

# ADJUSTABLE TORCH ARM

## 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.

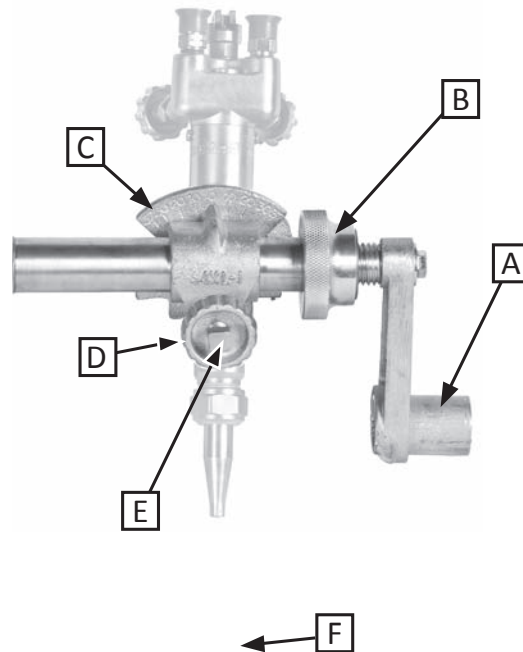


## Adjustable Torch Holder Manual

Models 284D  
For Band Type Beveling  
Model 206D

## Parts Diagram

*\*Note: Torch not included\**



- A. Mounting Frame
- B. Ring (Torch Adjustment)
- C. 37.5-0-37.5 Degree/Bevel Indicator
- D. Knob (Position Adjustment)
- E. Square Nut (Bevel Indicator)
- F. Knob (Torch Holder Adjustment)



### WARNING

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



### WARNING

**WARNING:** Refer to torch manufacturer for safety settings.

## Tools Needed for Assembly\*



1/2" Wrench

*\*Not Included*

### 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

# ADJUSTABLE TORCH ARM

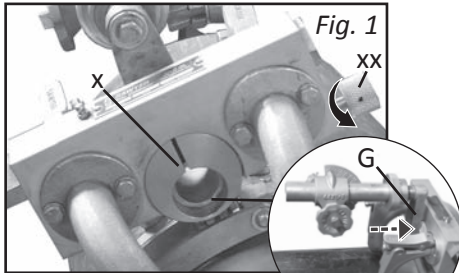


Fig. 1

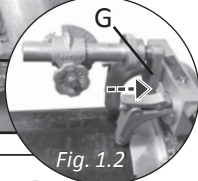


Fig. 1.2

## Installation

1. Slide Mounting Frame (G, Fig. 1.2) into Crawler Donut (x).  
A. Tighten knob (xx, Fig. 1) on Crawler
2. Mount hoses to torches according to manufacturer's specs.

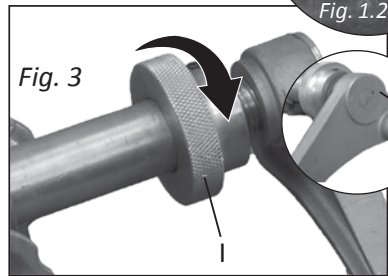


Fig. 3

## Operation

1. Loosen and tighten adjustment knob to position assembly on and off pipe/tube (I, Fig. 3)  
*Tip: This screw is to adjust free motion of torch arm*

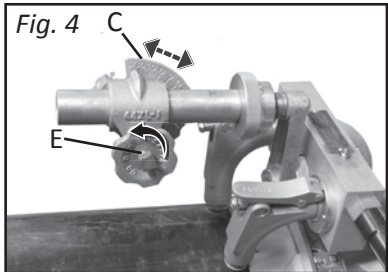


Fig. 4

## Adjustable Torch Arm Setup

### 1. Bevel Angle Adjustment.

- A. Loosen square nut on bevel indicator. (E, Fig. 4)
- B. Adjust Bevel Indicator to desired bevel angle. (C, Fig. 4)
- C. Retighten square nut. (E, Fig. 4)

*Tip: Use 1/2" wrench.*

### 2. Install torch into Torch Holder and adjust for desired height

- A. Loosen knob on Torch Holder. (C, Fig. 5)
- B. Install torch inside Torch Holder. (Fig. 6)
- C. Retighten knob. (C, Fig. 5)

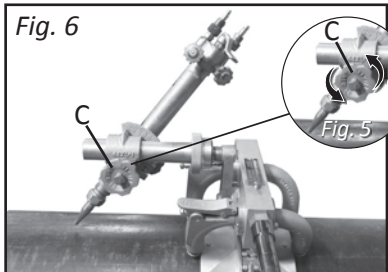


Fig. 6

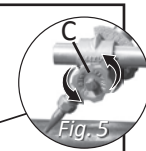


Fig. 5

### 3. Position Adjustment

- A. Loosen ring for position adjustment. (D, Fig. 7)
- B. Move assembly to desired position on Mounting Frame (A).
- C. Retighten ring. (D, Fig. 7)

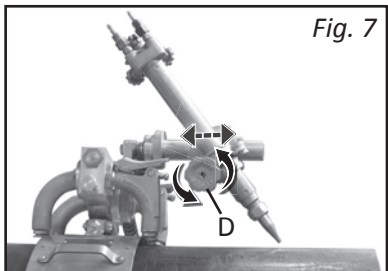


Fig. 7

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