

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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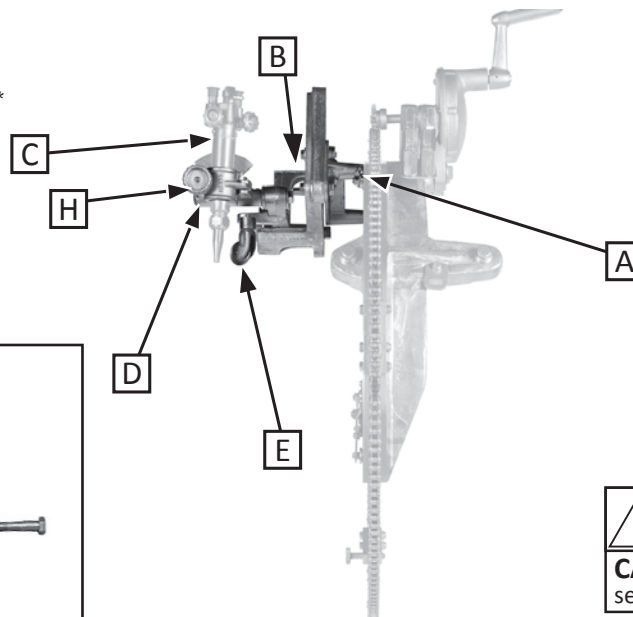
Out-of-Round Attachment Manual

Models 281A
For Compact Beveling
Model 200C

Parts Diagram

Note: Torch not included

Note: Compact machine not included



- A. Out of Round Pin Assembly
- B. Position Adjustment Knob
- C. 37.5-0-37.5 Degree Bevel Indicator
- D. Bevel Indicator Square Nut
- E. Out of Round Adjustment Wheel
- F. (2x) 9/16" Bolts **not pictured**
- G. (2x) Washers **not pictured**
- H. Torch Holder Adjustment Knob



Tools Needed for Assembly*

**Not Included*



9/16" Nut Drive

Soap Stone

3/4" Wrench

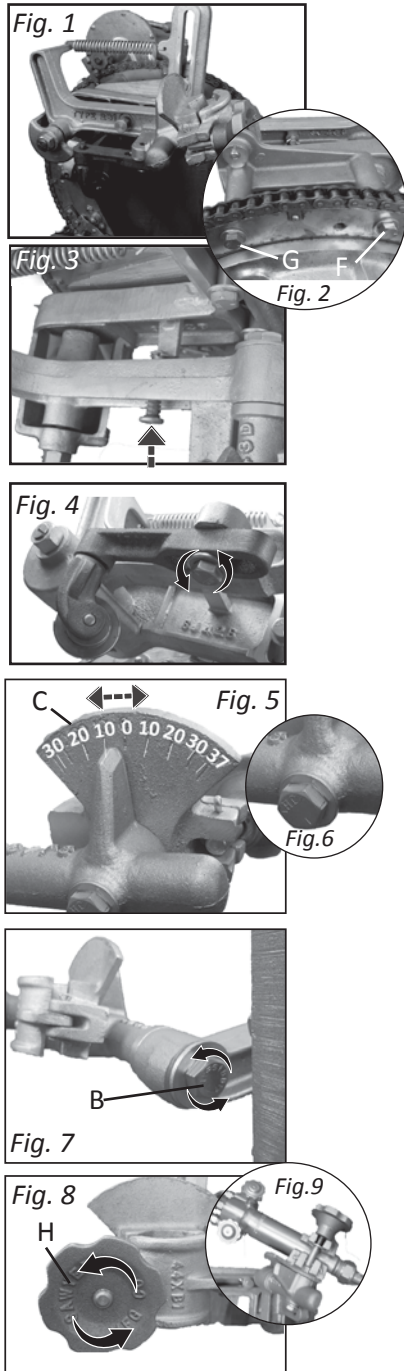
1/2" Wrench

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 Out of Round attachment to Compact machine (Fig. 1) using 9/16th bolts (F, Fig. 2) and washers. (G, Fig. 2)

Note: Installation is easier if pin assembly is unlatched.

Tip: Use 9/16" nut drive.

Note: Mount assembly using the 2 unthreaded holes on Compact machine.

Tip: Cycle Compact machine away from gearbox for easier installation.

2. Latch out of round pin assembly. (Fig. 3)

Operation

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

1. Engage pin assembly. (A, Fig. 3)

Please refer to the Compact manual for Installation of the Compact machine.

2. Adjust wheel assembly to appropriate position. (Fig. 4)

3. Cycle Compact machine around pipe making sure wheel touches at all points.

Tip: Place torch in torch holder to aide in setup

4. Torch arm Setup

- A. Bevel angle adjustment. (Fig. 5)

1. Loosen adjustment bolt. (Fig 6)
2. Adjust bevel indicator (C) to desired angle. (Fig. 5)
3. Tighten adjustment bolt. (Fig. 6)

Tip: Use 9/16" wrench.

- B. Assemble position adjustment. (Fig. 7)

1. Loosen position adjustment bolt. (B, Fig. 7)
2. Set assembly to desired position. (Fig. 7)
3. Tighten position adjustment bolt. (B, Fig. 7)

Tip: Use 3/4" wrench.

- C. Mounting torch into torch holder.

1. Loosen torch holder adjustment knob. (H, Fig. 8)
2. Install torch to torch holder. (Fig. 9)
3. Tighten torch holder adjustment knob. (H, Fig. 8)

Please refer to the Compact manual for Operation of the Compact machine.