

"QUICK-SET" PIPE CUTTING AND BEVELING MACHINES

Model 205CS

Specifications

Machine Number	Pipe Size		Weight	
	in	mm	lb	kg
0	1½ - 4	38.1 - 101.6	9.0	4.1
1	3 - 8	76.2 - 203.2	14.0	6.4
2	8 - 14	203.2 - 355.6	19.5	8.8

Patent No. 3,473,271

Accessory Equipment

- Out of Round Attachment
- Double Cut Extension Kit
- Electric Motorizing Kit
- Aluminum Carrying Case

Setting and Operating Instructions

Machine # 0,1,2

To set the "Quick-Set" Pipe Cutting/Beveling Machine for cutting and/or beveling, loosen adjustment arm cap screws. Position both left and right adjustment arms to desired pipe size by aligning corresponding graduation mark with cast arrow points located on bosses and tighten cap screws firmly. Double check adjustment setting after tightening cap screws. (Caution should be used not to apply excessive torque on cap screws to prevent thread damage in bosses.

After adjustment arms have been set, mount the "Quick-Set" Beveling Machine on pipe by slipping it over the end of the pipe, or if required, center traveling ring opening by cranking and pull latch knob out to permit the traveling ring to open for straddling of pipe. Close travelling ring and lock in, pushing latch knob in.

Adjust boomer chain to length required by selecting correct chain link to be linked to swivel snap. Correct chain length should permit boomer hook to be hooked onto adjustment arm link with the boomer in open position. Boomer can now be closed which should secure the "Quick-Set" Beveling Machine firmly to pipe.



Determine desired bevel angle to be cut and set torch clamp to this angle by aligning pointer to degree graduation marks cast in tube adapter. Install torch to desired cutting clearance and cutting lead angle. Tighten both knob and cap screw. The "Quick-Set" Beveling Machine is now ready for cutting and/or beveling.

For best results in starting cutting and/or beveling, preheating is suggested by cranking the traveling ring in short clockwise and counter-clockwise movements before applying oxygen. Crank handle should be rotated clockwise during cutting operation. If electric motorized unit is used, the preheating can be accomplished by switching the operating switch on the speed control to forward and reverse positions as required, before applying oxygen. Switch should be in forward position for cutting operation. Correct selection and periodic cleaning of cutting tip is suggested. Please consult your equipment supplier for additional information.

Machine #0

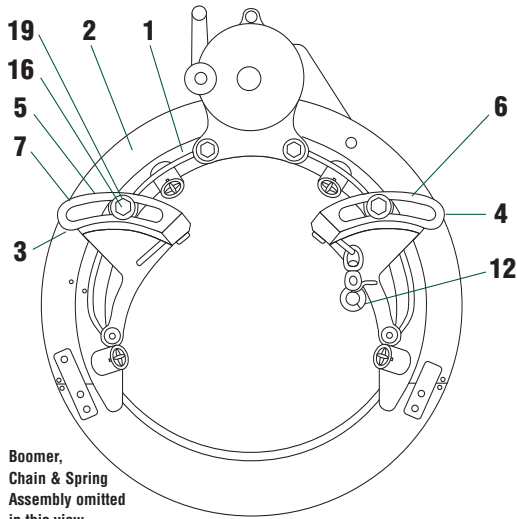
Rotate clamp swing bar 90 degrees for straddling of pipe. Rotate clamp swing bar to detent position and manually tighten clamp screw firmly. (Do not use tools) Close traveling ring and lock by pushing latch knob in.



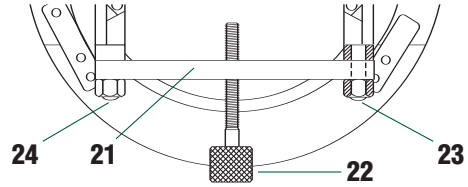
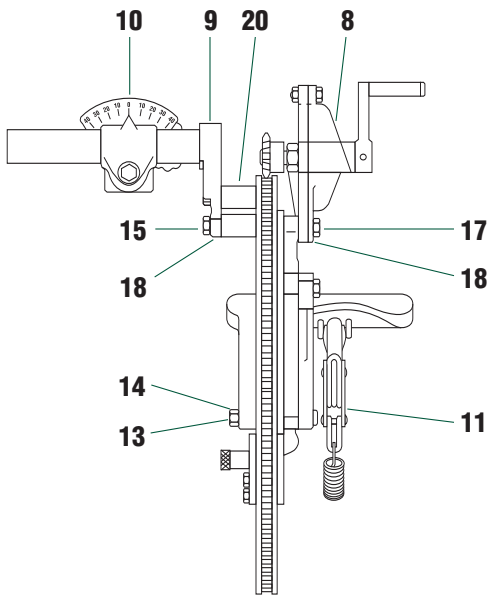
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MODEL 205CS "QUICK-SET" PIPE CUTTING AND BEVELING MACHINES

Model 205CS



Boomer,
Chain & Spring
Assembly omitted
in this view.



No. 0 Machine
(Clamp Bar Assy.)

Parts List

Machine Number		0 Machine		1 Machine		2 Machine	
No.	Part Name	Part No.	Qty.	Part No.	Qty.	Part No.	Qty.
1	Frame Assy.	24XBV-1A	1	24XBP-1A	1	24XBS-1A	1
2	Traveling Ring Assy.	24XBW-1A	1	24XBR-1A	1	24XBT-1A	1
3	Adjustment Arm - Left	43XVL-1A	1	43XSL-1A	1	43XTL-1A	1
4	Adjustment Arm - Right	43XVR-1A	1	43XSR-1A	1	43XTR-1A	1
5	Graduation Plate - Left	55BL	1	55CL	1	55DL	1
6	Graduation Plate - Right	55BR	1	55CR	1	55DR	1
7	Graduation Plate Ret. Screw	151-005	4	151-005	4	151-005	4
8	Gear Box Assy.	2J-2	1	2J-1	1	2J-1	1
9	Torch Bracket	42AK-1	1	42AK-1	1	42AK-1	1
10	Torch Clamp Assy.	44DI-A	1	44DI-A	1	44DI-A	1
11	Boomer, Spg. & Chain Assy.	None		4AW-1	1	4AW-2	1
12	Swivel Snap	None		300-001	1	300-001	1
13	Pivot Bolt	140-047	2	140-050	2	140-051	2
14	Lock Unit	127-005	2	127-005	2	127-005	2
15	Torch Bracket Capscrew	120-105	2	120-105	2	120-105	2
16	Adjustment Arm Capscrew	120-100	2	120-100	2	120-100	2
17	Gear Box Capscrew	120-100	2	120-100	2	120-100	2
18	Washer	131-004	4	131-004	4	131-004	4
19	Washer		2		2		2
20	Spacer	30T	1	30T	1	30T	1
21	Clamp Swing Bar	44AE	1	None		None	
22	Clamp Screw	63M	1	None		None	
23	Bar Pivot Pin	135-045	1	None		None	
24	Spring Plunger	194-015	1	None		None	
25	283 Floating Torch Carrier	Opt.-283	1	Opt.-283	1	Opt.-283	1



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SETTING THE STANDARD FOR PIPELINE AND WELDING EQUIPMENT SINCE 1948

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