

8" Tapering Tool Scarfing Instructions

Use this bulletin and Bulletin No. F6608, Assembly & Operating Instructions for 8" Tapering Tool

Note: Refer to **Bulletin No. F6608**, Assembly & Operating Instructions for 8" Tapering Tool, for general tool instructions, figures, and photographs. **Bulletin No. F6608** is included along with a special blade holder and a diameter tape as part of your 8" Scarfing Kit.

1. Insert the tool into a plain end piece of pipe. The small shoulder on the mandrel should be against the end of the pipe.
2. Expand the mandrel by tightening the $\frac{3}{8}$ " hex head expansion bolt on the back center of the tool. **DO NOT OVERTIGHTEN.**
3. Mount the special blade holder marked SC as shown below for scarfing set-up but **DO NOT TIGHTEN.**
4. Rotate the blade holder to the bottom of the pipe. Insert the blade with the wide side facing the standard blade holder. Be sure that the blade extends past the pipe but does not touch the tool body.
5. Be sure the blade is resting properly in the slot. Tighten the three hex head cap screws to secure the blade.
6. The depth stop bolt must be backed out far enough to allow full travel of the cutting head. The depth stop bolt will be used later to set the depth of your cut. (Refer to the tool figure in Bulletin F6608.)
7. Tighten the cutting head feed knob until there is $\frac{1}{4}$ " clearance between the pipe and the blade. Start tool rotation (counterclockwise) and check for high spots on the pipe. Let the tool go completely around the pipe to shave off any

high spots on the outside diameter (O.D.) Continue feeding in the cutting head very slowly until cutting begins. Always make at least one revolution between adjustments. Continue cutting until you have obtained the correct scarf dimension.

8. Check the scarf dimension using Table 1 or Table 2 on page 1. To check the scarf dimension, you will need an O.D. tape or a standard tape measure. A diameter tape that has a standard tape measure on the opposite side is included in your scarfing kit. Instructions for using the diameter tape are on page 2.

Check the scarf dimensions several times throughout the operation. Wrap the diameter tape around the scarf and measure.

9. Check each SC scarf by placing it in the socket of a two-piece containment fitting. The scarfed pipe end must always fit snugly into the socket of the fitting with no gaps between the fitting halves.

Check Marine-Offshore scarfs by placing a fitting onto the freshly scarfed pipe. Fitting must fit snugly but must not scrape the walls of the fitting.

10. Once the scarf meets the specified dimensions, run the cutting head down until it makes light contact with the scarfed surface of the pipe. Tighten the two lock nuts on the cutting head feed knob until they are tight against the control knob assembly. Use this as a reference mark for your other scarfs. (Always check each scarf with a diameter tape.)

11. If using a gauge nipple to set up the tool, follow step 10.

Table 1 - Scarfing Dimensions for Secondary Containment			
Containment Pipe Size	Scarf Diameter Using Diameter tape ($\pm .020$ "	Scarf Circumference Using Standard Tape Measure ($\pm \frac{1}{16}$ "	Scarf Length
In.	In.	In.	In.
8	8.570	$26\frac{15}{16}$	4
10	10.570	$33\frac{3}{16}$	5
12	12.550	$39\frac{7}{16}$	5
14	14.410	$45\frac{1}{4}$	5
16	16.410	$51\frac{9}{16}$	5

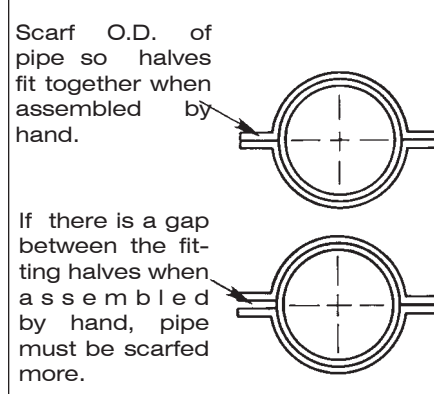


Table 2 - Scarfing Dimensions for Green Thread® 175/250 Marine-Offshore Piping									
Pipe Size		Scarf Diameter Using Diameter Tape		Scarf Circumference Using Standard Tape Measure		Scarf Length		Scarf Length for Flanges	
In	mm	In	mm	In	mm	In	mm	In	mm
8	200	8.740-8.750	222.0-222.3	27.469-27.500	697.7-698.5	$3\frac{1}{4}$	83	$3\frac{1}{4}$	83
10	250	10.820-10.830	274.8-275.1	34.0-34.031	863.6-864.4	$4\frac{1}{4}$	108	$3\frac{1}{2}$	89
12	300	12.840-12.850	326.1-326.4	40.344-40.375	1024.7-1025.5	$4\frac{1}{4}$	108	$3\frac{1}{2}$	89

- NOTE:**
1. Maximum taper over entire scarfed area cannot exceed 0.030".
 2. Be sure you are using the correct grinding drum. The scarfing drum is marked "SC."

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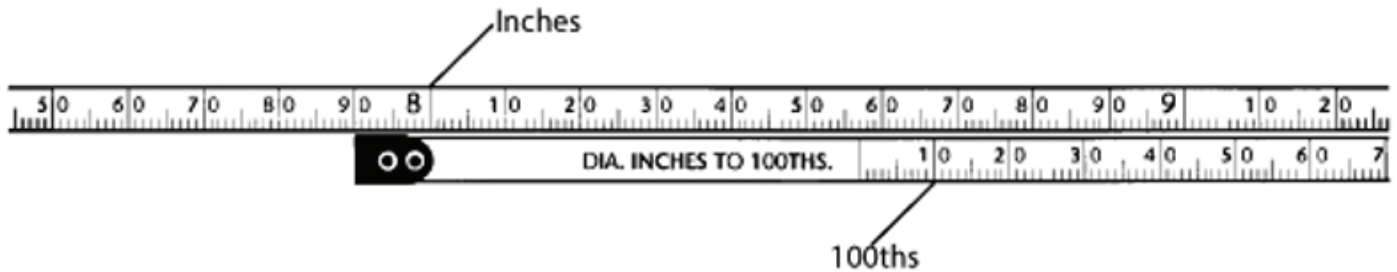
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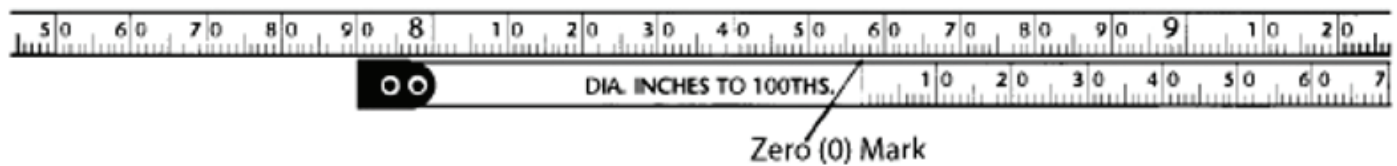
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Reading an O.D. Tape

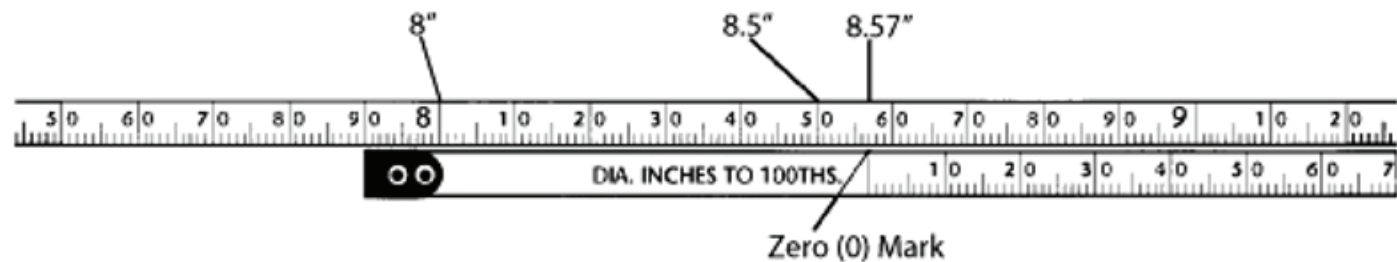
1. The diameter tape measures from inches to one-hundredth inches.



2. Wrap the diameter tape around the pipe tightly, laying the overlap side by side with the zero mark of the tape facing you.
3. Match up the zero mark of the tape with the corresponding number directly above it on the other end of the tape.



4. The outside diameter (O.D.) of the pipe shown in the figure below is 8.57 inches.



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F6609 February 2009