

# Model 2600 or 2600-I Power Tool

## Introduction

The Model 2600 or 2600-I (Model 2600-I tool is a 50 cycle, 240 volt unit.) power tool consists of a grinding drum centrally located between a set of five mandrels. The tool is capable of scarfing 1½"- 6" GREEN THREAD® 175 and GREEN THREAD 250 Marine-Offshore pipe. The scarfing diameter is factory set. To compensate for wear of the grinding drum, NOV Fiber Glass Systems provides a thickness adjustment (see Adjust Thickness).

**Warning:** Use caution when operating this tool. Hold pipe firmly. Do not allow machine to turn pipe. Check mandrels often to make sure they are properly tightened.

## Optional Shop Vac Connection

1. Remove cap from the vacuum port on side of tool.
2. Insert standard shop vac hose nozzle into port.
3. Start the vacuum before scarfing the pipe.
4. The vacuum may not remove all the dust. Remove the four bolts holding the dust cover in place and dump the dust from the tool. Replace the dust cover.

## Non Shop Vac Assisted Operation

1. Remove the dust cover by loosening the four bolts holding it in place. There is one on each side and two on the bottom. (See Fig. 1b.)
2. Replace the cap in the vacuum port.

## Scarfig

1. Cut pipe ends square ( $\pm 1/8"$ ), and set tool in either the horizontal or the vertical position.
2. Turn motor on. Allow a few seconds until the motor reaches speed.
3. Slowly insert the pipe onto the mandrel, making sure alignment is as even as possible. Rotate in a counter-clockwise direction until the end of the pipe rests against the back plate. Do not turn the pipe too quickly, as this can stall the motor. If the motor starts to bog down, slow your rotation and insertion, but do not stop. The sound of the motor will indicate whether the motor is bogging down. Keep turning until the pipe is making minimum contact with the grinding drum. Make two to three complete revolutions and retract pipe from the tool while continuing to rotate pipe. Turn motor off. Any remaining gloss on the spigots should be removed by sanding



Figure 1a

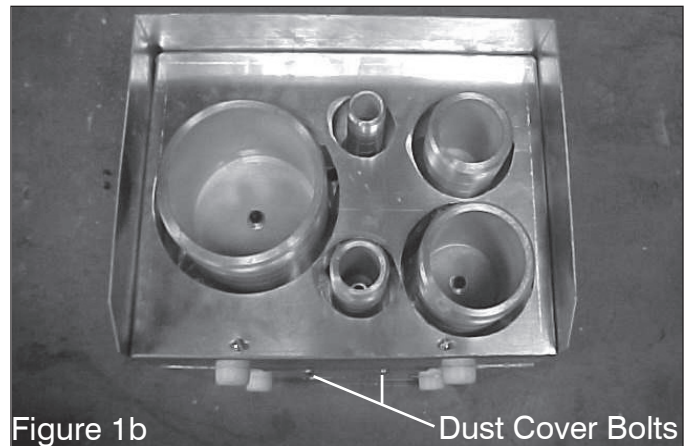


Figure 1b

Dust Cover Bolts

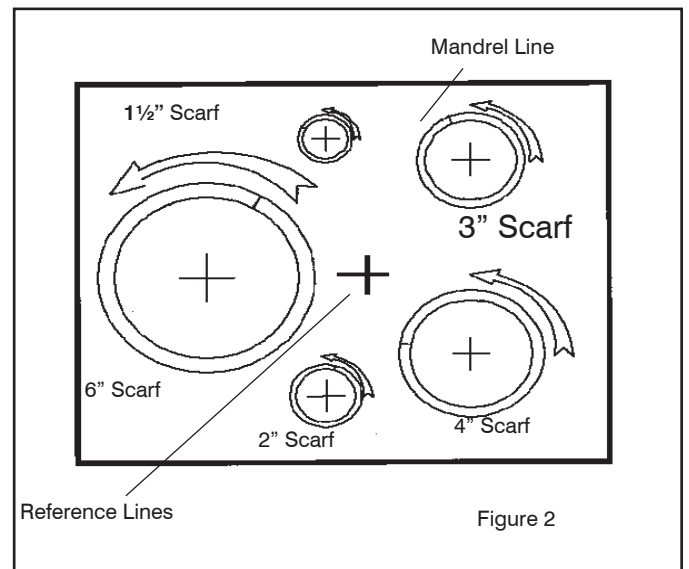


Figure 2

4. If the grinding drum locks up on the pipe, **turn the motor off immediately** and try to wiggle the pipe loose. If this doesn't work, cut the pipe off as near the mandrel as possible, loosen the mandrel (socket head bolt inside of mandrel), remove pipe, and retighten the mandrel.

5. Occasionally check the scarfed pipe by inserting into the socket of a factory fitting.

**Scarf Dimensions for 1½" - 6" Socket Joints Only**

Size (In.)	Scarf Diameter (+0/-0.10) (In.)	Scarf Length (±.125") (In.)
1½	1.87	1.4
2	2.45	2.0
3	3.59	2.0
4	4.59	2.0
6	6.74	2.7

**Adjust Thickness**

1. Loosen the 5/16" socket head bolt located in the center of the hollowed out mandrel. A hex key wrench with extensions works well.

2. Adjust machined thickness as follows:

- a. Rotate mandrel line away from reference line to increase thickness, i.e. to make thicker (see Fig. 2).
- b. Rotate mandrel line towards reference line to decrease thickness, i.e. to make thinner.
- c. Tighten the socket head bolt securely.

**PRODUCT FEATURES AND BENEFITS**

- Weighs approximately 50 lbs.
  - Electrically powered
- Adaptable to shop vac for dust-free operation
  - Scarfs 1½" - 2" pipe in 10 seconds
  - Scarfs 3" pipe in 20 seconds
  - Scarfs 4" pipe in 35 seconds
  - Scarfs 6" pipe in 45 seconds
- No loose blades, blade holders, or mandrels
  - Specially designed for scarfing GREEN THREAD 175 and 250 piping



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