

OUT OF ROUND

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.



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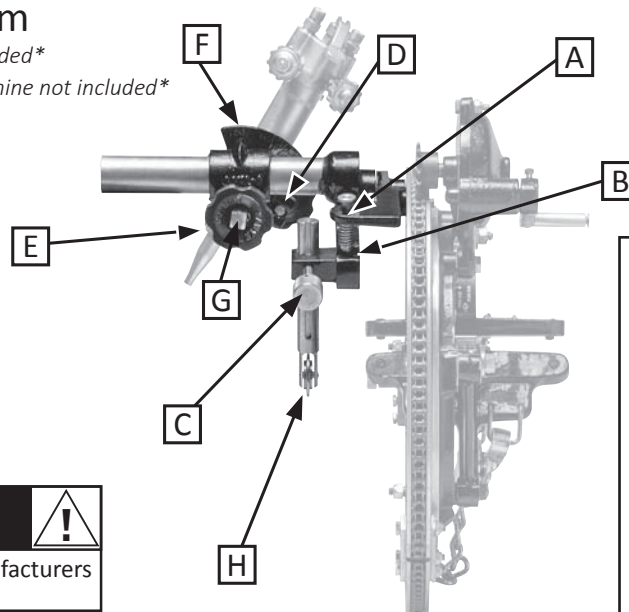
Out-of-Round Attachment Manual

Models 281B & 205CS
For Quick Set Beveling
Model 205CS

Parts Diagram

Note: Torch not included

Note: Quick Set machine not included



- A. Out-of-Round Pivot Arm Spring
- B. Out-of-Round Pin Assembly
- C. Out-of-Round Adjustment Knob
- D. Torch Holder Adjustment Knob
- E. Position Adjustment Knob
- F. 37-1/2 - 0 - 37 Degree Bevel Indicator
- G. Bevel Indicator Square Nut
- H. Out-of-Round Adjustment Wheel
- I. (2x)-9/16" Nuts **not pictured**
- J. Long Bolt **not pictured**
- K. Short Bolt **not pictured**
- L. (2x) Washers **not pictured**
- M. Brass bushing **not pictured**



Tools Needed for Assembly*

**Not Included*



9/16" Nut Drive

Soap Stone

1/2" Wrench

Warranty

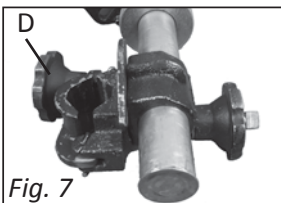
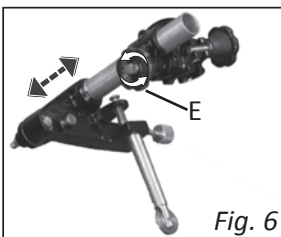
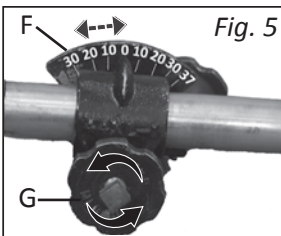
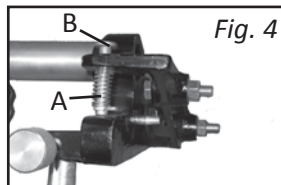
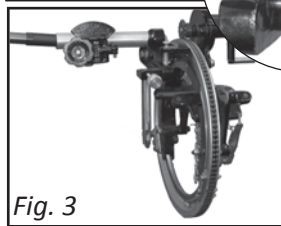
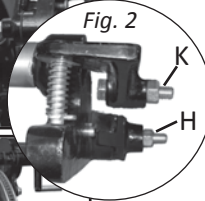
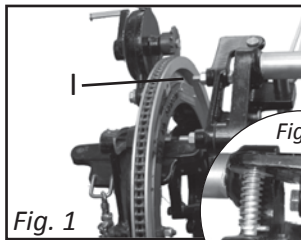
All products manufactured by or for Sawyer Manufacturing Company are guaranteed against defects due to faulty workmanship or materials for twelve months from the date of purchase.

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.

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V1.2

OUT OF ROUND



Installation

1. Mount long bolt (K, Fig. 2) and short bolt (H, Fig. 2) to Quick Set machine.

Note: Installation is easier if pin assembly is unlatched

Note: Do not mount attachment with 9/16" nuts attached

Tip: Use 9/16" nut drive

2. Latch pin assembly. (Fig. 3)

Operation

To derive the correct out of round attachment configuration for egged pipe follow these steps.

1. A. Engage pin assembly (B, Fig. 4) while compressing spring. (A, Fig. 4)
B. Raise torch arm wheel assembly (H) to the highest setting.
C. Tighten wheel adjustment knob. (C)
2. A. Cycle the Quick Set machine to the highest point of the pipe.
B. Loosen adjustment knob (C) for wheel assembly (I) until it touches the pipe.
C. Tighten wheel assembly adjustment knob. (C)
3. A. Disengage pin assembly. (B, Fig. 4)
B. Cycle the Quick Set so that the torch tip reaches the lowest point on the pipe.
C. Set-up the torch to cut from this point.

4. Torch arm Setup

- A. Adjust torch arm assembly height by loosening the 9/16" nut. (I)
 1. Adjust 9/16" nut (I) to desired position.
 2. Tighten 9/16" nut (I) for desired height.
- B. Bevel angle adjustment. (J, Fig. 5)
 1. Loosen square nut set screw. (G, Fig. 5)
 2. Adjust to desired bevel angle. (F, Fig. 5)
 3. Tighten square nut set screw. (G, Fig. 5)

Tip: use 1/2" wrench

- C. Assemble position adjustment. (E, Fig. 6)
 1. Loosen adjustment knob. (E, Fig. 6)
 2. Move assembly to desired position.
 3. Tighten adjustment knob. (E, Fig. 6)
- D. Mounting torch arm.
 1. Loosen adjustment knob. (D, Fig. 7)
 2. Install torch to holder.
 3. Tighten adjustment knob. (D, Fig. 7)

Please refer to the Quick Set manual for Operation of Quick Set