

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.

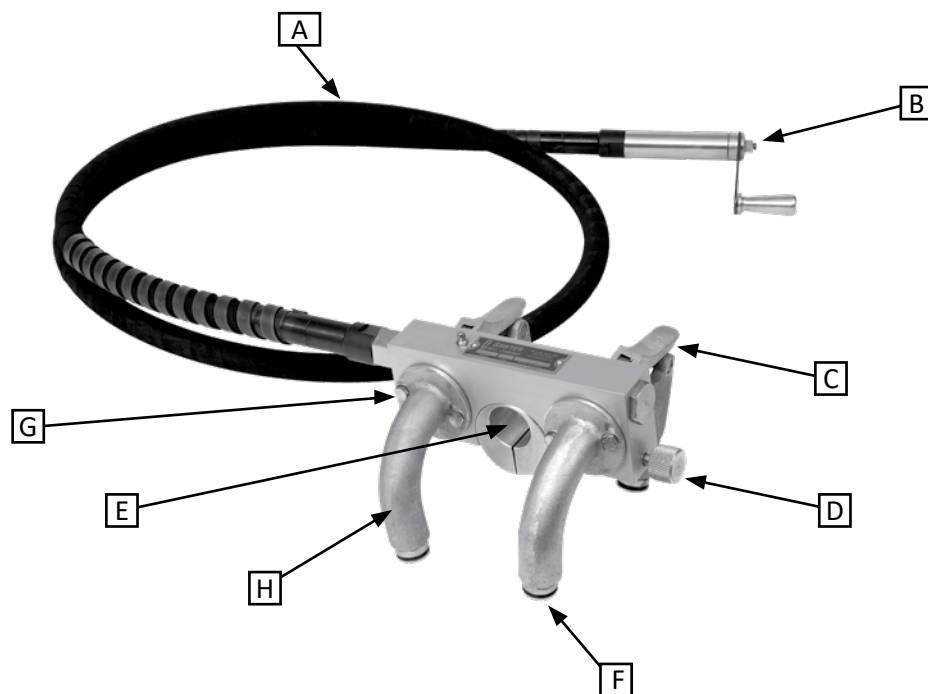
This user operation manual has been made to instruct you for the best use and operation of your Sawyer product. Your satisfaction with our products is our main goal. Please read this entire manual carefully, noting all tips, notes and warnings. Safety always comes first.



Beveling Band Crawler Manual

Model 206A

Parts Diagram



Operation Diagram

- A. Whip
- B. Crank Handle
- C. Latch Handle
- D. Set Screw Assembly
- E. Torch Holder
- F. Drive Wheels
- G. $\frac{7}{16}$ " Cap Screws
- H. Legs

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

Record the following information for warranty purposes:

Where purchased: _____

Purchase date: _____

Equipment Serial #: _____

Warranty

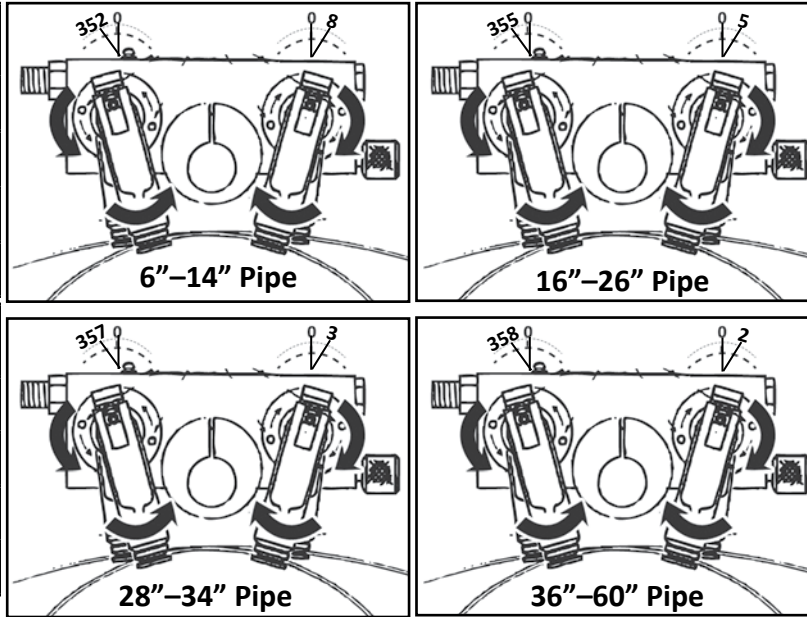
All products manufactured by or for Sawyer Manufacturing Company are guaranteed against defects due to faulty workmanship or materials for twelve months from the date of purchase.

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

| Pipe Diameter | Rotation | Legs |
|---------------|-------------|------|
| 6"-14" | 352 Degrees | Left |
| 16"-26" | 355 Degrees | Left |
| 28"-34" | 357 Degrees | Left |
| 36"-60" | 358 Degrees | Left |

| Pipe Diameter | Rotation | Legs |
|---------------|-----------|-------|
| 6"-14" | 8 Degrees | Right |
| 16"-26" | 5 Degrees | Right |
| 28"-34" | 3 Degrees | Right |
| 36"-60" | 2 Degrees | Right |



Pipe Circumference Chart

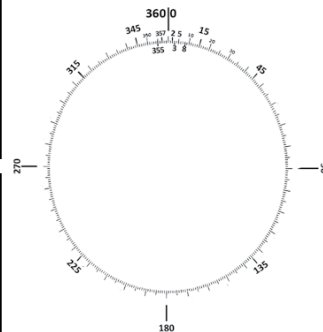


Figure X1

Note: This is an approximation (degrees may vary from castings by the foundry).

Crawler Installation

Note: Refer to band for installation of band.

1. Loosen (4) leg cap screws. (G, Fig.1)

Tip: Use a $\frac{7}{16}$ " wrench.

2. Swing front and rear pairs of legs inward or outward to match band radius.

Note: For a more precise adjustment, please follow these steps.

- A. Move legs (H, Fig.1) to most outward point (0 | 360 degrees).

Note: To find 0|360, Measure $1\frac{3}{8}$ " from edge of block to top of leg. Make a tick mark.

- B. Turn the legs (H, Fig. X1) inward depending on the band chart.
- C. Tighten cap screws. (G, Fig. 1)

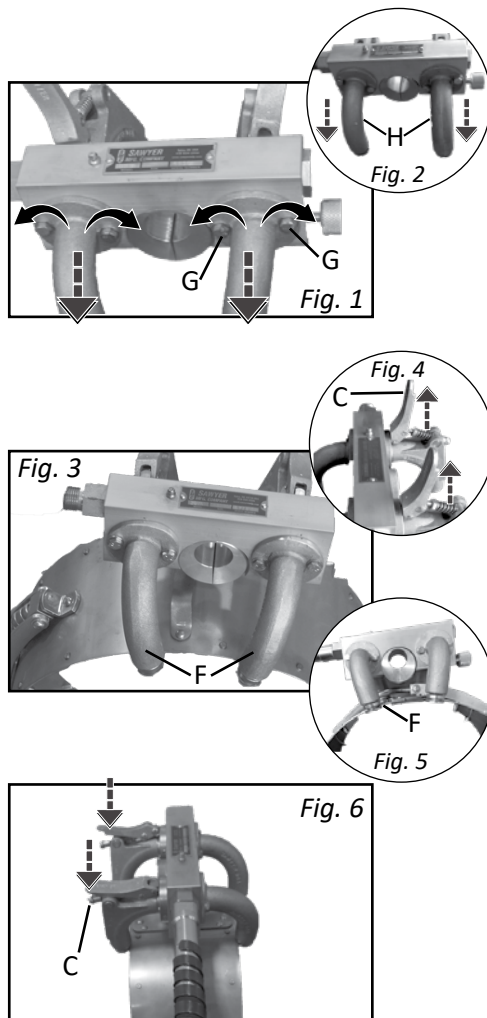
3. Mount crawler to band. (Fig. 3)

- A. Open the leg latch handles. (C, Fig. 4)
- B. Insert drive wheel assemblies (F, Fig. 5) onto band.
- C. Turn the wheels (F, Fig. 5) until they are centered onto the radius of the band.

4. Clamp leg latch handles (C) in down position. (Fig. 6)

Note: To tighten tension, screw the $\frac{7}{16}$ " nut under the latch handles until the spring is tight.

Note: Do not over-tighten as this can damage the band

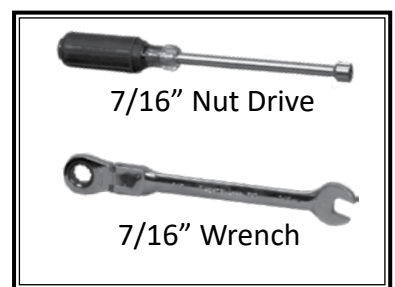


Installation

Tools Needed For Operation/Cutting*

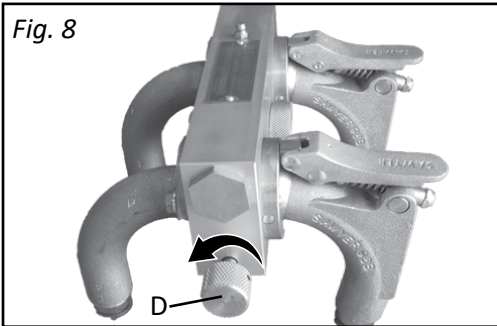


**Not Included*



Tools Needed For Assembly*

Fig. 8



Torch Installation

1. Turn set screw assembly (D) counterclockwise to loosen torch holder. (E, Fig. 8)

2. Place torch inside torch holder. (E, Fig. 9, Fig. 10)

Note: Use long barrel torch with angle head adapter.

Fig. 9

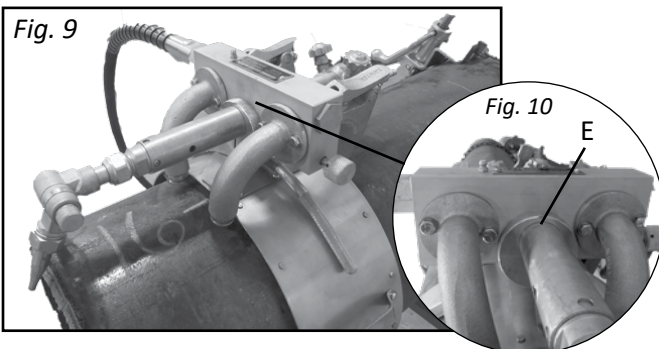
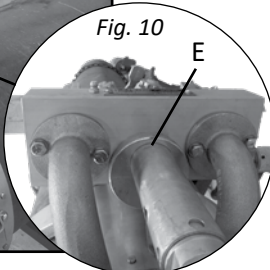
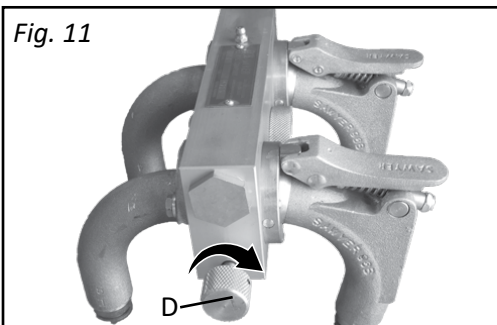


Fig. 10



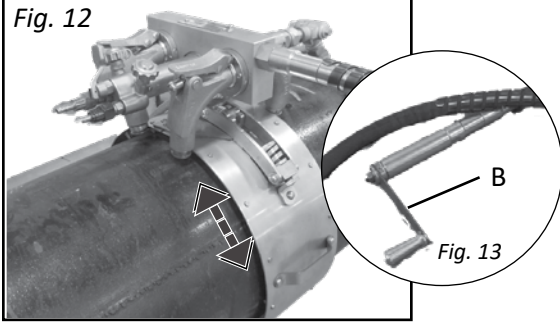
3. Tighten set screw assembly (D) clockwise to tighten torch inside torch holder. (E, Fig. 11)

Fig. 11



Operation

Fig. 12

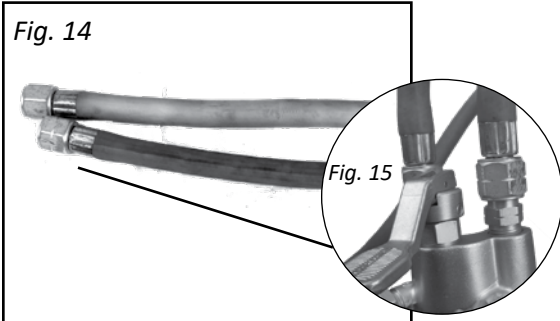


Note: Refer to band for operation of band.

1. Rotate Crawler around band (Fig. 12) by turning crank handle. (B, Fig. 13)

*Note: Band can travel either clockwise or counter clockwise.
Tip: Preheat is recommended.*

Fig. 14



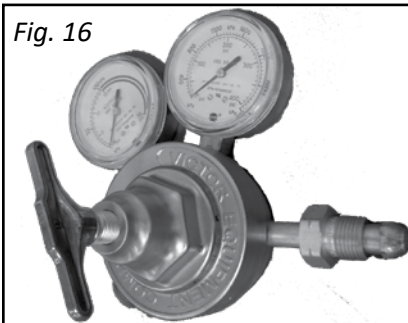
2. Install fuel gas and oxygen hoses to torch. (Fig. 14)

Note: Notches on hose end are for fuel gas only. (Fig. 15)

Note: Red Hoses= Fuel Gas

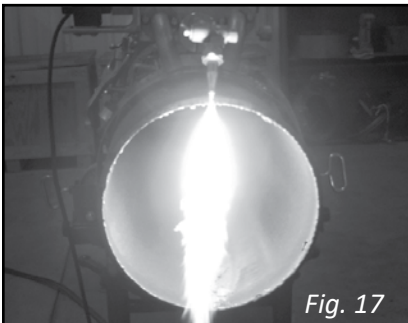
Green Hoses = Oxygen (Fig. 13)

Fig. 16



3. Turn on oxygen and fuel gas at the cylinder. (Fig. 16)

Note: Set pressures to manufactures settings.



4. To light torch, turn fuel gas knob. (Fig. 17)

5. Turn the oxygen knob on torch. (Fig. 18)

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.

