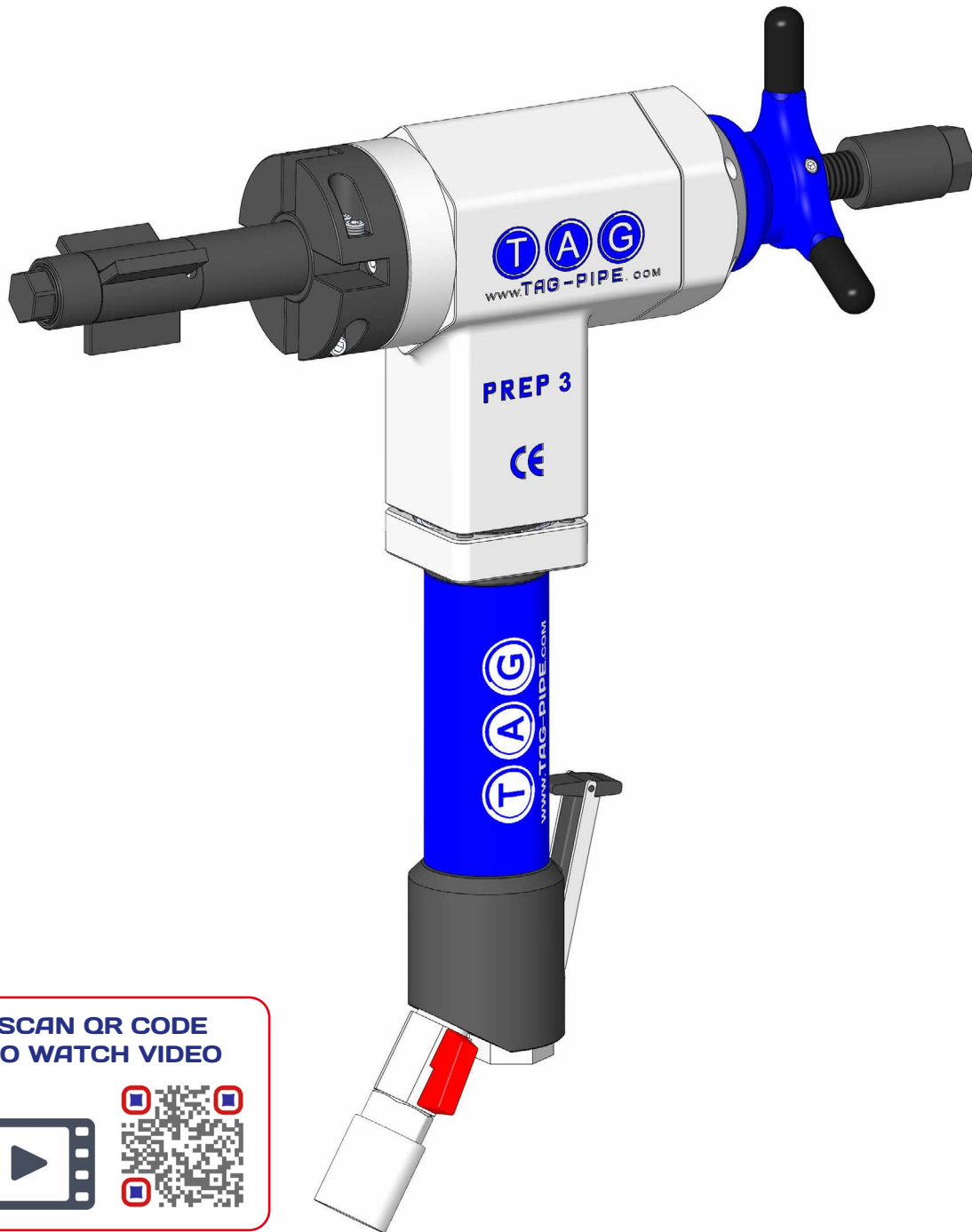




OCTOBER 2022

PIPE EQUIPMENT SPECIALISTS

PREP 3 PIPE BEVELLING 1" to 3" MANUAL



SCAN QR CODE
TO WATCH VIDEO





SPECIALIZED FABRICATION EQUIPMENT GROUP

S.F.E. GROUP - INTERNATIONAL TERMS AND CONDITIONS

S.F.E. GROUP - INTERNATIONAL HEREINAFTER REFERRED TO AS S.F.E. GROUP CONDITIONS OF SALE (MARCH 2022)

These conditions of sale override any clauses in buyers' purchase orders and in any other communications if in conflict therewith.

PRICES - All prices are quoted ex-works, **S.F.E. Group** reserves the right to alter the prices of the terms offered to any buyer without notice. Prices and terms shall be those ruling at the date of despatch. All prices quoted are ex-works S.F.E. Group **UK** (unless stated otherwise).

MINIMUM ORDER CHARGE - There is a minimum order charge of **£250.00 / €275.00 / \$300.00**

CARRIAGE & PACKING - The Company reserves the right as part of this contract to impose such surcharge or carriage charge as shall be laid down by the Company policy at any time. The Company has sole choice of method of delivery and of carrier employed unless specifically agreed in writing to the contrary.

PAYMENT TERMS - The Company's standard terms of payment are nett cash 30 days. New customers will be subject to proforma payment. Overdue invoices may be subject to interest charge at 5% above Barclays Bank plc base lending rate.

DELIVERY - Time for delivery is given as accurately as possible. The customer shall have no right to damages or to cancel the order for failure for any cause to meet any delivery time stated. All dispatch times quoted are subject to prior sales.

DAMAGE/LOSS IN TRANSIT - (1) The Company accepts no liability for any damage to goods in transit unless notified to the Company and the carrier concerned within five days after delivery. (2) In the case of non-delivery the Company accepts no liability of any sort unless written notice of non-delivery is given to the Company within twelve days after the date of the advice of despatch. (3) The Company's liability for damage in transit or non-delivery of goods duly notified to it in accordance with the above, shall in any event be limited solely to replacement of the goods within a reasonable time, whether non-delivery or damage is due to the Company's negligence or otherwise.

RETENTION OF TITLE - (1) Until **S.F.E. Group** has been paid in full for the goods comprised in this or any other contract between them, the goods comprised in the contract remain the property of **S.F.E. Group** although the risk passes to the buyer at the point of delivery in the contract. (2) If the buyer fails to pay for the goods on the due date or commits any act of bankruptcy or if any resolution of petition to wind-up the buyer's business shall be passed (other than for the purposes of amalgamation or reconstruction) or if a receiver of the buyer's undertakings is appointed **S.F.E. Group** may recover possession of the goods at any time from the buyer and for that purpose **S.F.E. Group**, our servants or agents may enter upon any land or building upon which the goods are situated. (3) The buyer has a right to dispose of the goods in the course of his business for the account of **S.F.E. Group** and to pass good title to the goods to his customer being a bona fide purchaser for value without notice of **S.F.E. Group** rights. In the event of such disposal the buyer has the fiduciary duty to **S.F.E. Group** to account to **S.F.E. Group** for the proceeds (which shall be kept separate and identifiable from the buyer's own monies) but may retain therefrom an excess of such proceeds over the amount outstanding under this or any sale contract between them.

GUARANTEE - **S.F.E. Group** agrees to replace or repair at its option goods or parts manufactured by **S.F.E. Group** and proved to be defective due to faulty workmanship within a period of 12 months from the date of invoice (fair wear and tear or damage due to misuse of faulty operation excepted). The Warranty contained in the previous paragraph does not extend to any equipment not manufactured by **S.F.E. Group**, although supplied by **S.F.E. Group**, nor does it extend to any second hand or reconditioned goods. Equipment not manufactured by **S.F.E. Group** carry only the Warranty (if any) of their makers and the purchaser is entitled to the benefit thereof only so far as **S.F.E. Group** have the power to transfer it.

LIABILITY - (1) The Buyer agrees that apart from the express terms contained herein or in the quotation or in any document expressly stipulated therein to form part of the contract and to be outside the provisions of this clause no statement or representation has been made by **S.F.E. Group** relating to the goods supplied, or if any such statement of representation has been made the buyer warrants that he understood it to be a statement of opinion only, and did not rely on. (2) No liability is accepted for any direct or indirect costs, damages or expenses relating to damage to property or injury or loss of any person, firm or company or for any loss of profits or production arising out of or occasioned by any defect in or failure of goods or materials or parts thereof supplied by **S.F.E. Group**. (3) **S.F.E. Group's** liability, whether in respect of one claim or in the aggregate, arising out of any contract shall not exceed the purchase price payable under contract.

DATA - Illustrations, weights, measures, specifications and performance schedules set out in the sales literature of **S.F.E. Group** are statements of opinion and are provided for information only and form no part of the contract.

CANCELLATION - Cancellation of an order will not normally be accepted by **S.F.E. Group**. However **S.F.E. Group** may at its discretion agree to cancellation on the strict condition that all costs and expenses incurred by **S.F.E. Group** up to the time of cancellation and all loss of profits and other loss or damage resulting to **S.F.E. Group** by reason of such cancellation will be reimbursed by the customer to **S.F.E. Group** forthwith.

RETURN OF GOODS - Goods supplied in accordance with the buyer's order may later be returned to **S.F.E. Group** only with **S.F.E. Group's** permission in writing. For standard stock items the buyer will be required to pay to **S.F.E. Group** a handling charge of 15% of the list price of such returned goods. In the case of special items the handling charge will depend on the value to **S.F.E. Group** of the returned goods.

HIRE - For hire terms see hire agreement

CONTRACT LAW - This contract will be deemed to be the subject of the law of England.

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SPECIALIZED FABRICATION EQUIPMENT
GROUP

*Our group policy is one of continuous improvements and acquisitions.
Products and data tables are subject to change or vary from those illustrated.*

OUR BRANDS



1. PREFACE

This manual provides the essential information and step-by-step guidance to the principle, configuration, installation and usage of the TAG PIPE EQUIPMENT SPECIALISTS LTD's PREP models machine (in short: TAG Pipe and PREP).

The TAG PREP models are a high-tech portable inside diameter locking cold pipe bevelling machine. The basic functions of the PREP models are the facing, external bevelling, internal bevelling and counterboring of pipes within the selected model's working range (inside diameter). The PREP models can be used on any type of steel and exotic alloys.

The PREP models are available with the following motorizations: pneumatic, hydraulic and servo electric motor. The PREP models configuration are flexible due to its modular character: components (e.g. toolbox, striker block, etc.) and motors can be (within their limitations) exchanged, upgraded and replaced. The PREP models accept a wide range of accessories and bevelling tooling to increase their performance and expand their machining capacities.

Please read the instruction manual carefully before using the equipment.


NOTE

In the event of queries on installation, commissioning, operation or special conditions at the operation's site, or on usage, please contact your nearest TAG Pipe partner or our customer service department on **+44 (0)1869 324 144**, or via e-mail: **sales@tag-pipe.com**.

DISCLAIMER

TAG Pipe's liability related to the operation of the PREP models are restricted solely to the function of the equipments. No other form of liability, regardless of type, shall be accepted. This exclusion of liability shall be deemed accepted by the user on commissioning of the equipment. TAG Pipe is unable to monitor whether or not the instructions in this manual or the conditions and methods are observed during installation, operation, usage and maintenance of the PREP. An incorrectly performed installation can result in material damage and injure persons as a result. For this reason, TAG Pipe does not accept any responsibility or liability of losses, damages or costs arising from incorrect installation, improper operation or incorrect usage and maintenance or any actions connected to this in any way possible.

2. SAFETY INSTRUCTIONS

 **WARNING** - TAG Pipe takes great pride in manufacturing safe, quality products with user safety as key priority. TAG Pipe recommends that all users comply with the following safety rules and instructions when operation the PREP models.

For your safety and the safety of others, read and understand these safety recommendations before installing and operating the PREP models. Keep this manual at all time clean and stored safely, accessible for any operator's reference at any time.

The TAG PREP is a high-tech portable inside diameter locking cold pipe bevelling machine. The basic functions of the PREP are the facing, external bevelling, internal bevelling and counterboring of pipes within the selected model's working range (inside diameter). The PREP can be used on any type of steel and exotic alloys. The PREP can be used on site or in a workshop environment. At all time it is the operator's responsibility to be aware of and adhere to the local applicable rules and legislation related to the operation of the equipment.

Wrong use or abuse of the PREP can lead to lethal accident and/or material damage (not limited to the equipment itself) and the environment.

The PREP should be operated at all time by a qualified operator, who has received adequate training on the equipment. Throughout the operation the operator must be familiar with:

- The controls of the equipment.
- The operation of the equipment.
- General and local safety regulations.
- The technical, physical and practical limitations of the equipment.

3 - GENERAL SAFETY INSTRUCTIONS

- Keep working space clean.
- Assess the working conditions properly prior to using the equipment.
- The operator should wear appropriate personal protective equipment when operating the equipment.
- When operating any heavy equipment, it is imperative that the operator is careful and observant of all moving components.
- Keep away from rotating parts during operation of the equipment.
- The operator should be physically and mentally capable of operating the equipment. In case of illness, tiredness or any medical or mental condition limiting the correct and safe operation of the equipment, the operator should be prohibited to conduct any work with the equipment.
- Make sure the grounding is connected properly and electrical cabinets are closed.
- Don't operate the electric switch, or button, or cables with wet hands, for fear of electrical shock. Protect the body from injury due to electric shock by avoiding touching any electrical parts when under power.
- Use only the foreseen earth connection. Do not ground to this equipment as it is possible to short-circuit the motor and/or control box when grounding to this equipment. Improper grounding poses a risk of electrical shock.
- Make sure power supply is disconnected when not operating or executing maintenance on the equipment.
- Do not make any modifications to existing or original electrical circuits, cabinets, safety stops and other related original components.
- Do not operate the equipment before closing all covers of the equipment. Great danger exists in naked terminals of power supply.
- Make sure all power cables are in good condition. In case of wear or damage, replace immediately.
- Don't pull the equipment by its cable(s) and don't disconnect the power cable from the equipment to cut off power. The cable(s) should be kept away from heat, power, oil, dirt and sharp-pointed tools or debris. Check the cable(s) before, during and after every operation.
- Protect yourself from toxic fumes that may be produced during welding operations. Make sure there is appropriate ventilation and/or fume extraction in the working area.
- Wear impact resistant eye and ear protection while operation the equipment. If there is a lot of dust or fumes, wear dust-proof respirator or mask.
- Make sure all of equipment's safety measures, covers and other devices are normal condition and checked.

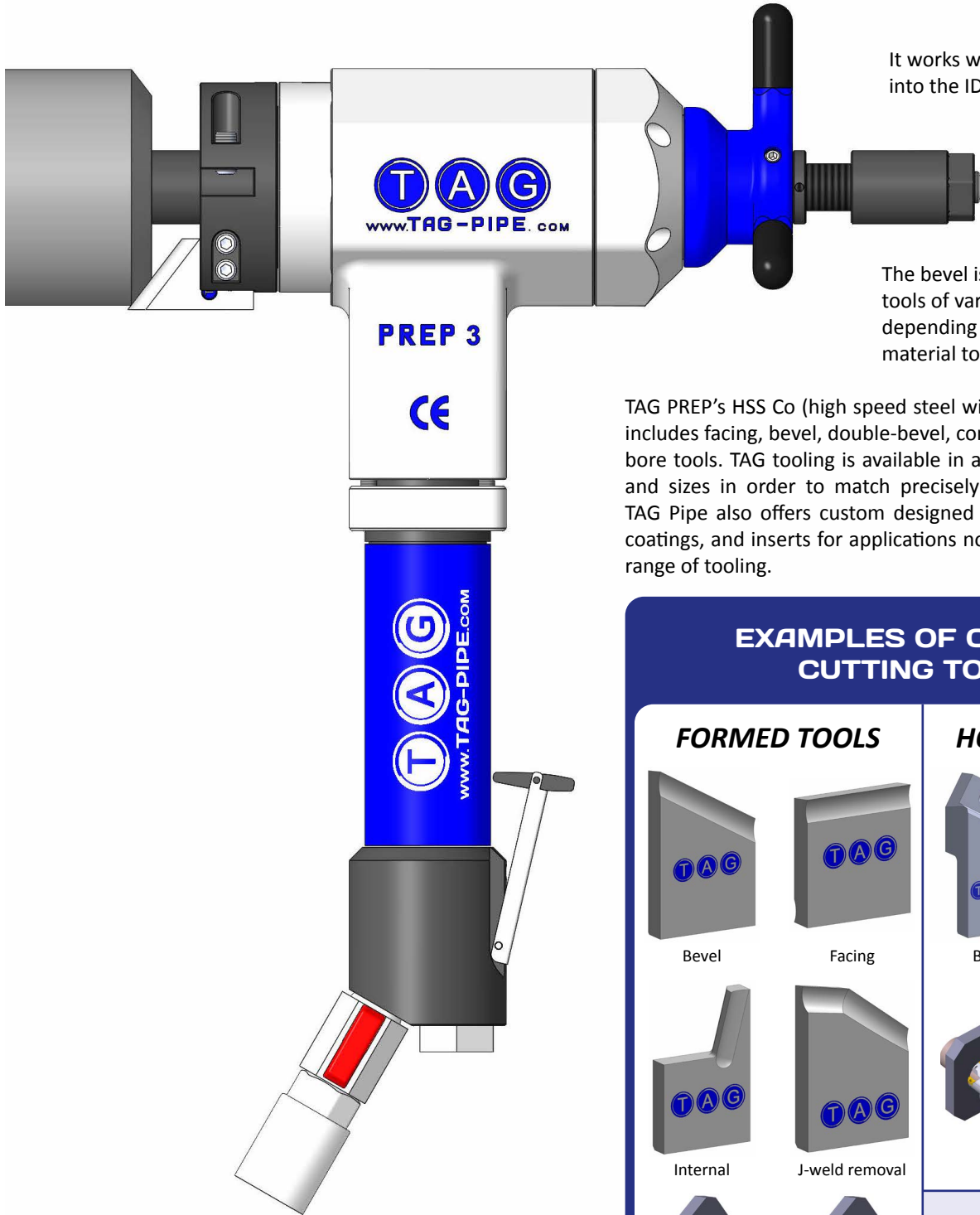
4 - SPECIFIC INSTRUCTIONS

- Use solely original TAG Pipe components, accessories, tooling and (spare) parts.
- The equipment should only be used for its intended purpose.
- Considering the working environment of operation, don't get the equipment unnecessarily wet and don't use the equipment in overly humid conditions. Ensure the machine has the best possible conditions for operation.
- Do not remove or modify any component or part from the original PREP.
- Maintain the equipment regularly. In order to maintain the performance of the machine, keep it clean at all times and add oil lubricant and replace (spare) parts as per periodic recommendations.
- Prior to conducting any maintenance or change of accessories, (spare) parts or tooling, ensure that the power plug or air supply has been disconnected. The machine should not be 'powered' or in 'running mode'.
- When the power supply is connected, consider the machine in 'running mode'. Don't put hands on or near the switch.
- Before using the PREP make sure to inspect the machine on its completeness of all components, proper installation and general condition. In case of any sign of damage, wear or tear replace the affected components or parts prior to using the machine.
- Store and transport the equipment in the designated boxes in order to protect it from damage or deterioration due to environmental conditions.
- The PREP machines shall only be serviced and repaired by TAG Pipe or an authorised TAG Pipe partner.
- Follow carefully the instructions and technical specification related to the motorization of the PREP (voltage input, air pressure, quality of compressed air supply et cetera).
- Check the handle and safety pedal regularly (applied only to pneumatic motorized machines).

5 - MACHINE WORKING PRINCIPLE

The TAG PREP is a high-tech portable inside diameter locking cold pipe bevelling machine. The basic functions of the PREP are the cutting, facing, external bevelling, internal bevelling and counterboring of pipes within the selected model's working range (inside diameter). The PREP can be used on any type of steel and exotic alloys. The PREP can be used on site or in a workshop environment.

The PREP models are available with the following motorizations: pneumatic, electric and battery motor. The PREP configuration is flexible due to its modular character: motors can be (within their limitations) exchanged, upgraded and replaced. The PREP models accept a wide range of accessories and cutting and bevelling tooling to increase their performances and expand their machining capacities.



It works while inserted and locked into the ID of the pipe.

The bevel is obtained by bevelling tools of various shape and materials, depending by the nature of the material to be bevelled.

TAG PREP's HSS Co (high speed steel with cobalt) range of tooling includes facing, bevel, double-bevel, compound bevel and counter bore tools. TAG tooling is available in a range of different lengths and sizes in order to match precisely the required application. TAG Pipe also offers custom designed tooling, special tool steel, coatings, and inserts for applications not covered by the standard range of tooling.

EXAMPLES OF COMMON CUTTING TOOLS

FORMED TOOLS



Bevel



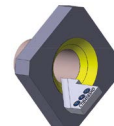
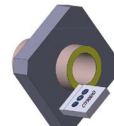
Facing



Internal



J-weld removal



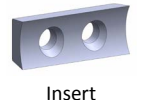
HOLDER / INSERT



Bevel



Facing



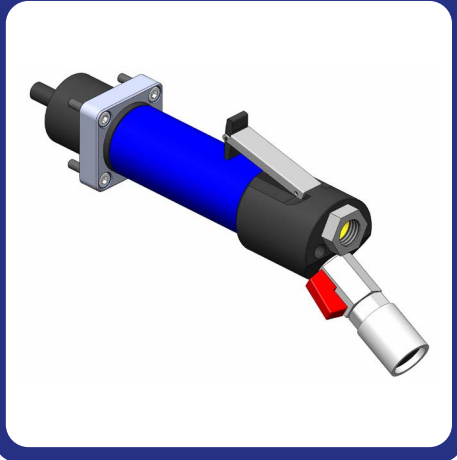
Insert

All shapes, sizes and angles available

The TAG PREP models are modular in the sense that any of the following motor types can be mounted. This increases the overall user friendliness and flexibility. The motors can be installed and/or exchanged rapidly on the same motor mounting.

The TAG PREP 3 can be equipped with the following motor types:

PNEUMATIC



ELECTRIC



BATTERY



The TAG PREP 3 can be equipped with optionals:

REDUCED SHAFT

20 - 30 mm i/d
0.8 - 1.2" i/d



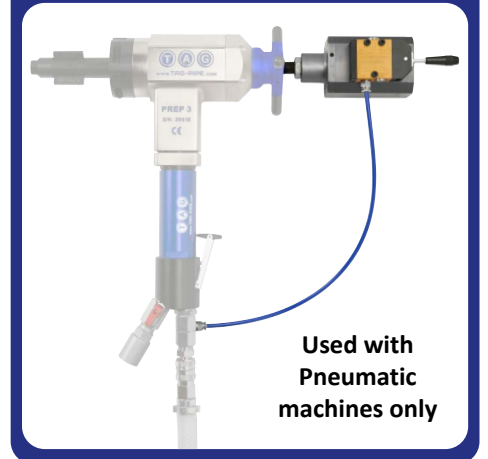
ELBOW / FITTINGS SHAFT

38 - 79 mm i/d
1.5 - 3" i/d



AUTO LOCK

Used with
Pneumatic
machines only



RATCHET HANDLES



FEED STOPPER

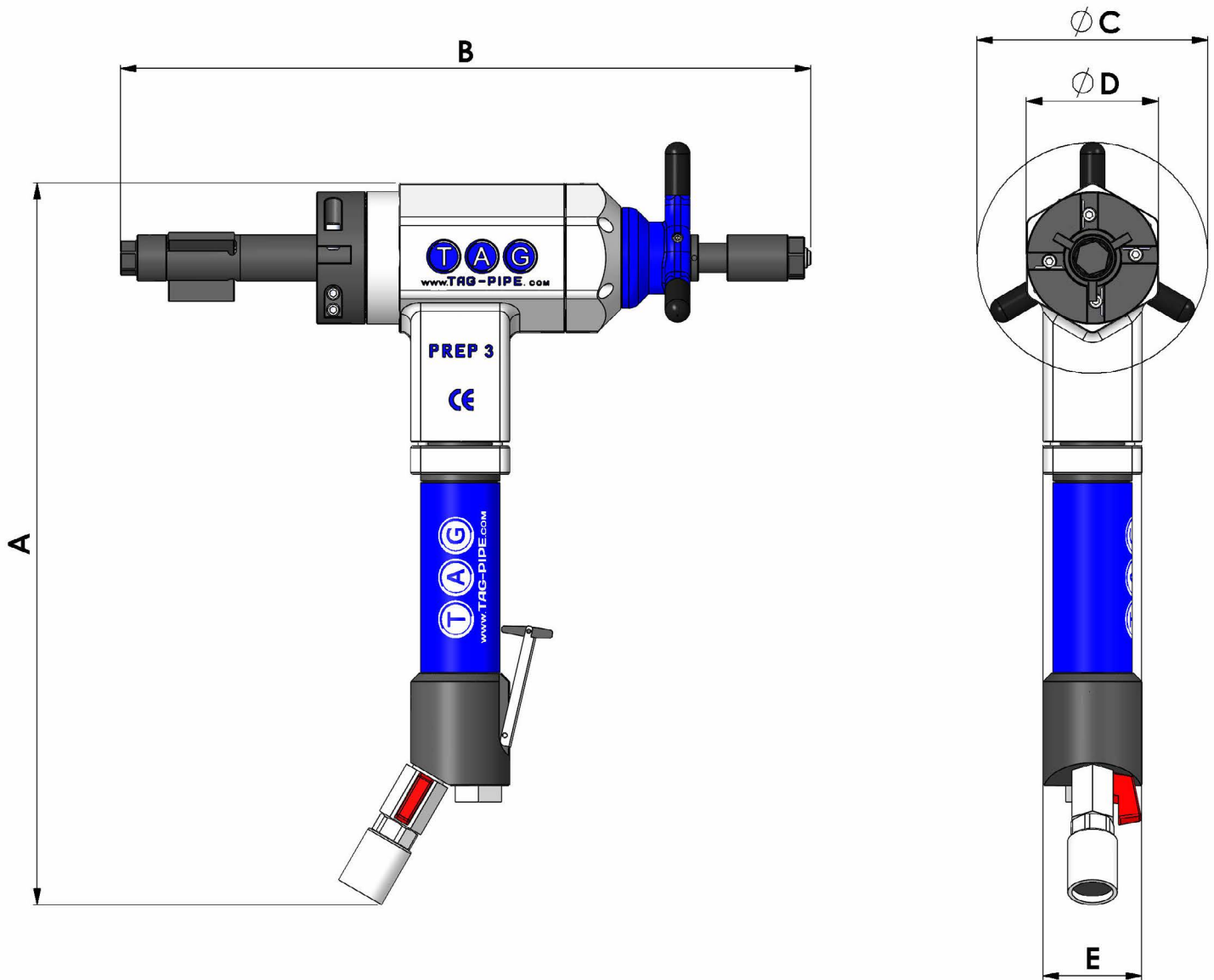


MILLING HEADS



6 - MACHINE TECHNICAL DATA

The TAG PREP 3 dimensional specifications.



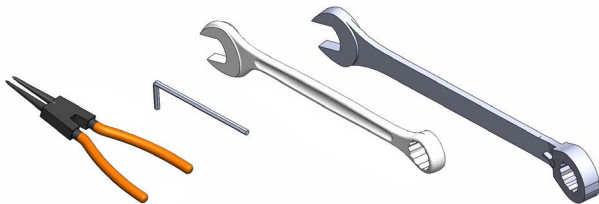
DIM	PNEUMATIC	ELECTRIC	BATTERY
A	435 mm	500 mm	530 mm
B	402 mm	402 mm	402 mm
Ø C	140 mm	140 mm	140 mm
Ø D	80 mm	80 mm	80 mm
E	60 mm	90 mm	90 mm

PREP 3 TECHNICAL FEATURES

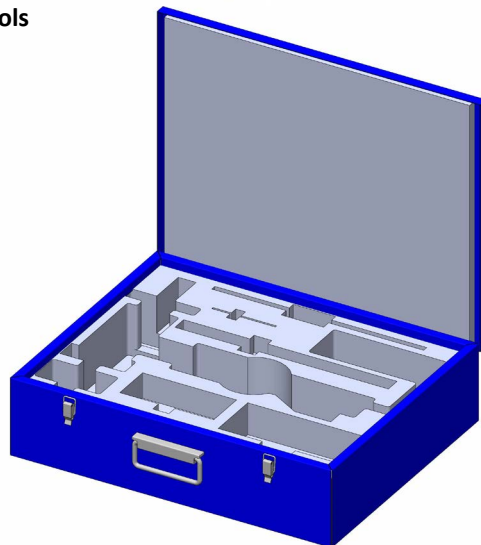
DESCRIPTION	MEASUREMENT	PNEUMATIC	ELECTRIC	BATTERY
Part Number	n/a	TP3P	TP3E110 / TP3E220	TP3B110 / TP3B220
Locking tube range	mm (i/d)	28 - 76 optional from 20	28 - 76 optional from 20	28 - 76 optional from 20
Locking tube range	inch (i/d)	1 - 3" optional from 0.8"	1 - 3" optional from 0.8"	1 - 3" optional from 0.8"
Idle speed	rpm	5 - 120	5 - 82	23 / 37 / 50
Torque	N m	140	152	140
Length of axial feed	mm	40.5	40.5	40.5
Maximum operating temperature	°C	55	55	55
Maximum acoustic radiation	dB	75	75	75
Pneumatic motor power	hp	1.35	n/a	n/a
Air consumption	cfm / l/min.	36 / 1020	n/a	n/a
Air working pressure	psi / bar	90 / 6.5	n/a	n/a
Air hose connection	inches	½"	n/a	n/a
Electric motor power	watt	n/a	1300	800
Voltage	volt	n/a	110 or 220	charger 110 or 220
Frequency	Hz	n/a	50 / 60	charger 50 / 60
Unit weight	kg / lbs	8.9 / 19.5	9.9 / 22	10.4 / 23
Packing dimensions	mm	640 x 500 x 140	640 x 500 x 140	640 x 640 x 140
Packing weight	kg / lbs	23 / 51	24 / 53	25 / 55

Our group policy is one of continuous improvement. Products and Data Tables are subject to change or vary from those illustrated.

7 - MACHINE STANDARD EQUIPMENT



Service Tools



Metal Case

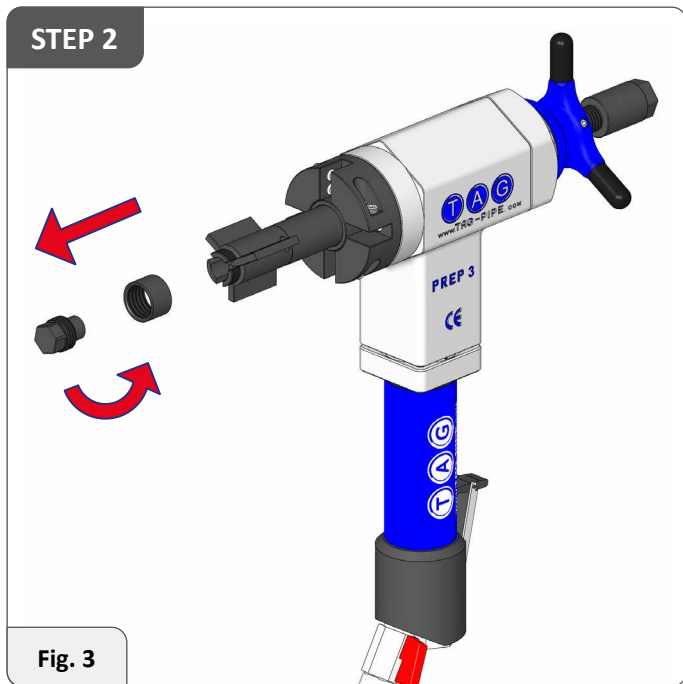
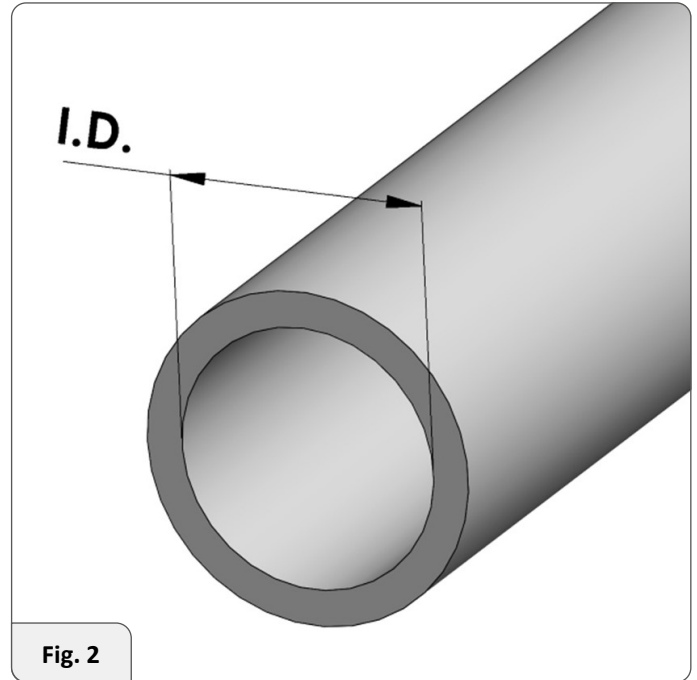


User Manual

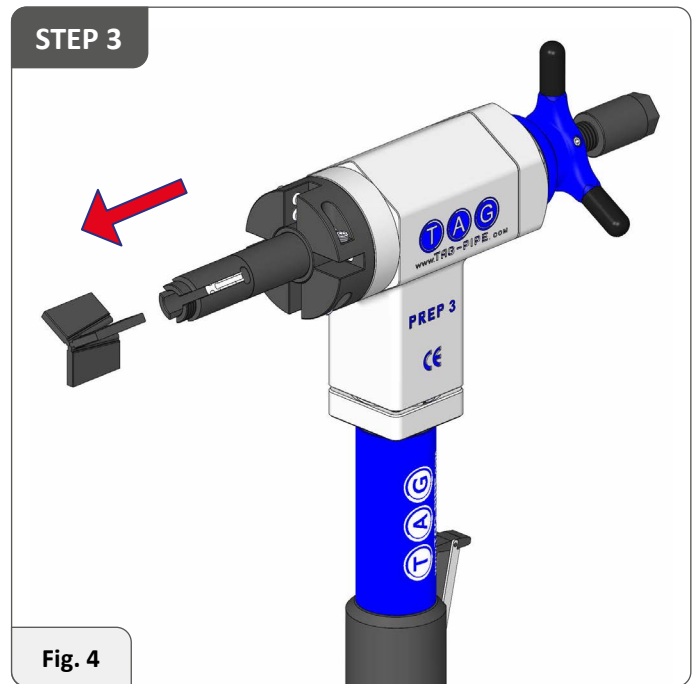
8 - MACHINE SETUP AND OPERATION

8.1 - PREP LOCKING JAWS

Prior to mounting the PREP it is important to measure the inside diameter (in short: i/d) of the workpiece.

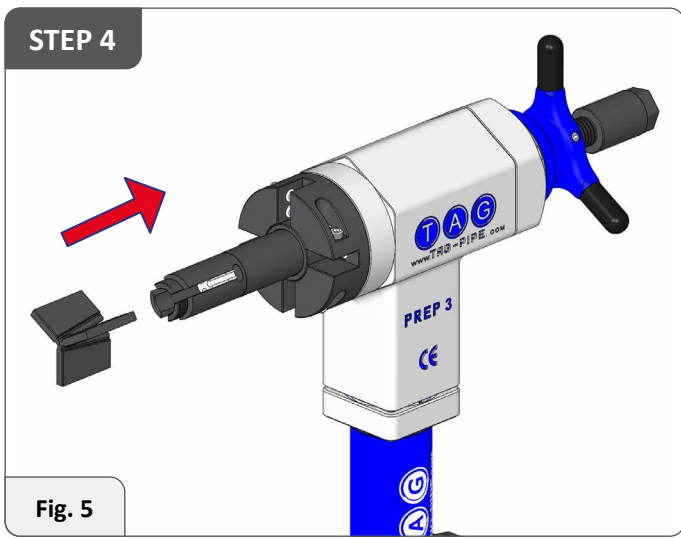


Unscrew the shaft end nut and the shaft ring anti-clockwise.

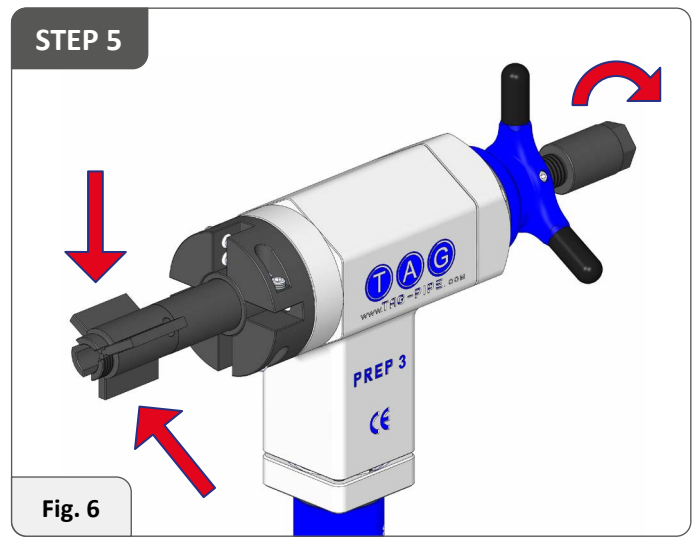


Remove the locking jaws you want to replace.

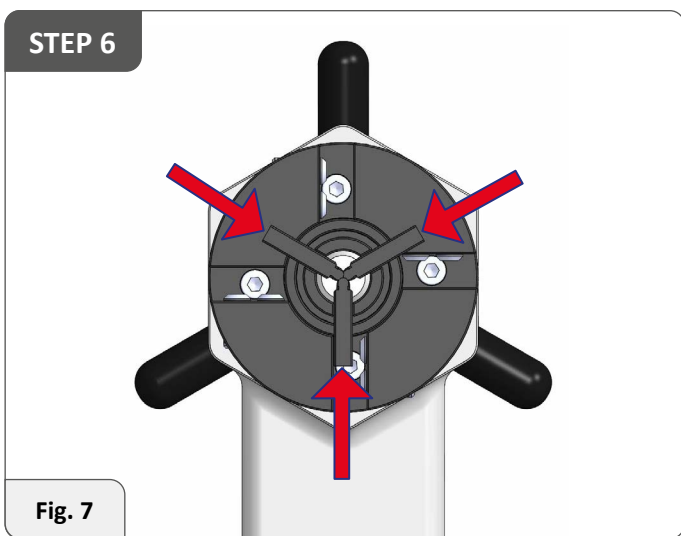
⚠ WARNING - DO NOT MOVE THE INSIDE SHAFT The inside shaft can be moved by the vane expansion nut after having replaced the locking jaws.



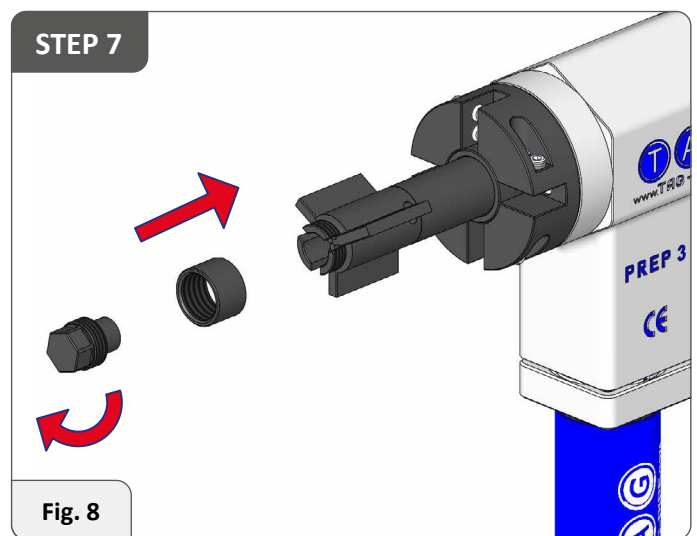
Select the locking jaws according to the diameter of the pipe and install them on the inside shaft as shown in Fig. 5.



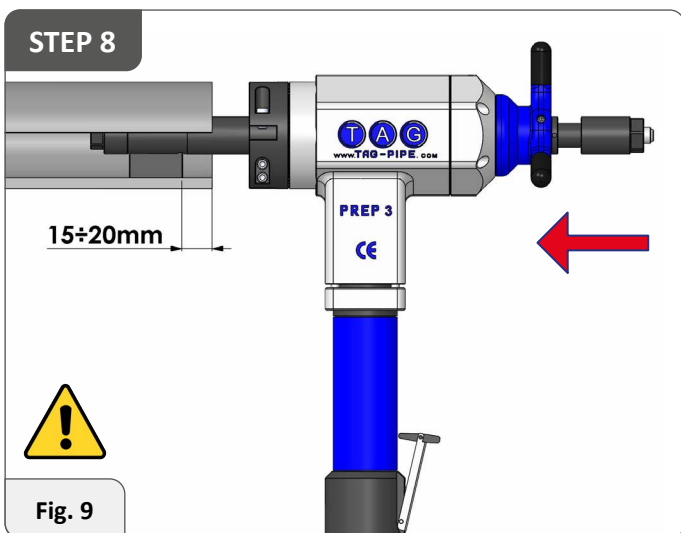
While holding the three locking jaws you have just mounted, screw the lock/unlock nut in order to let them enter their seat.



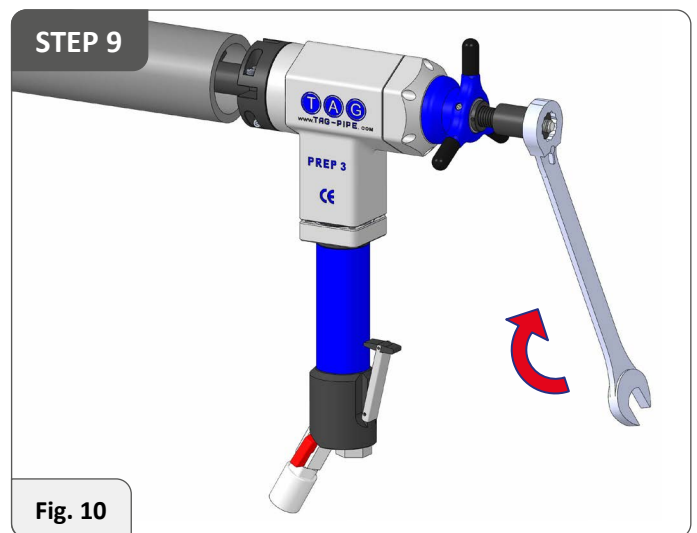
If the procedure is correctly made the locking jaws should have a little play.



Screw back on the shaft ring nut clockwise all the way down and then the shaft end nut.



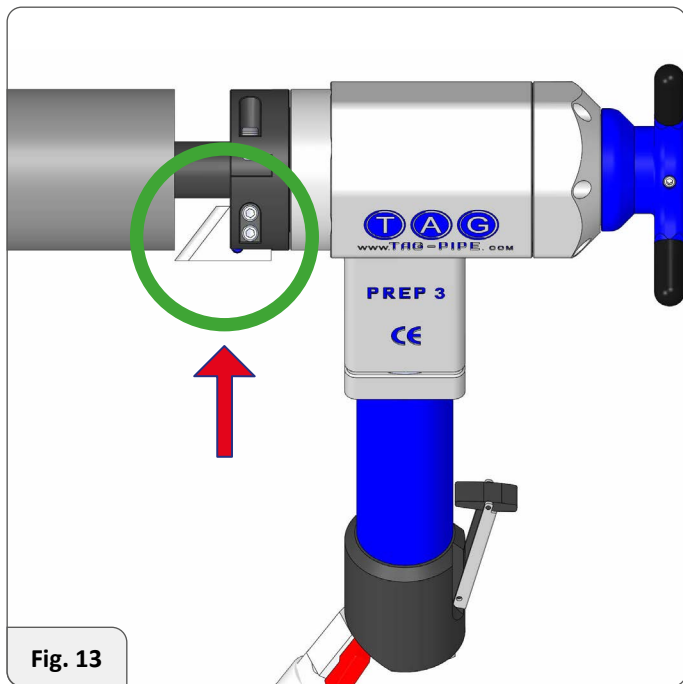
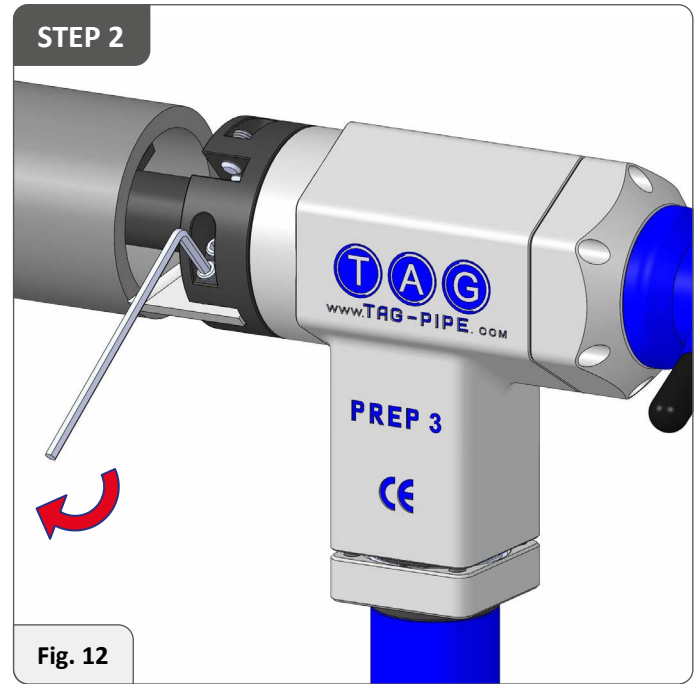
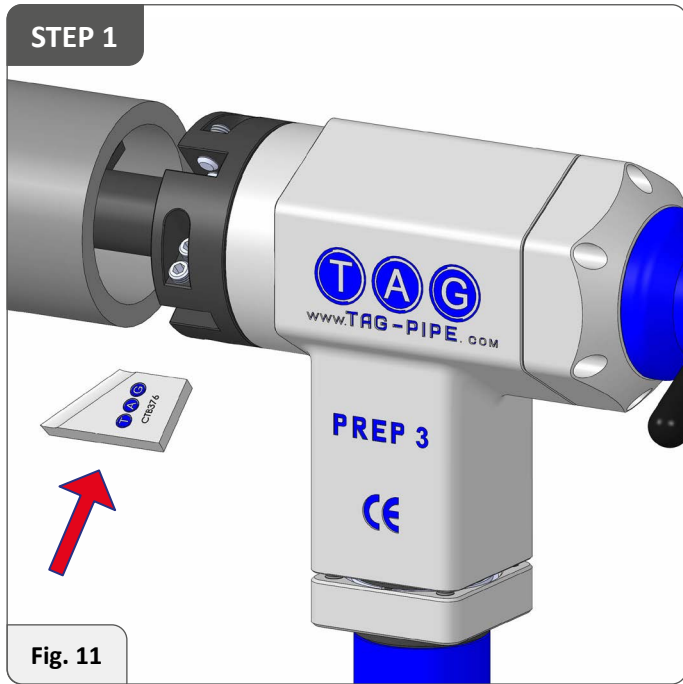
WARNING - In order to achieve the perfect positioning and locking, the jaws have to be inserted in the i/d at least $15 \div 20$ mm as shown in the picture (Fig. 9).



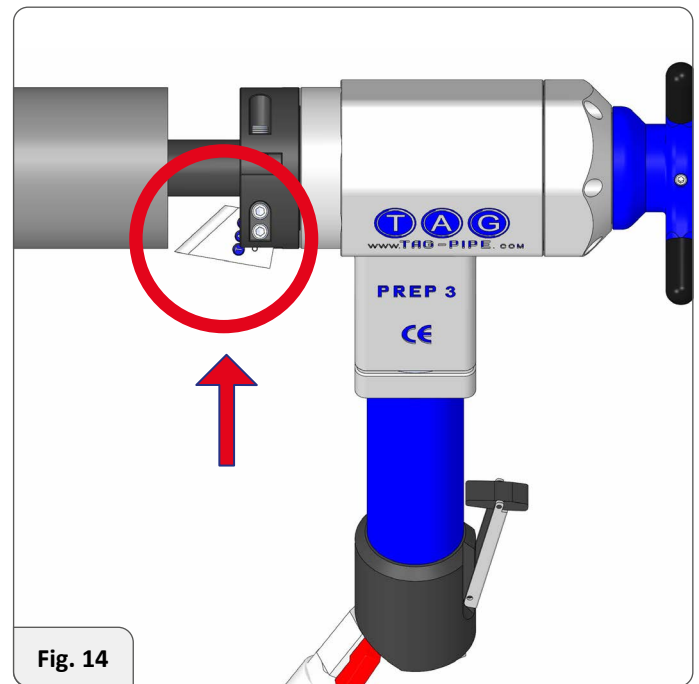
Keep the machine aligned with the axis of the pipe and fasten the lock/unlock nut tightly with a wrench turning it clockwise.

8.2 - TOOLS SETUP

Select the bevelling tool in regard to the bevel you need to perform and insert it on the chuck locking it with the grub screws by using the Allen key. You will need to use paired cutting tools and one facing tools when required.



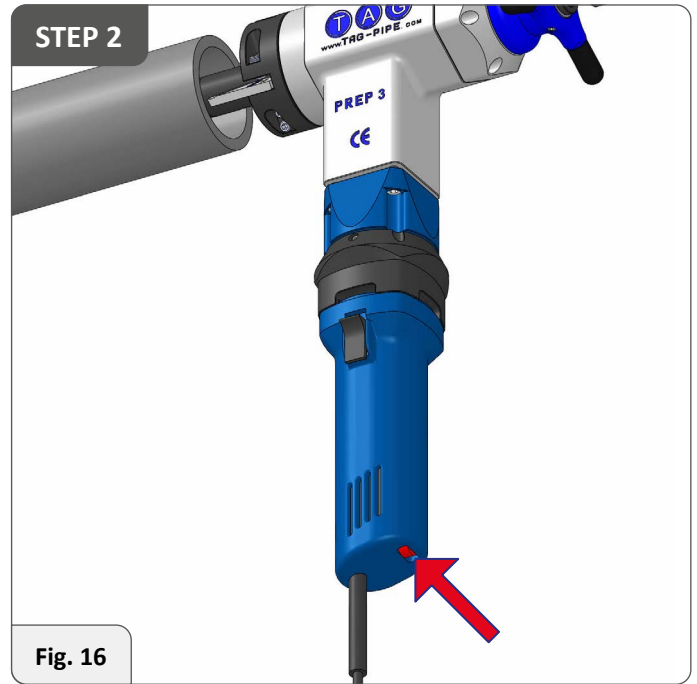
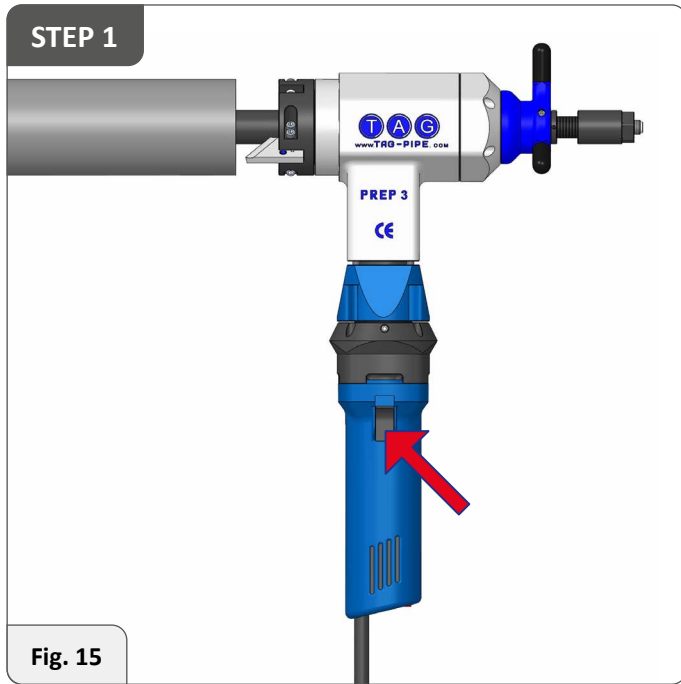
YES



NO

8.3 - OPERATION

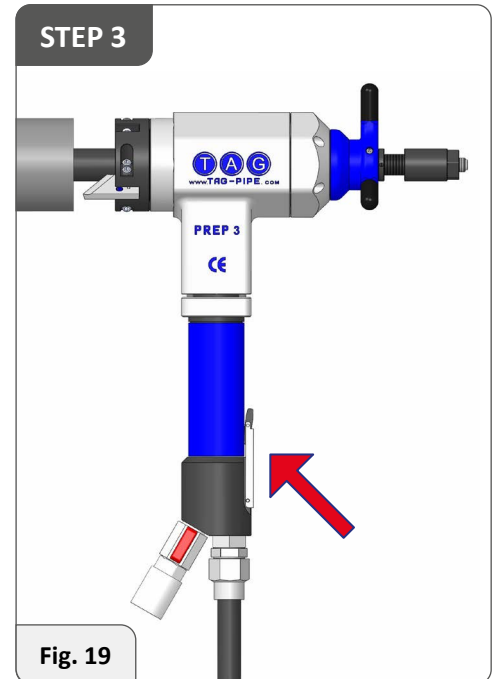
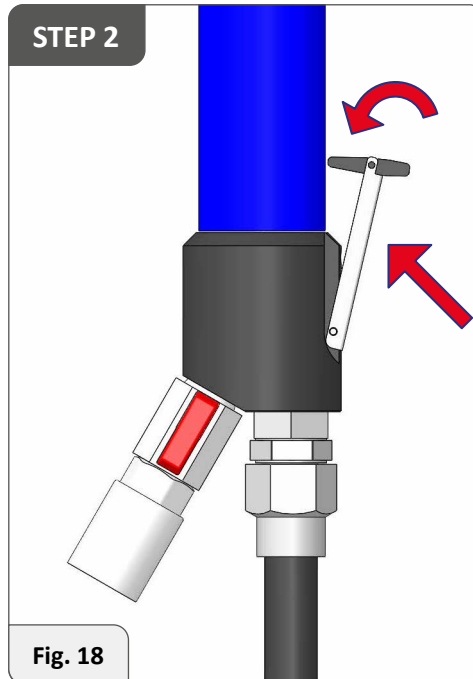
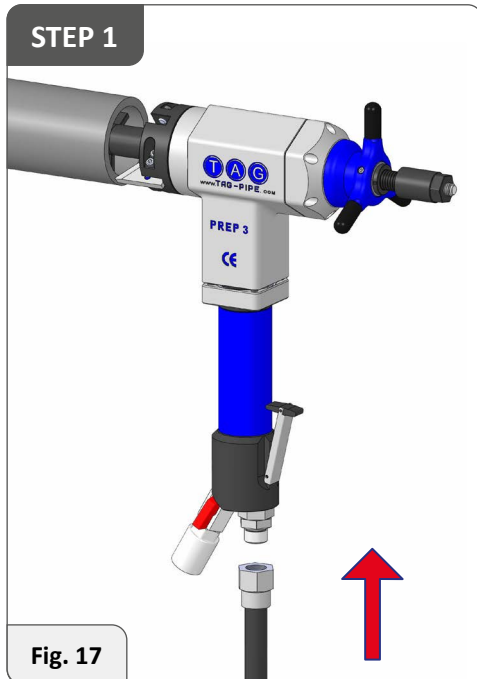
ELECTRIC MODEL



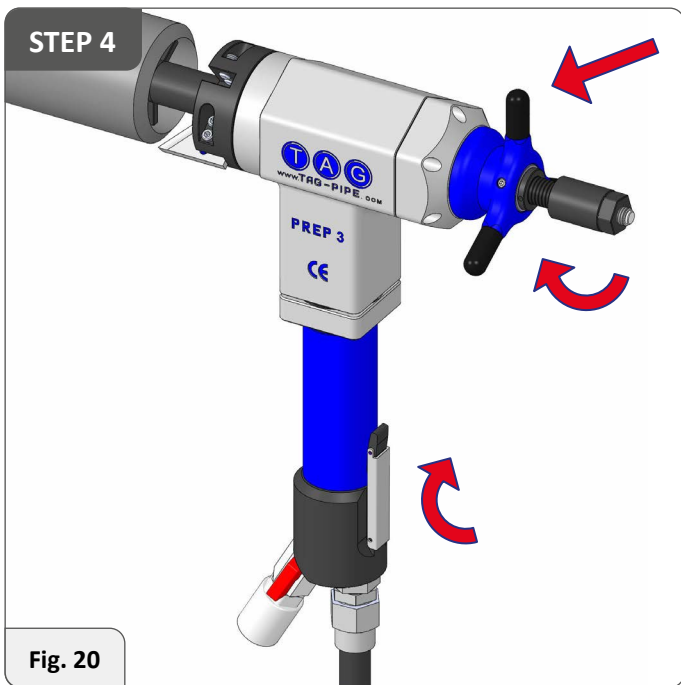
Connect the cable to the 220V/110V and actuate the machine by pressing the switch shown by the arrows in the picture (Fig. 15). On the bottom of the electric motor (Fig. 16) there is the speed control dial to regulate the rpm on the chuck.

PNEUMATIC MODEL - Connect the air hose to the machine and to the air system.

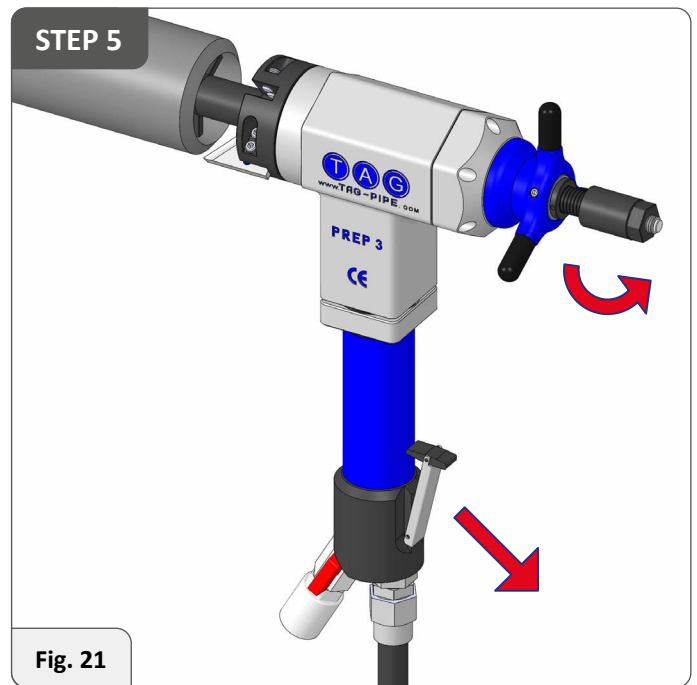
⚠ WARNING - Size of air hole ½" and air consumption 36 cfm or 1020 l/min. air working pressure 90 PSI or 6,5 BAR.



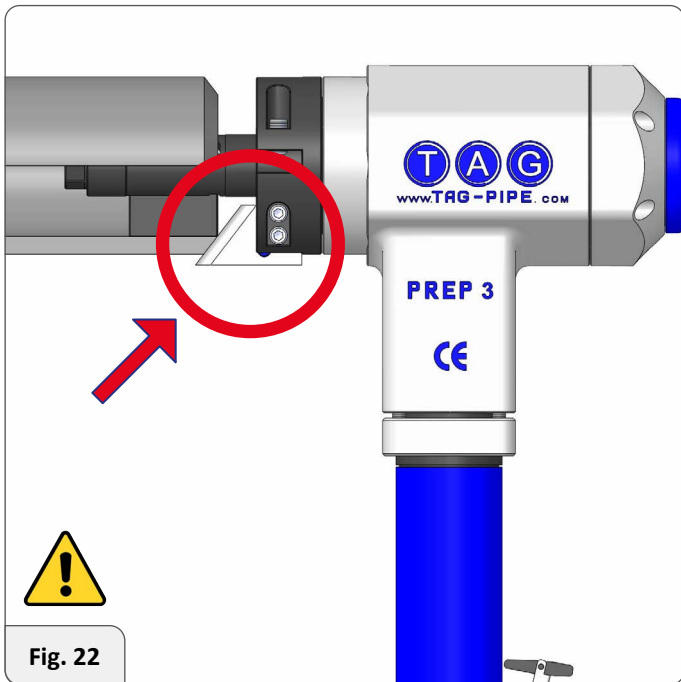
Actuate the machine by pressing the lever as shown by the arrows (Fig.18).



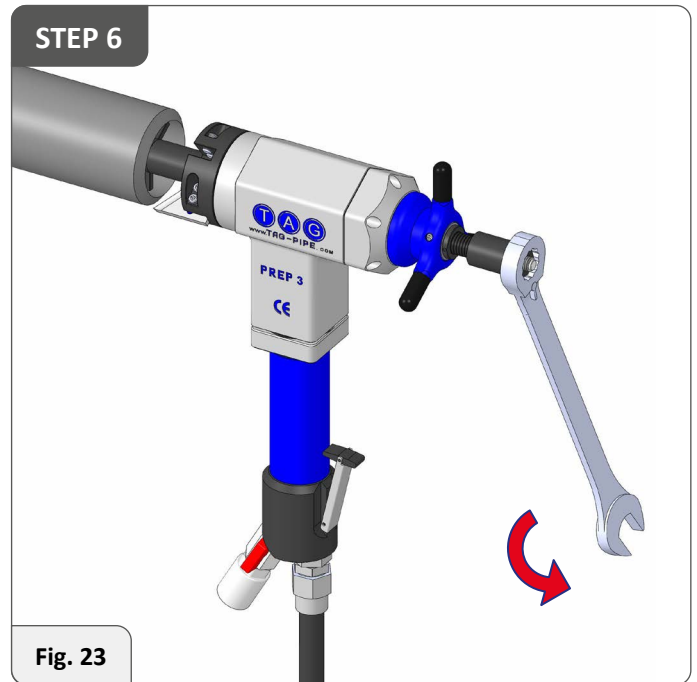
The machine feeding is achieved by acting on the hand wheel as shown in the picture (Fig. 20). For a perfect result it is important that you maintain a constant feeding rate.



When the job is finished, release the security lever and the machine will automatically stop.

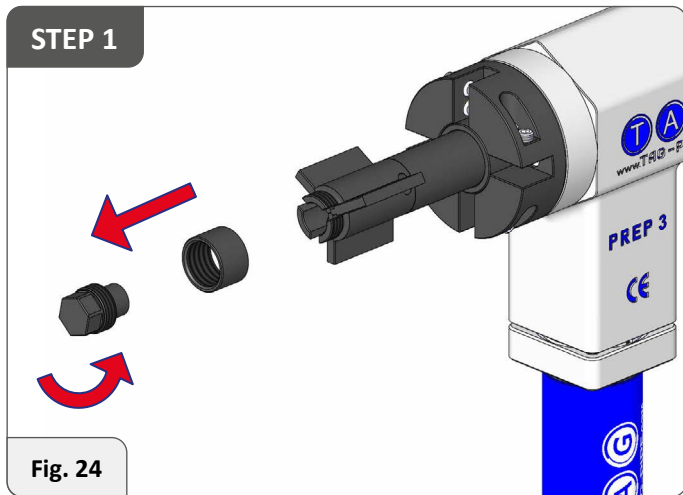


WARNING - During the operation, the beveling tool should never come in contact with the locking jaws as they may be damaged.

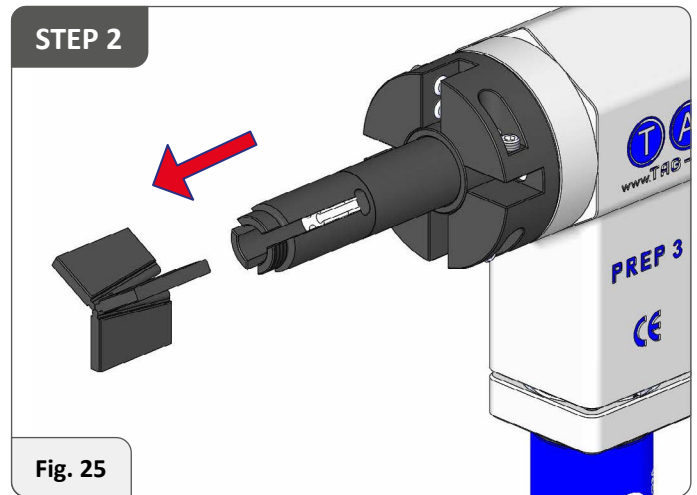


To remove the machine from the pipe unscrew the lock/unlock nut anti-clockwise using the wrench supplied with the machine.

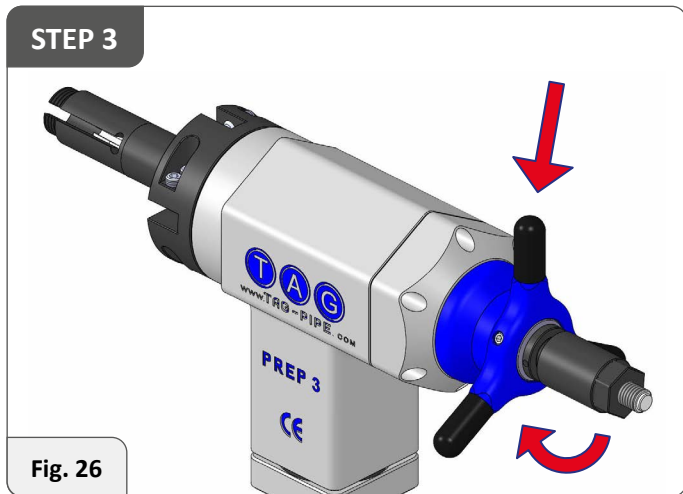
8.4 - REDUCED SHAFT ASSEMBLY KIT



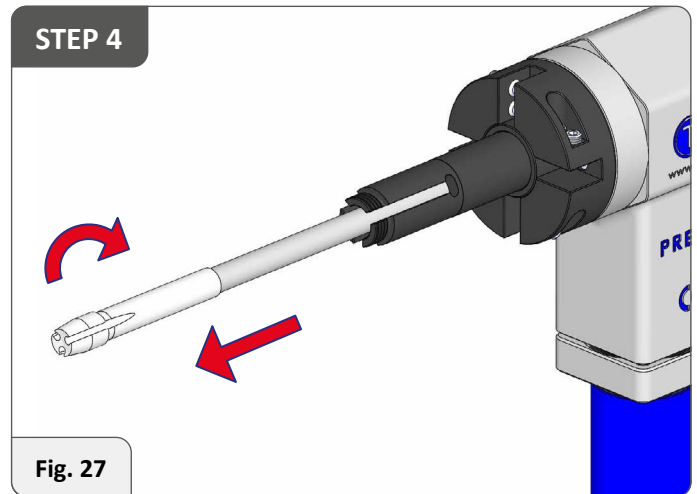
Unscrew the shaft end nut and the shaft ring anti-clockwise.



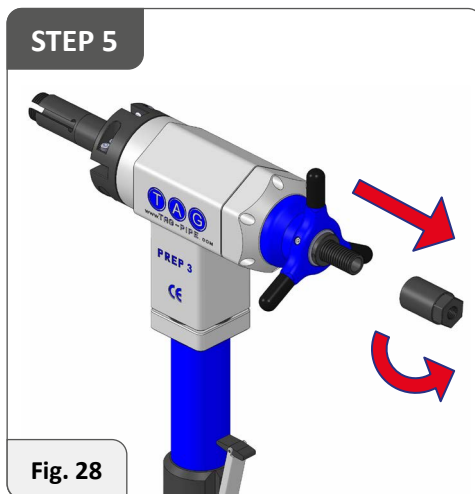
Remove the locking jaws.



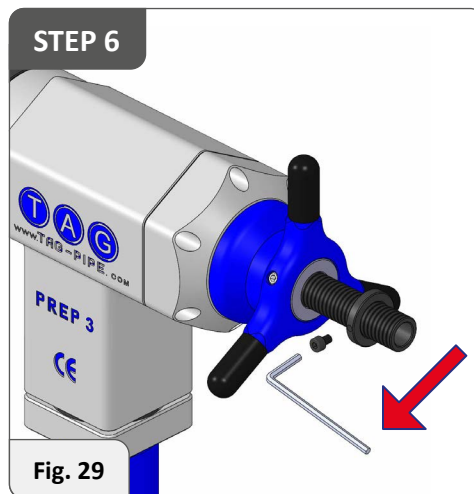
Rotate the lock/unlock nut in clockwise direction.



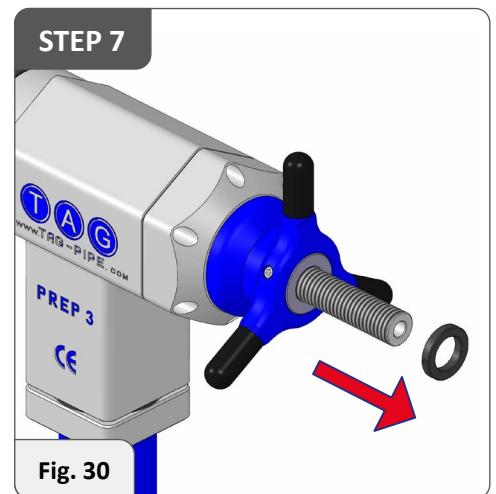
By using long nose pliers rotate the inside shaft clockwise until it comes out.

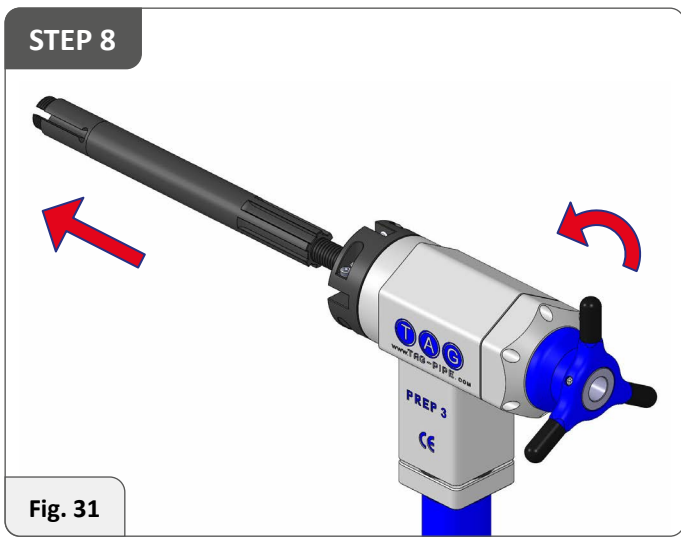


Rotate the lock/unlock nut in anti-clockwise direction.

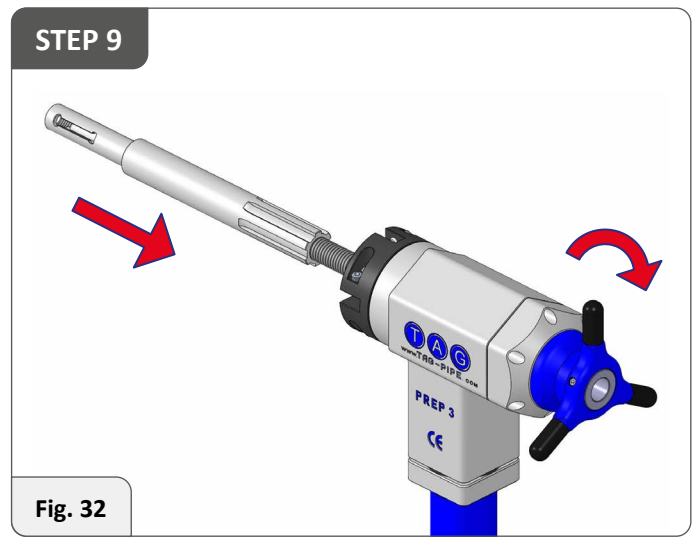


Remove the Allen screw from the ring and remove stop ring.

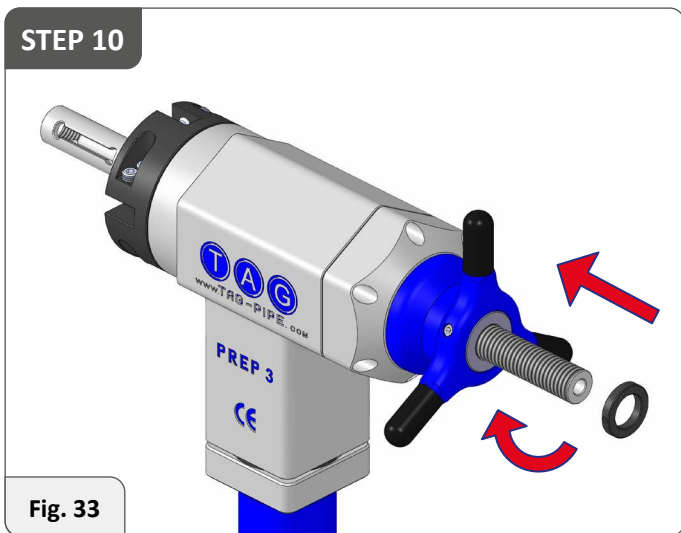




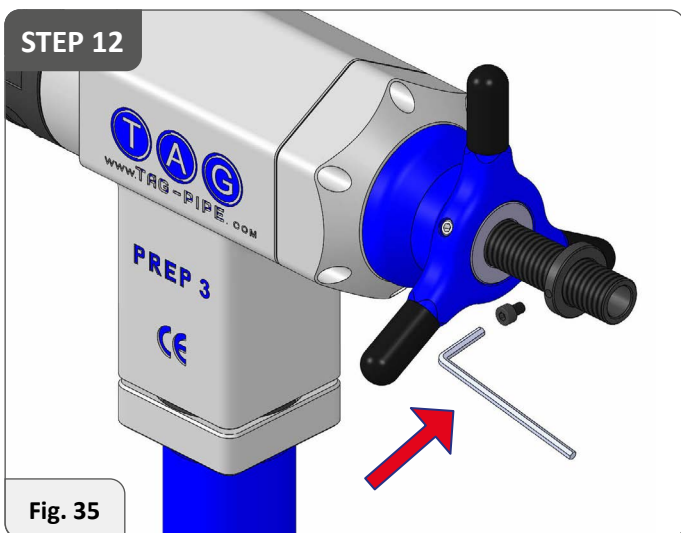
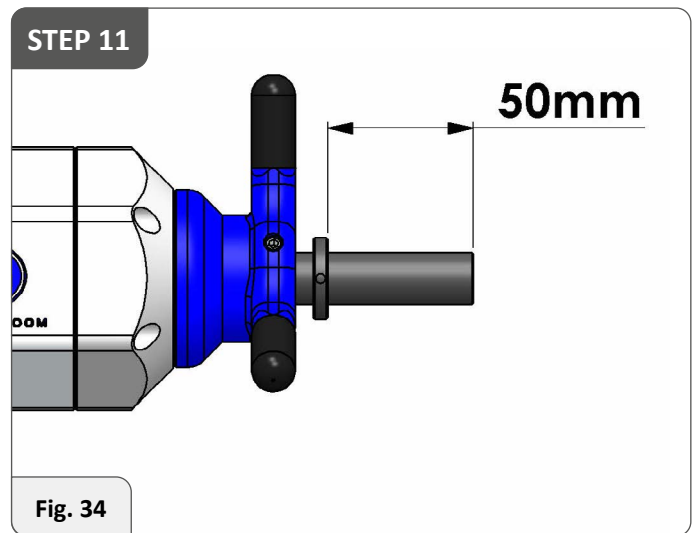
Remove the outside shaft by rotating the feeding wheel anti-clockwise.



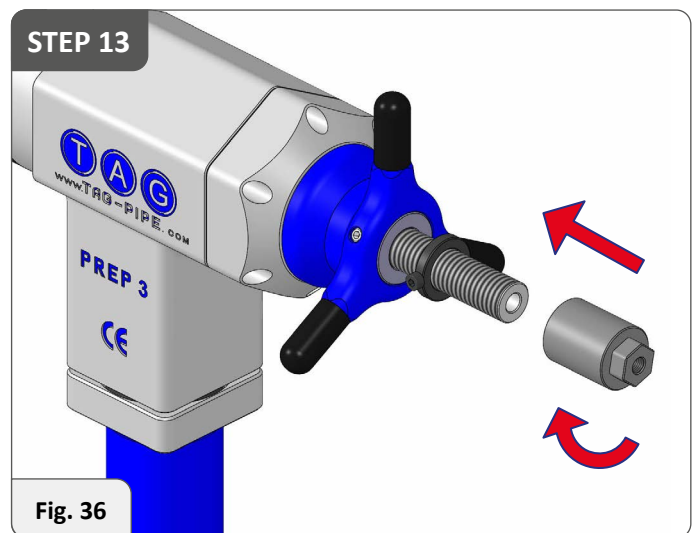
Take the outside shaft from the reduced shaft kit and screw in to the machine clockwise.



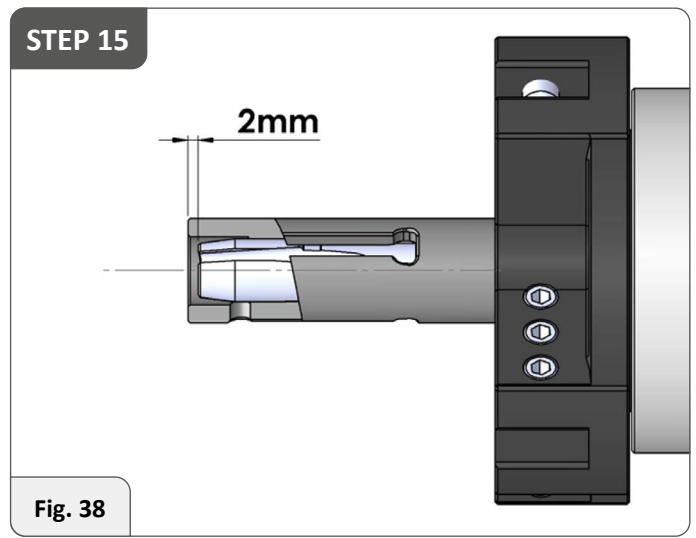
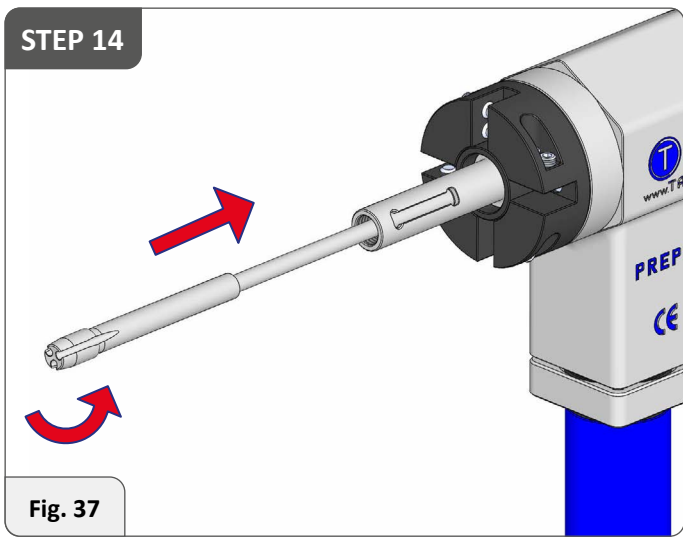
Screw on the stop ring clockwise at 50 mm from the edge (Fig.34).



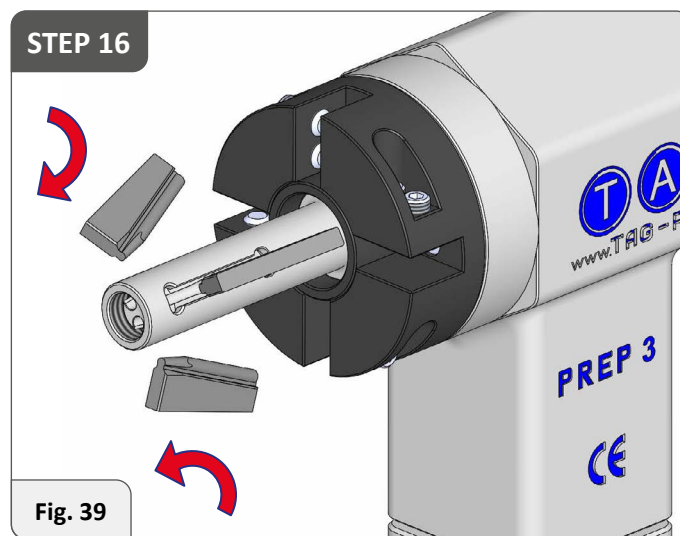
Lock the ring by screw and Allen key.



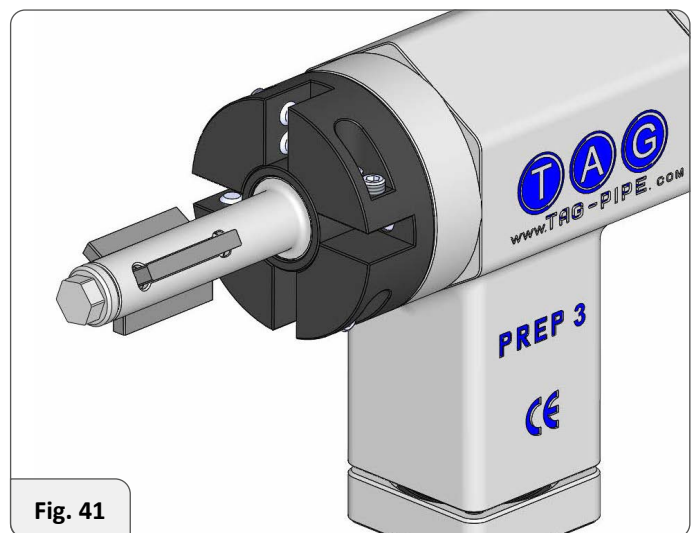
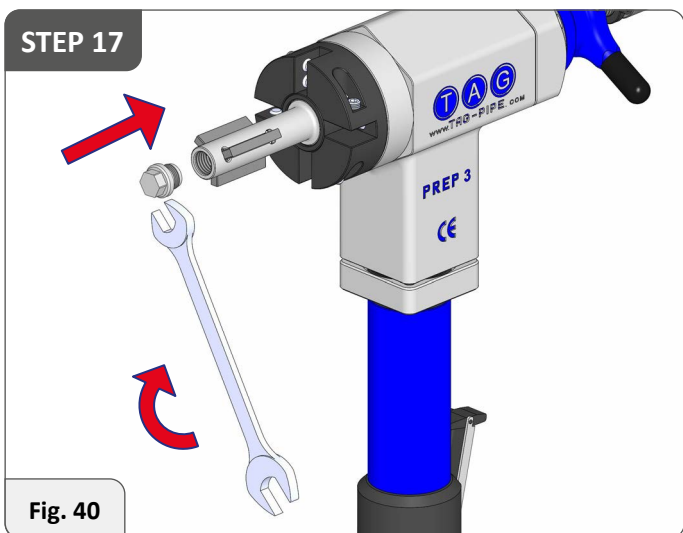
Screw the lock/unlock nut all the way down.



Insert the reduced inside shaft. By using the long nose pliers screw the inside shaft (left thread) anti-clockwise until it is positioned 2 mm inside from the end of the outside shaft as shown in the picture (Fig. 38).

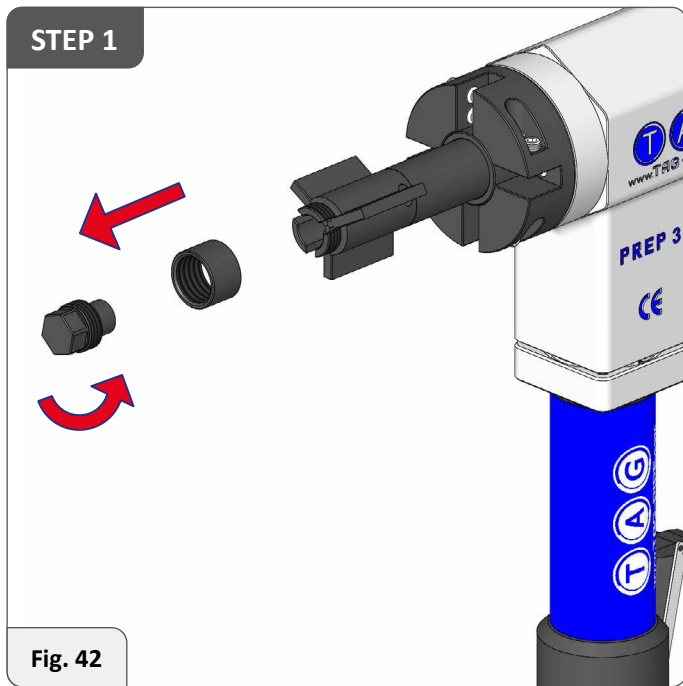


Select the correct locking jaws according to the inside diameter of the pipe you need to work on and place them in the shaft as shown in the picture.

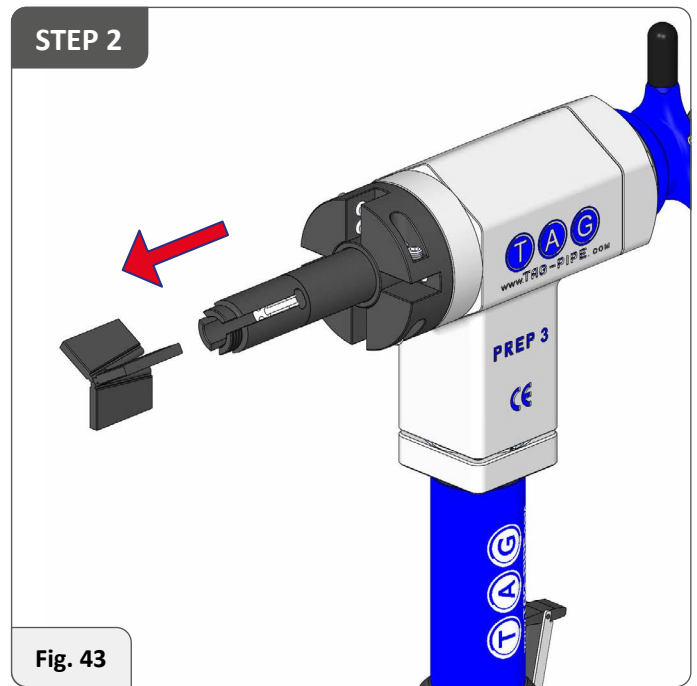


Pull back the locking jaws by rotating the lock/unlock nut in anti-clockwise direction and screw on the shaft stop nut.

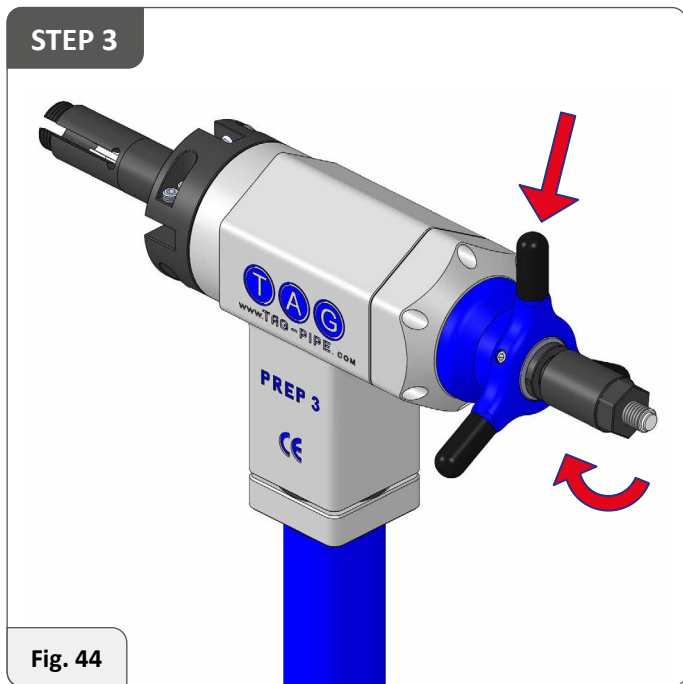
8.5 - ELBOW SHAFT ASSEMBLY KIT



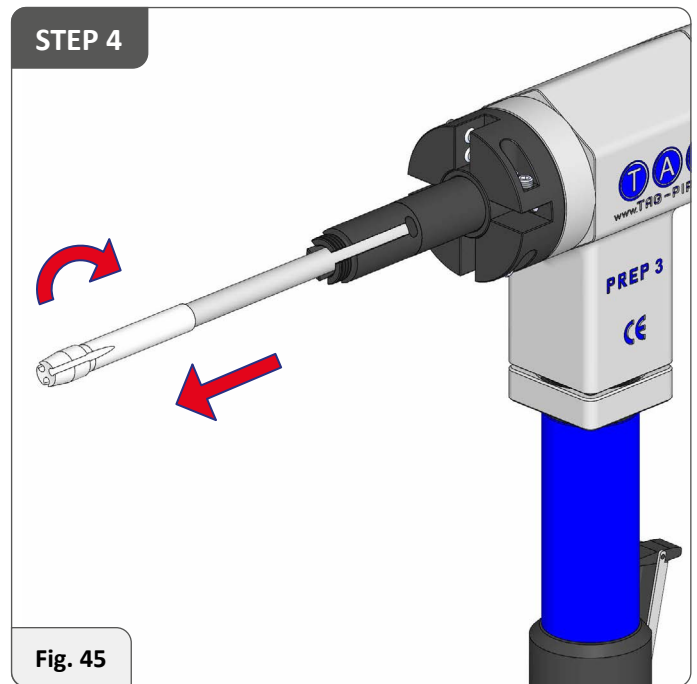
Unscrew the shaft end nut and the shaft ring anti-clockwise.



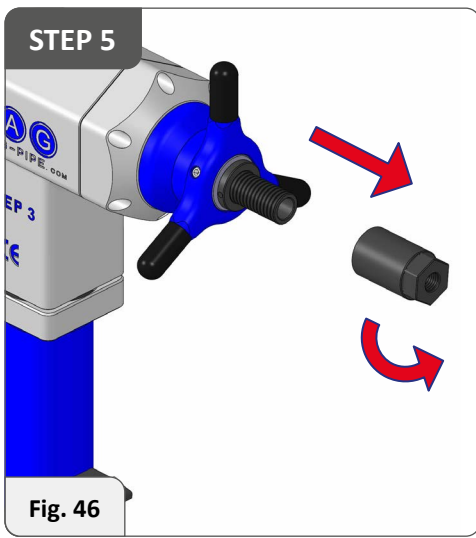
Remove the locking jaws.



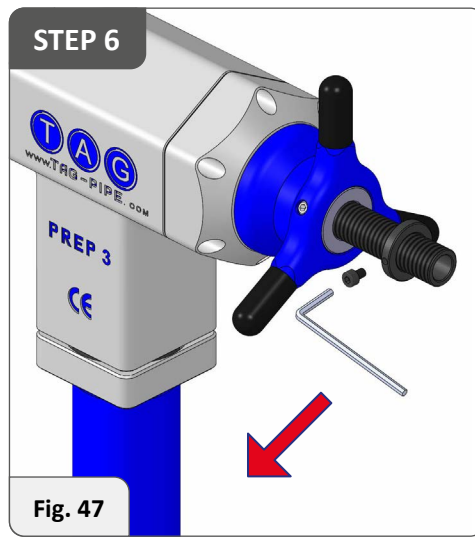
Rotate the lock/unlock nut in clockwise direction.



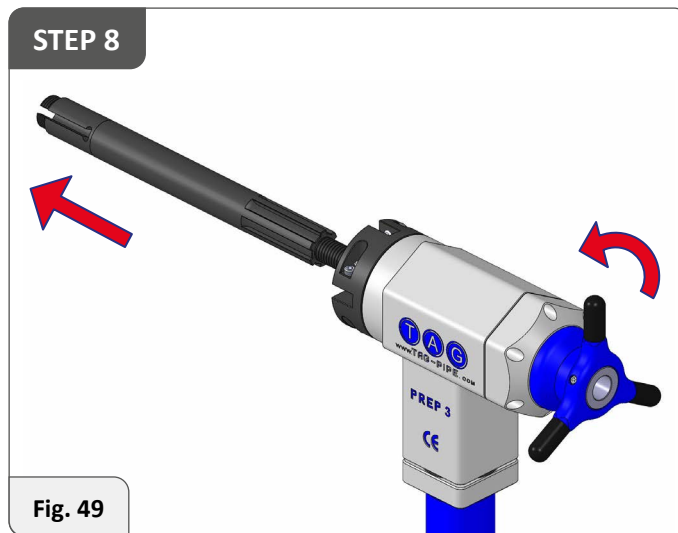
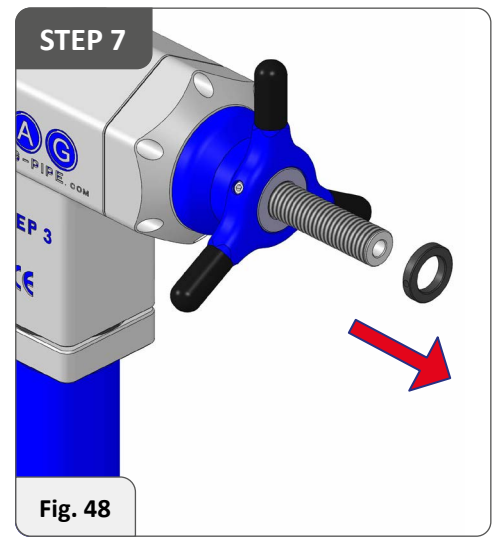
By using long nose pliers rotate the inside shaft clockwise until it comes out.



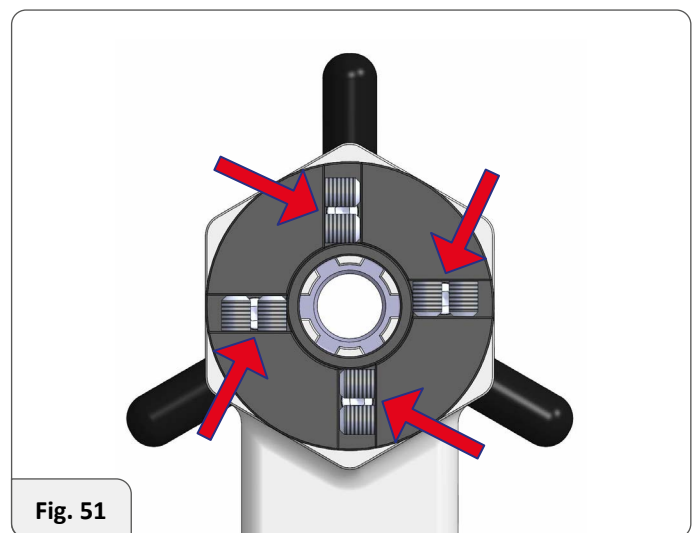
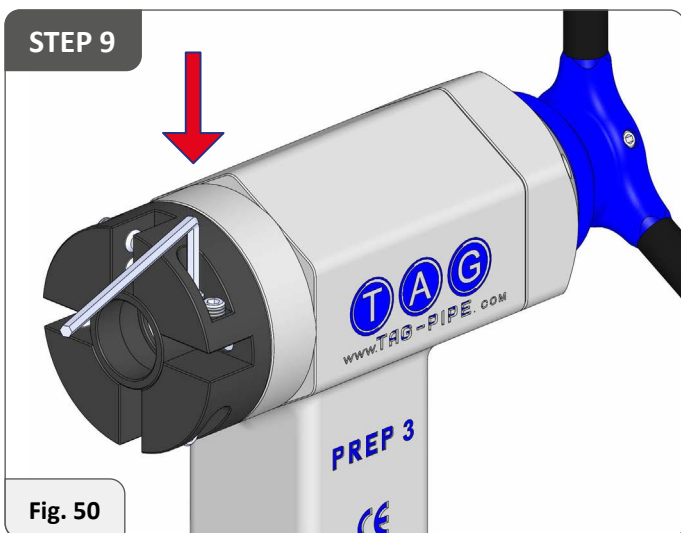
Rotate the lock/unlock nut in anti-clockwise direction.



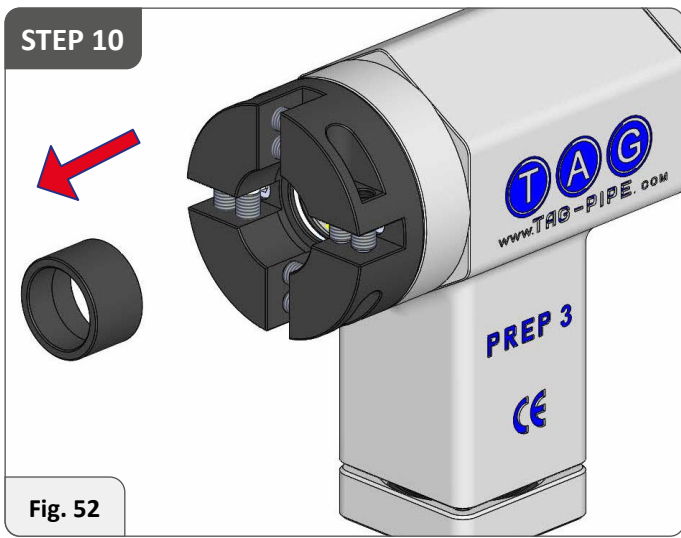
Remove the Allen screw from the ring and remove stop ring.



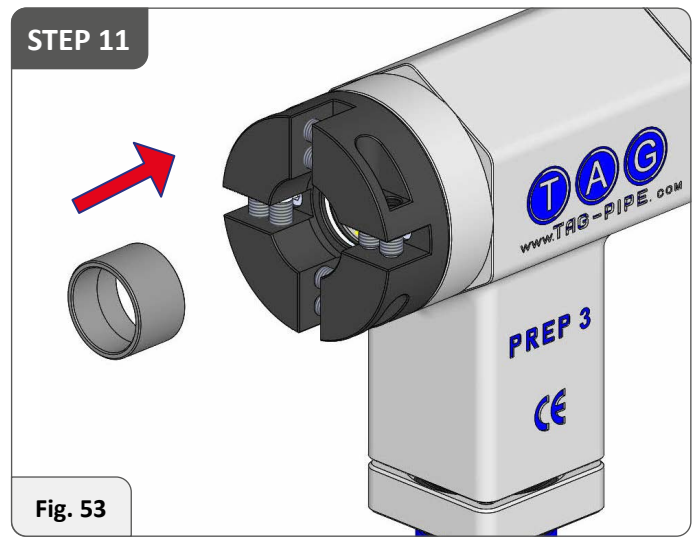
Remove the outside shaft by rotating the feeding wheel anti-clockwise.



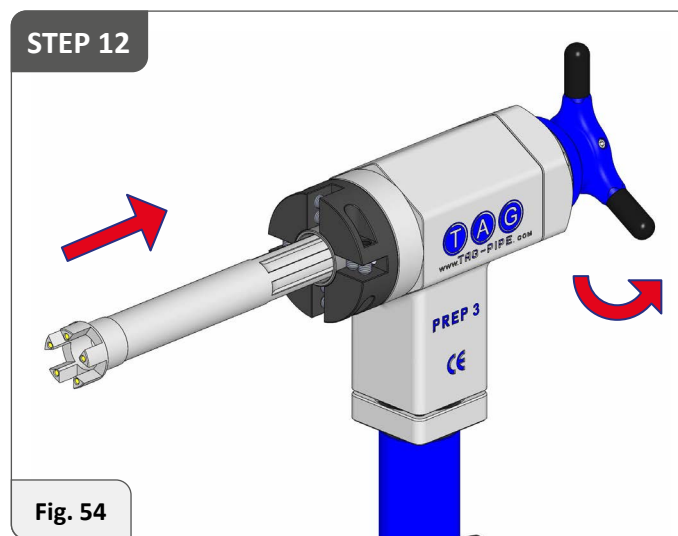
Screw in all grub screws tight to be able to take out the bush.



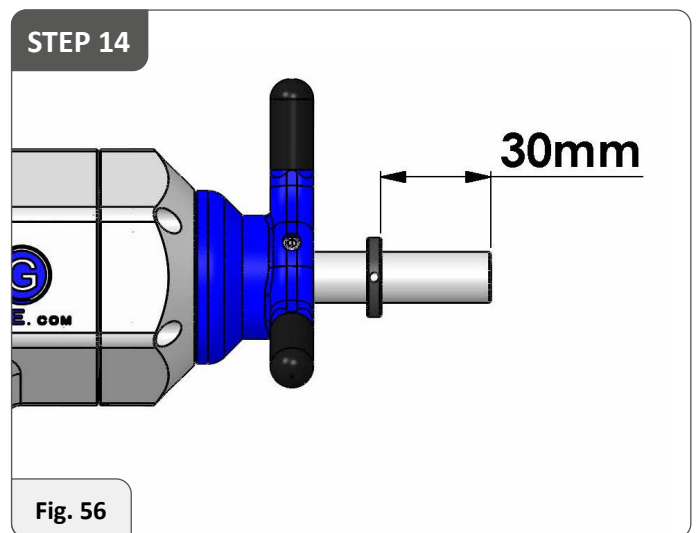
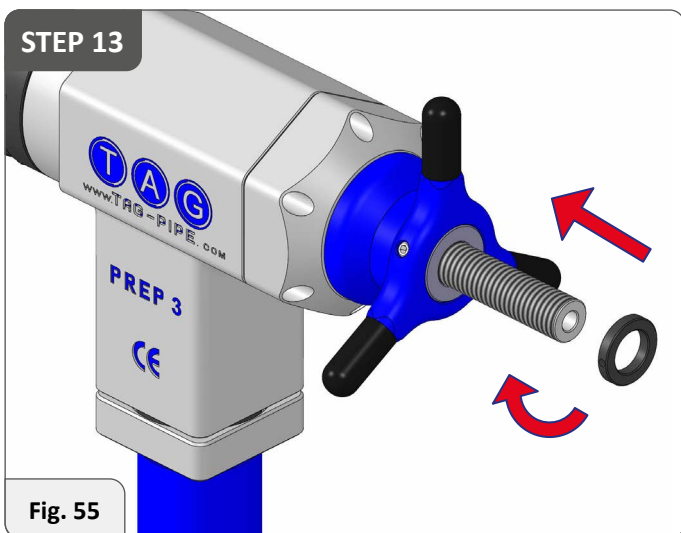
Take out the bush and change with the one from the elbow kit.



Put in the new bush from elbow kit.



Take the outside elbow shaft from the elbow kit and turn the feed wheel clockwise.



Screw on the stop ring clockwise at 30 mm from the edge (Fig. 56).

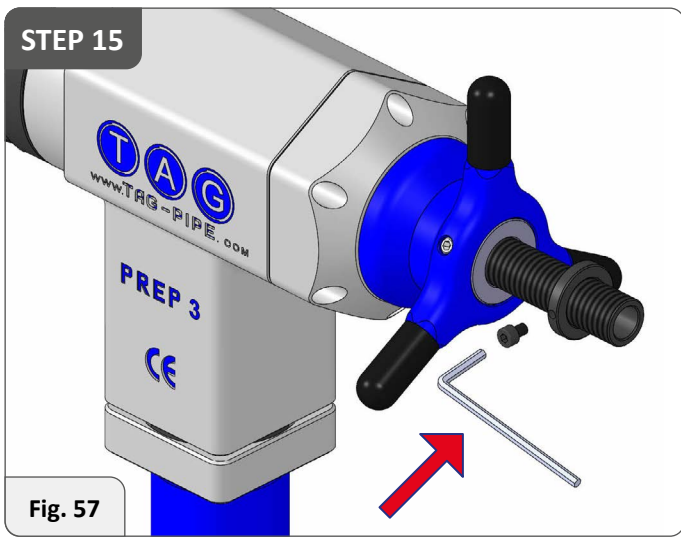


Fig. 57

Lock the ring by screw and Allen key.

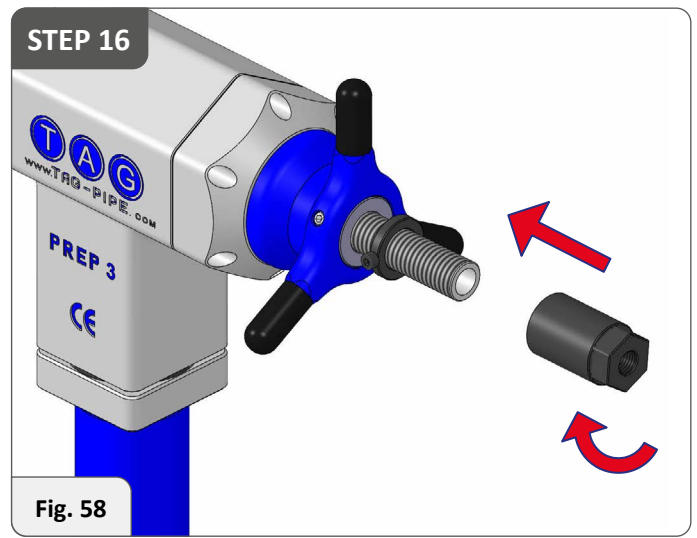


Fig. 58

Screw on the jaws lock/unlock nut 24 mm.

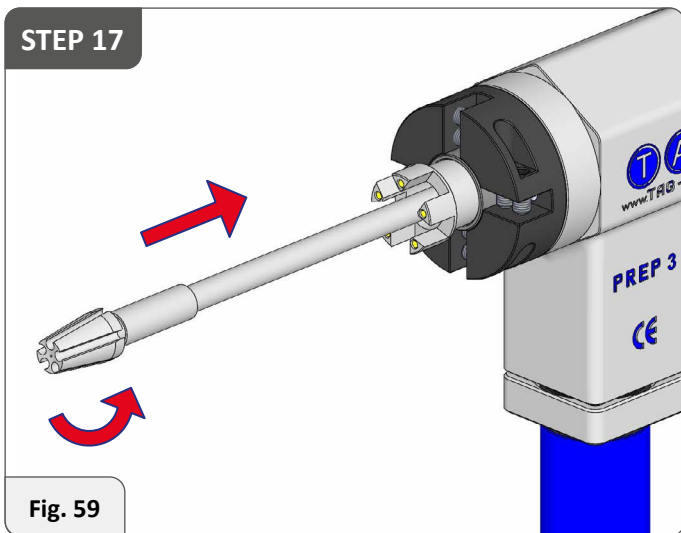


Fig. 59

Then insert the inside elbow shaft provided in kit (reverse threaded) anti-clockwise.

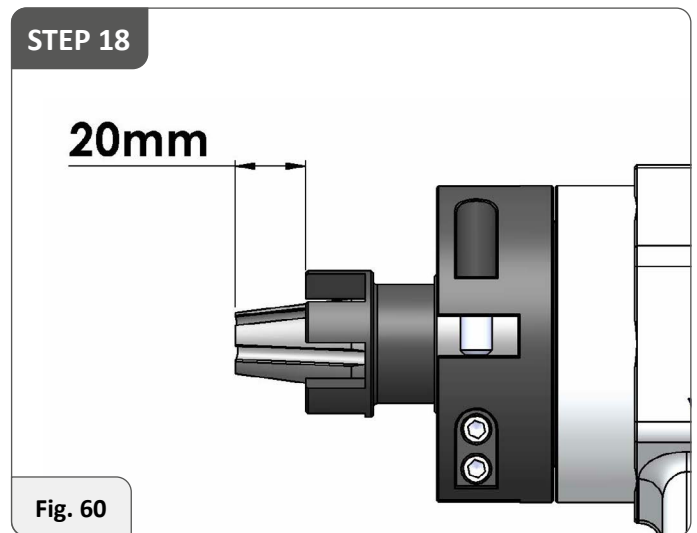


Fig. 60

Screw in anti-clockwise until have 20 mm from the top of inside shaft to the head of outside shaft.

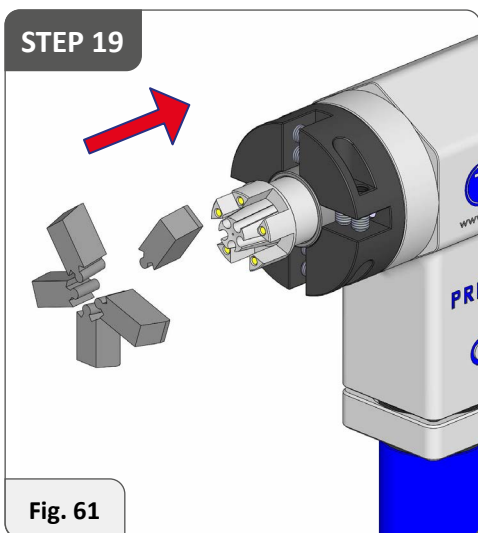


Fig. 61

Insert the locking jaws size required. Slot jaws into groove on inside shaft.

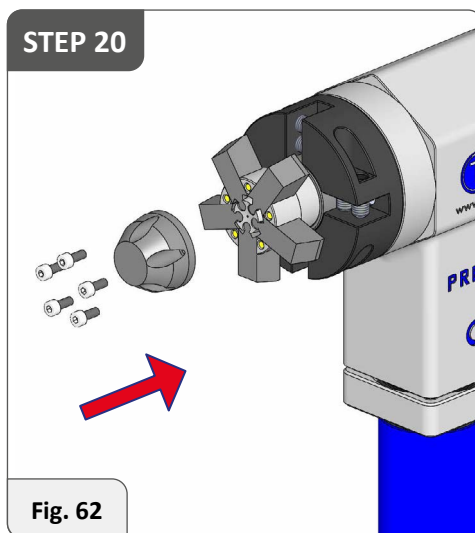


Fig. 62

Place the locking jaws securing cap on and tighten with 5 x screws.

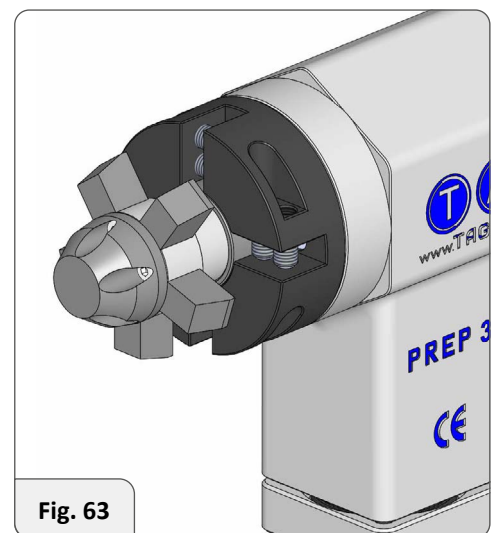
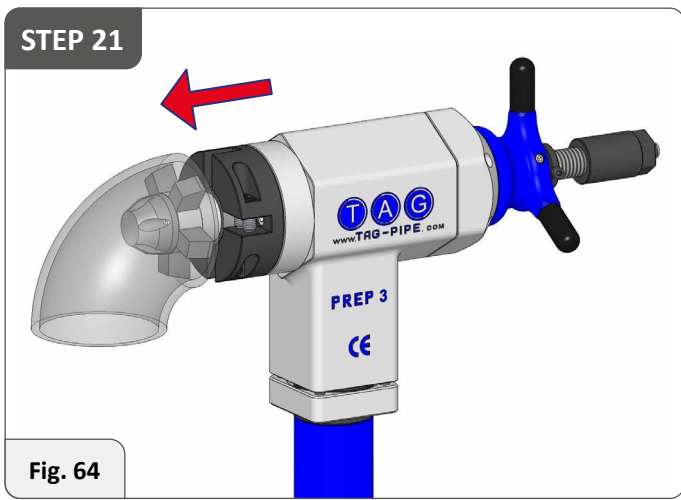
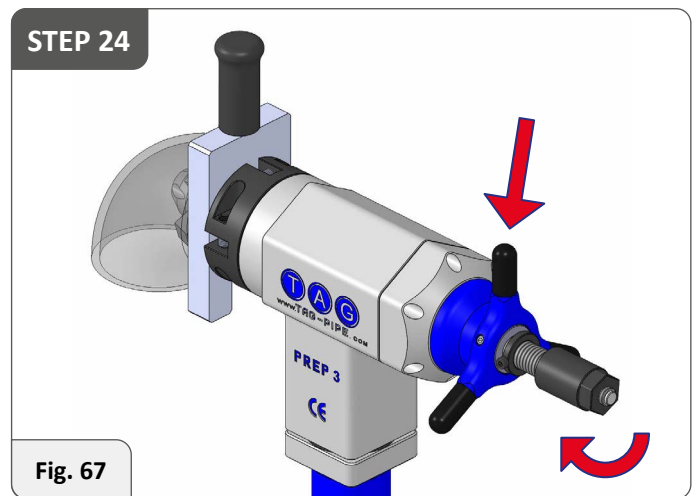
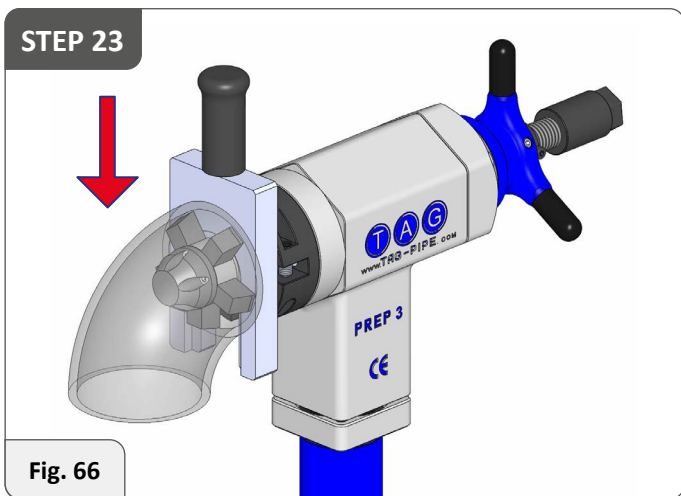


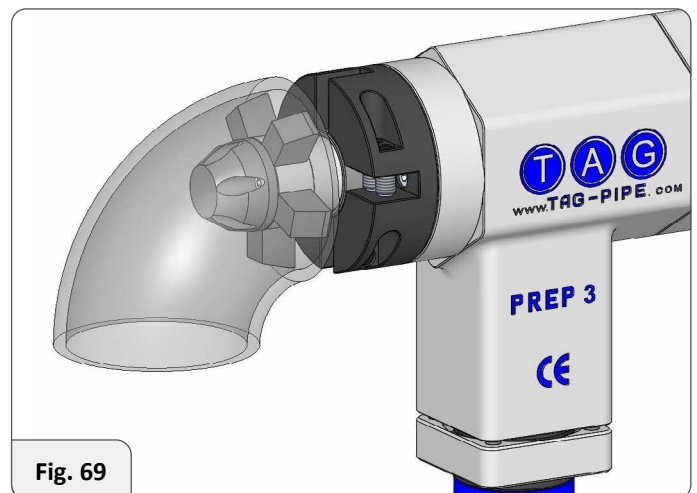
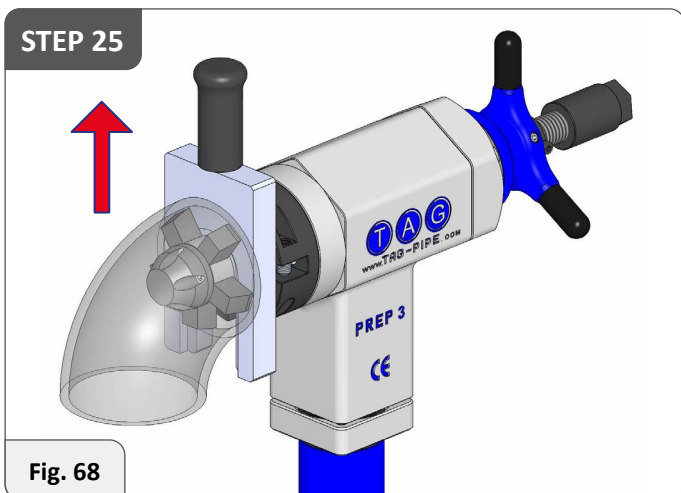
Fig. 63



Place the machine into the elbow and loosely lock clockwise.



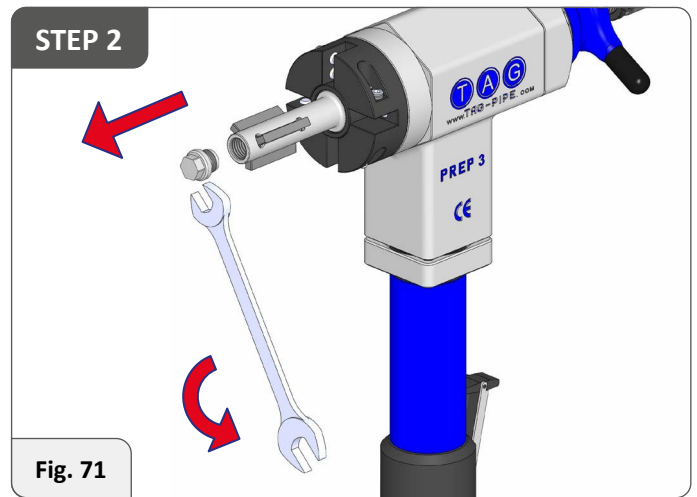
Insert the elbow positioner between elbow and chuck.
Turn the feed wheel clockwise tight to straighten the elbow in locking jaws then lock the lock/unlock nut.



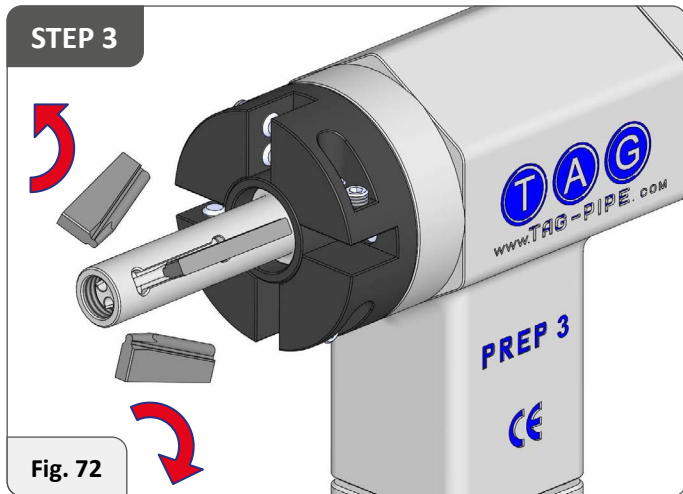
Loosen the feed wheel then remove elbow positioner.

⚠ WARNING - Now you can set up the cutting tools as shown in Fig. 11.

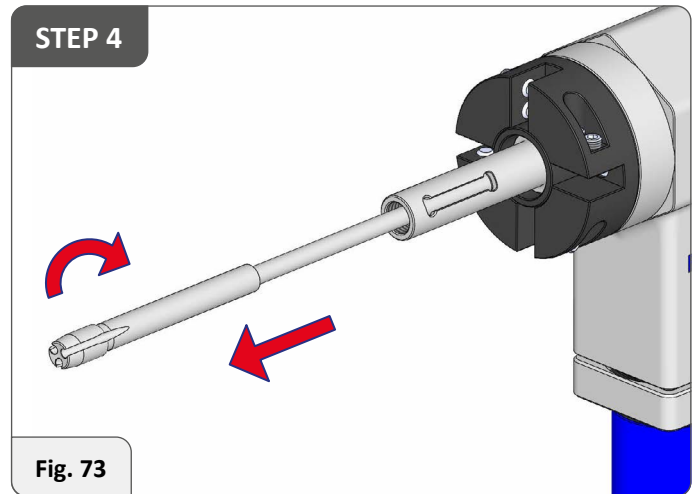
8.6 - STANDARD SHAFT ASSEMBLY KIT



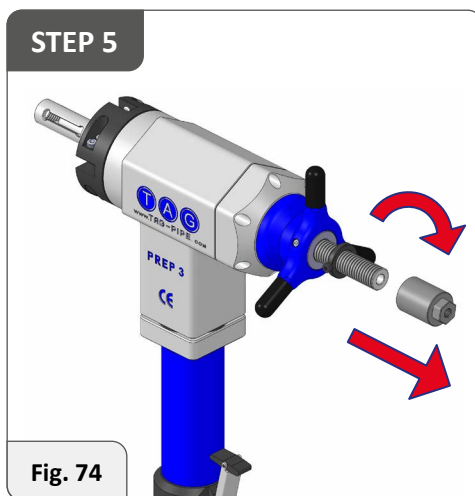
Unscrew the shaft stop nut anti-clockwise.



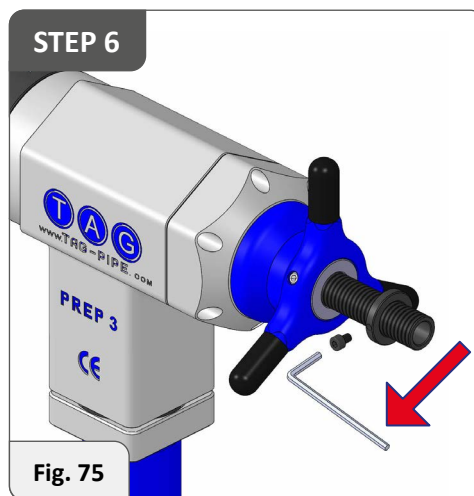
Remove the locking jaws.



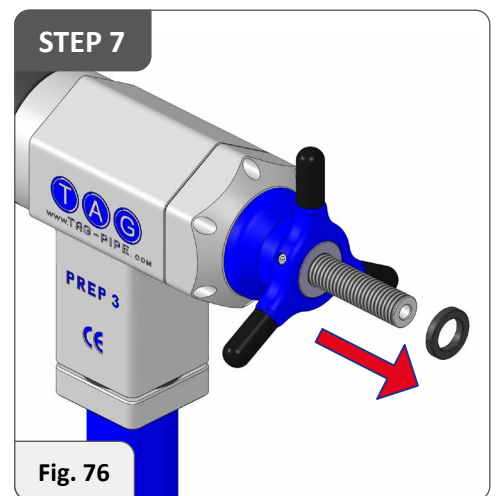
Remove the reduced inside shaft.

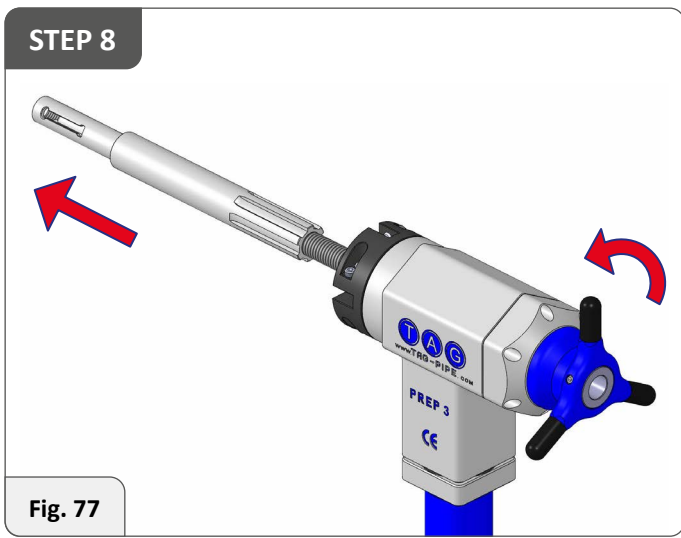


Unscrew the lock/unlock nut.

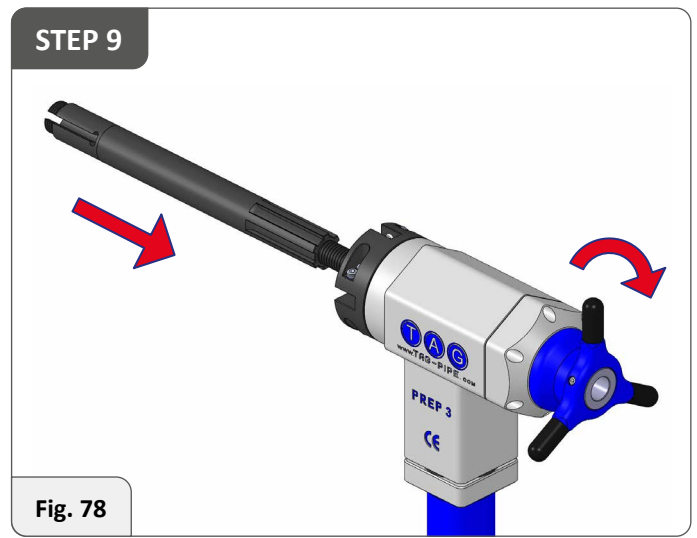


Remove the Allen screw from the ring and remove the stop ring.

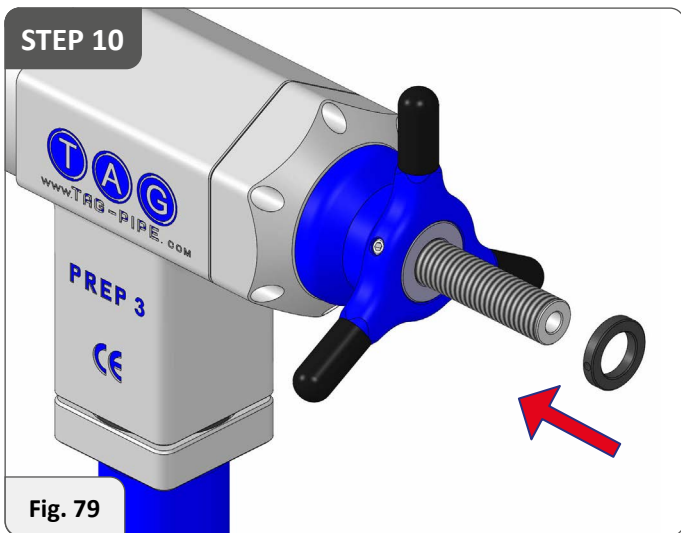




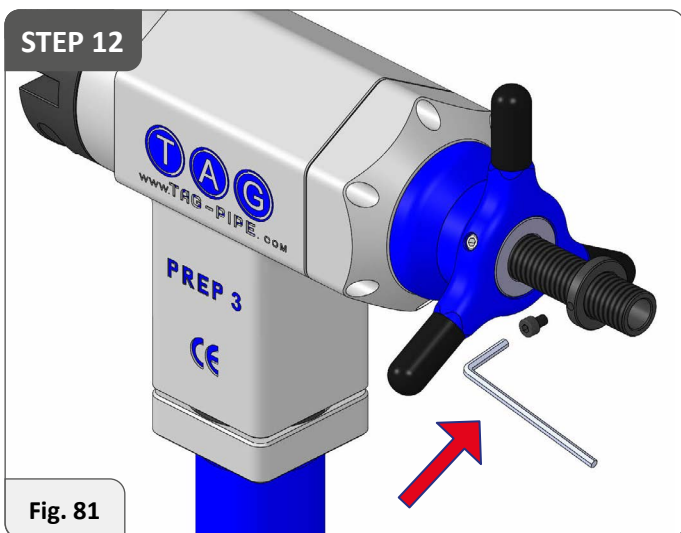
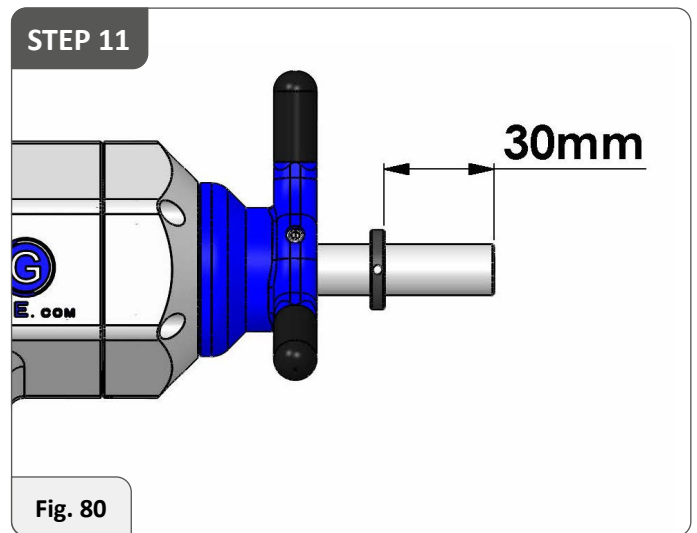
Remove the outside shaft by rotating the feeding wheel anti-clockwise.



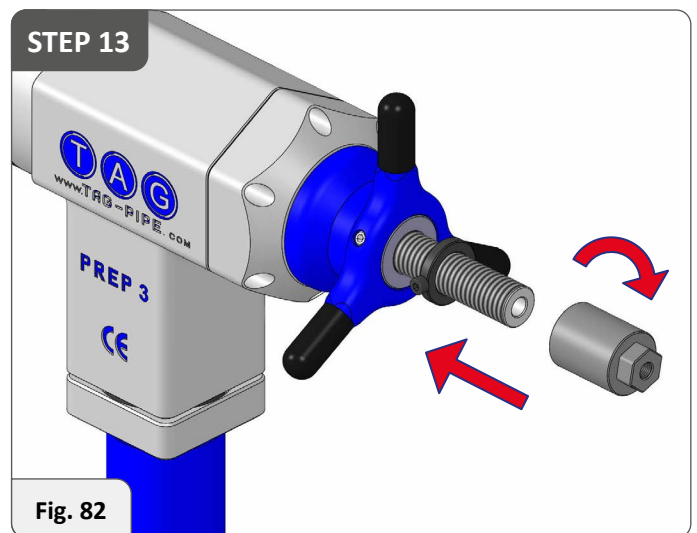
Insert the outside shaft by rotating the feeding wheel clockwise.



Insert stop ring up to 30 mm (Fig. 80).



Insert the Allen screw on the ring.



Screw in the lock/unlock nut clockwise all the way down.

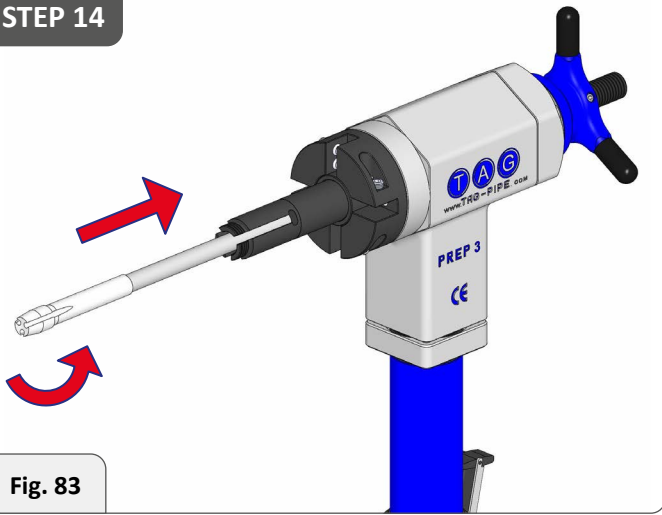
STEP 14

Fig. 83

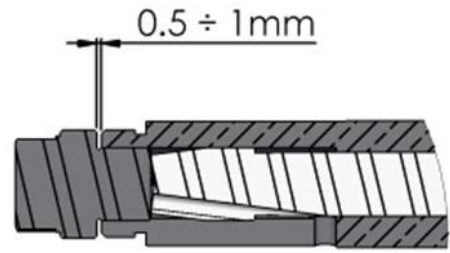
STEP 15

Fig. 84

Insert and screw the inside shaft anti-clock wise until you have $0.5 \div 1$ mm gap between the shaft as shown in the picture. Use the shaft end nut to measure the gap.

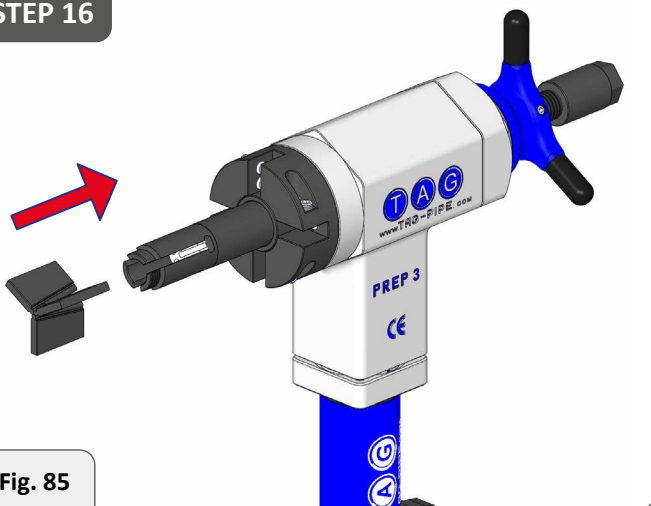
STEP 16

Fig. 85

Select the locking jaws according to the diameter of the pipe and install them on the inside shaft as shown in Fig. 85.

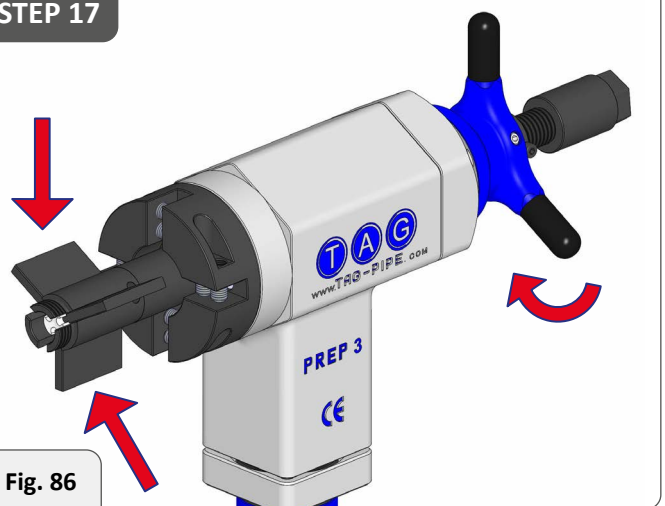
STEP 17

Fig. 86

While holding the three locking jaws you have just mounted, unscrew the lock/unlock nut in order to let them enter their seat.

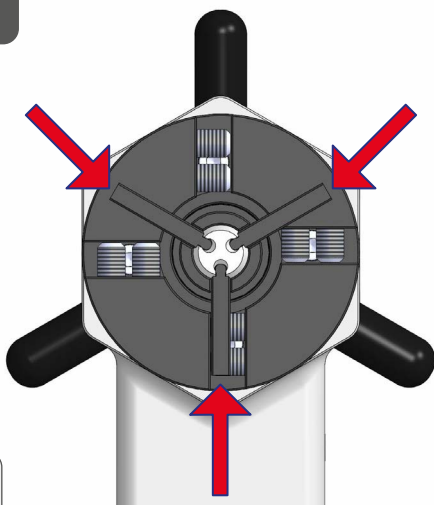
STEP 18

Fig. 87

If the procedure is correctly made the locking jaws should have a little play.

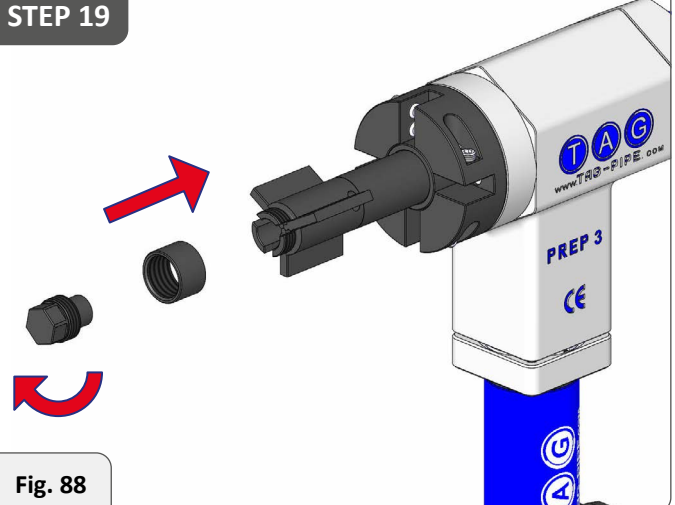
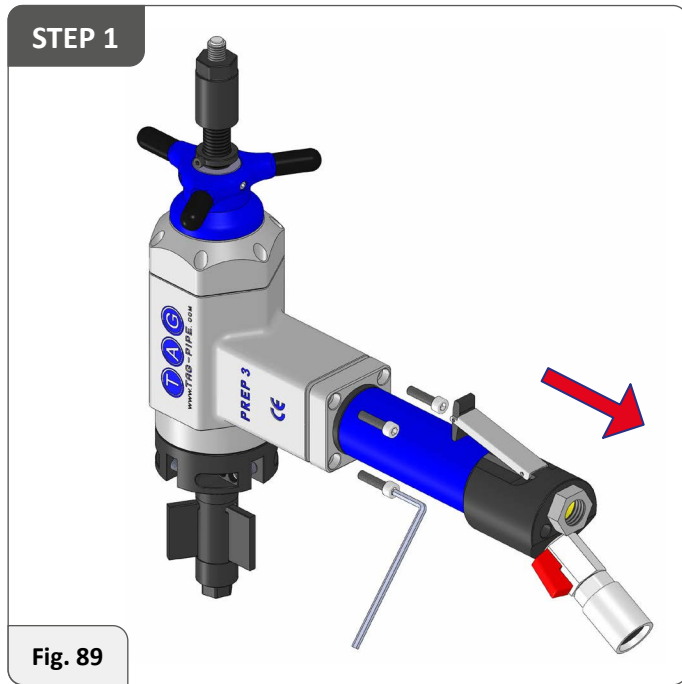
STEP 19

Fig. 88

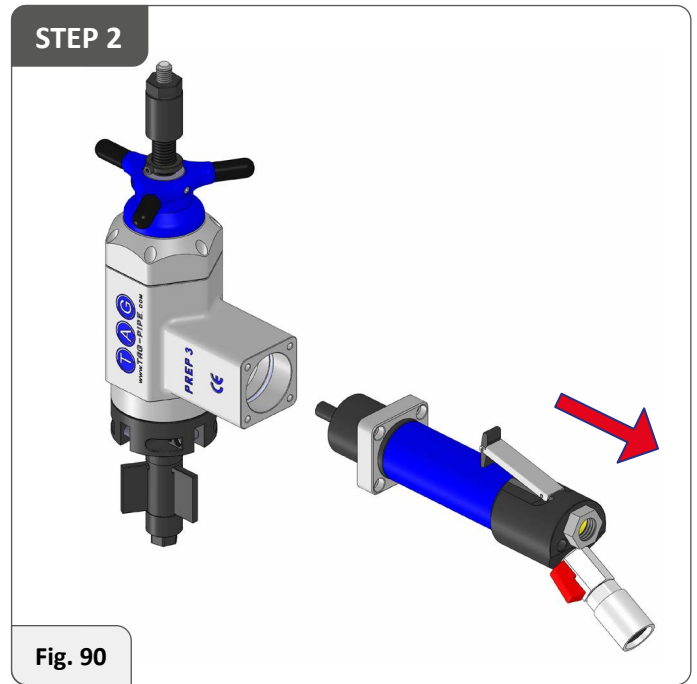
Screw back on the shaft ring nut clockwise all the way down and then the shaft end nut.

8.7 - DRIVER KIT REPLACEMENT

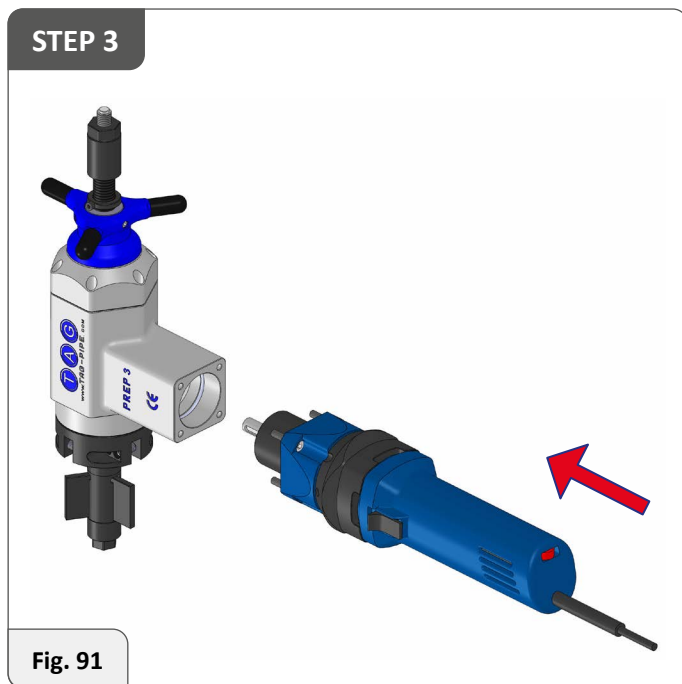
⚠ WARNING - Before replacing the transmission kits, make sure that you have eliminated any connections that may accidentally activate the machine.



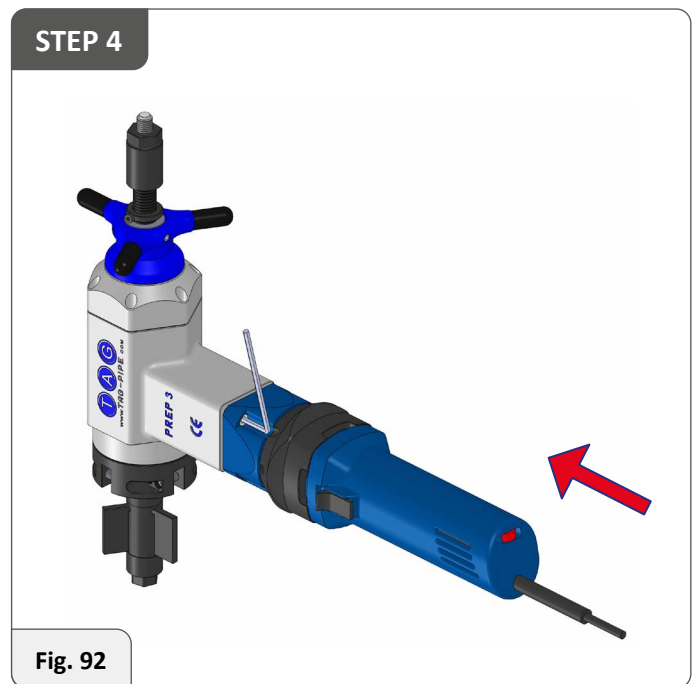
Remove the 4 screws as shown in the image (Fig. 89).



Remove the pneumatic transmission kit.

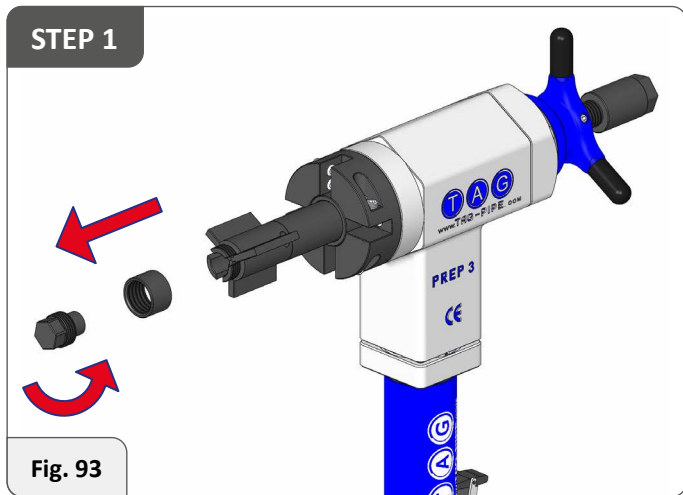


Insert the electric transmission kit.

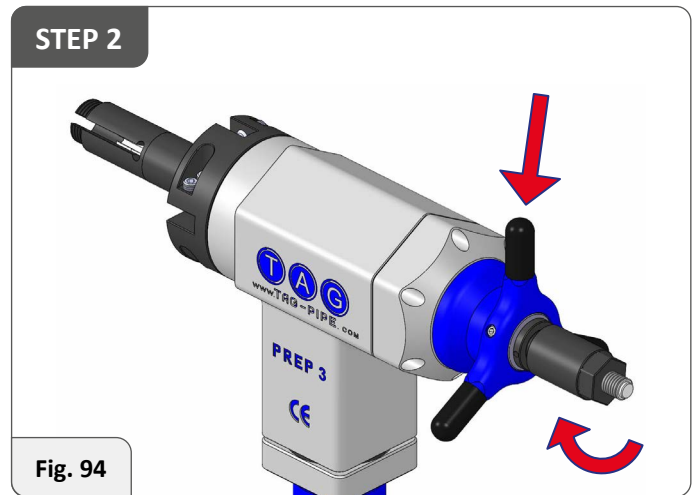


Screw in the 4 screws.

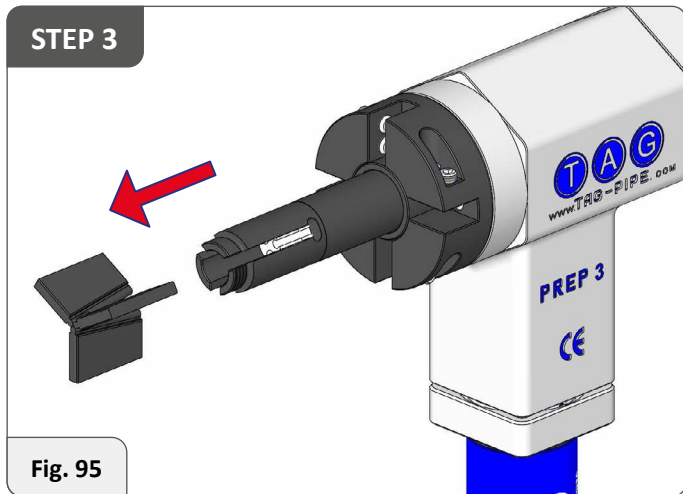
8.8 - AUTOMATIC LOCKING DEVICE KIT



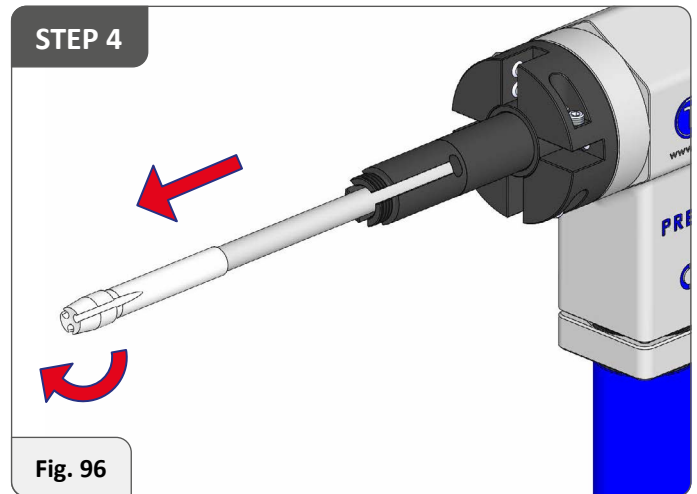
Unscrew the shaft end nut and the shaft ring anti-clockwise.



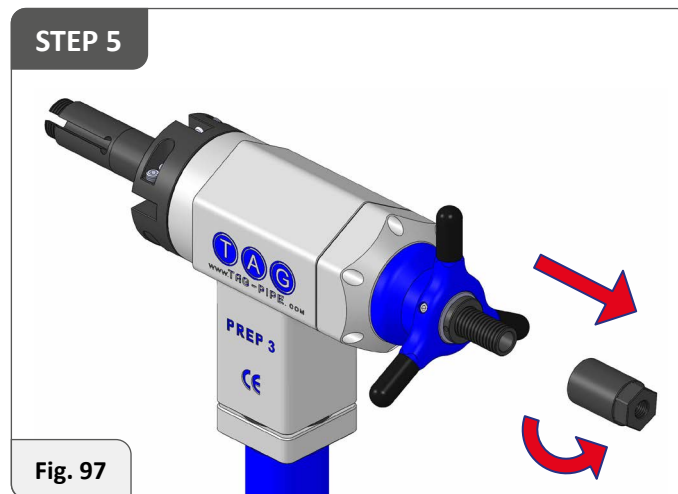
Rotate the lock/unlock nut in clockwise direction.



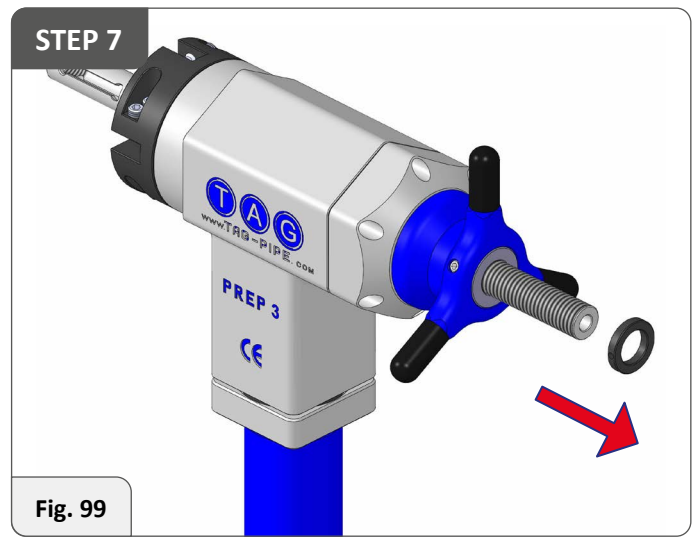
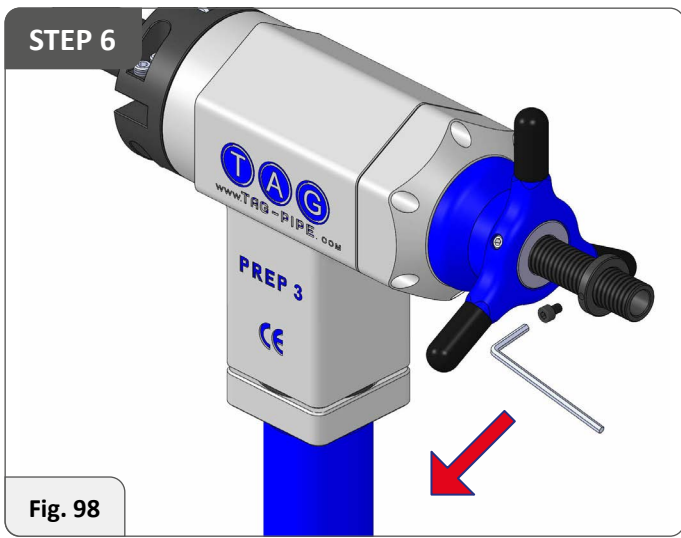
Remove the locking jaws.



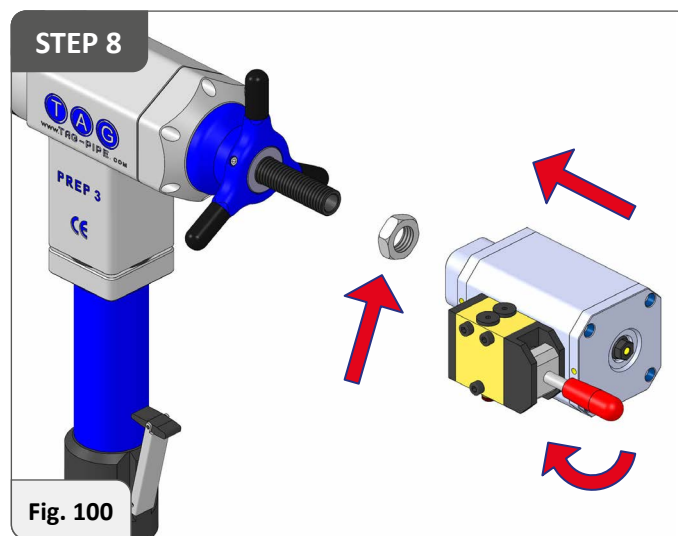
By using long nose pliers rotate the inside shaft clockwise until it comes out.



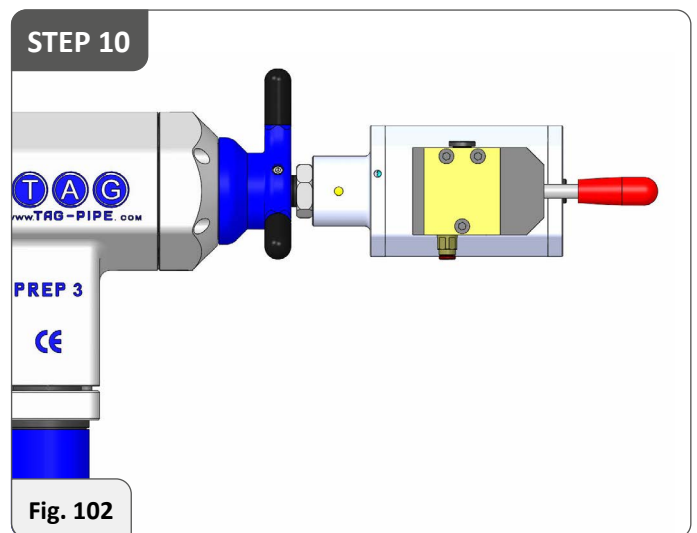
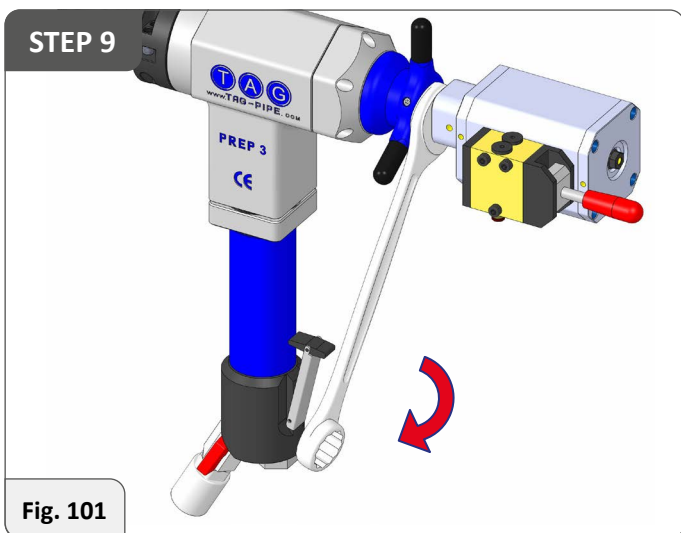
Rotate the lock/unlock nut in anti-clockwise direction.



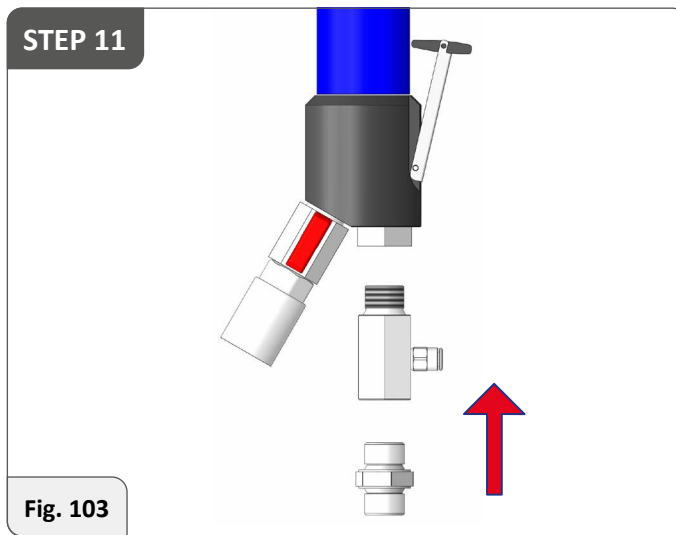
Remove the Allen screw from the ring and remove stop ring.



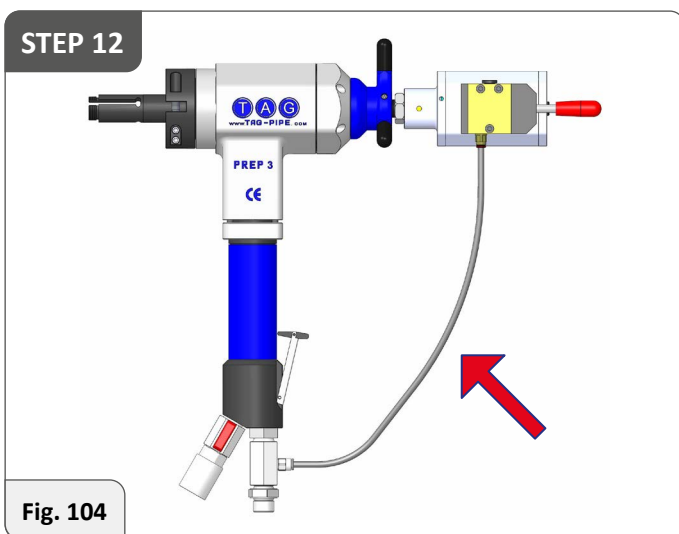
Screw the locking device nut and the locking device clockwise until it stops.



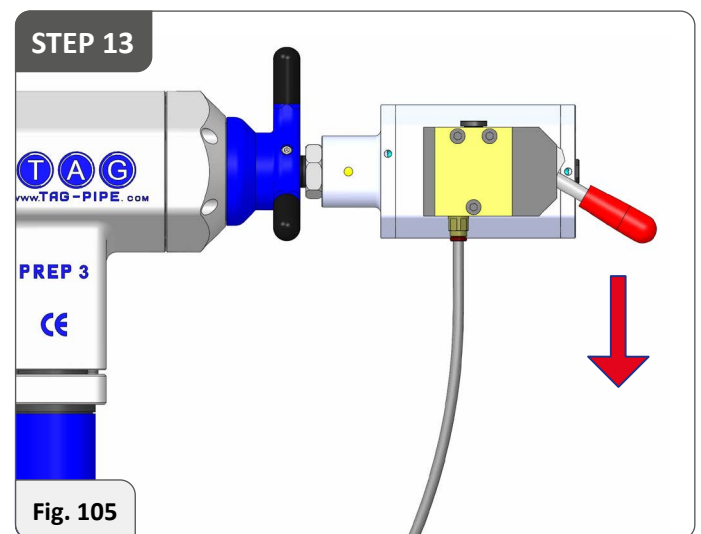
Turn in the right position and lock the nut against the locking device.



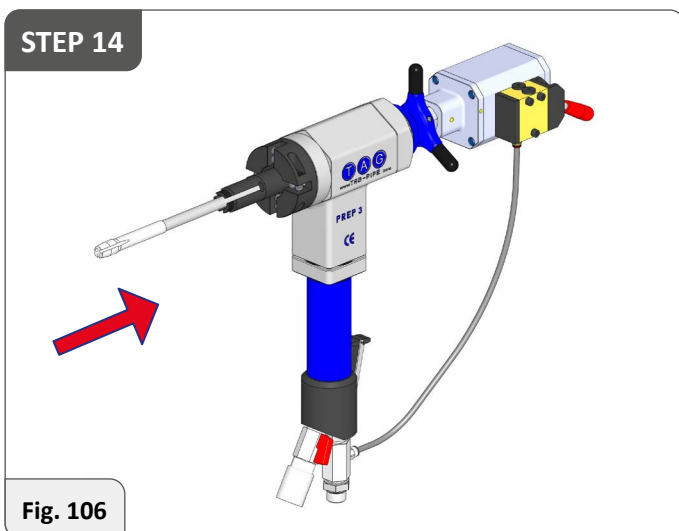
Screw in the special connection as shown in the picture.



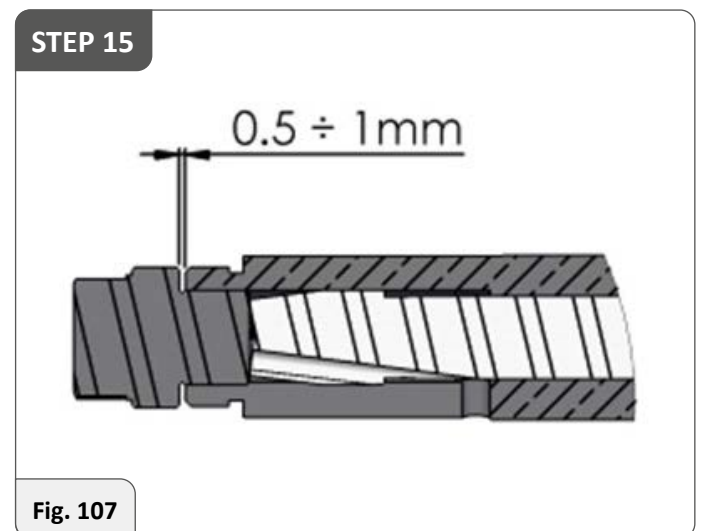
Connect the hose from the special connector to the locking device.

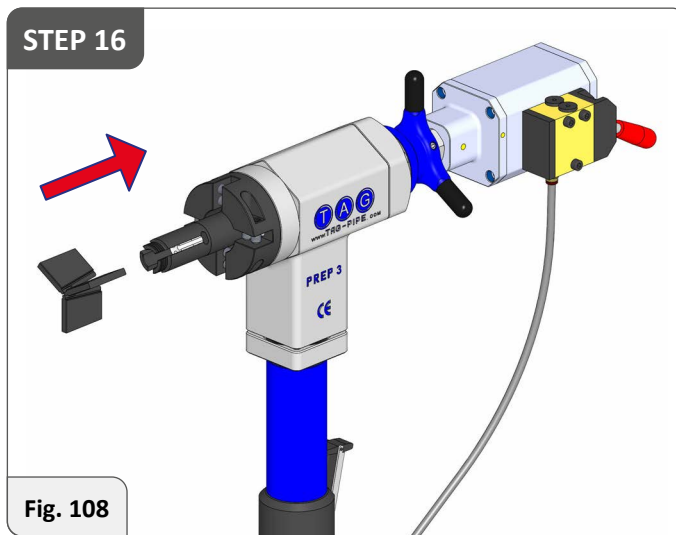


Connect the air and move the lever down to achieve the maximum forward piston.

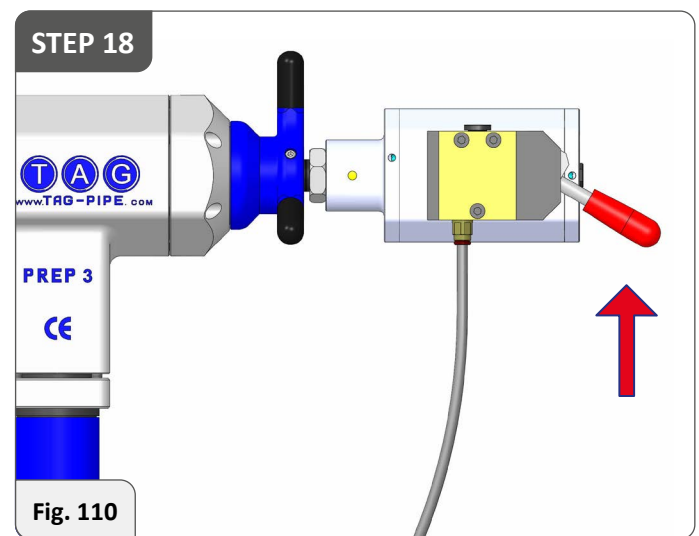
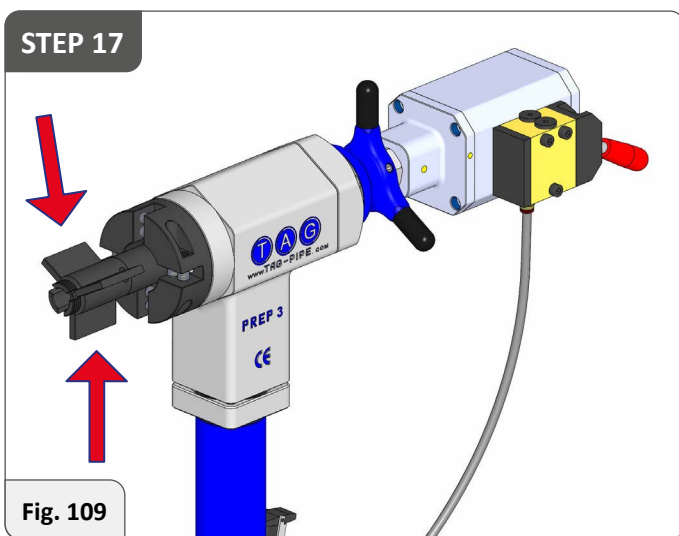


Insert and screw the inside shaft anti-clock wise until you have a $0.5 \div 1 \text{ mm}$ gap between the shaft as shown in the picture (Fig. 105). Use the shaft end nut to measure the gap.

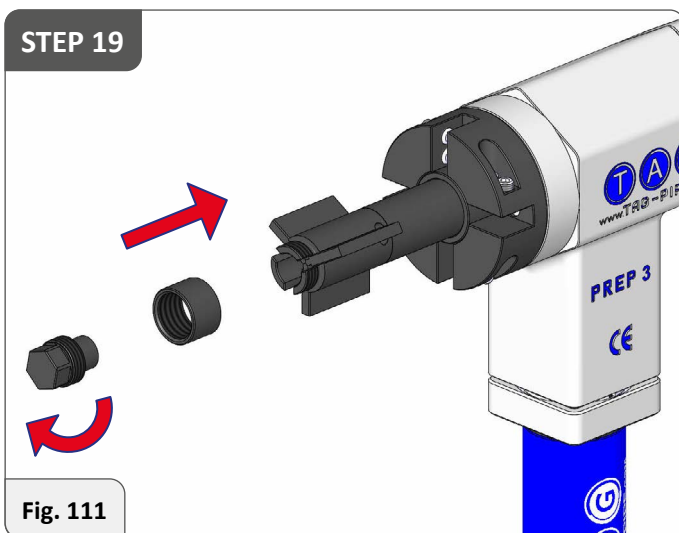




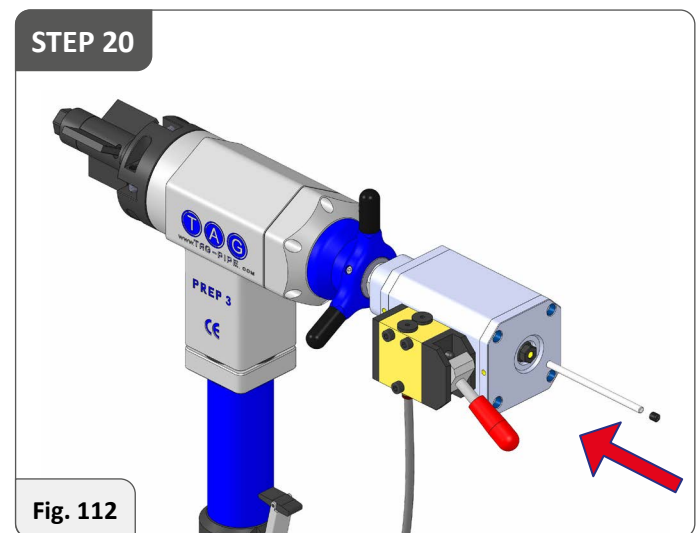
Select the locking jaws according to the diameter of the pipe and install them on the inside shaft as shown in the picture.



Connect the air and with your hand hold the jaws in position, move the lever up to achieve the backward position of inside shaft.



Screw back on the shaft ring nut clockwise all the way down and then the shaft end nut.



Insert the pin inside the locking device and lock with the first grub screw shown in the picture and then the second one.

9 - PERIODIC MAINTENANCE AND REPAIR

Continued safe operation of the equipment depends on regular maintenance and testing of its operating and protective controls. The equipment should only be inspected, tested and maintained by qualified trained personnel.

Should any test indicate that the equipment being tested or observed is not in good operating condition, it should be repaired immediately. Record and maintain records of repairs or changes so that a complete record will be available for review at any time.

It is advisable to regularly check the machine for any deficiencies; in case of non-conformities, do not use the equipment and initiate repair activities. Any repair should be conducted by TAG Pipe or by a TAG Pipe authorised machine repair partner. All spare parts used during repair activities should be genuine TAG Pipe original spare parts. The warranty on the equipment voids in case any form of repair is conducted by any unauthorised individual or service provider and/or in case non-genuine spare parts are used during any form of repair activity.

PERIODIC MAINTENANCE

- Prior to conducting any form of maintenance, make sure the equipment is not powered.
- When not using the equipment, keep the equipment safe and clean in the storage boxes.
- Do not store the equipment in humid storage area.
- Keep the equipment clean at all times in order to allow for optimal working conditions and performance.
- After use, the equipment should be thoroughly cleaned by brush and anti-rust spray or grease should be applied.
- Do not clean the equipment by using compressed air.
- Make sure no metal particles or swarf is remaining on any parts of the equipment.
- Before and after usage check all components, especially the power cords, and connecting hoses for pneumatic and hydraulic motors.
- Check the tension and accuracy of the toolboxes.
The high precision feed and tolerance (0.1 mm feed per revolution) is of critical performance of the equipment.
- It is advised to conduct an annual inspection and formal maintenance check-up by TAG Pipe or any of its authorised service partners.



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