

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.



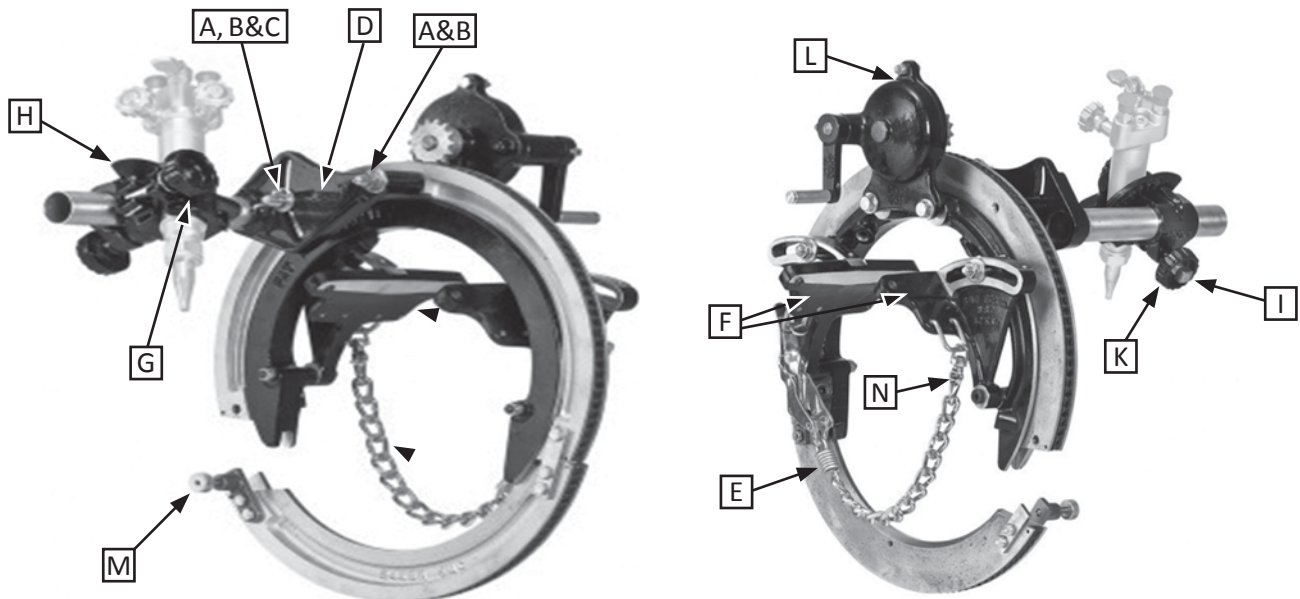
Quick Set Manual

Beveling Model 205CS

- 0. (1 1/2"-4", 9lbs)
- 1. (3"-8", 14lbs)
- 2. (8"-14", 19.5lbs)
- 3. (14"-20", 33lbs)

Parts Diagram

Note: Torch not included



- | | |
|--|---|
| <ul style="list-style-type: none">A. (2x) 9/16" NutB. (2x) WasherC. SpacerD. Torch Arm Assembly (42AK-1)E. Locking Boomer, Spring, Chain (4AW-1, 4AW-2 & 4AW-3)F. Adjustable Mounting ArmsG. Torch Holder Adjustment KnobH. 37.5-0-37.5 Degree /Bevel Indicator (4HT) | <ul style="list-style-type: none">I. Square NutJ. (2x) Torch Arm Mounting Bolts <i>*not shown*</i>K. Position Adjustment KnobL. Gear Box Assembly (2J-2 & 2J-1)M. Locking and Unlocking Saddle Arm PinN. Swivel Snap (300-001)O. Clamp Swing Bar <i>*not shown, #0 only*</i>P. Clamp Screw <i>*not shown, #0 only*</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.

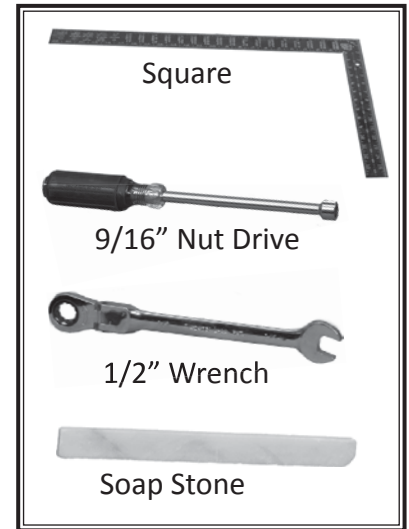
This guarantee is limited to the repair or replacement of any parts found to be defective, and no other liability, expressed, implied or contingent is assumed.

Installation

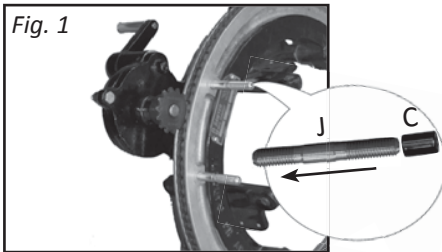
Tools Needed For Operation/Cutting*



Tools Needed For Assembly*



*Not Included

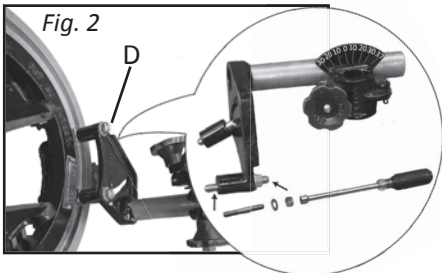


Installation

1. Mount bolts to machine. (J, Fig. 1)
 - A. Place free floating spacer (C) onto bolt. (J)

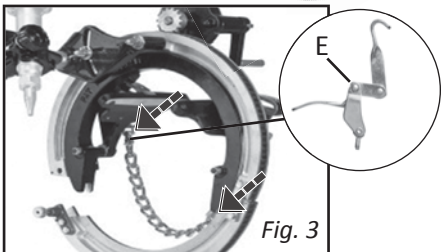
Note: Long threads thread into Quick Set machine not short threads.

Tip: Do not thread $\frac{1}{4}$ " past opening.

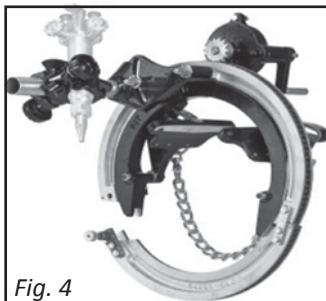


2. Mount torch arm assembly to machine. (D, Fig. 2)
 - A. Use 2 washers (B), & 2 9/16" nuts. (A)

Tip: use 9/16" nut drive.



3. Latch boomer to Quick Set machine. (E, Fig. 3)



4. Final picture of finished Quick Set machine. (Fig. 4)



Operation

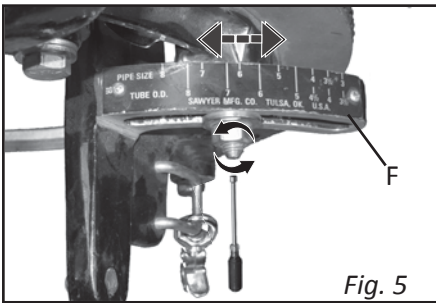


Fig. 5

1. Adjust mounting arms (F, Fig. 5) to appropriate pipe/tube size.

Note: Small slashed numbers = pipe
Large slashed numbers = tube

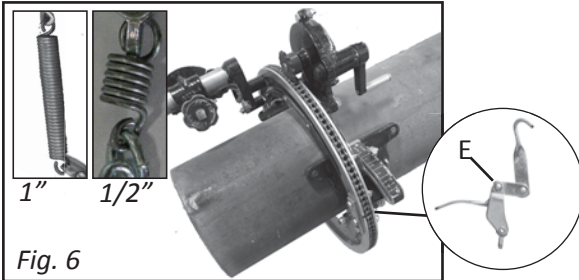


Fig. 6

2. Mount Quick Set machine to pipe/tube. Clamp boomer (E, Fig. 6) around pipe.

Note: When latch is fully extended, 1" = large spring. 1/2" = small spring
Note: To mount quick set to middle of pipe/tube undo the saddle arm locking pin. (M, Fig. 4)

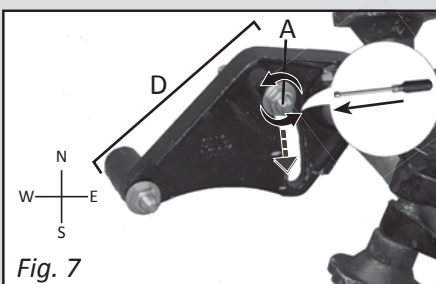


Fig. 7

3. Torch arm Setup

- A. Adjust torch arm assembly (D, Fig. 7) by loosening the 9/16" nut. (A, Fig. 7)

A-1. Adjust torch arm assembly (D, Fig. 7) to most southern point.

Note: for short barrel torches you may need to move the torch arm assembly halfway between north & south.

A-2. Tighten 9/16" nut. (A, Fig. 7)

Tip: Place torch in torch holder to aide in setup.

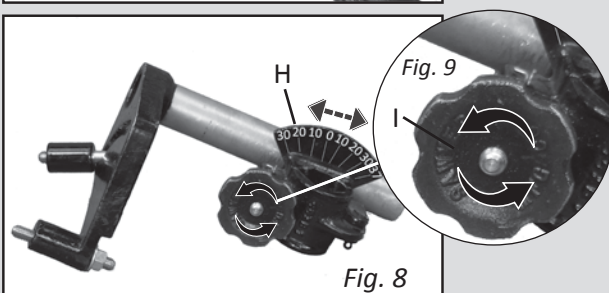


Fig. 8

- B. Bevel angle adjustment. (H, Fig. 8)

B-1. Loosen bevel indicator square nut. (I, Fig. 9)

B-2. Adjust to desired bevel angle. (H, Fig. 8)

B-3. Tighten bevel indicator square nut. (I, Fig. 9)

Tip: use 1/2" wrench.

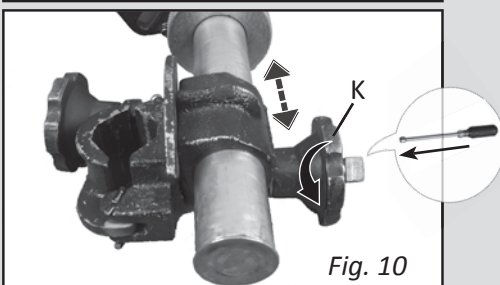


Fig. 10

- C. Position adjustment. (K, Fig. 10)

C-1. Loosen position adjustment knob. (K, Fig. 10)

C-2. Move assembly to desired position.

C-3. Tighten position adjustment knob. (K, Fig. 10)

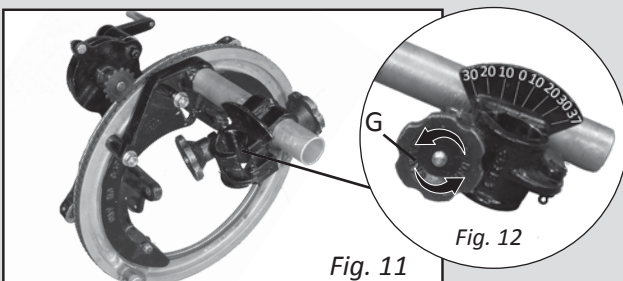


Fig. 11

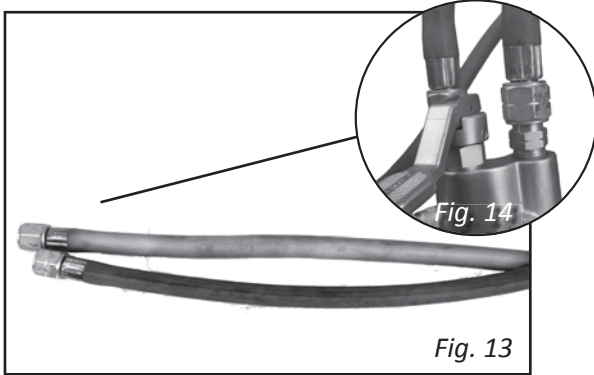
- D. Install torch inside torch holder.

D-1. Loosen adjustment knob. (G, Fig. 12)

D-2. Install torch inside torch holder.

D-3. Tighten adjustment knob. (G, Fig. 12)

Operation

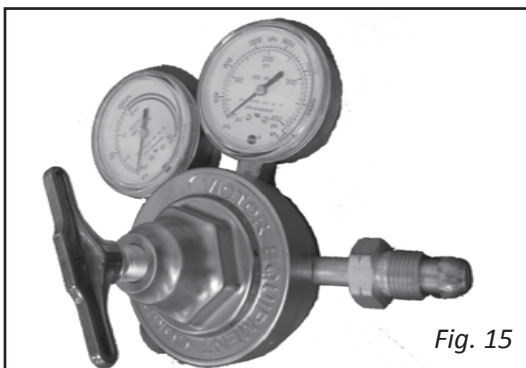


4. Install fuel gas and oxygen hoses to torch. (Fig. 13)

Note: Notches on hose end are for fuel gas only. (Fig. 14)

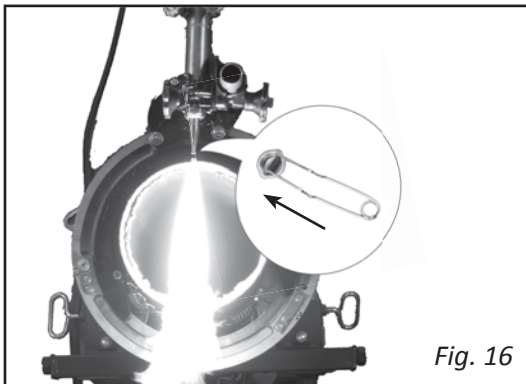
Note: Red hoses= fuel gas

Green hoses = oxygen (Fig. 13)

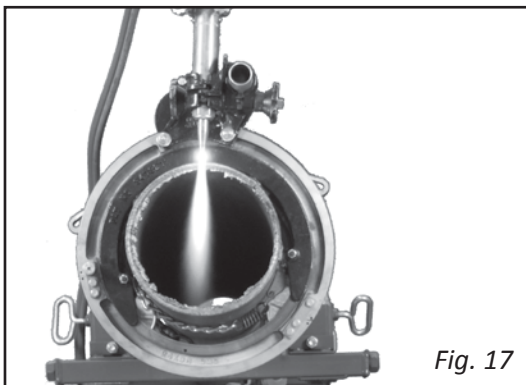


5. Turn on oxygen and fuel gas at the cylinder. (Fig. 15)

Note: Set pressures to manufactures settings.



6. To light torch, turn fuel gas knob and light with striker. (Fig. 16)



7. Turn the oxygen knob on torch. (Fig. 17)

Tip: For best cutting have a neutral flame.

Open blow-through tab on torch.

Tip: keep hoses from binding.

Tip: preheat is recommended.

When finished turn off fuel gas then oxygen

Disassemble in opposite order of operation.

