

## 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!

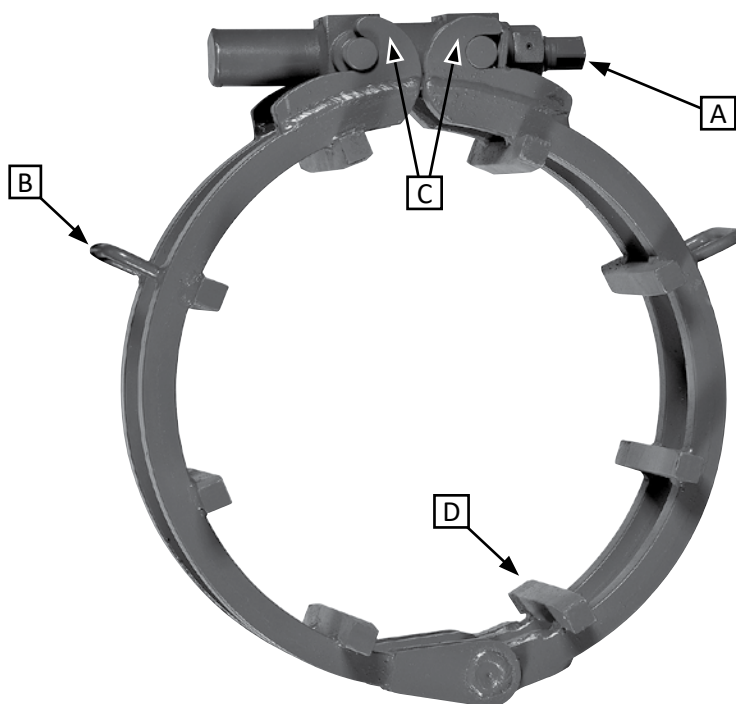
Sawyer Manufacturing Company is the world leader in the design and manufacture of pipeline and welding equipment and has been since 1948. Sawyer equipment has become a standard in the industry and continues to set the benchmark for quality and durability.

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.





# Ratchet Cage Clamp Manual


**Model 255R**




## Operation Diagram

- A. Ratchet Bolt
- B. Clamp Handle
- C. Ratchet Holding Ears
- D. Tack Bar 
- E. No Tack Bar *\*Not Pictured\** 

*The components shown are not available for individual purchase. For a parts diagram or replacement part information, please contact Sawyer.*



**CAUTION**



**CAUTION:** Sawyer Manufacturing offers a line of easy to use cage clamps for the purpose of welding two pipes together. We recommend two people for the installation of the clamp. The cage clamps are not intended to be used as sole support of the pipe nor to lift the pipe. These clamps are not designed for the use of tees, elbows, valves or other fittings. After each use clean and store in a warm, dry area.

Record the following information for warranty purposes:

Where purchased: \_\_\_\_\_

Purchase date: \_\_\_\_\_

Equipment Serial #: \_\_\_\_\_

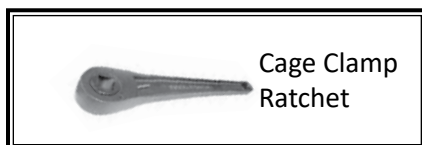
### Warranty

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.

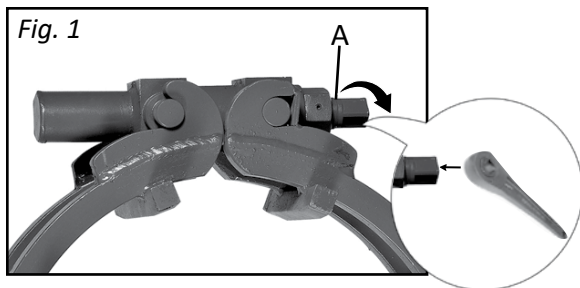
This guarantee is limited to the repair or replacement of any parts found to be defective, and no other liability—expressed, implied, or contingent—is assumed.

# Operation

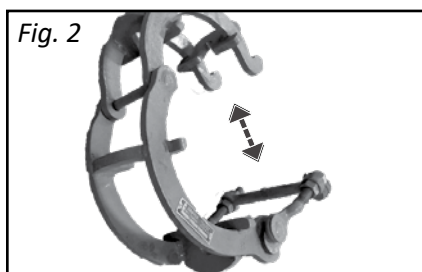
## Tools Needed For Operation\*



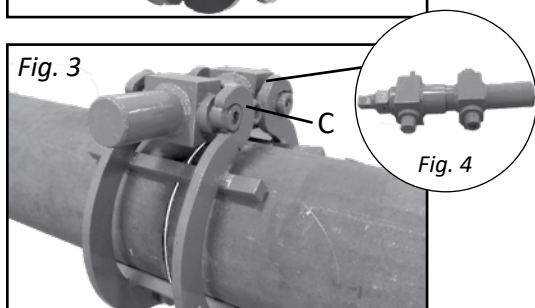
*\*Not Included*



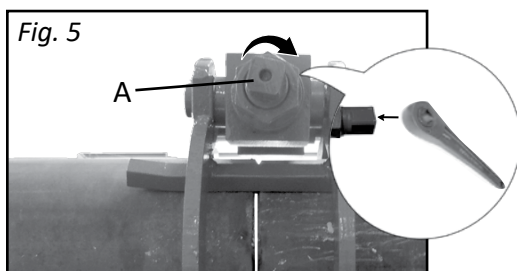
**1.** Open clamp by loosening ratchet bolt. (*A, Fig. 1*)



**2.** Remove ratchet from holding ears. (*C, Fig. 2*)



**3.** Place clamp in middle of pipes to be welded. (*Fig. 3*)  
Insert ratchet into holding ears. (*C, Fig. 4*)



**4.** Close clamp onto pipes by tightening down on the ratchet bolt. (*A, Fig. 5*)