

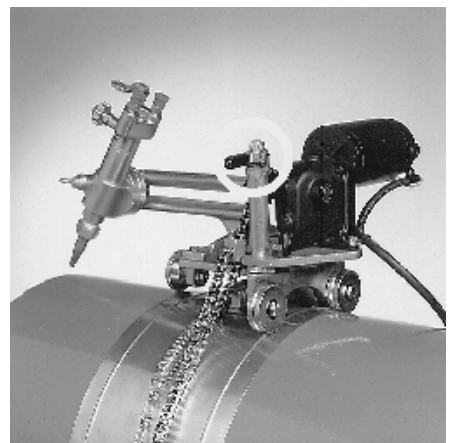
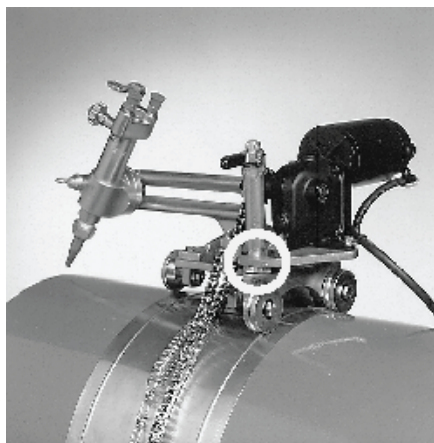
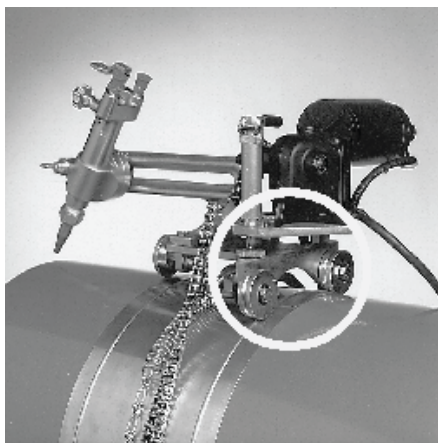
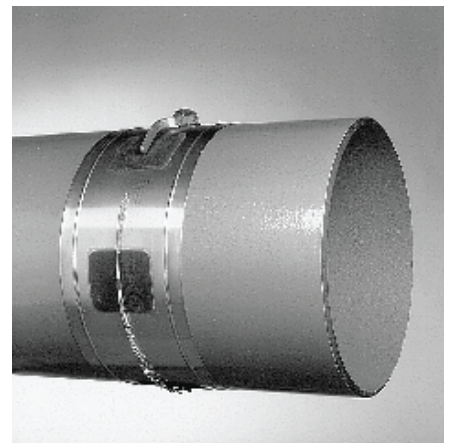
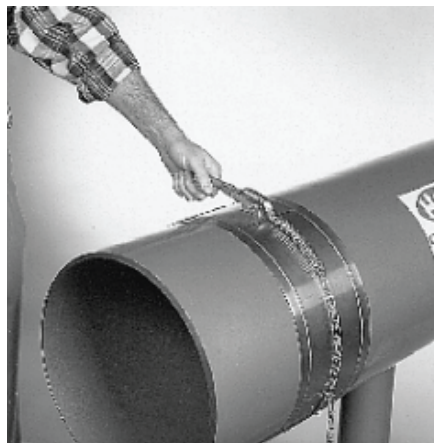
## Band-Type Beveling Machine Operation Manual

### Operation Instructions

1. Place the band around the pipe with the boomer handle positioned on top (see Diagram 6A). Make sure the overlapping portions of the band mesh squarely. Pull the slack from the band and secure by using the boomer and chain provided (see Diagram 6B). The boomer chain is equipped with a small hooked spring on its end. This spring is used to secure any excess boomer chain by hooking it into one of several small holes located on the band. It is necessary to secure any excess boomer chain to eliminate any possible interference with the beveling machine head during the cutting operation (see Diagram 6C for an example of the completed process).

2. Place the motorized or manual head on the band. Position the tractor's two grooved wheels over the raised bead on the band (see the circled item on Diagram 6D). The hinged plate that has the motor mounted on it should be lowered to its lowest possible position before the roller chain is positioned around the pipe. To accomplish this task lower the Variable Adjusting Screw to its lowest possible position (see the circled item on Diagram 6E) and completely release the Toggle Clamp so no spring tension is placed on the Plunger (see the circled item on Diagram 6F).

NOTE: The band should be positioned on the pipe about 8" back from the proposed cut line when placing a bevel. If making a straight cut place the band about 4" back from the cut line.



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3. Position the roller chain around the pipe and the sprocket located on the drive motor (see Diagram 7A). One end of the chain is equipped with a bronze coupling (see Diagram 7B). MAKE SURE THE OPEN SIDE OF THE COUPLING FACES AWAY FROM THE DRIVE MOTOR AND THE CHAIN FEEDS UP THROUGH THE COUPLING. Place the loose end of the roller chain in the coupling while taking up as much slack as possible (see the inset of Diagram 7B). Position the roller chain over the latch pin to secure the chain in the coupling. A continuous chain is formed and will pass over the drive sprocket.

4. With the slack taken out of the chain and the coupling in place, completely lower the handle on the Toggle Clamp to apply spring tension to the Plunger (see Diagram 7C). Position the Variable Adjusting Screw up against the Plunger until 1/4" of the Plunger is exposed.

NOTE: When the chain tension is correct the Plunger will have about 1/4" of spring-loaded travel remaining.

5. Install a two-hose machine cutting torch (short barrel) in the torch holder provided and set the desired bevel angle (see Diagram 7D). Plug the power cord into a 110-volt AC outlet. Refer to Step 7 for Manual Beveling Head instructions.

6. The electronic control box provided is equipped with a three-position toggle switch. The center position is "off," the left position is "clockwise travel" and the right position is "counterclockwise travel."

The control box is also equipped with a rheostat for varying the rate of travel speed (see Diagram 7E). The numbers associated with the rheostat are for reference only and do not represent inches-per-minute. H & M's Motorized e Beveling Machine Head (BMH) is geared to provide a speed range of 2 to 26 ipm. This speed is appropriate for oxygen/fuel gas cutting.

If a plasma cutting system is to be used and additional speed is required, a larger drive sprocket is available to increase the travel speed to 65 ipm at a nominal additional charge. Please contact H & M for specific details.

7. H & M's Manual Beveling Machine Head (BMH-C) is fitting with an 8.5' flexible drive cable and crank handle. Rotating the crank handle provides motion to the beveling machine in either the clockwise or counterclockwise direction (see Diagram 7F).

