOUBLE CUT TORCH CARRIER



Double Cut Torch Carrier Manual

Model 283D
For Beveling Band Crawler
Model 206D

About Us

We appreciate your business!

Congratulations on your new SAWYER product. We are proud to have you as our customer and will strive to provide you with the best service and reliability in the industry. This product is backed by our extensive warranty and world-wide service network. To locate your nearest distributor or service agency, please contact us at the phone number and address listed on the bottom of each page.

You are in good company!

Sawyer Manufacturing Company is the world leader in the design and manufacture of pipeline and welding equipment since 1948. Sawyer equipment has become a standard in the industry and continues to set the benchmark for quality and durability.

This user operation manual has been made to instruct you for the best use and operation of your Sawyer product. Your satisfaction with our products is our main goal. Please read this entire manual carefully noting all tips, notes and warnings. Safety always comes first.

WARNING

WARNING: Refer to torch manufacturer for safety settings.

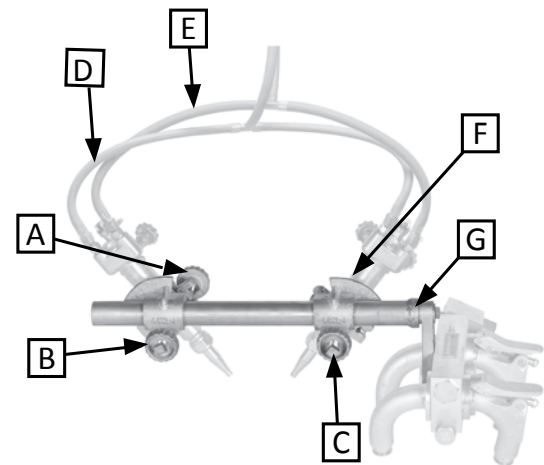
Note: When back beveling, place torch tip as close to the pipe as possible (recommend pinky nail length). Do not place flame directly on pipe. Rotate the assembly to your desired angle. Then once you have the correct angle it should be positioned for a back bevel.

CAUTION

CAUTION: When back beveling, the cutting flame is directed toward the machine. It is important the torch be positioned as far as possible to the opposite end of the torch arm to prevent the heat from damaging the machine warnings. Safety always comes first.


Parts Diagram

Note: Torch not included
Note: Crawler not included



- | | |
|-----------------------------------|---------------------------------------|
| A. Knob (Torch Holder Adjustment) | E. Fuel Gas Hose |
| B. Knob (Position Adjustment) | F. 37.5-0-37.5 Degree/Bevel Indicator |
| C. Square Nut (Bevel Indicator) | G. Mounting Frame |
| D. Oxygen Hose | |

Tools Needed for Assembly*


1/2" Wrench
*Not Included

WARNING

WARNING: Moving parts can snag and pull. Keep loose items clear.

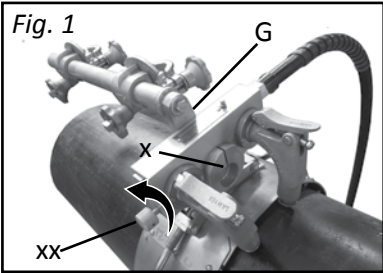
Warranty

All products manufactured by or for Sawyer Manufacturing Company are guaranteed against defects due to faulty workmanship or materials for twelve months from the date of purchase. This guarantee is limited to the repair or replacement of any parts found to be defective, and no other liability, expressed, implied or contingent is assumed.

DOUBLE CUT TORCH CARRIER

Installation

1. Slide Mounting Frame (G, Fig. 1) into Crawler Donut (x).
A. Tighten knob (xx, Fig. 1) on Crawler
2. Mount hoses to torches according to manufacturer's specs.



Operation

Please refer to the Crawler and Beveling Band manuals for Installation of the Beveling Band Machine

Double Cut Torch Arm Setup

1. Bevel Angle Adjustment
 - A. Loosen square nut on bevel indicator. (C, Fig. 3)
 - B. Adjust bevel indicator to desired bevel angle. (F, Fig. 4)
 - C. Retighten square nut (C, Fig. 3)

Tip: Use ½" wrench.
2. Install torch into Torch Holder and adjust for desired height
 - A. Loosen knob on Torch Holder. (A, Fig. 5)
 - B. Install torch inside Torch Holder. (Fig. 6)

Note: Long or short torch

 - C. Retighten knob. (A, Fig. 5)
3. Position Torches

Note: Opposite of Torch Holder

 - A. Loosen knob for position adjustment. (B, Fig. 4)
 - B. Move assembly to desired position on mounting frame. (G, Fig. 4)
 - C. Retighten knob. (B, Fig. 4)

