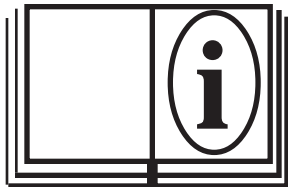


Socket Weld Removal System
1/2" thru 2"
Model SWA 052/1 (52-000-AX)
SWR 052/1 (52-000-RA)



	TUBE & PIPE	CE
	CUT-OFF MACHINES	
Mod. SWA/R	Ser.No.	<input type="text"/> <input type="text"/> <input type="text"/> <input type="text"/> <input type="text"/> <input type="text"/> <input type="text"/>
E.H. WACHS COMPANIES 100 Shepard St. Wheeling Il. 60090 Patent Pending		

Part Number: 52-MAN-01

Revision No: 2



Revised:
Feb. 99

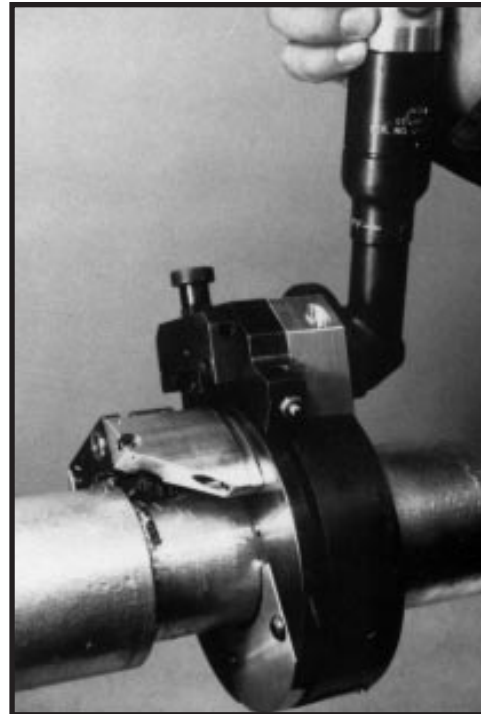
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SOCKET WELD REMOVAL SYSTEM

SECTION I

INTRODUCTION



INTRODUCTION

The E. H. Wachs 1/2" through 2" socket weld and pipe cutting system is designed for quick and simple socket weld removal as well as small pipe cutting and beveling. The system utilizes a fast one-step collet to locate and clamp to the pipe. The starwheel feed tool slide is simple and easy to use.

PACKAGING

The machine is shipped in a heavy duty storage case with form inserts for maximum machine protection.

MACHINE SPECIFICATIONS

1" Machine:	1/2, 3/4 and 1" pipe, 3000 lb and 6000 lb socket weld fittings and valves.
2" Machine:	1-1/4", 1-1/2" and 2" pipe 3000 lb and 6000 lb socket weld fittings and valves.
System Function:	Socket Weld excavation on most fittings and valves without damage to pipe or socket. When equipped with the radial slide, the socket weld machine can be used to cut and bevel pipe.
Machine Capacity:	1/2" through 2" socket weld & pipe
Machine Function:	Part off and bevel; also socket weld cutting up to 7/16" wall
Machine Feed Rate:	Fixed starwheel feed .0018 per revolution
Drive System:	Right angle air drive 1/2" square
Set-Up Time:	Approximately 5 minutes
Drive System:	Standard with a right angle air motor or optional with a right angle gear box to use any standard 3/8" electric drill motor.

SOCKET WELD REMOVAL SYSTEM

SECTION II

SAFETY INSTRUCTIONS

The E. H. Wachs Company takes great pride in manufacturing safe, quality products with user safety a priority.

The E.H. Wachs Company recommends that all users comply with the following safety rules and instructions when operating our equipment.



Read the Following thoroughly before proceeding.

	CAUTION Keep clear of rotating parts during operation. Hands and arms should be kept a minimum of 2' away from moving parts except during starting and stopping.
--	--

1. **READ THE OPERATING MANUAL!!** Reading the setup and operating instructions prior to beginning the setup procedures can save valuable time and help prevent injury to operators or damage to machines.
2. **INSPECT MACHINE & ACCESSORIES!** Prior to machine setup physically inspect the machine and it's accessories. Look for worn tool slides, loose bolts or nuts, lubricant leakage, excessive rust, etc. A properly maintained machine can greatly decrease the chances for injury.
3. **ALWAYS READ PLACARDS & LABELS!** All placards, labels and stickers must be clearly legible and in good condition. Replacement labels can be purchased from the manufacturer.
4. **KEEP CLEAR OF ROTATING PARTS!** Keep hands, arms and fingers clear of all rotating or moving parts. Always turn machine off before attempting any adjustments requiring contact with the machine or it's accessories.
5. **SECURE LOOSE CLOTHING & JEWELRY!** Loose fitting clothing, jewelry; long, unbound hair can get caught in the rotating parts on machines. By keeping these things secure or removing them you can greatly reduce the chance for injury.
6. **KEEP WORK AREA CLEAR!** Be sure to keep the work area free of clutter and nonessential materials. Only allow those personnel directly associated with the work being performed to have access to the area if possible.

For your safety and the safety of others, read and understand these safety recommendations and operating instructions before operating.

ALWAYS WEAR PROTECTIVE EQUIPMENT:

	WARNING Impact resistant eye protection must be worn while operating or working near this tool.
--	---

For additional information on eye and face protection, refer to federal OSHA regulations, 29 Code of Federal Regulations, Section 1910.133., Eye and Face Protection and American National Standards Institute, ANSI Z87.1, Occupational and Educational Eye and Face Protection. Z87.1 is available from the American National Standards Institute, Inc., 1430 Broadway, New York, NY 10018.

	CAUTION Personal hearing protection is recommended when operating or working near this tool.
--	--

Hearing protectors are required in high noise areas, 85 dBA or greater. The operation of other tools and equipment in the area, reflective surfaces, process noises and resonant structures can substantially contribute to and increase the noise level in the area. For additional information on hearing protection, refer to federal OSHA regulations, 29 Code of Federal Regulations, Section 1910.95, Occupational Noise Exposure and ANSI S12.6 Hearing Protectors.

	CAUTION Some individuals are susceptible to disorders of the hands and arms when exposed to tasks which involve highly repetitive motions and/or vibration. Disorders such as Carpal tunnel syndrome and tendonitis can be caused or aggravated by repetitious, forceful exertions of the hands and arms.
--	---

- Use minimum hand grip force.
- Keep wrists straight.
- Avoid prolonged, continuous vibration exposure.
- Avoid repeated bending of wrists and hands.
- Keep hands and arms warm and dry.

	CAUTION Gloves are not a form of protection and should not be worn while operating machinery. Chips and debris which are generated during operation should be disposed of in a safe manner. This should be done with the use of a dust pan and broom to avoid exposure to hands.
--	--

SICHERHEITSVORSCHRIFTEN

D

Seit 1883 hat EH Wachs seinen Ruf für Qualität und Zufriedenstellung seiner Kunden aufgebaut. Wachs übernimmt demgemäß die zusätzliche Verantwortung, sein Bestes zu tun, einen möglichst sicheren Umgang mit seiner Ausrüstung zu gewährleisten, und hat daher eine Liste von Sicherheits-Gedächtnisstützen zusammengestellt, die den Kunden in der Erschaffung einer möglichst sicheren Arbeitsumgebung zu unterstützen. Wir empfehlen, die aufgeführten Vorsichtsmaßnahmen genau zu beachten.



BITTE NACHFOLGENDES SORGFÄLTIG VOR DEM FORTFAHREN DURCHLESEN !

1. DIE BETRIEBSANLEITUNG LESEN!

Bedienungsmänner können wertvolle Zeit einsparen und Verletzungen und Beschädigungen der Maschine vermeiden, wenn Sie die Aufbau- und Betriebsanleitungen vor dem Aufbau durchlesen.

2. MASCHINE UND ZUSATZGERÄTE ÜBERPRÜFEN!

Vor dem Aufbau der Maschine sollte diese und die Zusatzgeräte physisch überprüft werden. Prüfen Sie, ob abgenutzte Werkzeugschlitzen, lockere Bolzen und Schraubenmütter, Schmiermittelabgänge, übermäßiger Rost, usw. bestehen. Mit einer ordnungsgemäß gewarteten Maschine kann die Wahrscheinlichkeit eines Unfall stark verringert werden.

3. IMMER INFORMATIONEN UND ETIKETTEN LESEN!

Alle Informationen, Etiketten und Aufkleber müssen gut lesbar und in gutem Zustand sein. Vom Hersteller können Ersatzetiketten angefordert werden.

4. BLEIBEN SIE ROTIERENDEN TEILEN FERN!

Die Hände, Arme und Finger sollten von allen sich drehenden Teilen ferngehalten werden. Vor der Durchführung von Nachstellungen, die Sie in Berührung mit der Maschine oder deren Zusatzgeräte bringen, die Maschine stets abschalten!

5. WEITE KLEIDUNG UND SCHMUCK BEFESTIGEN!

Weite Kleidung, Schmuck und lange, nicht gelöstes Haar können in den rotierenden Teilen der Maschine hängenbleiben. Die Wahrscheinlichkeit einer Verletzung kann stark herabgesetzt werden, wenn Sie diese Dinge befestigen bzw. abnehmen.

6. ARBEITSBEREICH FREIHALTEN!

Stets darauf achten, daß sich keine unnötigen Materialien, usw. im Arbeitsbereich befinden. Nur dem direkt mit der zu leistenden Arbeit in Zusammenhang stehenden Personal Zugang zum Arbeitsbereich gestatten!

STETS SCHUTZAUSRÜSTUNG TRAGEN!

	WARNUNG! Schlagbiegegeste Augenschutzbriillen müssen stets bei Betrieb dieses Werkzeugs oder in der Nähe dieses Werkzeugs getragen werden.
--	--

	ACHTUNG! Ein Ohrschutz muß stets bei Betrieb dieses Werkzeugs oder in der Nähe dieses Werkzeugs getragen werden.
--	--

	ACHTUNG! Manche Personen leiden an Funktionsstörungen der Hände und Arme, wenn sie sich dauernd wiederholende Aufgaben auszu-führen haben, die andauernde Bewegungen und/oder Schwing-ungen mit sich führen. Funktion-sstörungen, wie beispielsweise Handwurz-el- und Sehnenentzündungen, können durch eine sich wiederholende und mit viel Kraft ausgeübter Anwendung der Hände und Arme entweder hervorgerufen oder verschlimmert werden.
--	---

	ACHTUNG! Während des Betriebs von allen rotierenden Teilen Abstand halten. Außer während des An- und Abhaltens sollten Hände und Arme nicht näher als 60 cm an die sich bewegend Teile herankommen.
--	---

	ACHTUNG! Handschuhe stellen keinen Schutz dar und sollten nicht während des Betriebs der Maschinen getragen werden. Alle während des Betriebs entstandenen Splitter und Überreste sollten auf sichere Art und Weise entsorgt werden. Verwenden Sie dazu eine Kehrschaufel und vermeiden Sie den direkten Kontakt mit den Händen.
--	--

CONSIGNE DE SÉCURITÉ

F

Depuis 1883, la société EH Wachs a bâti sa réputation sur la qualité de ses produits et son engagement à satisfaire la clientèle. Conformément à ces principes, Wachs se doit également d'être aussi responsable pour faire de son mieux afin d'assurer l'utilisation la plus sûre de son matériel. Nous avons réuni une liste de rappels de sécurité pour aider à créer un cadre de travail aussi sûr que possible. Nous vous recommandons d'observer scrupuleusement les vérifications préalables indiquées ci-dessous.



Lisez ce qui suit avant d'aller plus avant

1. LIRE LE MANUEL D'UTILISATION !!

En lisant les instructions de réglage et de fonctionnement avant de commencer les procédures de réglage, vous pourrez économiser un temps précieux et vous éviterez aux machinistes de se blesser et d'abîmer les machines.

2. INSPECTER LA MACHINE ET LES ACCESSOIRES !

Avant de régler la machine, inspectez-la à l'oeil nu ainsi que ses accessoires. Recherchez les outils coulissants usagés, les boulons ou les écrous desserrés, les fuites de lubrifiant, les dépôts de rouille excessifs, etc. Avec une maintenance adéquate, vous diminuerez sensiblement les risques d'accidents.

3. LIRE SYSTÉMATIQUEMENT LES AFFICHES ET ÉTIQUETTES !

Toutes les affiches, étiquettes et autocollants doivent être parfaitement lisibles et en bon état. Vous pouvez acheter de nouvelles étiquettes auprès du fabricant.

4. SETENIR À DISTANCE DES PIÈCES ROTATIVES !

Tenez vos mains, bras et doigts éloignés de toutes pièces rotatives ou mobiles. Arrêtez toujours la machine avant de tenter de procéder au moindre réglage nécessitant un contact avec la machine ou ses accessoires.

5. PRENDRE GARDE AUX VÊTEMENTS AMPLES ET AUX BIJOUX !

Les vêtements amples, les bijoux, et les cheveux longs qui ne sont pas attachés peuvent être pris dans les pièces rotatives des machines. Enlevez ou attachez ce qui gêne de façon à réduire au maximum les risques d'accident.

6. CONSERVER UNE AIRE DE TRAVAIL DÉGAGÉE !

Ayez bien soin d'enlever les débris et les matériaux qui ne sont pas indispensables. N'autorisez que la présence des employés chargés du travail en cours d'exécution pour dégager au mieux l'aire de travail.

PORTER TOUJOURS UN ÉQUIPEMENT DE PROTECTION

	AVERTISSEMENT Protégez vos yeux avec des lunettes de sécurité antichoc lorsque cet outil est en marche ou si vous travaillez à proximité.
--	---

	ATTENTION Il est absolument indispensable de vous protéger con-stamment les oreilles lorsque cet outil est en marche ou si vous travaillez à proximité.
--	---

	ATTENTION Certaines personnes sont particulièrement sujettes aux troubles articulaires des mains et des bras lorsqu'elles sont soumises à des tâches nécessitant des gestes très répétitifs ou/et lorsqu'elles sont exposées à des vibrations. Le syndrome du canal carpien et les tendinites peuvent résulter ou être aggravés par des efforts rigoureux des bras et des mains.
--	--

	ATTENTION Tenez-vous à distance des pièces rotatives pendant le fonctionnement. Éloignez vos mains et vos bras d'au moins 60 cm de toute les pièces en mouvement, sauf au démarrage et à l'arrêt.
--	---

	ATTENTION Les gants ne constituent pas une forme de protection et ne doivent pas être portés pour faire fonctionner la machinerie. Les éclats et débris qui sont produits pendant l'opération doivent être déblayés avec précaution. Pour cela, il convient d'utiliser un balai et une pelle pour éviter de les toucher à mains nues.
--	---

INSTRUCCIONES DE SEGURIDAD

E

Desde 1883, EH Wachs ha ido forjando una reputación de calidad y compromiso hacia la satisfacción del cliente. De acuerdo con esto, Wachs debe aceptar la responsabilidad adicional de hacer todo lo posible para asegurar el uso seguro de nuestros equipos. Hemos reunido una lista de recordatorios de seguridad para ayudarle a crear el ambiente de trabajo más seguro posible. Recomendamos se observen cuidadosamente los pasos de precaución enumerados en la misma.



Lea lo siguiente detenidamente antes de proceder

1. ¡ LEA EL MANUAL DE OPERACIONES!

La lectura de las instrucciones de instalación y operación antes de comenzar los procedimientos de instalación puede ahorrarle tiempo valioso y ayudarlo a evitar daños a operarios o daño a las máquinas.

2. ¡ INSPECCIONA LA MAQUINA Y LOS ACCESORIOS!

Antes de la instalación de la máquina inspeccione físicamente la máquina y sus accesorios. Busque muecas de herramientas usadas, pernos o tuercas flojas, fugas de lubricante, excesiva corrosión, etc. Una máquina mantenida adecuadamente puede disminuir grandemente las ocasiones de daños.

3. ¡ LEA SIEMPRE LOS LETREROS Y ETIQUETAS!

Todos los letreros, etiquetas y adhesivos deben ser claramente legibles y estar en buenas condiciones. Pueden comprarse etiquetas de repuesto del fabricante.

4. ¡ MANTENGASE ALEJADO DE PIEZAS GIRATORIAS!

Mantenga las manos, brazos y dedos alejados de todas las piezas rotatorias o en movimiento. Desconecte siempre la máquina antes de intentar ningún ajuste que requiera entrar en contacto con la máquina o sus accesorios.

5. ¡ ASEGURE LA ROPA SUELTA Y JOYERÍA!

La ropa suelta, joyería; pelo largo y sin atar pueden engancharse en las partes rotatorias de las máquinas. Usted puede reducir grandemente las oportunidades de un accidente asegurando estas cosas o despojándose de ellas.

6. ¡ MANTENGA LIMPIA EL AREA DE TRABAJO!

Asegúrese de mantener el área de trabajo libre de obstáculos y materiales no esenciales. Si es posible permita solamente el acceso al área a aquellas personas directamente asociadas con el trabajo que se está realizando.

USE SIEMPRE EQUIPO

	AVISO Debe usarse protección ocular resistente al impacto mientras se opere o trabaje cerca de esta herramienta.
--	--

	PRECAUCION e requiere en todo momento protección auditiva personal cuando opere o trabaje cerca de esta herramienta.
--	--

	PRECAUCION Algunos individuos son susceptibles a desórdenes de brazos y manos cuando son sometidos a tareas que llevan consigo movimientos altamente repetitivos y/o vibración. Desórdenes tales como el síndrome del túnel carpiano y ten-donitis pueden ser causados o agravados por esfuerzos repetitivos y energéticos de las manos y brazos.
--	---

	PRECAUCION Manténgase alejado de las partes giratorias durante la operación. Las manos y los brazos deben mantenerse a una distancia mínima de 60 cm (2') de las partes móviles, excepto al empezar y al detener la operación.
--	--

	PRECAUCION Los guantes no son un medio de protección y no deben usarse al operar la maquinaria. Se deben desecher los fragmentos y escombros generados durante la operación, tomando en cuenta la seguridad de las personas. Esto debe hacerse con una pala para recoger basura y una escoba para evitar el contacto con las manos.
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INDICAZIONI PER LA SICUREZZA D'USO

I

Fin dal 1883, la EH Wachs si è guadagnata una reputazione per quanto riguarda qualità e impegno nella soddisfazione dei clienti. In questa ottica, alla Wachs dobbiamo anche assumerci la responsabilità di fare del nostro meglio per garantire la massima sicurezza d'uso dei nostri apparecchi. Abbiamo preparato un elenco di avvisi di sicurezza come ausilio nel creare il più sicuro ambiente di lavoro possibile. Raccomandiamo di seguire attentamente le precauzioni elencate.



Leggere attentamente quanto segue prima di proseguire

1. LEGGERE IL MANUALE D'USO!!

Leggere le istruzioni per la messa a punto e l'uso prima di iniziare la messa a punto per risparmiare tempo prezioso e prevenire lesioni e danni al macchinario.

2. CONTROLLARE LA MACCHINA E GLI ACCESSORI!

Prima di mettere a punto la macchina, controllare sia la macchina che gli accessori. Verificare che le slitte portautensili non siano consumate, che i bulloni e i dadi non siano allentati, che non vi siano perdite di lubrificante, ruggine eccessiva, ecc. Una macchina ben mantenuta può ridurre notevolmente le possibilità di danni.

3. LEGGERE SEMPRE TARGHETTE ED ETICHETTE!

Tutte le targhette, le etichette e gli adesivi devono essere chiaramente leggibili e in buone condizioni. Si possono acquistare etichette di ricambio presso il produttore.

4. NON AVVICINARSI A PARTI IN MOVIMENTO!

Tenere mani, braccia e dita ben lontane da tutte le parti in movimento. Spegnerle sempre la macchina prima di effettuare regolazioni che richiedono il contatto con la macchina o i suoi accessori.

5. FISSARE INDUMENTI E GIOIELLERIA!

Indumenti larghi, gioielli pendenti o lunghi; capelli lunghi sciolti possono rimanere incastrati nelle parti rotanti sulle macchine. Fissandoli o rimuovendoli si può ridurre notevolmente il rischio di lesioni.

6. MANTENERE L'AREA DI LAVORO SGOMBRA!

Mantenere l'area di lavoro sgombra da materiale non essenziale. Se possibile, consentire l'accesso solamente al personale direttamente interessato nel lavoro svolto.

INDOSSARE SEMPRE INDUMENTI PROTETTIVI:

	Indossare occhiali di sicurezza resistenti all'urto durante l'uso di questo strumento o quando si lavora in sua prossimità.
--	---

	AVVERTENZA Indossare sempre protezione auricolare durante l'uso di questo strumento o quando si lavora in sua prossimità.
--	---

	AVVERTENZA Alcuni individui possono soffrire disturbi alle mani e alle braccia nell'esecuzione di mansioni che comportino movimenti altamente ripetitivi e/o vibrazione. Disturbi quali la sindrome del tunnel carpale e tendiniti possono essere causati o aggravati da sforzi ripetuti delle mani e delle braccia.
--	--

	ATTENZIONE Stare lontani da parti rotanti durante l'uso. Tenere mani e braccia ad almeno 60 centimetri di distanza da parti in movimento tranne durante l'avvio e l'arresto.
--	--

	ATTENZIONE I guanti non costituiscono una forma di protezione e non dovrebbero essere indossati durante l'uso delle macchine. Schegge e detriti generati durante l'uso devono essere smaltiti in modo sicuro, usando una palette e una scopa per evitare di toccarli con le mani.
--	---

VEILIGHEIDSRICHTLIJNEN

N

Sinds 1883 heeft de firma E.H.Wachs een reputatie opgebouwd voor kwaliteit en heeft zich geëngageerd om voldoening te schenken aan de gebruiker. Dienovereenkomstig heeft E.H.Wachs de bijkomende verantwoordelijkheid op zich genomen het uiterste te betrekken om het gebruik van onze apparatuur onder de meest veilige omstandigheden te verzekeren. We hebben een lijst samengesteld van veiligheidsaanmaningen teneinde de meest veilige werkomgeving te scheppen.



We raden aan de hieronder vermelde voorzorgsmaatregelen strikt na te leven. Lees het volgende aandachtig vooraleer verder te gaan.

1. LEES HET BEDIENINGSHANDBOEK!

Lees de opstel- en bedieningsrichtlijnen vooraleer met de opstelwerkzaamheden te beginnen om kostbare tijd te besparen en om persoonlijke letsels en schade aan de machines te voorkomen.

2. INSPECTEER DE MACHINE EN TOEBEHOREN

Vooraleer de machine op te stellen, inspecteer de machine en haar toebehoren. Kijk uit voor versleten gereedschapsleden, losse bouten en moeren, olie lekken, overmatige roest, enz.. Een goed onderhouden machine kan de kans voor kwetsuren aanzienlijk verminderen.

3. LEES ALTIJD DE PLAKKAATEN EN ETIKETTEN

Alle plakkaaten, etiketten en zelfklevers moeten duidelijk leesbaar zijn en in goede staat. Vervangingsetiketten kunnen bij de fabrikant gekocht worden.

4. HOUD AFSTAND VAN DRAAIENDE ONDERDELEN

Houd handen, armen en vingers weg van alle draaiende of bewegende onderdelen. Schakel de machine uit vooraleer afregelingen te verrichten die contact vereisen met de machine of haar toebehoren.

5. VERMIJD LOSSE KLEDING EN SIERADEN

Los zittende kleding, sieraden, en lang los haar kunnen door draaiende machineonderdelen gegrepen worden. Door ze vast te maken of ze te verwijderen kunt u de kans op verwondingen aanzienlijk verminderen.

6. HOUD DE WERKRUIJTE VRIJ

Zorg ervoor dat de werkruimte vrij is van rommel en onnodige materialen. Toegang tot de werkruimte moet indien mogelijk enkel verleend worden aan personen die direct betrokken zijn bij het uit te voeren werk.

DRAAG ALTIJD BESCHERMENDE UITRUSTING

WAARSCHUWING

Een veiligheidsbril moet gedragen worden bij het bedienen van dit gereedschap of bij het werken in de buurt van dit gereedschap.

VOORZICHTIG

Persoonlijke gehoorbescherming is aangeraden bij het bedienen van dit gereedschap of bij het werken in de buurt van dit gereedschap.

VOORZICHTIG

Sommige personen zijn vatbaar voor hand- en arm-letsels wanneer zij blootgesteld zijn aan trillingen of handelingen die hoogst rep-ettieve bewegingen ver-ge-n. Letsels zoals Carpal tunnel syn-droom en tennisnis kunnen veroor-zaakt worden of verergeren door rep-ettieve krachtingspanningen van handen en armen.

VOORZICHTIG

Blijf tijdens het bedrijf op veilige afstand van draaiende onderdelen. Houd handen en armen minstens 5 cm weg van bewegende onderdelen, behalve tijdens het starten en stoppen.

VOORZICHTIG

Handschoenen zijn geen vorm van bescherming en mogen niet worden gedragen tenzij u de machines bedient. Deeltjes en rommel die tijdens het bedrijf ontstaan, moeten op een veilige manier worden opgeruimd. Dit dient te worden gedaan met een bezem en blik om blootstelling van de handen te voorkomen.

SÄKERHETSANVISNINGAR

S

EH Wachs har sedan 1883 etablerat ett gott anseende när det gäller kvalitet och kundtillfredsställelse. Wachs känner sig därför förpliktigt att göra sitt yttersta för att garantera säkrast möjliga användning av Wachs-utrustning. Vi har ställt samman en lista av säkerhetsanvisningar som ett led i vår strävan att skapa säkrast möjliga arbetsmiljö. Vi rekommenderar att de försiktighetsåtgärder som förtecknats följs noggrant.



Läs igenom nedanstående ordentligt innan du fortsätter.

ANVÄND ALLTID SKYDDSUTRUSTNING:

VARNING!

Stötsäkra skyddsglasögon måste bäras vid användning av eller arbete nära detta redskap.

OBS!

Hörselskydd krävs alltid vid användning av eller arbete nära detta redskap.

OBS!

Vissa personer är känsliga för de effekter som kan uppstå i händer och armar när de utför rörelser som är i hög grad repetitiva och/eller utsatta för vibrationer. Tillstånd såsom carpal tunnel syndrom och seninflammation kan orsakas eller förvärras om händer och armar används för att utföra repetitivt och ansträngande arbete.

VARNING!

Undvik roterande delar under drift. Händer och armar bör hållas på minst 0,6 m avstånd från rörliga delar utom när maskinen startas eller slås från.

VARNING!

Handskar skyddar inte och bör ej användas medan maskinen körs. Fusor och andra restprodukter som skapas under drift bör kasserats på ett säkert sätt. Använd kvast och sopskyffel för att undvika kontakt med händer.

1. LÄS IGENOM BRUKSANVISNINGEN!

Genomläsning av anvisningarna för klargöring och drift innan klargöringen påbörjas kan medföra en värdefull tidsbesparing och bidra till att person- och maskinskadorna undviks.

2. KONTROLLERA MASKINEN OCH DESS TILLBEHÖR!

Kontrollera maskinen och besiktiga dess tillbehör. Se efter om verktyghållare är släta, skruvar och muttrar lösa, smörjmedel läcker, kraftig rost förekommer o.d. En korrekt underhållen maskin medför kraftigt minskad risk för personskador.

3. LÄS ALLTID SKYLTLAR OCH ETIKETTER!

Alla skyltar och etiketter måste vara helt läsbara och i gott skick. Utbytesetiketter kan inköpas från tillverkaren.

4. HÅLL DIG BORTA FRÅN RÖTERANDE DELAR!

Håll händer, armar och fingrar borta från roterande eller rörliga delar. Slå alltid av maskinen innan justering som kräver kontakt med maskinen eller dess tillbehör utförs.

5. STOPPA IN LÖST SITTANDE KLÄDER OCH SMYCKEN!

Löst sittande kläder och smycken samt långt, hängande hår kan fastna i maskinens roterande delar. Genom att säkra dessa eller avlägsna kläder och smycken kan du minska risken för skador avsevärt.

6. HÅLL ARBETSSTÄLLET RENT!

Var noga med att hålla arbetsstället fritt från skräp och ej behövligt material. Ge om möjligt tillgång till arbetsstället endast till personal som är direkt inbegripen i det arbete som utförs.

INSTRUÇÕES DE SEGURANÇA

P

Já desde 1883 que a EH Wachs tem vindo a criar uma reputação de qualidade e um compromisso de satisfação dos consumidores. Nesta linha de conduta, a Wachs tem que assumir a acrescida responsabilidade de fazer o seu melhor para garantir a máxima segurança na utilização dos nossos equipamentos. Acabámos de compilar uma lista de lembretes de segurança destinados a ajudar na criação de um ambiente de trabalho o mais seguro possível. Aconselhamos que sejam observadas com todo o cuidado as várias fases precaucionárias descritas a seguir.



Ante de continuar, leia com o máximo cuidado o que vai a seguir

1. Leia o Manual de Operações!

A leitura das instruções de montagem e de funcionamento antes de iniciar os procedimentos de montagem poderá poupar um tempo precioso e prevenir ferimentos no operador ou danos nas máquinas.

2. Inspeccione a máquina e respectivos acessórios!

Antes de efectuar a sua montagem, faça uma inspeção física da máquina e seus acessórios. Dirija a sua busca para peças desilzantes já usadas, parafusos e porcas soltos, derrame de lubrificantes, ferrugem excessiva, etc. A manutenção adequada do maquinismo diminuirá os riscos de ferimentos.

3. Leia sempre os cartazes e as etiquetas!

Todos os cartazes, etiquetas e autocolantes deverão ser claramente legíveis e estar em perfeitas condições. Etiquetas acessórias de substituição poderão ser encomendadas directamente do fabricante.

4. Mantenha-se fora do alcance de peças rotatórias!

Mantenha as mãos, braços e dedos fora do alcance de todas as peças rotatórias ou em movimento. Desligue, primeiro, a máquina sempre que tiver de proceder a ajustamentos que requeiram contacto com a máquina ou com as suas peças.

5. Aperte bem a roupa folgada e peças de joalheria!

Roupa folgada, joalheria e cabelo solto e comprido poderão ser apanhados pelas peças rotatórias das máquinas. Manter estes artigos amarrados ou desfazer-se deles será a melhor maneira de reduzir a possibilidade de ferimentos.

6. Mantenha livre a área de trabalho!

Procure manter a área de trabalho livre de ajustamentos e de materiais não essenciais. O acesso a essa área só deverá ser permitido ao pessoal directamente envolvido no trabalho que estiver a ser executado, tanto quanto possível.

USE SEMPRE EQUIPAMENTO DE PROTECÇÃO

AVISO!

Sempre que trabalhar com esta ferramenta ou perto dela deverá usar uma protecção para a vista, à prova de choque.

CUIDADO!

É obrigatório usar protecção individual para os ouvidos durante todo o tempo que trabalhar com esta ferramenta ou perto dela.

CUIDADO!

Há pessoas que são propensas a sofrer certos sintomas nas mãos ou nos braços quando expostos a tarefas que envol-vam movimentos altamente repetitivos, acompanhados ou não de vibrações. Sintomas como, por exemplo, o síndrome do túnel cárpico e a tendinite poderão ser causados ou agravados elo uso esforçado e repetitivo das mãos e dos braços.

ATENÇÃO!

Mantenha distância das partes giratórias durante a operação. Braços e mãos devem ser mantidos a no mínimo 2 pés (60cm) das partes móveis, exceto durante a partida e parada.

ATENÇÃO!

Luas não são uma forma de protecção e não devem ser utilizadas durante a operação do equipamento. Deve-se desfazer adequadamente das lãs e apas prazudas durante a uso. Isto deve ser feito com a usa de pá de lixo e vassoura para evitar a cantata com as mãos.

TURVALLISUUSOHJEET

FIN

EH Wachs on tunnettu korkeasta laadusta ja tyytyväisistä asiakkaitaan jo vuodesta 1883. Wachs huolehtii myös siitä, että laitteiden käyttö on mahdollisimman turvallista.

Olemme koonneet tähän turvallisuutta koskevan muistilistan, jota noudattamalla työympäristöstä saadaan mahdollisimman turvallinen. Kehotamme noudattamaan tässä esitettyjä varotoimenpiteitä huolellisesti.



Lue seuraavat kohdat huolellisesti, ennen kuin jatkat.

VAROITUS

Käytä iskunkestäviä suojalaseja, kun käytät tätä työkalua tai työskentelet sen lähellä.

HUOMAA

Kuulosuojainten käyttöä vaaditaan aina, kun käytät tätä työkalua tai työskentelet sen lähellä.

HUOMAA

Pitkään jatkuva altistuminen toistuvalla liikkeellä ja/tai tärinällä voi aiheuttaa käsien ja käsivarren sairauksia jollekin henkilöille. Käsien ja käsivarren kohdistuva töistä ja voimakas liike voi aiheuttaa tai pahentaa sairauksia kuten rannkanavaoireyhtymä ja jännetulehdus.

VAROITUS

Pysyttele loitolla pyöriivistä osista käytön aikana. Kädet ja käsivarret tulee pitää vähintään 60 cm:n päässä liikkuvista osista paitsi käynnistyksen ja pysäytyksen aikana.

VAROITUS

Käsineet eivät toimi suojavarusteina, eikä niitä tule käyttää koneita käytettäessä. Käytön aikana syntyvät lastut ja jäte tulee hävittää turvallisella tavalla. Tämä tulee tehdä. Rikkalapiota ja harjaa käyttäen käsien altistumisen välttämiseksi.

1. LUE KÄYTTÖOHJEKIRJA!

Asennus- ja käyttöohjeisiin perehtyminen ennen asennuksen aloittamista säästää aikaa ja auttaa vähentämään tapaturmavaaraa ja koneiden vaurioitumisrisiä.

2. TARKASTA KONE JA LISÄLAITTEET!

Ennen kuin aloitat asennuksen, tarkasta kone ja lisälaitteet. Varmista, että teräkkelet eivät ole kuluneet, pultteja ja muttereita ei ole löysällä, voiteluainetta ei vuoda, koneessa ei ole liikaa ruostetta jne. Hyvässä kunnossa pidetty kone voi vähentää tapaturmavaaraa huomattavasti.

3. LUE KAIKKI KILVET JA MERKINNÄT!

Kaikkien kilpien, merkintöjen ja tarjojen on oltava selkeästi luettavissa ja hyvässä kunnossa. Vaihtotarjoja voit ostaa valmistajalta.

4. PYSYTTLE ETÄÄLLÄ PYÖRIVISTÄ OSISTA!

Pitä kädet, käsivarret ja sormet loitolla kaikista pyöriivistä tai liikkuvista osista. Kytke kone aina pois päältä ennen kuin suoritat säätöjä, joissa joudut koskemaan koneeseen tai sen lisälaitteisiin.

5. SIDO LÖYSÄT VAATTEET JA HUIKSET KIINNI!

Löysät vaatteet, korut ja pitkät huiukset voivat takertua koneen pyöriiviin osiin. Vähennät tapaturmavaaraa huomattavasti, kun poistat tai sidot kiinni löysät vaatteet ja korut ja sidot huiukset kiinni.

6. PIDÄ TYÖSKENTELYALUE SIISTINÄ!

Varmista, että työskentelyalueella ei ole roskia eikä tarpeetonta materiaalia. Päästä työskentelyalueelle vain kassilla olevaan työhön osallistuvia henkilöitä, mikäli mahdollista.

Siden 1883 har EH Wachs haft ry for deres kvalitet og varetagelse af kundtilfredshed og vil også gøre vort bedste for at sikre, at vore maskiner benyttes på en sikker og forsvarlig måde.

Vi har lavet en liste over påmindelser, der skal bidrage til at skabe det sikrest mulige arbejdsmiljø. Vi anbefaler, at sikkerhedsforanstaltningerne på listen omhyggeligt overholdes.



Læs følgende grundigt, inden der foretages andet

1. LÆS BRUGSANVISNINGEN!!

Hvis man læser anvisningerne i klargøring og drift, inden man begynder at gøre maskinen klar, kan man spare tid og forhindre person- og maskinskade.

2. INSPICÉR MASKINE OG Udstyr!

Inden maskinen gøres klar, skal man inspicere maskinen og udstyret. Se efter slidte fittings, løse bolte og møtrikker, olierækker, rust osv. Når maskinen holdes i god stand, er der langt mindre risiko for personskade.

3. LÆS ALTID SKILTE OG ETIKETTER!

Alle skilte og etiketter skal være letlæselige og i god stand. Nye skilte og etiketter fås hos forhandleren.

4. HOLD AFSTAND TIL BEVÆGELIGE DELE!

Hold hænder, arme og fingre væk fra alle roterende og bevægelige dele. Man skal altid slukke for maskinen, inden man påbegynder justering, hvor man kommer i kontakt med maskinen eller udstyret.

5. BRUG IKKE LØSTHÆNGENDE TØJ OG SMYKKER!

Løsthængende tøj, smykker og langt, løsthængende hår kan blive fanget i maskinens bevægelige dele. Man kan i høj grad nedsætte risikoen for personskade ved ikke at bruge løsthængende tøj og smykker og ved at samle langt hår oppe på hovedet.

6. HOLD ARBEJDSSTEDET RYDDET!

Arbejdsstedet skal holdes ryddeligt og fri for materialer, der ikke hører til. Uvedkommende personer bør ikke have adgang til arbejdsstedet, hvis det er muligt.

BRUG ALTID BESKYTTELSESDUSTYR:

	ADVARSEL Man skal bruge slag-resistente sikkerhedsbriller, når man arbejder med eller i nærheden af denne maskine.
--	--

	FORSIGTIG Man skal altid bruge hørevæv, når man arbejder med eller i nærheden af denne maskine.
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	FORSIGTIG Nogle mennesker er ds-poneret for lidelser i hænder og arme, når de udsættes for opgaver, der involverer stærkt repetitiv bevægelse og/eller vibration. Sygdomme, såsom karpal-tunnelsyndrom og ten-dinitis, kan forårsages eller forværes af repetitiv, kraftig brug af hænder og arme.
--	--

	FORSIGTIG Hold dig på afstand af roterende dele under drift. Hold hænder og arme mindst 60 cm væk fra bevægelige dele, undtagen ved start og stands fling.
--	--

	FORSIGTIG Handsker er ikke en form for beskyttelse. Gå ikke med handsker, mens maskinen betjenes. Spåner og findelt materiale, som udvikles under drift, skal bortskaffes på forsvarlig måde. Dette skal gøres ved brug af en fejebakke og en kost, for at undgå påvirkning af hænderne.
--	--

Από το 1883 η EH Wachs έχει δημιουργήσει μια φήμη ποιότητας και δέσμευση στην καινοτομία. Σίγουρα η Wachs είναι να αναλάβει την πρόβλεψη υποχώρησης να κανονιστεί το καλύτερο για να εξασφαλιστεί την ασφαλέστερη χρήση της εξοπλισμού μας.

Έχουμε καταρτίσει έναν κατάλογο υπομνήσεων ασφαλείας που βασίζονται στη δημιουργία του ασφαλέστερου δυνατού χώρου εργασίας. Σίγουρα την κατάλληλη εφαρμογή των προληπτικών μέτρων που αναγράφονται παρακάτω.



Πριν προχωρήσετε διαβάστε όλες τις παρακάτω υποδείξεις

1. ΔΙΑΒΑΣΤΕ ΤΟ ΒΙΒΛΙΟ ΟΔΗΓΙΩΝ!

Η ανάγνωση των οδηγιών εγκατάστασης και χειρ.ομ.δ. πριν αρχίσετε τις διαδικασίες εγκατάστασης μπορούν να σας εξοικονομήσουν πολύτιμο χρόνο και να βοηθήσουν στην απεριόριστη προαγωγή των χειριστών ή βλάβης των μηχανών.

2. ΕΠΙΘΕΩΡΗΣΤΕ ΤΗ ΜΗΧΑΝΗ ΑΙ ΤΑ ΕΞΑΡΤΗΜΑΤΑ!

Πριν από την εγκατάσταση της μηχανής επιθεωρήστε τη φυσική κατάσταση της μηχανής και των εξαρτημάτων. ελέγξτε για τυχόν φθορά στις γλίστρες των εργαλείων, λεπτομερώς μετωπικά ή παλιμάρδια. Ειδικά για λιπαντικό, υποβελονή σκουριά κτλ. Η μηχανή που λειτουργεί κανονικά μπορεί να μειώσει σημαντικά τις πιθανότητες τραυματισμού.

3. ΠΑΝΤΑ ΔΙΑΒΑΣΤΕ ΤΙΣ ΠΙΝΑ ΙΔΕΣ & ΤΙΣ ΕΤΙ ΕΤΕΣ!

Όλες οι πινακίδες, ετικέτες και αυτοκόλλητα πρέπει να διαβάζονται καθαρά και να βρίσκονται σε καλή κατάσταση. Επεξεργαστείτε ετικέτες μπορείτε να αγοράσετε από τον κατασκευαστή.

4. ΑΠΟΜΑ ΡΥΝΘΕΙΤΕ ΑΠΟ ΤΑ ΠΕΡΙΣΤΡΕΦΟΜΕΝΑ ΕΞΑΡΤΗΜΑΤΑ!

Ρετίστε χέρια, βραχιόνες, και δάχτυλα μακριά από όλα τα περιστρεφόμενα κι κινούμενα εξαρτήματα. Πάντα κλείνετε τη μηχανή πριν επιχειρήσετε οποιαδήποτε ρύθμιση που απαιτεί επαφή με τη μηχανή ή τα εξαρτήματά της.

5. ΜΑΖΕΨΤΕ ΤΑ ΛΥΤΑ ΡΟΥΧΑ & ΟΣΜΗΜΑΤΑ!

Τα ρούχα που δεν έχουν καλή εφαρμογή, τα κοσμήματα τα μακριά λυτά μαλλιά μπορεί να εισαχθούν στα περιστρεφόμενα εξαρτήματα της μηχανής. Στερεώνοντας ή βγάλοντας τα μπορείτε να μειώσετε σημαντικά την πιθανότητα τραυματισμού.

6. ΔΙΑΤΗΡΕΙΤΕ ΕΛΕΥΘΕΡΟ ΤΟ ΧΩΡΟ ΕΡΓΑΣΙΑΣ!

Φροντίστε να διατηρείτε το χώρο εργασίας ελεύθερο από αντικείμενα και εμπορεύματα. Επιτρέψτε την είσοδο μόνο στους έχοντες άμεση σχέση με την εκτελούμενη εργασία αν είναι δυνατό.

ΝΑ ΦΟΡΑΙΣΤΕ ΠΑΝΤΕΣ ΠΡΟΣΤΑΣΙΑΣ ΔΙΑΤΑΞΕΙΣ:

	ΠΡΟΕΙΔΟΠΟΙΗΣΗ Να φοράτε ειδική προστασία των ματιών κατά της πρόσκρουσης όταν χειρίζεστε ή εργάζεστε κοντά στο εργαλείο αμύδι.
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	ΠΡΟΣΟΧΗ Χρειάζεται πάντοτε ατομική προστασία των αυτιών όταν χειρίζεστε ή εργάζεστε κοντά στο εργαλείο αμύδι.
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	ΠΡΟΣΟΧΗ Μερικά όργανα είναι αιχμηρά στις διατάξεις των χεριών και των βραχιόνων όταν εκθέτονται σε εργασίες που συνδέονται εξαιρετικά επαναληπτικές κινήσεις και κραδαλισμούς. Οι διατάξεις όπως το σύνδρομο καρπικής σφραγίδας και η επανακίνηση μπορεί να προκαλέσουν ή να επιδεινωθούν από τις επαναληπτικές, ισχυρές εκκίσεις των χεριών και των βραχιόνων.
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SOCKET WELD REMOVAL SYSTEM

SECTION III

CE DECLARATION OF CONFORMITY

Name and address of manufacturer (if different) E.H. Wachs Company
100 Shepard St.
Wheeling, Il. 60090 USA

Distributed in the EC by:
Business address:

We declare that the machine described below conforms with the EHSR of the machinery directive 89/392/EEC and amendments 91/368/EEC, 93/44/EEC and 93/68/EEC

Machine Title Socket Weld Removal System

Model Number SWA 051 52-000-01, 52-000-02

Machine Description Portable machinery for socket weld removal as well
as small pipe cutting and beveling.

Serial Number _____

Harmonized Standards Used EN 292, EN 292-2, EN 294, EN 349

Other Safety Standards Used PR: EN 982, PR: EN 983: 10/95 PR: EN
792-1 PR: EN 1050

Name of person authorized to sign on behalf of the E.H. Wachs Companies Scott Weldon

Position Vice President / CFO

Signature *Scott Weldon*

Date February 15, 1999

SOCKET WELD REMOVAL SYSTEM

Section IV

SET UP & OPERATING PROCEDURES

SOCKET WELD REMOVAL SYSTEM

SECTION IV

SET UP & OPERATION

INTRODUCTION

The E. H. Wachs 1/2" through 2" socket weld and pipe cutting system is designed for quick and simple socket weld removal as well as small pipe cutting and beveling. The system utilizes a fast one-step collet to locate and clamp to the pipe. The starwheel feed tool slide is simple and easy to use.

PACKAGING

The machine is shipped in a heavy duty storage case with formed foam inserts for maximum machine protection.

MACHINE SPECIFICATIONS

System Capacity:

1" Machine 1/2", 3/4", and 1" pipe, 3000 lb, and 6000 lb socket weld fittings and valves.

2" Machine 1-1/4", 1-1/2", and 2" pipe, 3000 lb, and 6000 lb, socket weld fittings and valves.

System Function:

Socket weld excavation on most fittings and valves without damage to pipe or socket. When equipped with the radial slide, the socket weld machine can be used to cut and bevel pipe.

Drive System:

Standard with a right angle air motor or optional with a right angle gear box to use any standard 3/8" electric drill motor.

MACHINE SET UP

Set up Time: Under 5 minutes

1. Select machine size in accordance with the pipe size to be worked on. (See machine / collet chart on page 4)
2. Once the machine has been selected, choose proper collet assembly for pipe size. (See machine / collet chart on page 4)
3. Select tool bit needed to perform the desired operation. (See tooling chart on page 4)
4. To split the frame halves, four captivated bolts are located on the frame assemblies that will need to be loosened .

Once these have been loosened and the frame halves split, you will need to hold the rotating halves together with the stationary halves as there are no locking pins for them.

5. To mount frame on pipe place each half over the pipe and retighten the four bolts



NOTE: If axial slide dog leg tooling is being used, Refer to tool bit installation instructions for further details..

6. Install the collet assembly. The collet has a taper to it's O.D. The small side of the collet will go into the back of the machine first. On the back side of the large O.D. end of the collet you will see set screws and springs. One set screw will be missing. This is the opening end of the collet. Spread the collet open and close it around the O.D. of the pipe behind the machine with the small O.D. end closest to the machine. Push the collet into the collet receptacle as far as possible. Then, take the collet nut and separate the two halves, place them over the pipe behind the machine , join them and thread the nut into the back of the machine.



NOTE: Collet nut is a left handed thread .

- 6a. Install tooling (see tool bit installation instructions).
7. Slide machine into desired position for cutting. When using the axial tool slide, it is best to position the tool bit approximately 1/16" behind the edge of the weld. When using the radial tool slide, it is best to position the tool bit outer edge 1/16" over the top of the socket as the machine will move back away from the socket as the collet nut is tightened.
8. Using the provided spanner wrench, tighten the collet nut snug.
9. Position and install air motor.
10. Retighten the collet nut using the air motor as a lever .

SOCKET WELD REMOVAL SYSTEM

SECTION IV

SET UP & OPERATION

TOOL BIT INSTALLATION:

SWA 052 RA / Radial Tool Slide

Loosen the two set screws on the side of the tool holder and install the tool bit with the cutting edge set for clockwise rotation. Once the tool bit is in position, retighten the set screws. (see tool bit selection chart)



NOTE: Do not use the cover plate for the radial tool slide for socket weld removal. It is only used when performing cut and bevel operations.

SWA 052 AX / Axial Tool Slide

Loosen the set screw on the front of the tool block and top load the tool bit into position. Then retighten the set screw.

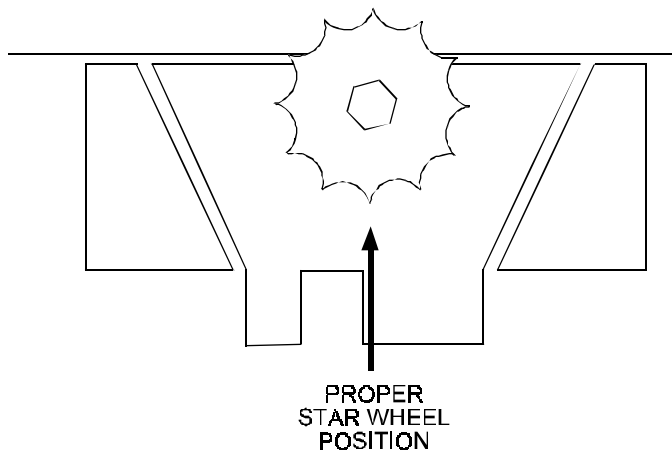


NOTE: When using the dog leg tool bit, you must install the tool bit from the bottom of the tool block before the machine is reassembled over the pipe.

MACHINING SOCKET WELDS

SWA 052 RA / RADIAL TOOL SLIDE:

1. Make sure the tool slide is fully retracted and proceed to time the starwheel. This is done by turning the starwheel with the Allen key in the Allen key socket on top of the starwheel, until one of the tips of the wheel is pointing to the front edge of the tool bit (See illustration below).



2. Press trip feed lever down to engage auto-feed.
3. Squeeze air motor trigger and begin removal of weld material.

SWA 052 AX / AXIAL TOOL SLIDE:

A.) 3000 LB. SOCKETS LESS THAN 1/4" TALL

(SINGLE STEP CUTTING, see illustration on page 14)

1. Loosen the set screw on the front of the tool block to reposition the tool bit. Drop the tool bit down until it contacts the O.D. of the pipe or, for best results, place a .010" shim under the tool to minimize tool bit to pipe contact.
2. Retighten set screw on the front of tool block.
3. Press trip feed lever down to engage auto-feed.
4. Squeeze air motor trigger and begin removal of weld material

B.) 6000 LB. SOCKETS GREATER THAN 1/4" TALL

(MULTISTEP CUTTING, see illustration on page 14)

1. Loosen set screw on the front of the tool block to reposition tool bit. Drop tool bit down to cut no more than the top 3/8" of weld material.
2. Retighten set screw on the front of tool block
3. Press trip feed lever down to engage auto-feed.
4. Squeeze air motor trigger and remove weld material until you are 1/32" past the boss of the socket.
5. Pull trip feed lever up to disengage auto-feed and continue rotating in order to clear chip load.
6. Retract tool slide with 5/32" ball driver supplied. Insert the driver into Allen key socket on the front of the tool slide.
7. Loosen the set screw on the front of the tool block to reposition the tool bit. Drop the tool bit down to cut no more than the next 3/8" of weld material or the balance of the weld material. When making the final cut, drop the tool bit down until it contacts the O.D. or, use a .010" shim to minimize tool bit pipe contact.
8. Retighten the set screw on the front of the tool block.
9. Press trip feed lever to engage auto-feed.

SOCKET WELD REMOVAL SYSTEM

SECTION IV

SET UP & OPERATION

10. Squeeze air motor trigger and remove weld material.



NOTE: When possible, use a factory approved coolant to prolong tool life.

MACHINE REMOVAL

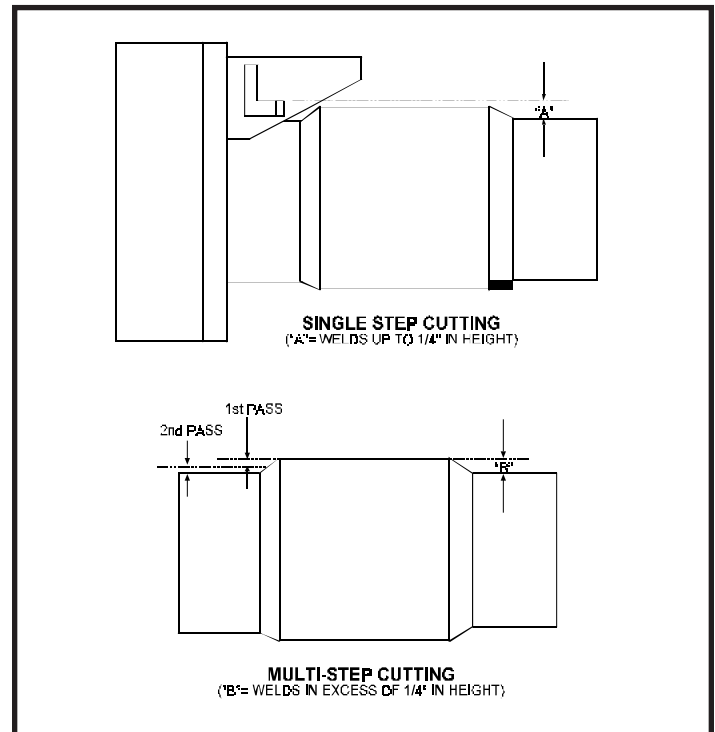
1. When penetration occurs, release the air motor trigger.
2. Retract the tool slide to its starting point by using the tools provided. You will find an Allen key insertion point at the top of the starwheel on the radial slide, or on the front of the feed screw on the axial slide.
3. Loosen the collet nut on the back of the machine and remove it. Then loosen the four bolts on the frame and re-split the frame. Remove the collet assembly from the pipe.

NOTE: If when completed, you have an open end of pipe, you can simply loosen the collet nut and slide the machine off of the open end.

ALARA TIPS:

When socket weld removal is needed in a high rad area, here are some tips that can keep your dose ALARA.

1. Know how the machine operates prior to going into a high rad job. Mock-up practice will greatly improve your efficiency with the socket weld removal time. (LOW STAY TIME)
2. You may wish to install a long hose whip with a valve at the end onto the air motor, then tape over the air motor trigger. This will allow you to increase your distance from the source during machining time. Possibly enough to get behind shielding. (DISTANCE & SHIELDING)



Single and multi-step cutting

SOCKET WELD REMOVAL SYSTEM

Section V

TROUBLESHOOTING

SOCKET WELD REMOVAL SYSTEM

SECTION V

TROUBLE SHOOTING

Trouble	Possible Cause	Remedy
Machine won't run.	No air pressure.	Check air pressure.
Machine shifts during cutting operation.	4-jaw clamp system loose.	Tighten Clamps.
Poor end prep.	Dull or damaged Tool Bit.	Replace Tool Bit.
Machine chatters.	RPM too fast.	Slow down air motor.
Tool Slide does not feed.	Broken Trip Pin.	Replace Trip Pin.

If a problem persists or is not listed in the above chart, cease operation and consult the manufacturer for additional instructions.

SOCKET WELD REMOVAL SYSTEM

Section VI

MISCELLANEOUS CHARTS AND GRAPHS

SOCKET WELD REMOVAL SYSTEM

SECTION VI

OPERATIONAL CHARTS & GRAPHS

AXIAL TOOL SLIDE TOOLING CHART

	DESCRIPTION	TOOL #	1" MACHINE RANGE OF CUT		2" MACHINE RANGE OF CUT	
			MAX.DIA	MIN. DIA.	MAX. DIA	MIN. DIA
	AXIAL STRAIGHT HHS	52-701-01	1.315	.500	2.375	1.625
	AXIAL DOG LEG HSS**	52-701-02	1.315	.500	2.375	1.625
	AXIAL DOG LEG HSS**	52-701-03	1.315	.500	2.375	1.625
	STRAIGHT CARBIDE	52-702-01	1.315	.500	2.375	1.625
	DOG LEG CARBIDE	52-702-02	1.315	.500	2.375	1.625

RADIAL TOOL SLIDE TOOLING CHART

	DESCRIPTION	TOOL #	1" MACHINE RANGE OF CUT		2" MACHINE RANGE OF CUT	
			MAX.DIA	MIN. DIA.	MAX. DIA	MIN. DIA
	Weld Removal Tool (radial)	52-703-01	2.000	.875	3.125	2.000
	Weld Removal Tool (radial)	52-703-02	1.625	.500	2.750	1.625
	Weld Removal Tool (radial)	52-703-03	1.250	.500	2.375	1.250

37.5 DEG CUT & BEVEL TOOLING CHART

	DESCRIPTION	TOOL #	1" MACHINE RANGE OF CUT		2" MACHINE RANGE OF CUT	
			MAX.DIA	MIN. DIA.	MAX. DIA	MIN. DIA
	37.5 DEG CUT & BEVEL	52-704-01	1.375	.500	2.375	1.250
	37.5 DEG CUT & BEVEL	52-704-02	1.063	.500	2.063	.938
	37.5 DEG CUT & BEVEL	52-704-03	.750	.500	1.875	.750

COLLET SIZE SELECTION CHART

1" MACHINE

2" MACHINE

PART #	COLLET SIZE	PIPE	O.D.		PART #	COLLET SIZE	PIPE	O.D.
52-105-01	1/2"	1/2"	.840		52-105-02	1-1/4"	1-1/4"	1.660
52-104-01	3/4"	3/4"	1.050		52-104-02	1-1/2"	1-1/2"	1.200
52-103-01	1"	1"	1.315		52-103-02	2"	2"	2.375

SOCKET WELD REMOVAL SYSTEM

SECTION VI

OPERATIONAL CHARTS & GRAPHS

SOCKET WELD TOOLING CHART	
PART NO.	DESCRIPTION
52-703-01	CUT/BEVEL TOOL - SHORT
52-703-02	CUT/BEVEL TOOL - MEDIUM
52-703-03	CUT/BEVEL TOOL - LONG
52-704-01	CUT/BEVEL TOOL, 37 -1/2° - SHORT
52-704-02	CUT/BEVEL TOOL, 37-1/2° - MEDIUM
52-704-03	CUT/BEVEL TOOL, 37-1/2° - LONG
56-706-00	BEVEL TOOL, 30°

SOCKET WELD REMOVAL SYSTEM

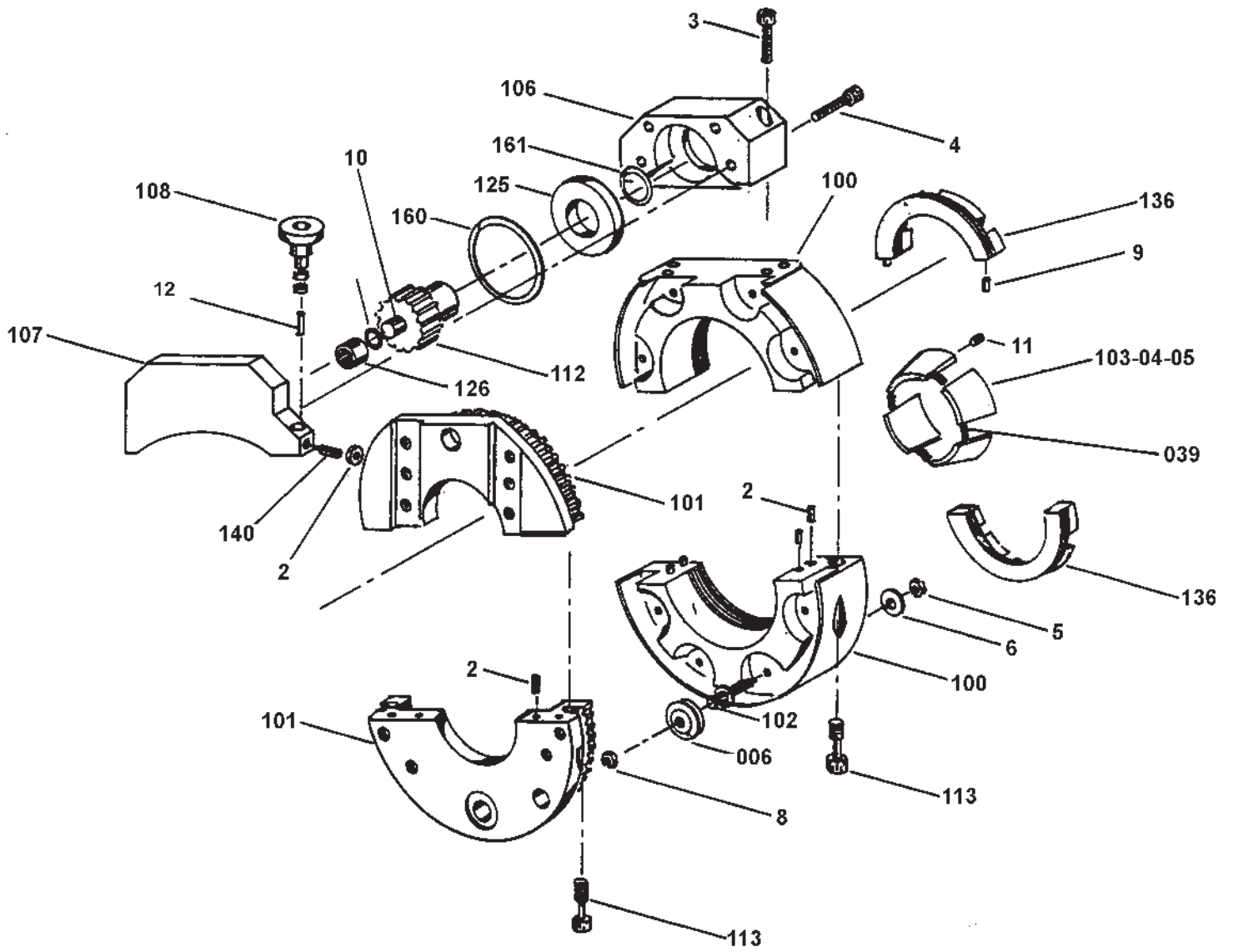
Section VII

PARTS LISTS AND EXPLODED VIEW DRAWINGS

SOCKET WELD REMOVAL SYSTEM

1" SOCKET WELD REMOVAL MACHINE FRAME ASSEMBLY 52-000-01

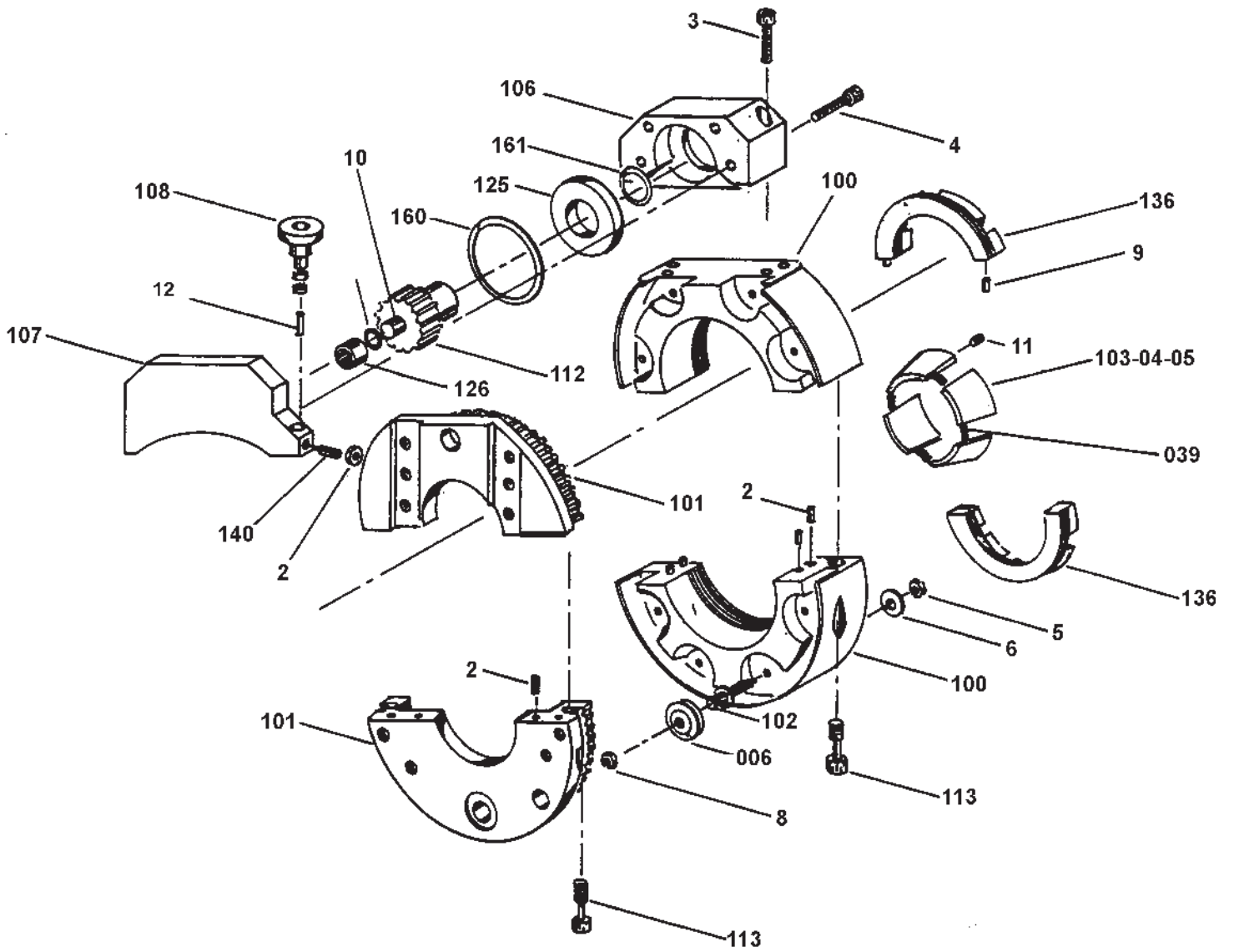
REF	PART No.	QTY.	DESCRIPTION
100	52-100-01	1	FRAME, STATIONARY 1"
101	52-101-01	1	FRAME, ROTARY 1"
102	52-102-00	8	SHAFT, ECCENTRIC
006	43-006-00	8	BEARING
103	52-103-01	1	COLLET - 1"
104	52-104-01	1	COLLET - 3/4"
105	52-105-01	1	COLLET - 1/2"
106	52-106-00	1	HOUSING, PINION-REAR
107	52-107-01	1	HOUSING, PINION-FRONT
108	52-108-00	1	PIN, TRIP
112	52-112-00	1	PINION, DRIVE
125	60-125-00	1	BEA RING, PINION-REAR
126	60-126-00	1	BEARING, PINION-FRONT
161	60-145-00	1	RING, RETAIN
160	60-160-00	1	RING, RETAIN LC1-12
113	52-113-00	4	BOLT, CAPTIVATED
136	52-136-01	1	NUT, COLLET - 1"
142	52-142-00	1	WRENCH, COLLET (NOT SHOWN)
209	60-209-00	1	SEAL, PINION HOUSING
039	31-039-00	2	SPRING, COLLET
N/S	43-054-00	1	INSERT, FOAM
N/S	16-082-00	1	CASE
FASTENERS			
2	90-046-03	8	3/16" DIA. X 3/8" LG.DOWEL PIN
3	90-050-15	2	SHCS, 1/4-20 X 1-1/2"
4	90-040-12	4	SHCS, 10-24 X 1-1/4"
5	90-055-02	8	HEX NUT, 1/4-28
6	90-055-54	8	WASHER, AN 1/4"
8	90-045-01	8	NUT, 10-32 JAM
9	90-046-02	2	PIN, DOWELL 3/16" X 1/4"
10	90-076-07	1	PIN, DOWEL 3/8" X 3/4"
11	90-044-00	21	10-24 X 3/16" CONE POINT SSS
12	90-026-15	3	1/8" x 1-1/2" DOWEL PIN



SOCKET WELD REMOVAL SYSTEM

2" SOCKET WELD REMOVAL MACHINE FRAME ASSEMBLY 52-000-02

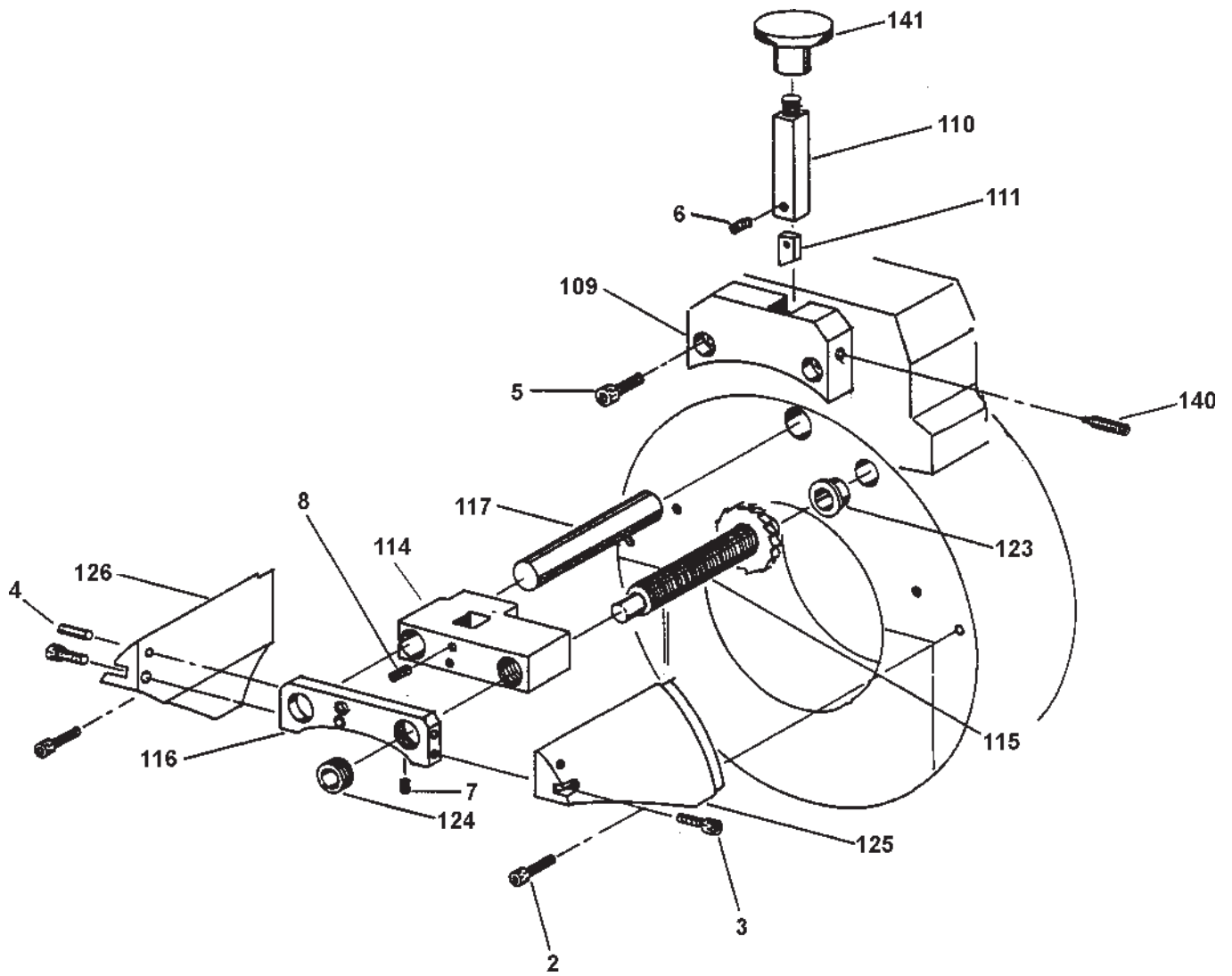
REF	PART No.	QTY.	DESCRIPTION
006	43-006-00	8	BEARING
039	31-039-00	12	SPRING COLLET
100	52-100-02	1	FRAME, STATIONARY 2"
101	52-101-02	1	FRAME, ROTARY 2"
102	52-102-00	8	SHAFT, ECCENTRIC
103	52-103-02	1	COLLET - 2"
104	52-104-02	1	COLLET - 1-1/2"
105	52-105-02	1	COLLET - 1-1/4"
106	52-106-00	1	HOUSING, PINION-REAR
107	52-107-02	1	HOUSING, PINION-FRONT
108	52-108-00	1	PIN, TRIP
112	52-112-00	1	PINION, DRIVE
113	52-113-00	4	BOLT, CAPTIVATED
123	52-123-00	1	BUSHING
125	60-125-00	1	BEARING, PINION-REAR
126	60-126-00	1	BEARING, PINION-FRONT
136	52-136-02	1	NUT, COLLET-2"
140	52-140-00	1	PLUNGER
142	52-142-02	1	WRENCH, COLLET-2" (NOT SHOWN)
145	52-145-00	1	RING, RETAINING
146	52-146-00	1	TAG, SERIAL
160	60-160-00	1	RING, RETAIN LC1-12
209	60-209-00	1	SEAL, PINION HOUSING
N/S	43-054-00	1	INSERT, FOAM
N/S	16-082-00	1	CASE
FASTENERS			
2	90-046-03	8	3/16" DIA. x 3/8" LG.DOWEL PIN
3	90-050-15	2	SHCS, 1/4-20 x1-1/2"
4	90-040-12	4	SHCS, 10-24 x 1-1/4"
5	90-055-02	8	HEX NUT, 1/4-28
6	90-055-54	8	WASHER, AN 1/4"
8	90-045-01	8	NUT, 10-32 JAM
8	90-055-02	8	HEX NUT, 1/4-28
9	90-046-02	2	PIN, DOWEL 3/16"x 1/4"
10	90-076-07	1	PIN, DOWEL 3/8" x 3/4"
11	90-044-00	21	10-24 x 3/16" CONE POINT SSS
12	90-026-15	3	1/8" x 1-1/2" DOWEL PIN



SOCKET WELD REMOVAL SYSTEM

SOCKET WELD REMOVAL AXIAL FEED TOOL SLIDE ASSEMBLY 52-401-00

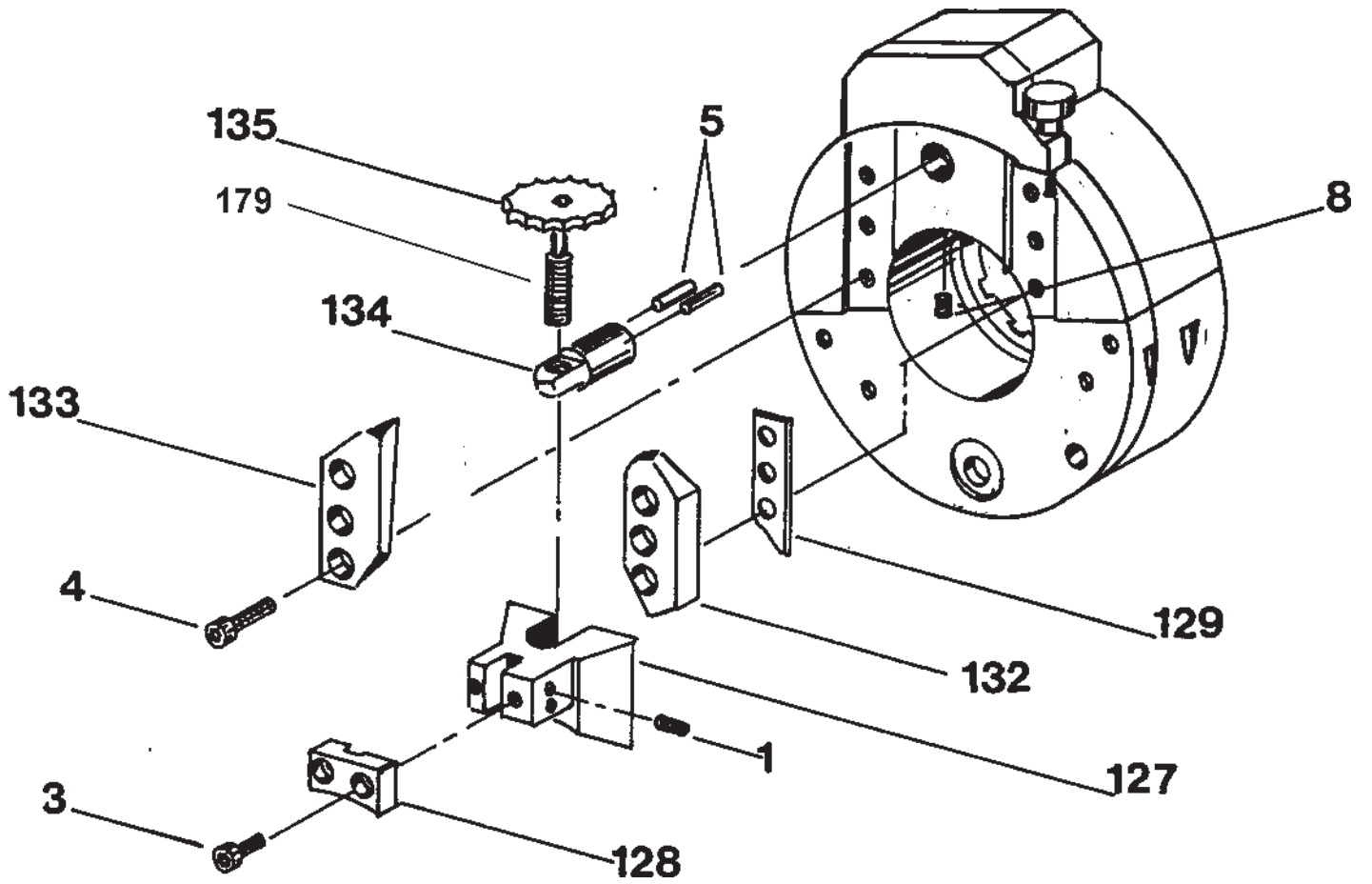
REF	PART No.	QTY.	DESCRIPTION
140	52-140-00	1	PLUNGER, BALL
109	52-110-00	1	HOUSING, TRIP-AXIAL
110	52-109-00	1	BLOCK, TRIP
111	52-111-00	1	INSERT, TRIP
114	52-114-00	1	SLIDE, TOOL-AXIAL
115	52-115-00	1	SCREW, FEED-AXIAL
116	52-116-00	1	PLATE
117	52-117-00	1	ROD
123	52-123-00	1	BUSHING, FEED-AXIAL
124	52-124-00	1	BUSHING, PRELOAD
125	52-125-00	1	BUTTRESS, LEAD
126	52-126-00	1	BUTTRESS, TRAIL
N/S	52-131-00	1	COVER, RADIAL SLIDE
141	52-141-00	1	KNOB
 FASTENERS			
N/S	90-052-03	4	BHCS, 1/4-20 X 3/8"
2	90-040-07	4	SHCS, 10-24 X 3/4"
3	90-040-05	2	SHCS, 10-24 X 1/2"
4	90-026-02	2	PIN, DOWEL 1/8" X 1/4" LONG
5	90-050-06	2	SHCS, 1/4-20 X 5/8"
6	90-044-01	1	SSS, 10-24 X 1/8"
7	90-044-00	3	SSS, 10-24 X 3/16"



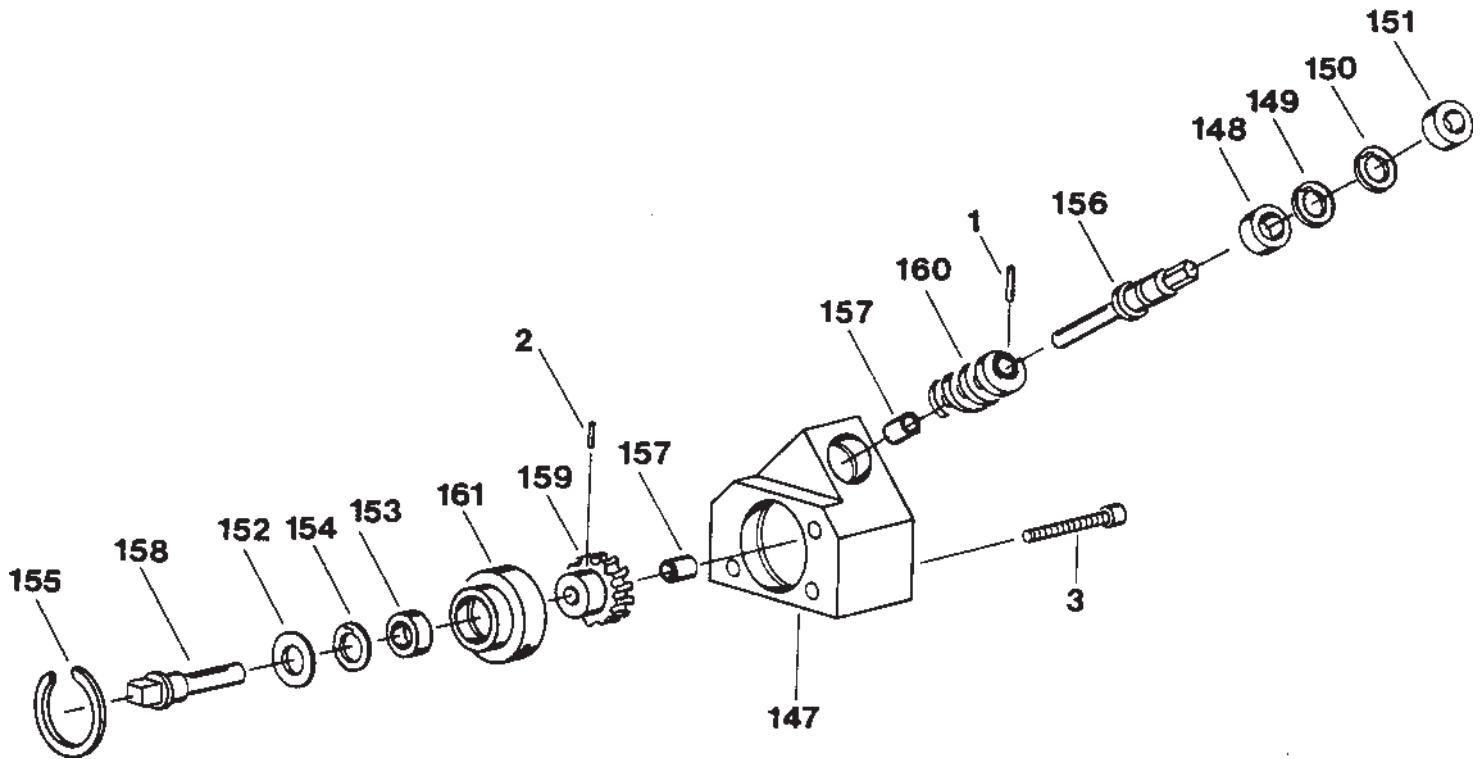
SOCKET WELD REMOVAL SYSTEM

SOCKET WELD REMOVAL RADIAL FEED TOOL SLIDE ASSEMBLY 52-402-00

REF	PART No.	QTY.	DESCRIPTION
108	52-108-00	1	HOUSING, TRIP PIN (SEE FRAME ASSY. DRAWING)
127	52-127-00	1	SLIDE, MALE
128	52-128-00	1	COVER, TOOL SLIDE
129	52-129-00	18	SHIM, .001"
N/S	52-130-00	1	COVER, AXIAL SLIDE
132	52-132-00	1	DOVETAIL, ADJUSTABLE
133	52-133-00	1	DOVETAIL, FIXED
134	52-181-00	1	SUPPORT, FEED SCREW
135	52-180-00	1	STAR WHEEL
137	52-137-00	1	SCREW, 1/4-20 X 7/16"
N/S	52-138-00	1	STICKER, PIN LENGTH
140	52-140-00	1	PLUNGER, BALL (SEE FRAME ASSY. DRAWING)
179	52-179-01	1	FEED SCREW
FASTENERS			
1	90-024-02	2	SSS, 8-32 X 1/4" LONG
2	90-045-01	1	NUT, 10-32 JAM (SEE FRAME ASSY. DRAWING)
3	90-040-05	2	SHCS, 10-24 X 1/2"
4	90-050-07	6	SHCS, 1/4-20 X 3/4"
5	90-026-05	2	PIN, DOWEL 1/8" X 1/2"
6	90-026-15	1	PIN, DOWEL 1/8-1 X 1-1/2" (SEE FRAME ASSY. DRAWING)
N/S	90-042-03	4	BHCS, 10-24 X 3/8"
8	90-054-06	1	1/4-20 X 7/16" DOG POINT SSS



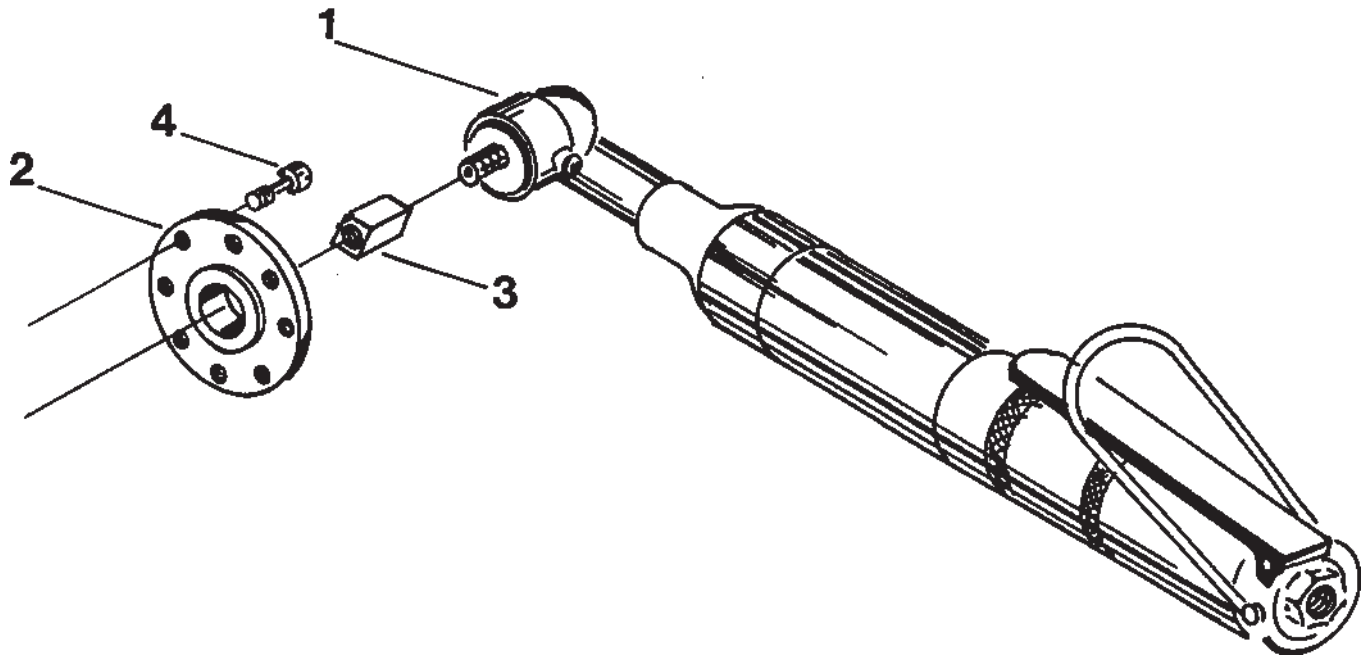
SOCKET WELD REMOVAL SYSTEM



SOCKET WELD REMOVAL
RIGHT ANGLE DRIVE-3/8" DRILL
 52-405-00

REF	PART No.	QTY.	DESCRIPTION
147	52-147-00	1	HOUSING, GEARBOX
148	52-148-00	1	BEARING, INPUT
149	52-149-00	1	RING RETAINING, SHAFT
150	52-150-00	1	RING RETAINING, HOUSING
151	52-151-00	1	SEAL, INPUT
152	52-152-00	1	SEAL, OUTPUT SHAFT
153	52-153-00	1	BEARING, OUTPUT SHAFT
154	52-154-00	1	RING, RETAINING SLEEVE
155	52-155-00	1	RING, RETAINING HOUSING
156	52-156-00	1	SHAFT, IMPUT
157	52-157-00	2	BEARING, SLEEVE
158	52-158-00	1	SHAFT, OUTPUT
159	52-159-00	1	GEAR, WORM
160	52-160-00	1	WORM
161	52-161-00	1	SLEEVE
FASTENERS			
1	90-016-51	1	PIN, ROLL 7/64 x 1/2
2	90-026-56	1	PIN, ROLL 1/8 x 5/8
3	90-050-15	3	SHCS, 1/4-20 x 1/2

SOCKET WELD REMOVAL SYSTEM



BILL OF MATERIAL

52-403-00 AIR DRIVE

REF. NO.	PART NO.	QTY.	DESCRIPTION
1	52-120-00	1	MOTOR, AIR
2	52-121-00	1	FLANGE, AIR
3	52-122-00	1	BLOCK, ADAPTER
4	43-067-00	2	SCREW, CAPTIVE

To place an order or to get more detailed information on any E.H. Wachs products, call us at:
1-800-323-8185.

ORDERING REPLACEMENT PARTS

Please use parts list provided in manual. Have part description and part number of required replacement part or parts to help expedite order and insure proper parts are being ordered.

REPAIR INFORMATION

Please call E.H. Wachs Company prior to returning any equipment for repair. We will advise you of shipping and handling. Please enclose with equipment to be repaired your name, address, phone number and a brief description of problem or work to be done or estimated.

All repair work done at our plant will be estimated and the customer advised of cost and time required to complete repair.

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RETURN GOODS ADDRESS

E.H. Wachs Company
100 Shepard Street
Wheeling, Illinois 60090



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