

MODEL 2700 POWER TOOL Operating Instructions

INTRODUCTION

The Model 2700 power tool consists of a grinding drum centrally located between a set of three mandrels. The tool is designed to taper 2", 3" and 4" SILVER STREAK® pipe. The tapering angle is factory set. To compensate for wear of the grinding drum, Fiber Glass Systems provides a thickness adjustment.

FEATURES AND BENEFITS:

- Weighs approximately 50 lbs.
- Electrically powered
- Tapers 2"-4" pipe in just 10 seconds
- No loose blades, blade holders, or mandrels
- Designed for tapering SILVER STREAK pipe

TAPERING INSTRUCTIONS

1. Cut pipe ends square ($\pm 1/8"$) and set up 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, keeping alignment as even as possible. Rotate pipe 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 begins to bog down as can be detected by the sound, slow the rotation and insertion but do not stop. 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.
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 (Allen head bolt inside of mandrel), remove pipe, and retighten the mandrel.
5. Occasionally check the tapered pipe by inserting a field-made spigot into the bell of a factory fitting and compare the insertion with the insertion of a factory spigot into the same bell. Insertion tolerance for the field-made spigot is $\pm 1/8"$.

ADJUSTING THICKNESS

1. Loosen the Allen head bolt located in the center of the hollowed out mandrel.
2. Adjust machined thickness as follows:
 - Rotate mandrel line away from reference line to increase thickness, i.e. to make thicker see Figure 1.0.
 - Rotate mandrel line towards reference line to decrease thickness, i.e. to make thinner.
 - Tighten the Allen head bolt securely.



WARNING: Use caution when operating this tool. Hold pipe firmly. Do not allow machine to turn pipe. Check mandrels daily to assure they are properly tightened. Do not place hand over the end of the pipe to turn it as this could result in serious injury.

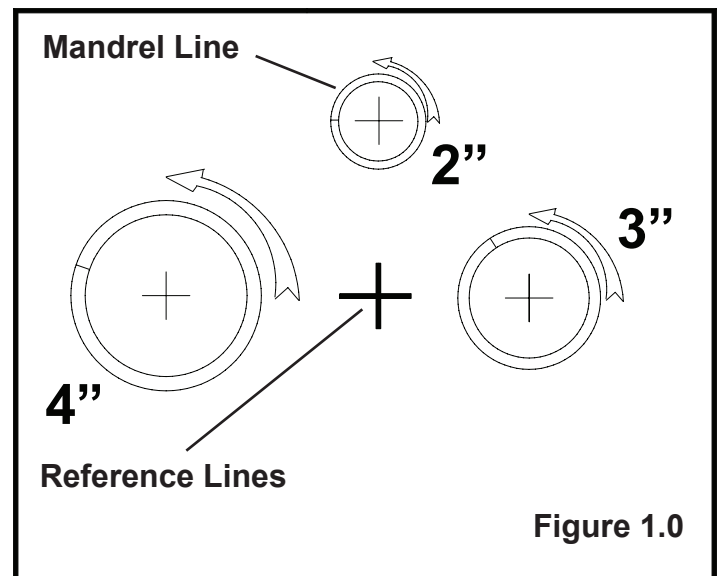


Figure 1.0



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