

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 and has been 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.



Excalibur Manual

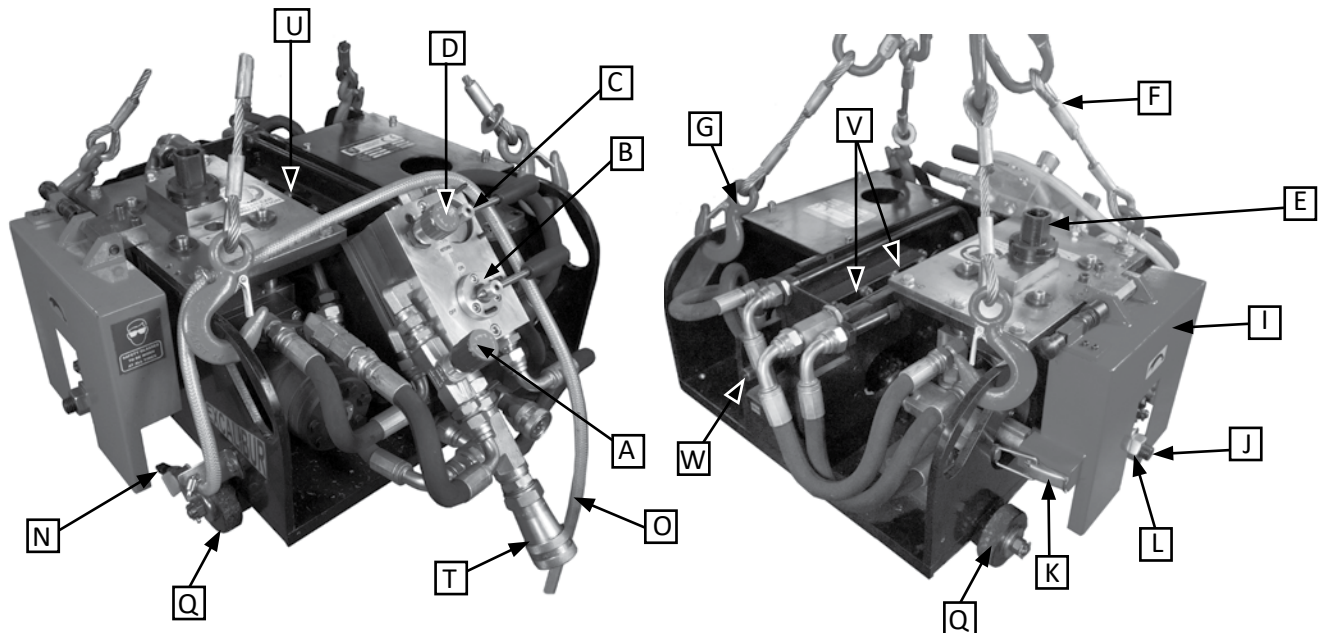
Cold Cutting Model 210

210H - Oil (Hydraulic Driven)

210E - Electric (Electric Driven)

210P - Air (Pneumatic Driven)

Parts Diagram - 210H



- | | | |
|--|---|---|
| A. Blade Speed Control | I. Blade Safety Cover | Q. Guide Wheels |
| B. Start/Stop Control | J. Cutter Spindle | R. Guide Wheel Tracks <i>(not shown)</i> |
| C. Machine Directional Control | K. Blade Safety Device | S. Socket Head Cap Screws <i>(not shown)</i> |
| D. Machine Speed Control | L. Cutter Lock Nut & Cutter Collar Support | T. Hydraulic Hose Connector |
| E. Feed Screw | M. Milling Cutter <i>(not shown)</i> | U. Drive Chain <i>(not shown)</i> |
| F. Lifting Cables | N. Lubricator Nozzle | V. Drive Chain Sprockets |
| G. Lifting Spring Clips | O. Mist Lubrication System Hose | W. Chain Tensioning Screw |
| H. Blade Lowering/Raising Handle <i>(not shown)</i> | P. Coolant Container <i>(not shown)</i> | X. Single Chain Pin <i>(not shown)</i> |

Record the following information for warranty purposes:

Where purchased: _____

Purchase date: _____

Equipment Serial #: _____

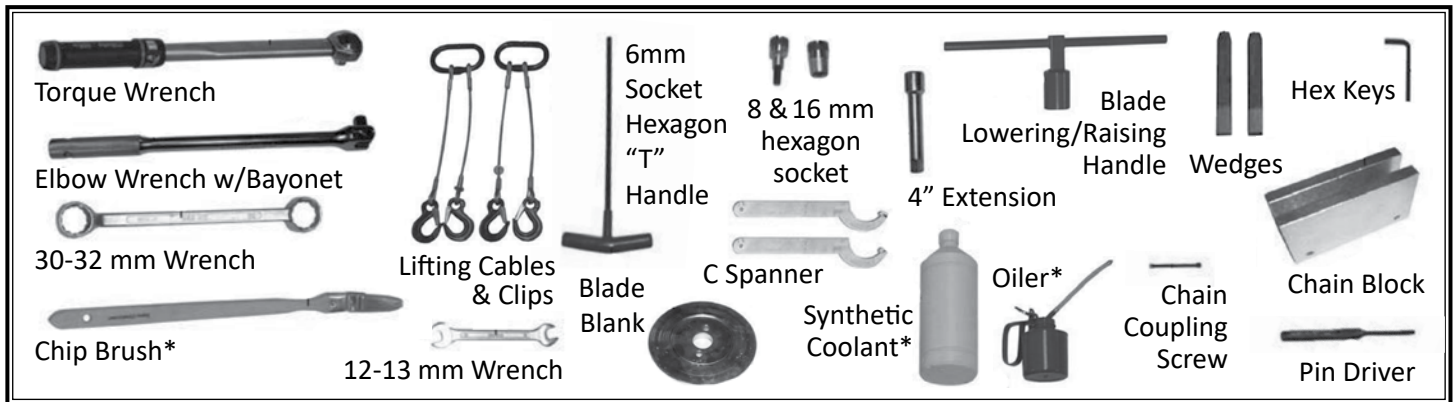
Warranty

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.

Installation

Tools Needed For Installation and Operation/Cutting*



*Not Included

Installation

****Photos in this manual are of the Hydraulic Machine****

1. Connections and Power Sources

A. Hydraulic Machine

1. Connect machine to hydraulic power supply (Fig. 1) with the capability of minimum pressure of 110 bars at 72 L/min. with 25 micron filter and air-cooled heat exchanger.
2. Ensure power supply is connected properly by checking for clockwise rotation of blades.
3. Connect the Mist Lubrication System Hose (O, Fig. 2) to the Coolant Container (P). Use a synthetic coolant oil type BIO/42 EP or similar.

Note: A small air compressor is required to operate the Automatic Double Mist Lubrication system.

4. Turn the Start/Stop Control (B, Fig. 3) to the On position to ensure clockwise rotation of blades. Turn Off.

Tip: If hydraulic hose longer than 50 feet (15 meters) is required, the hose diameter should be increased accordingly to ensure adequate pressure.

B. Pneumatic Machine

1. Connect machine to compressor with a minimum capacity of 4000 liters and pressure of 116psi (8 bars). For the LP (Low Pressure) variant, the minimum operating pressure is 6 bar, to a maximum of 10 bar.
2. The regulator of the air filter/lubrication device should be set at 90psi (6 bar).
3. Connect the Cutter Lubricator System to the coolant container. Use a synthetic coolant oil type BIO/42 EP or similar.
4. Turn the Start/Stop Control to the On position to ensure clockwise rotation of blades. Turn Off.

Note: If an automatic dual mist lubrication system has been specified, refer to operating instructions with the supplied compressor.

Tip: If air hose longer than 50 feet (15 meters) is required, the hose diameter should be increased accordingly to ensure adequate pressure and volume of air.

C. Electric Machine

1. Connect machine to 3-phase, 380/440V power supply with N and E.
2. Connect the Double Mist Lubrication System to the Coolant Container. Use a synthetic coolant oil type BIO/42 EP or similar.

Note: A small air compressor is required to operate the Automatic Double Mist Lubrication system.

4. Turn the Start/Stop Control to the On position to ensure clockwise rotation of blades. Turn Off.

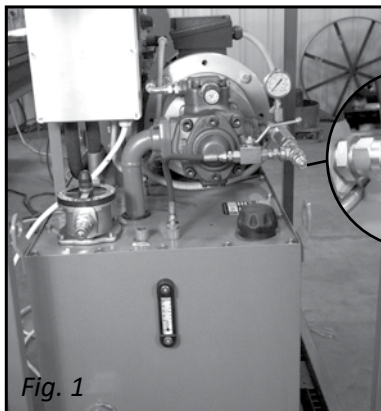


Fig. 1

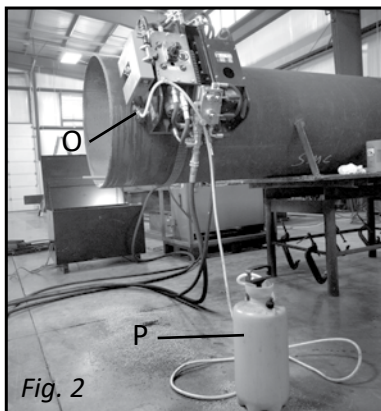


Fig. 2

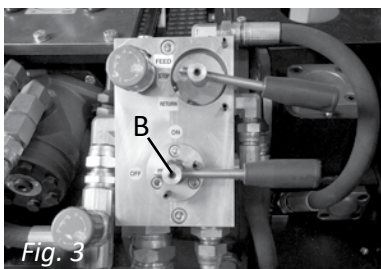


Fig. 3