



Coupon Cutter Manual

Model 270D

About Us

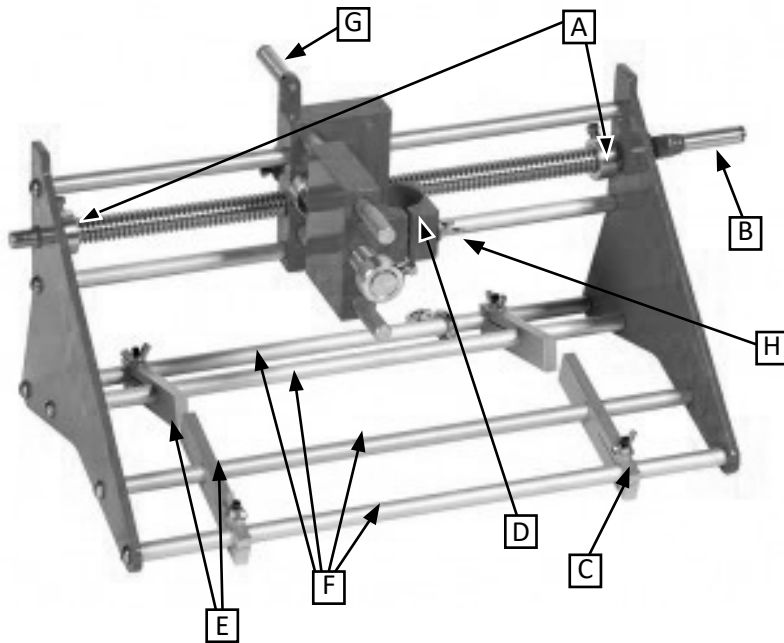
We appreciate your business!

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.



- A. Bump Stops
- B. Turn Handle (length)
- C. Rectangular Rest Wing Nuts
- D. Torch Holder
- E. Rectangular Rests
- F. Support Rods
- G. Turn Handle (width)
- H. Torch Holder Thumbscrew
- I. Boomer Chain Assembly
not pictured



CAUTION

CAUTION: Sawyer Manufacturing offers an easy to use line of internal line up clamps for the purpose of welding two pipes together. The internal line up clamps are not intended to be used as sole supports of the pipe nor to lift the pipe. After each use clean and store in a warm, dry area.

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.

Record the following information for warranty purposes:

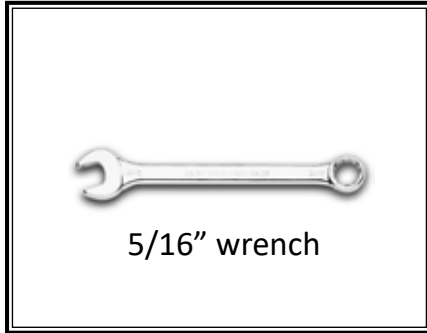
Where purchased: _____

Purchase date: _____

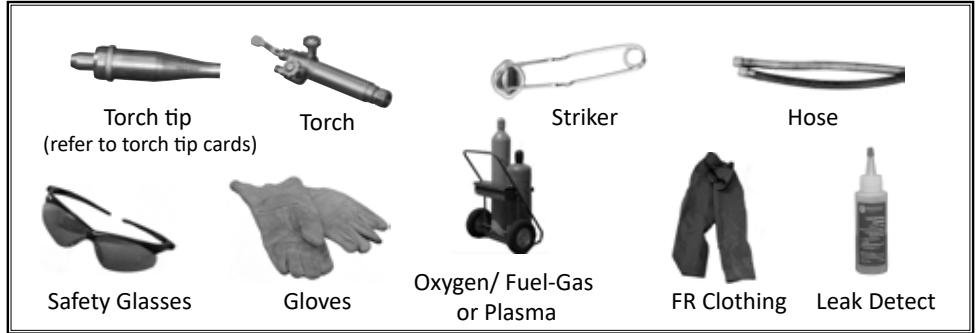
Equipment Serial #: _____

Installation

Tools Needed For Installation*

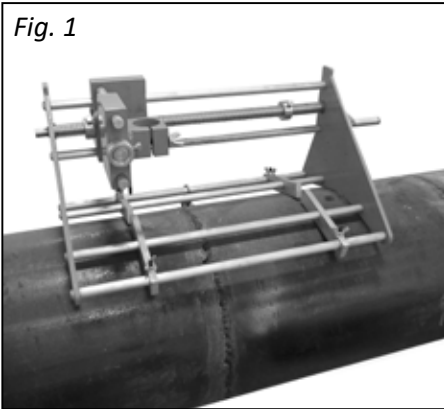


Tools Needed For Operation/Cutting*



*Not Included

Fig. 1



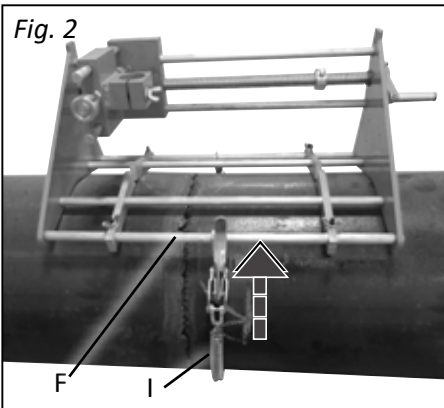
Coupon Cutter Installation

1. Place Coupon Cutter on top center of pipe. (Fig. 1)

Note: Rectangular rests are adjusted for small pipe length.

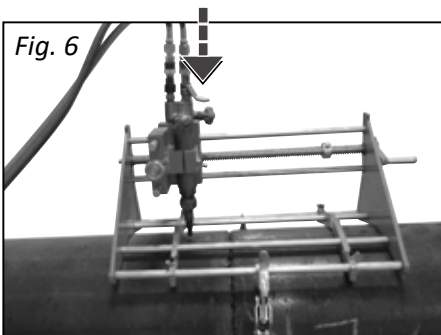
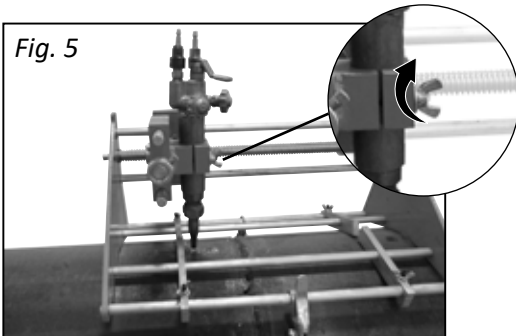
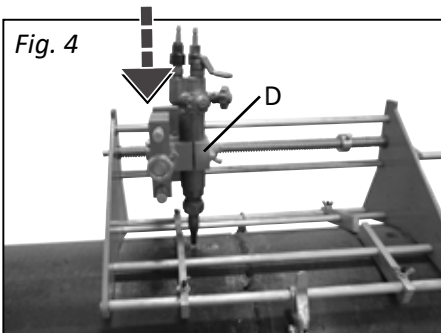
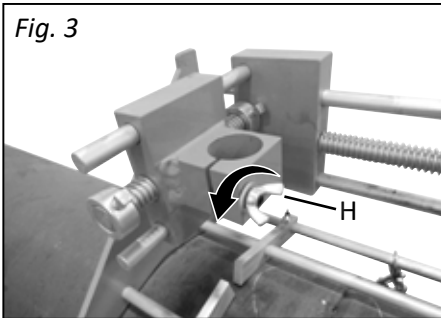
Note: Coupon cutter is also designed for flat plate.

Fig. 2



2. Wrap boomer chain (I) around pipe. Clamp onto support rod. (F, Fig. 2)

Installation



Torch Installation

3. Loosen torch holder thumbscrew. (*H*, Fig. 3)

4. Install torch inside torch holder. (*D*, Fig. 4)

Note: Long or short barrel torches can be used.

5. Tighten torch holder thumbscrew. (*H*, Fig. 5)

6. Install fuel gas and oxygen hoses to torch. (Fig.6)

Note: Notches on hose end are for fuel gas only

Note: Red Hoses = Fuel Gas

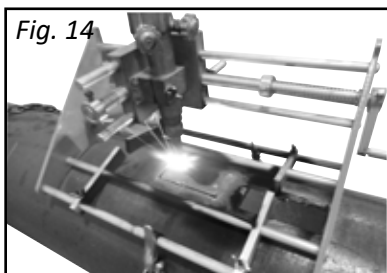
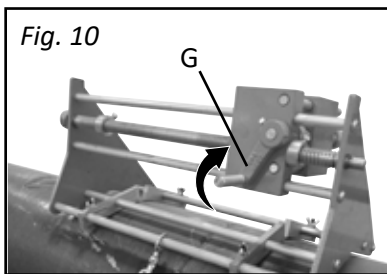
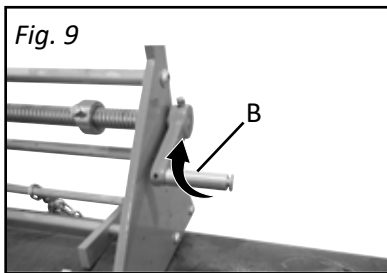
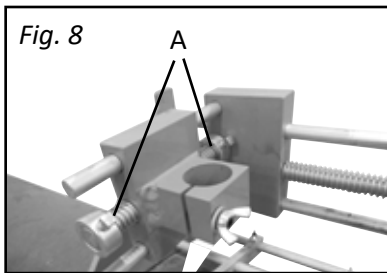
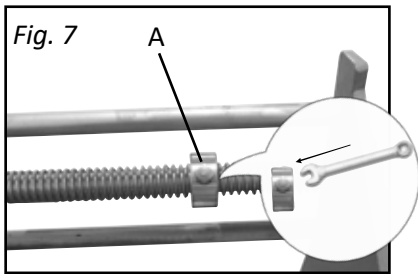
Green Hoses = Oxygen

Note: For coupon sample size and thickness please refer to the correct API, ASME and AWS codes.

Note: Coupon samples should be cut to a maximum 1 3/4" x 7 1/2" in conjunction with the Sawyer Manufacturing Tensile Testers.



Operation



1. Set (4) bump stops (A, Fig 7 & Fig. 8) to desired position.
Tip: Use 5/16" wrench to loosen bump stop set screws.

2. Turn handle (B) for coupon length (Fig. 9), turn handle (G) for coupon width. (Fig. 10)

3. Light torch based on manufacturers instructions. (Fig. 14)

Tip: For best cutting have a neutral flame.

A. Open blow-through tab on torch.

Tip: Keep hoses from binding.

B. When finished turn off fuel gas then oxygen.

Tip: Preheat is recommended.

C. Disassemble in opposite order of operation.