

UPRIGHT 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.

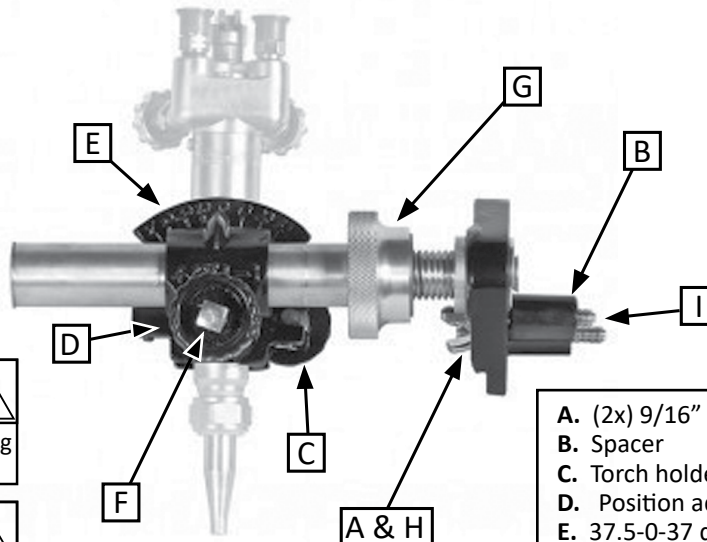


Upright Torch Holder Manual

Models 284C
For Quick Set Beveling
Model 205CS

Parts Diagram

Note: Torch not included

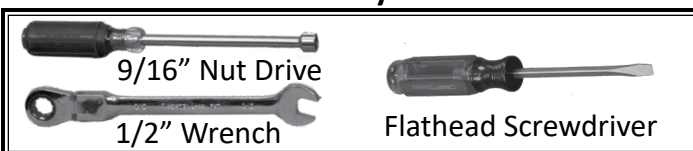


- A. (2x) 9/16" nut
- B. Spacer
- C. Torch holder adjustment knob
- D. Position adjustment knob
- E. 37.5-0-37 degree/bevel indicator
- F. Bevel indicator square nut
- G. Torch adjustment knob
- H. (2x) Washer **not pictured**
- I. (2x) Torch arm mounting bolts *(not pictured)*



Tools Needed for Assembly*

**Not Included*



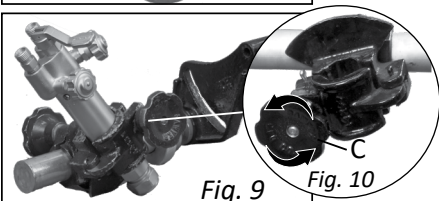
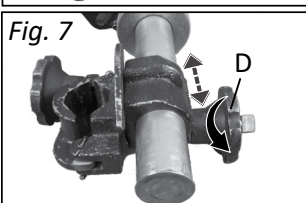
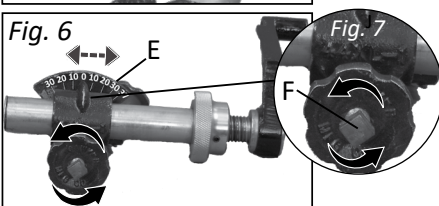
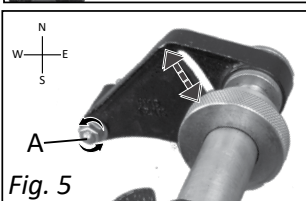
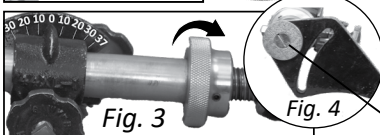
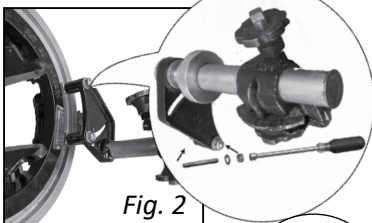
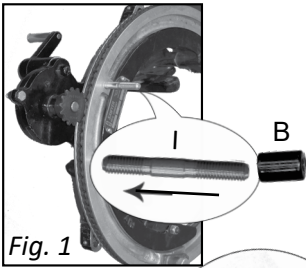
Warranty

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.

Sawyer Manufacturing Company
7799 S. Regency Dr., Tulsa, OK 74131 USA
P 918.834.2550 | F 918.834.0318
sawyerfmfg.com | info@sawyerfmfg.com

V1.2

UPRIGHT TORCH ARM



Installation

1. Mount bolts to Quick Set machine (I, Fig. 1)

A. Place free floating spacer (B) onto bolt (I)

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

Tip: Do not thread ¼" past opening

2. Mount torch arm assembly to Quick Set machine (Fig. 2)

A. Use 2 washers (H), & 2 9/16" nuts (A)

Tip: use 9/16" nut driver

Please refer to the Quick Set manual for installation of the Quick Set machine

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

Upright Torch Arm Setup

1. Adjust torch arm assembly (Fig. 5)

A. By loosening the 9/16" nut (A, Fig. 5) Adjust torch arm assembly (Fig. 5) to most southern point.

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

B. Tighten 9/16" nut. (A, Fig. 5)

2. Bevel angle adjustment. (Fig. 6)

A. Loosen bevel indicator square nut. (F, Fig. 7)

B. Adjust to desired bevel angle. (Fig. 6)

C. Tighten bevel indicator square nut. (F, Fig. 7)

Tip: Use ½" wrench.

3. Position adjustment. (D, Fig. 8)

A. Loosen position adjustment knob. (D, Fig. 8)

B. Move assembly to desired position.

C. Tighten position adjustment knob. (D, Fig. 8)

4. Install torch inside torch holder.

A. Loosen adjustment knob. (C, Fig. 10)

B. Install torch inside torch holder.

C. Tighten adjustment knob. (C, Fig. 10)

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