

## 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.



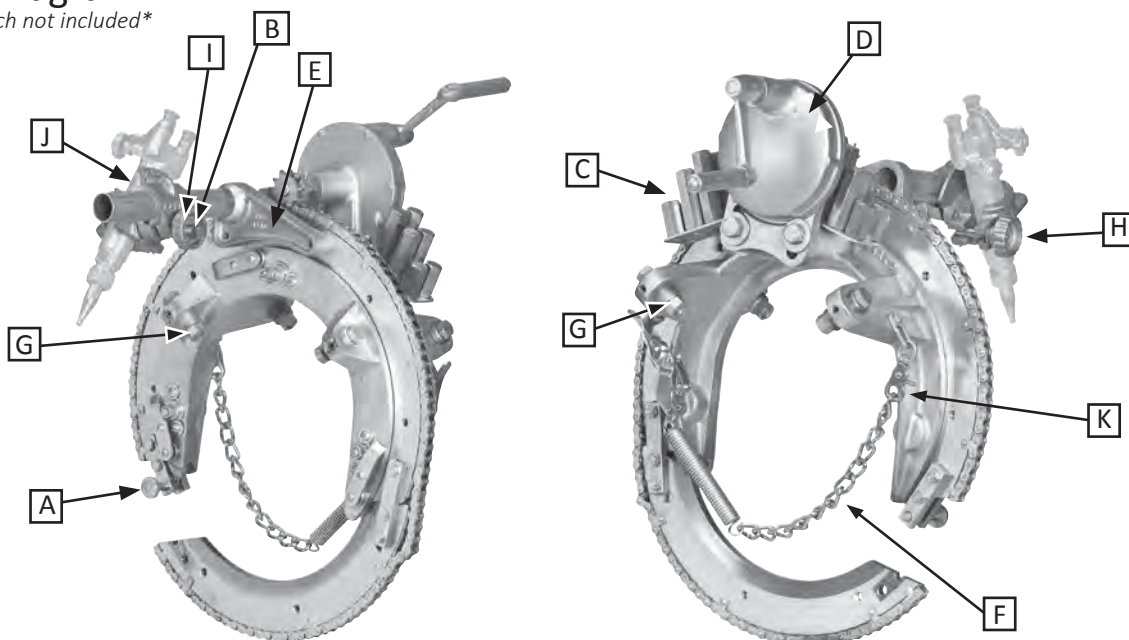
## Compact Manual

### Beveling Model 200C

1. (3"-8", 38lbs)
2. (8"-14", 40lbs)
3. (14"-20", 50lbs)
4. (20"-26", 60lbs)
5. (26"-30", 83lbs)
6. (30"-36", 90lbs)
7. (36"-42", 140lbs)
8. (44"-48", 152lbs)
9. (50"-56", 190lbs)
10. (54"-60", 210lbs)

## Parts Diagram

*\*Note: Torch not included\**



- A. Locking and Unlocking Saddle Arm Pin
- B. Bevel Indicator Square Nut
- C. Spacers (Refer to Spacer Chart)
- D. Gear Box Assembly (251A)
- E. Torch Arm Assembly (42BA-1)
- F. Locking Boomer, Spring, Chain
- G. Spacer Mounting Points

- H. Torch Holder Adjustment Knob
- I. Position Adjustment Knob
- J. 37.5-0-37.5 Degree/Bevel Indicator (4HT-1)
- K. Swivel Snap
- L. (2x) 9/16" Bolts *\*not pictured\**
- M. (2x) Washers *\*not pictured\**



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.

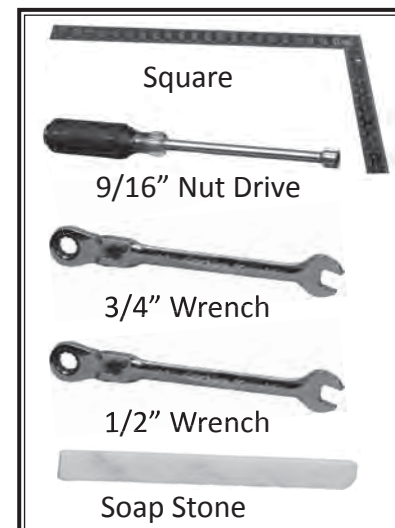
This guarantee is limited to the repair or replacement of any parts found to be defective, and no other liability—expressed, implied, or contingent—is assumed.

# Installation

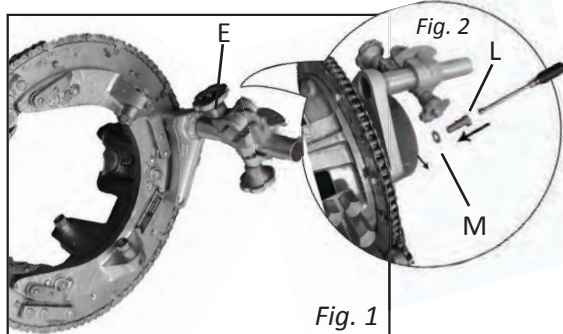
## Tools Needed For Operation/Cutting\*



## Tools Needed For Assembly\*



\*Not Included



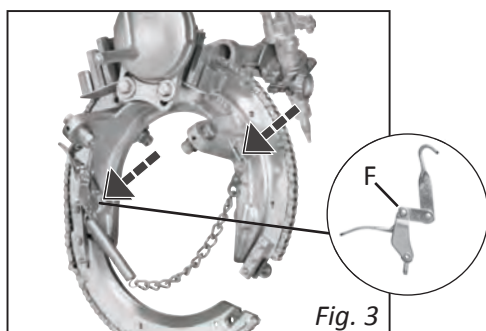
## Installation

1. Mount torch arm assembly (E, Fig. 1) to Compact machine.  
A. Use 2 washers (M, Fig. 2), & 2 9/16" bolts. (L, Fig. 2)

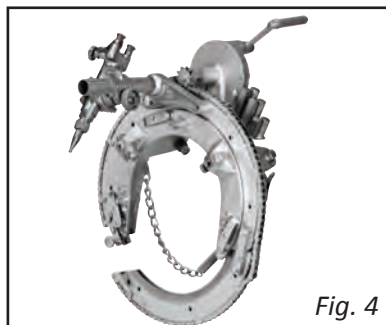
Tip: Use 9/16" nut drive.

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

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



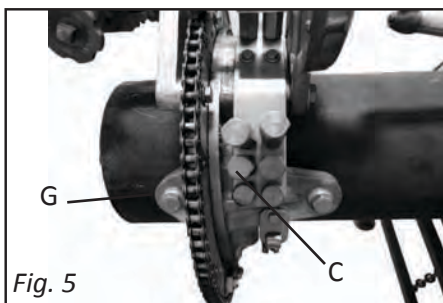
2. Latch locking boomer, spring, chain (F, Fig. 3) to Compact machine.



3. Final picture of finished Compact machine. (Fig. 4)



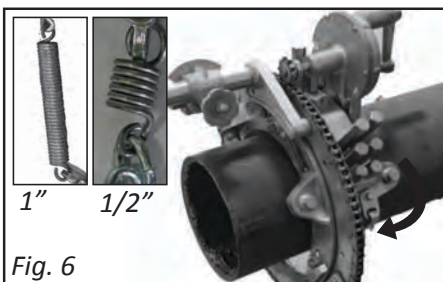
# Operation



1. Install (4x) spacers (C) to Compact machine mounting points. (G, Fig. 5)

*Note: Refer to spacer chart.*

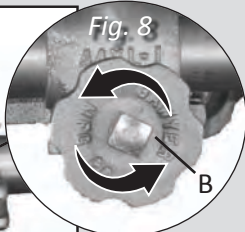
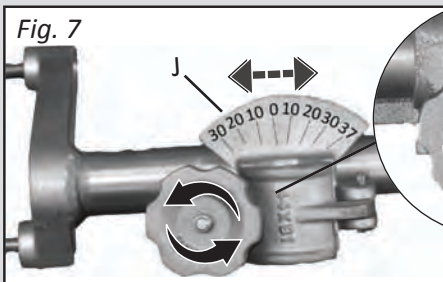
*Tip: Use 3/4" wrench.*



2. Mount Compact machine to pipe/tube. Clamp boomer, spring, chain (F, Fig. 6) around pipe.

*Note: Compact machine spring should extend 1" when fully latched.*

*Note: To mount Compact machine to middle of pipe undo the saddle arm locking pin. (A)*



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

## Torch Arm Setup

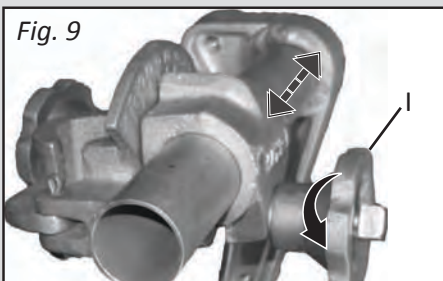
1. Bevel angle adjustment. (Fig. 7)

A. Loosen bevel indicator square nut. (B, Fig. 8)

B. Adjust bevel indicator (J) to desired angle. (Fig. 7)

C. Tighten bevel indicator square nut. (B, Fig. 8)

*Tip: Use 1/2" wrench.*

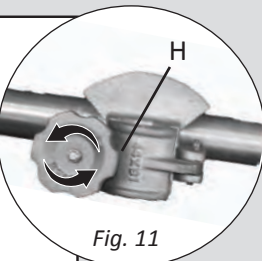
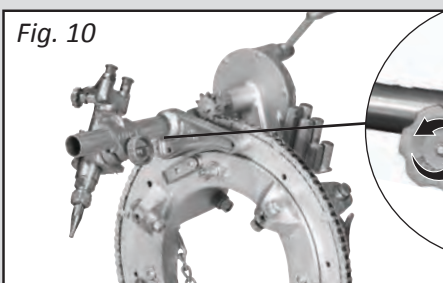


2. Position adjustment. (Fig. 9)

A. Loosen position adjustment knob. (I, Fig. 9)

B. Move assembly to desired position.

C. Tighten position adjustment knob. (I, Fig. 9)



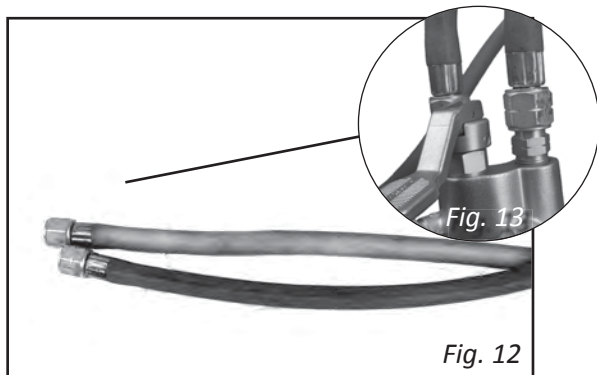
3. Install torch inside torch holder. (Fig. 10)

A. Loosen torch holder adjustment knob. (H, Fig. 11)

B. Install torch inside torch holder. (Fig. 10)

C. Tighten torch holder adjustment knob. (H, Fig. 11)

# Operation

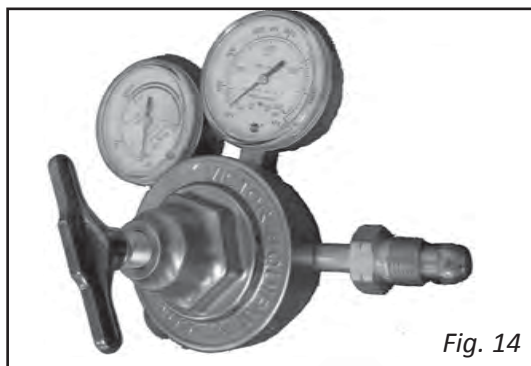


4. Install fuel gas and oxygen hoses to torch. (Fig. 12)

*Note: Notches on hose end are for fuel gas only. (Fig. 13)*

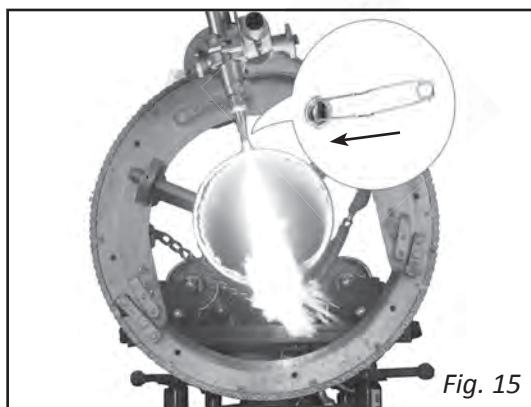
*Note: Red Hoses= Fuel Gas*

*Green Hoses = Oxygen (Fig. 12)*

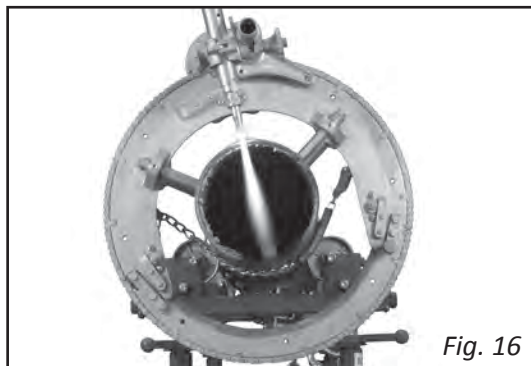


5. Turn on oxygen and fuel gas at the cylinder. (Fig. 14)

*Note: Set pressures to manufactures settings.*



6. To light torch, turn fuel gas knob and light with striker. (Fig. 15)



7. Turn the oxygen knob on torch. (Fig. 16)

*Tip: For best cutting have a neutral flame.*

A. Open blow-through tab on torch.

*Tip: Keep hoses from binding.*

*Tip: Preheat is recommended.*

B. When finished turn off oxygen then fuel gas.

C. Disassemble in opposite order of operation.

