DOUBLE CUT TORCH CARRIER

About Us
We appreciate your business!

Congratulations on your new SAWYER product. We are proud to have you as our customer and will strive to provide you with the best service and reliability in the industry. This product is backed by our extensive warranty and world-wide service network. To locate your nearest distributor or service agency, please contact us at the phone number and address listed on the bottom of each page.

You are in good company!

Sawyer Manufacturing Company is the world leader in the design and manufacture of pipeline and welding equipment since 1948. Sawyer equipment has become a standard in the industry and continues to set the benchmark for quality and durability.

This user operation manual has been made to instruct you for the best use and operation of your Sawyer product. Your satisfaction with our products is our main goal. Please read this entire manual carefully noting all tips, notes and warnings. Safety always comes first.
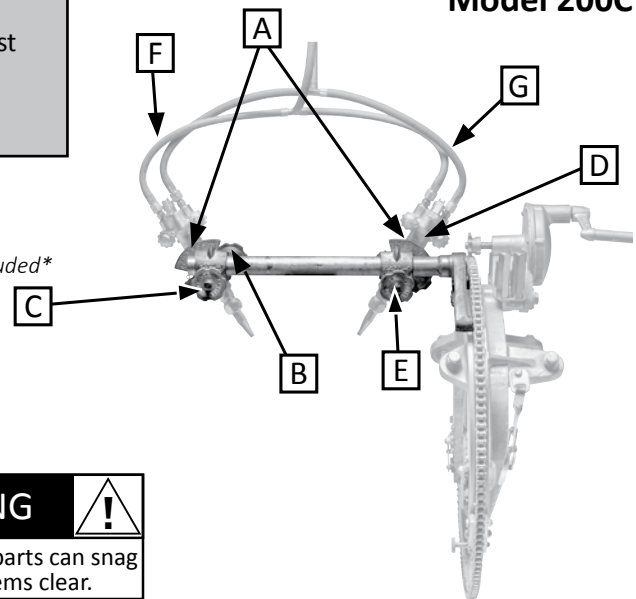
SMC SAWYER MFG COMPANY

Double Cut Torch Carrier Manual

Model 283A
For Compact Beveling
Model 200C

Parts Diagram
Note: Torch Not Included
Compact Machine Not Included

⚠ WARNING ⚠
WARNING: Refer to manufacturers settings for safety settings.

Note: When back beveling, place torch tip as close to the pipe as possible (recommend pinky nail length). Do not place flame directly on pipe. Rotate the assembly to your desired angle. Then once you have the correct angle it should be positioned for a back bevel.

⚠ CAUTION ⚠
CAUTION: *When back beveling, the cutting flame is directed toward the machine. It is important the torch be positioned as far as possible to the opposite end of the torch arm to prevent the heat from damaging the machine warnings. Safety always comes first.*

⚠ WARNING ⚠
WARNING: Moving parts can snag and pull. Keep loose items clear.

A. Torch Arm Assembly
B. Torch Holder Adjustment Knob
C. Position Adjustment Knob
D. 37.5-0-37 Degree/Bevel Indicator
E. Bevel Indicator Square Nut
F. Oxygen Hose (Green) *Not Included*
G. Fuel Gas hose (Red) *Not included*
H. (2x) Torch Arm Mounting Bolts *Not Pictured*
**I.** (2x) Washers *Not Pictured*

Tools Needed for Assembly*
*Not Included

9/16" Nut Drive
18mm Wrench
1/2" Wrench
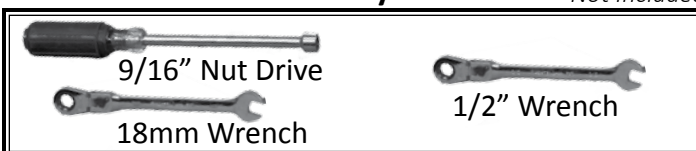
Warranty
All products manufactured by or for Sawyer Manufacturing Company are guaranteed against defects due to faulty workmanship or materials for twelve months from the date of purchase.
This guarantee is limited to the repair or replacement of any parts found to be defective, and no other liability, expressed, implied or contingent is assumed.
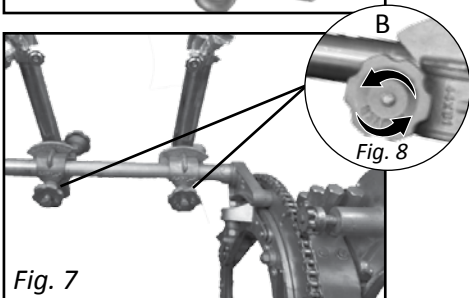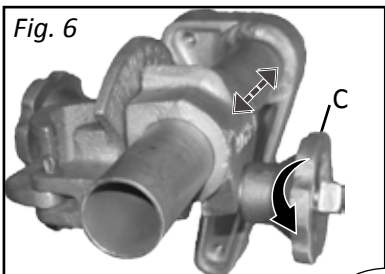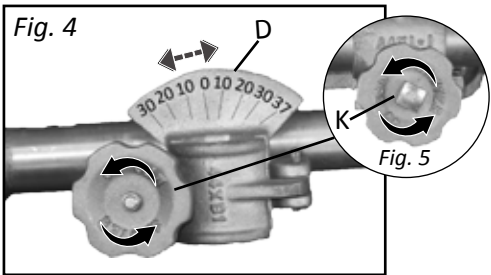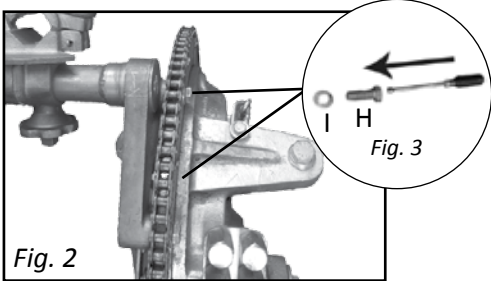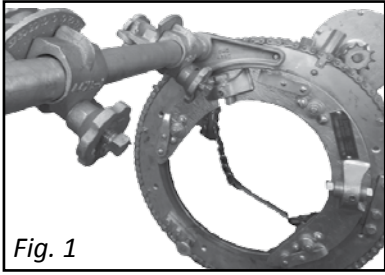
Fig. 1

Fig. 2

Fig. 3

Installation

1. Mount Torch Arm Assembly to Compact Machine. *(Fig. 1)*

    A. Use 2 Washers *(I, Fig. 3)*, & 2, 9/16" bolts. *(H, Fig. 3)*

Tip: Use 9/16" nut drive. (Fig. 3)

Note: Mount assembly using the 2 unthreaded holes on compact machine. (Fig. 2)

Tip: Cycle compact machine away from gearbox for easier installation.

2. Mount oxygen and fuel gas hoses to torches.

Tip: Use 18mm wrench.

Note: Oxygen Hoses are green and Fuel Gas Hoses are red.

Note: Fuel Gas Hoses have notches on them and thread counter clockwise.

Tip: It is recommended to use a male-to-male adapter.

Please refer to the Compact manual for Installation of Compact Machine

Fig. 4

Fig. 5

Fig. 6

Fig. 7

Fig. 8

Operation

Torch Arm Setup

1. Bevel angle adjustment. *(D, Fig. 47)*

    A. Loosen bevel indicator square nut. *(E, Fig. 5)*

    B. Adjust to desired bevel angle. *(D, Fig. 4)*

    C. Tighten bevel indicator square nut. *(E, Fig. 5)*

    Tip: Use ½" wrench.

2. Position adjustment. *(C, Fig. 6)*

    A. Loosen position adjustment knob. *(C, Fig. 6)*

    B. Move assembly to desired position.

    C. Tighten position adjustment knob. *(C, Fig. 6)*

3. Install torch inside torch holder. *(Fig. 7)*

    A. Loosen adjustment knob. *(B, Fig. 8)*

    B. Install torch inside torch holder. *(Fig. 7)*

    C. Tighten adjustment knob. *(B, Fig. 8)*

Please refer to the Compact manual for Operation of Compact Machine