

# DOUBLE CUT TORCH CARRIER

## 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!**

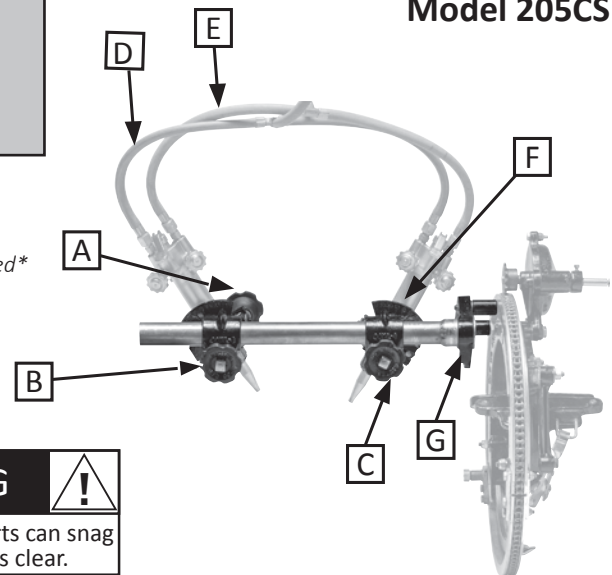
Sawyer Manufacturing Company is the world leader in the design and manufacture of pipeline and welding equipment since 1948. Sawyer equipment has become a standard in the industry and continues to set the benchmark for quality and durability.

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.



## Double Cut Torch Carrier Manual

Model 283B  
For Quick Set Beveling  
Model 205CS



**WARNING**

**WARNING:** Refer to manufacturers settings for safety settings.

### Parts Diagram

*\*Note: Torch not included\**

*\*Note: Quick Set machine not included\**

**Note:** When back beveling, place torch tip as close to the pipe as possible (recommend pinky nail length). Do not place flame directly on pipe. Rotate the assembly to your desired angle. Then once you have the correct angle it should be positioned for a back bevel.

**WARNING**

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

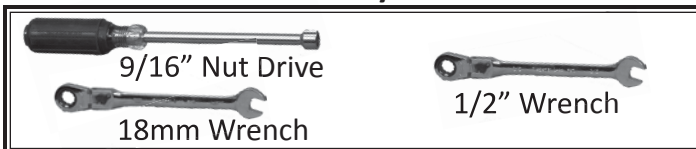
**CAUTION**

**CAUTION:** When back beveling, the cutting flame is directed toward the machine. It is important the torch be positioned as far as possible to the opposite end of the torch arm to prevent the heat from damaging the machine warnings. Safety always comes first.

- |                                       |                                           |
|---------------------------------------|-------------------------------------------|
| A. Torch Holder Adjustment Knob       | G. Torch Arm Assembly                     |
| B. Position Adjustment Knob           | H. 9/16" Nut <i>*not pictured*</i>        |
| C. Bevel Indicator Square Nut         | I. 2-Washers <i>*not pictured*</i>        |
| D. Oxygen Hose (Green)                | J. Wing Nut <i>*not pictured*</i>         |
| E. Fuel Gas hose (Red)                | K. Spacer <i>*not pictured*</i>           |
| F. 37.5-0-37.5 Degree/Bevel Indicator | L. 2 Threaded Bolts <i>*not pictured*</i> |

### Tools Needed for Assembly\*

*\*Not Included*

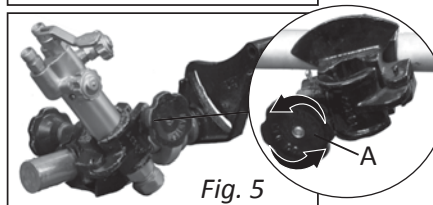
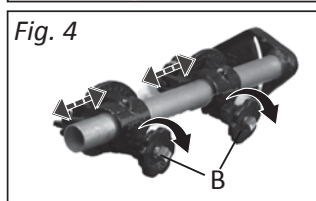
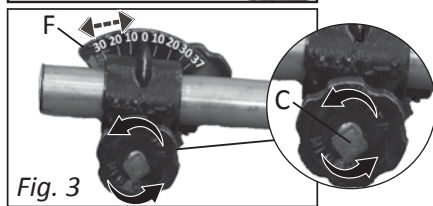
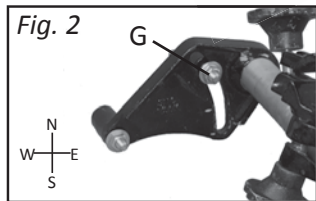
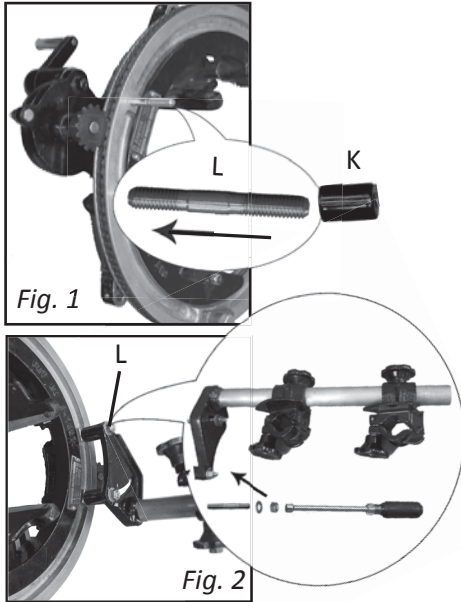


**Warranty**

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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# DOUBLE CUT TORCH CARRIER



## Installation

1. Mount threaded bolts (L, Fig. 1) to Quick Set machine.
  - A. Place free floating spacer (K, Fig. 1) onto threaded bolt. (L, Fig 1)

*Note: Short threads into Quick Set machine not long threads.*

2. Mount torch arm assembly (G) to Quick Set machine.
  - A. Use 2 washers (I, Fig. 1), & 2 9/16" nuts. (H, Fig. 1)

*Tip: Use 9/16" Wrench.*

3. Mount hoses to torches.

*Note: Oxygen Hoses are green and Fuel Gas Hoses are red.*

*Note: Fuel Gas Hoses have notches on them and thread counter clockwise.*

*Tip: It is recommended to use a male-to-male adapter.*

## Operation

*\*Please refer to the Quick Set manual for Installation of Quick Set\**

### Torch Arm Setup

1. Adjust torch arm assembly. (F, Fig. 2)
  - A. By loosening the 9/16" nut. (G, Fig. 2) Adjust torch arm assembly (G, Fig. 2) to most southern point.
  - B. Tighten 9/16" nut. (H, Fig. 2)
2. Bevel Angle Adjustment. (Fig. 3)
  - A. Loosen bevel indicator square nut. (C, Fig. 3)
  - B. Adjust bevel indicator (F) to desired angle. (Fig. 3)
  - C. Tighten bevel indicator square nut. (C, Fig. 3)

*Tip: Use 1/2" wrench.*
3. Position Adjustment. (Fig. 4)
  - A. Loosen position adjustment knob. (B, Fig. 4)
  - B. Move assembly to desired position.
  - C. Tighten position adjustment knob. (B, Fig. 4)
4. Install Torch Inside Torch Holder.
  - A. Loosen torch holder adjustment knob. (A, Fig. 5)
  - B. Install torch inside torch holder.
  - C. Tighten torch holder adjustment knob. (A, Fig. 5)

*\*Please refer to the Quick Set manual for Operation of Quick Set\**