

# 2"-12" Remote Drive Power Tool



## CAUTION

- Always wear a dust mask and hearing protection when using this tool.
- Keep hands away from grinding drum at all times.
- Keep unplugged when setting up or servicing.

## Setting Up

1. Connect flex cable to grinding head. Be sure  $\frac{3}{8}$ " hex shaft inside the cable is fully inserted into the drive socket on the tool head. If the shaft is not inserted far enough into the drive socket, the hex shaft may wear prematurely.

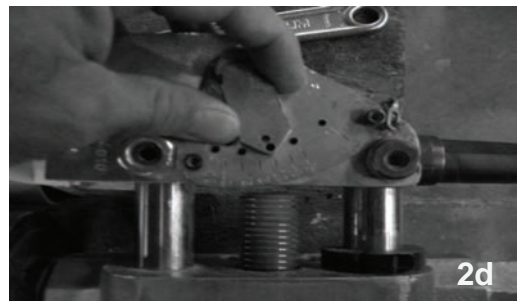
2. For 2"-6" pipe, set the taper angle to  $1\frac{3}{4}$  degrees. For 8"-12" pipe, set taper angle to 1 degree.

- Loosen the bolt (2a) on top of the grinding head and the nut (2b) on the cam shaft.



- Pull the taper angle pin (2c) and adjust the angle pointer to the correct angle. Insert pin to secure (2d) adjustment.

- Tighten nut (2a) and bolt (2b) to quarter turn past snug. **CAUTION:** Do not move the angle pointer without loosening the nut and bolt listed above or damage will occur.



3. Stack collets to the proper size:

- Move grinding head (up or down) to make clearance for the collets.
- Slide each collet over the other until the proper size is reached. Do not force the collet over each other as damage may occur. Spring open by hand and gently feed over the smaller collet. Be sure indentation pins on the inside of the collets fall into place.

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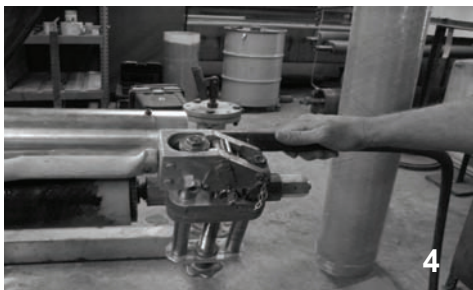
4. Slide tool into a **factory taper** to set the depth of cut. The end of the collet should extend  $\frac{1}{4}$ " beyond the end of the pipe. Tighten mandrels  $\frac{1}{4}$  to  $\frac{1}{2}$  turn past hand tight with a wrench. **DO NOT OVERTIGHTEN.** Turn the feed knob so that the grinding drum makes light contact with the factory taper. **Check to make sure the tool angle matches the factory taper.** Slide the depth stop (split collar on grinding head shaft) flush with the grinding head body (Photo 3). Tighten using a  $\frac{3}{16}$ " Allen wrench.



5. Remove tool from the factory taper.

### Pipe Tapering

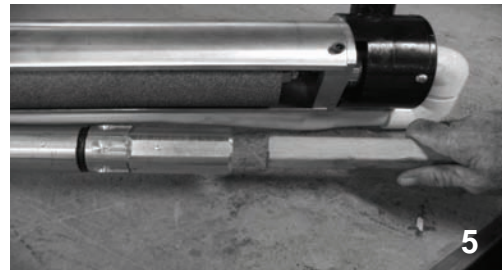
1. Connect dust collector bag.
2. Insert tool into pipe to be tapered and tighten mandrels (see Step 4 above).
3. Plug tool in and turn on the power. Use the end of the flex cable near the grinding head for a handle and rotate counterclockwise (Photo 4). Turn feed knob clockwise to feed into pipe while turning the grinding head. Taper a little bit at a time. Attempting to take too big a bite at one time will result in damage to the tool. Taper until the grinding head bottoms out on the depth stop (split collar). Remove from pipe.



4. Check taper by comparing the insertion of the factory nipple into a fitting with the field tapered pipe into the same fitting. The insertion should be  $\pm \frac{1}{8}$ " for 2"-6" pipe and  $\pm \frac{1}{4}$ " for 8"-12" pipe.

### Short Nipples

1. Place 1" square bar in vice.



2. Place the pipe (nipple) with one end already tapered onto the tool mandrel and tighten mandrel. Slide tool onto the nipple bar (Photo 5) and taper as instructed above.

### Operating Tips

Check to be sure the tool is set to the correct taper angle,  $1\frac{3}{4}$  degree for 2"-6" pipe and 1 degree for 8"-12" pipe.

Work in an open area when possible.

A fan should be available to blow away excess dust.

Always check to assure the flex shaft is securely connected and fully engaged at ALL times.

Empty dust bag after every taper.

Extra dust collector drive belts must be available.



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