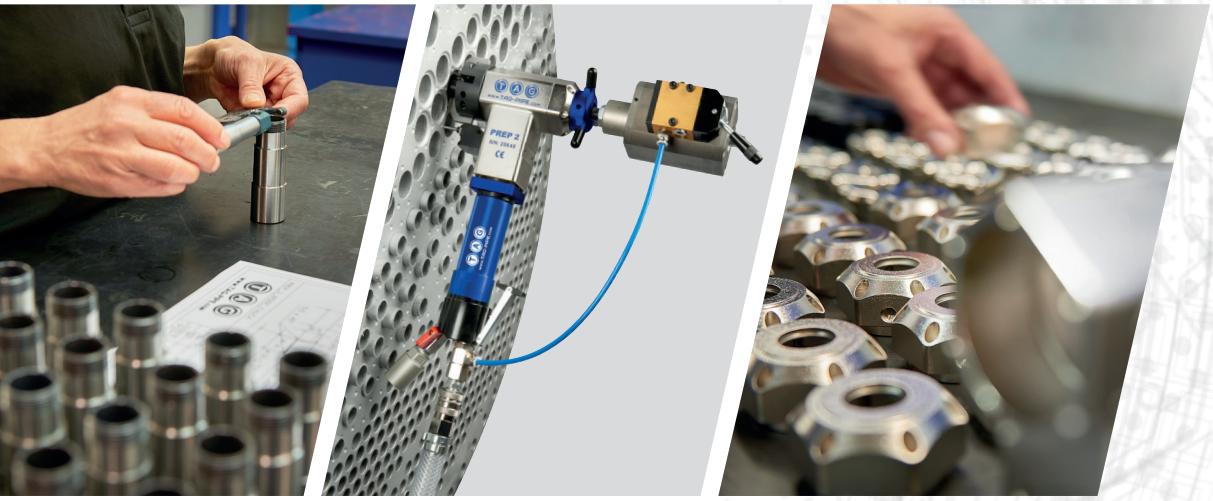
PREP 2 PORTABLE PIPE BEVELLING MACHINE

0.9 - 1.65" i/d / 23 - 42 mm i/d

(optional from 0.5" i/d / 12.5 mm i/d)

ORIGINAL INSTRUCTIONS / NOTICE ORIGINAL



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TO WATCH VIDEO

TAG
PIPE EQUIPMENT SPECIALISTS

INSTRUCTION MANUAL

www.TAG-PIPE.com

*The **Specialized Fabrication Equipment Group** (in short: **S.F.E. Group**) was founded in 2019 after the merger of three world leading OEM's in the field of pipe fabrication tooling and machinery: B&B Pipe and Industrial Tools LLC (USA), Mathey Dearman Inc. (USA) and TAG Pipe Equipment Specialists (UK). In a time span of 5 years, another 4 renowned and market leading companies were acquired and added to the **S.F.E. Group** portfolio: Axxair (France, 2022), Magnatech (USA, 2023), Climax (USA, 2023) and Sumner (USA, 2025).*

*The vision and philosophy of the **S.F.E. Group** is to offer globally a comprehensive innovative and cost-effective range of specialized fabrication, welding and machining equipment and derived rental solutions, for a wide range of applications within all critical industries, while optimizing performance, efficiency and safety.*

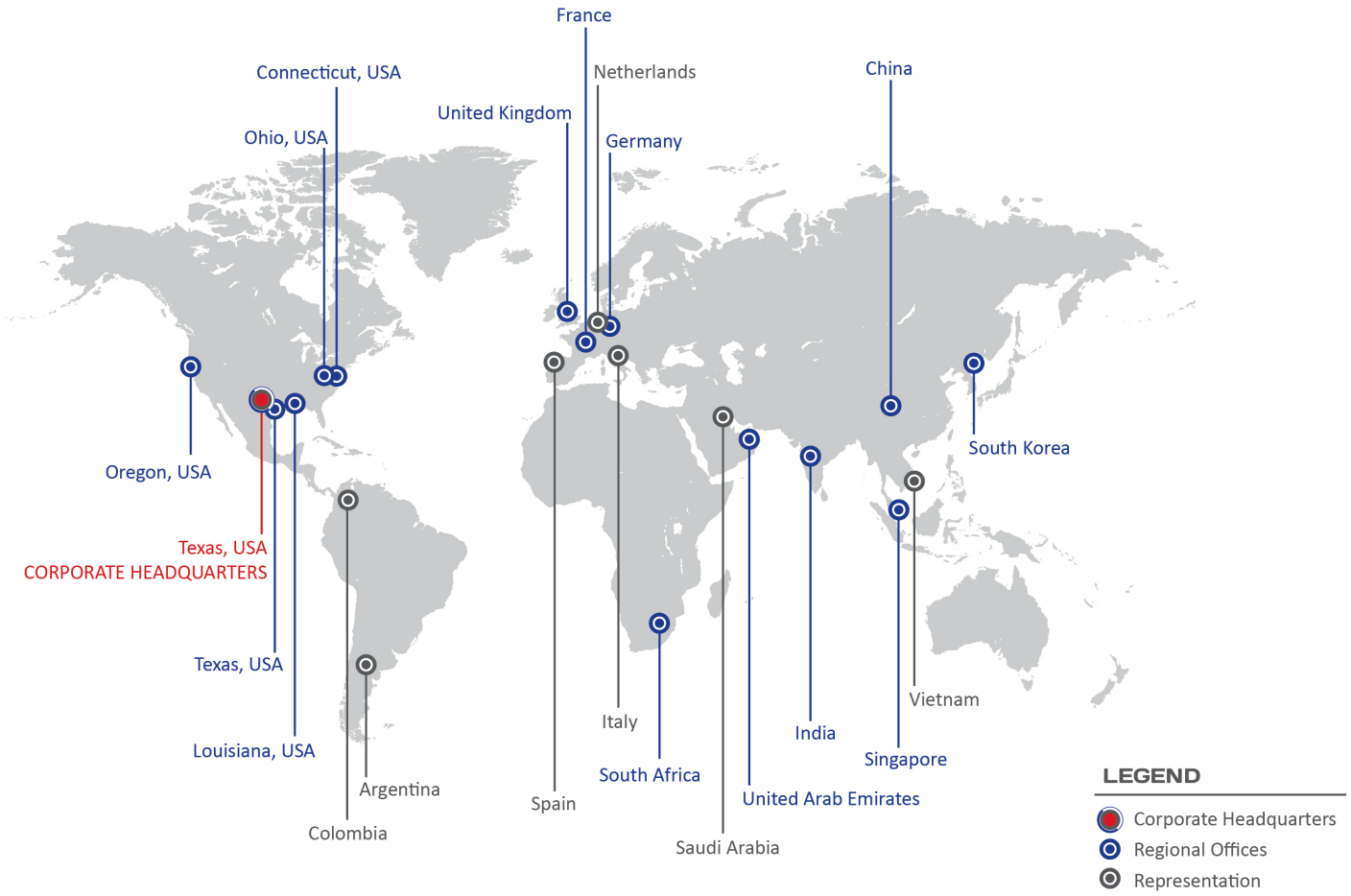
*Leveraging over 200 years of combined experience in engineering, manufacturing, and field applications, the **S.F.E. Group** is committed to driving innovation. Through continuous product development and strategic acquisitions, the **S.F.E. Group** is actively growing its portfolio and expanding its global presence to meet the demands of industries around the world. Currently, the **S.F.E. Group** consists of 12 complimentary brands, each supporting the others in delivering cutting-edge solutions.*

*With offices and warehousing on 5 continents, 400+ employees and more than 500 partnerships and distributors worldwide, **S.F.E. Group** prides itself on consistently offering the highest standards of both product quality and service locally to all its customers.*

S.F.E. Group looks forward to welcoming you into its global network as a partner, distributor or end user customer and remains at your disposal at any time.

Contact International: sales-int@sfe-brands.com

S.F.E. GROUP GLOBAL PRESENCE



INTRODUCING TAG PIPE

*The S.F.E. Group's brand **TAG Pipe Equipment Specialists LTD** (in short: **TAG PIPE**) has its roots in the 1980's in the United Kingdom with the manufacturing and supplying of pipework fabrication tools and machinery. Over the years TAG PIPE became internationally one of the foremost leaders in its field, and today S.F.E. Group's unrivalled **TAG PIPE** range of cold cutting and bevelling machines is established and recognized as a world class leading brand.*

*Backed by more than 40 years of development, **TAG PIPE** not only offers the highest quality heavy duty machines utilizing the latest technology, but also stands for an emphasis on continuous R&D and tailor made solutions. As an OEM, S.F.E. Group prides itself being renowned for its innovations, ground-breaking developments and patented designs within the **TAG PIPE** range. With its engineering capabilities, customer-oriented focus and flexibility, the **TAG PIPE** brand provides the possibility to design out-of-the-box machining applications and solutions to fulfil customers' projects' specific needs in particular, and to cater for an ever-evolving industry in general.*

*The **TAG PIPE** brand portfolio consists of a complete range of portable pipe bevel machines (PREP machines covering 1 - 24"), the **TAG PIPE** cutting and bevelling splitframe clamshell machines (1 - 120"), as well as the stationary, yet moveable E-Z FAB machines (2 - 16") for pipe cutting and bevelling, the E-Z pipe saws and finally the PMM plate bevel machines.*

***TAG PIPE** machines are always nearby available within the S.F.E. Group global network and can be consulted on the dedicated website: **www.TAG-PIPE.com**.*

INDUSTRIES SERVED

OUR BRANDS

CLIMAX · TAG PIPE EQUIPMENT SPECIALISTS · H&S TOOL · MATHEY DEARMAN · AXXAIR · MAGNATECH · B&B SUMNER · CALDER · BORTECH · PPM PIPE PURGE MASTERS · FIT-UP PRO By Mathey Dearman · SUMNER MATERIAL LIFTS & CARTS


TAG PREP 2
TAG PREP 24

1 - PREFACE

This manual provides the essential information and step-by-step guidance to the principle, configuration, installation and usage of the AXXAIR SAS – S.F.E. Group's TAG PREP machine models (in short: S.F.E. Group, TAG PREP or 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 theirs performance and expand theirs 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 S.F.E. Group authorised partner or our France International Head Office - customer service department: **+33 4 75 57 50 79**. You can also email us: **sales-int@sfe-brands.com**.

DISCLAIMER
AXXAIR SAS – S.F.E. Group'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. S.F.E. Group 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, S.F.E. Group 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** - S.F.E. Group takes great pride in manufacturing safe, quality products with user safety as key priority. S.F.E. Group 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 S.F.E. Group 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 TAG 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.

You'll find below the various significations and explanations on the symbolic used in this manual.
In this manual, warning messages and symbols are used to alert you about the danger of injuries or material damage during the use of machinery. It is essential to read carefully and to keep in mind these warnings in order to work safely.

DIRECT DANGER - Non observance could result in death or critical injury. Observe and carefully apply usage recommendations.

POSSIBLE DANGER - Non observance could result in serious injury. Observe and carefully apply usage recommendations.

SAFETY BOOTS - Protective footwear must be worn.

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. 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.

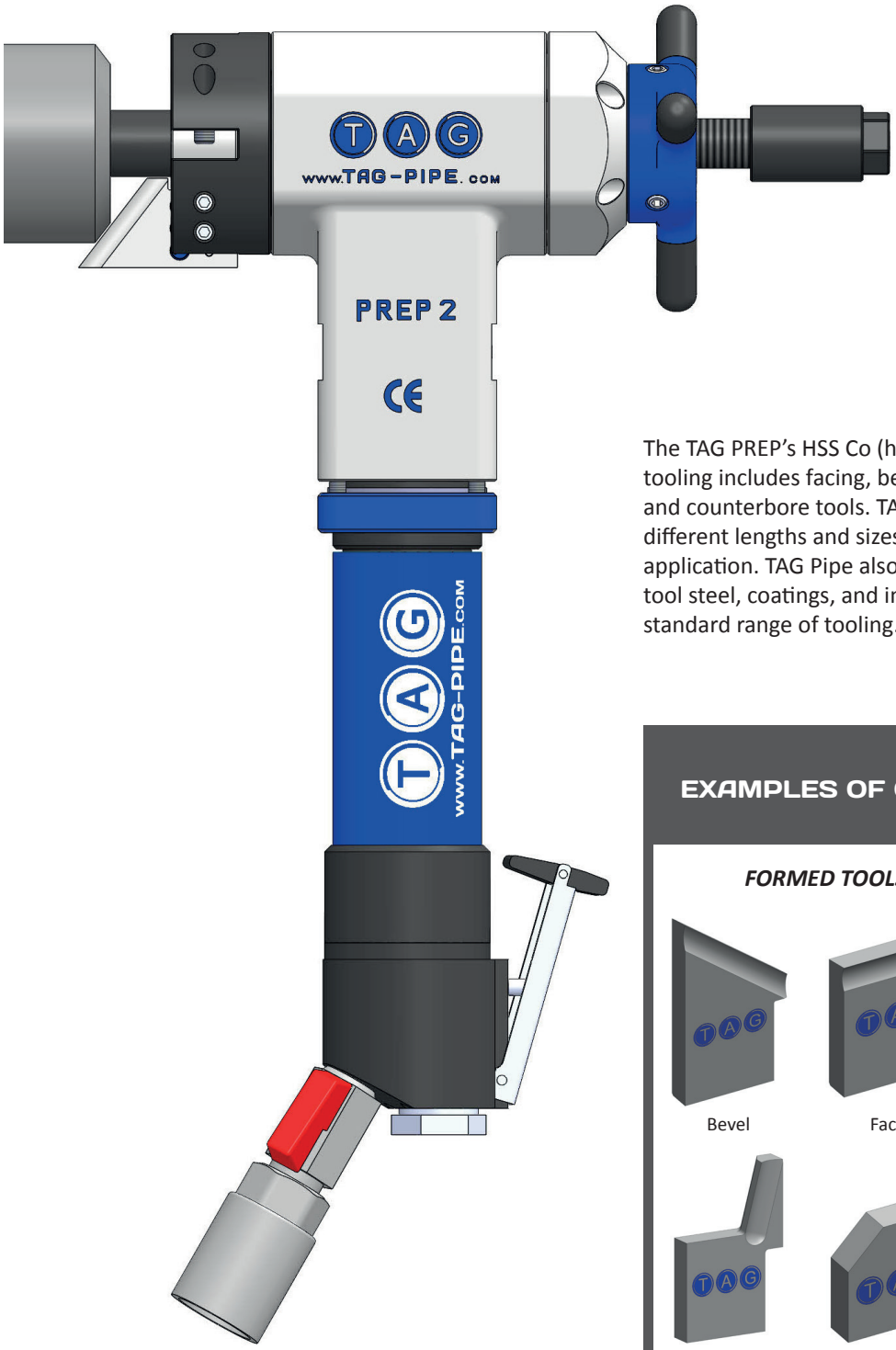
4 - SPECIFIC INSTRUCTIONS

- Use solely original TAG 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 S.F.E. Group or an S.F.E. Group authorised 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 motorisations: 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 performance and expand their machining capacity.

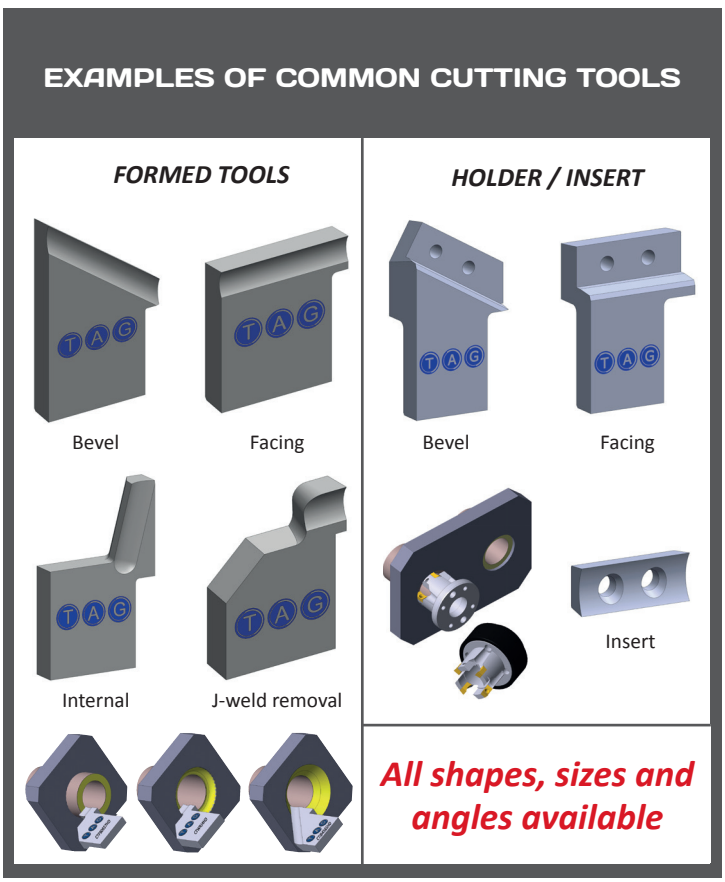


It works while inserted and locked into the ID of the pipe.

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

The TAG PREP's HSS Co (high speed steel with cobalt) range of tooling includes facing, bevel, double-bevel, compound bevel and counterbore 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



SAFETY BOOTS (MANDATORY)
Protective footwear must be worn when handling this machine.

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 2 can be equipped with the following motor types:

PNEUMATIC

ELECTRIC

BATTERY

The TAG PREP 2 can be equipped with optionals:

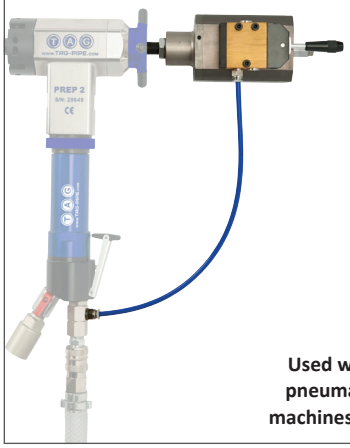
REDUCED SHAFT

0.5 - 0.9" i/d
12.5 - 23 mm i/d

ELBOW / FITTINGS SHAFT

1 - 2" i/d
26 - 51 mm i/d

AUTO LOCK

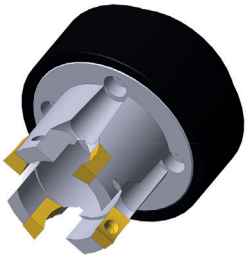


Used with pneumatic machines only

RATCHET HANDLES

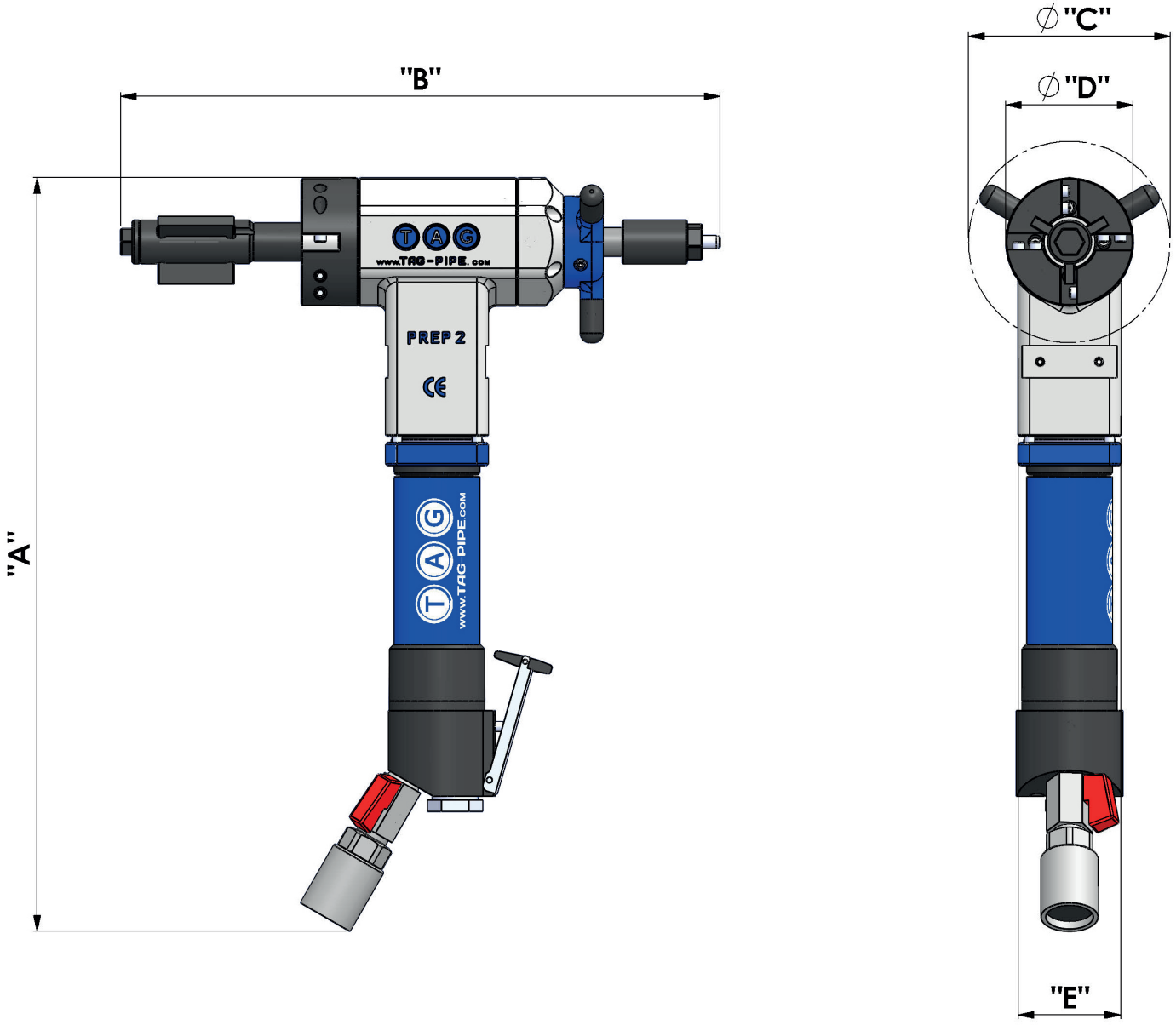
FEED STOPPER

MILLING HEADS



6 - MACHINE TECHNICAL DATA

The TAG PREP 2 dimensional specifications.



DIM	PNEUMATIC	ELECTRIC	BATTERY
A	400 mm	430 mm	470 mm
B	316 mm	316 mm	316 mm
Ø C	106 mm	106 mm	106 mm
Ø D	67 mm	67 mm	67 mm
E	54 mm	72 mm	72 mm

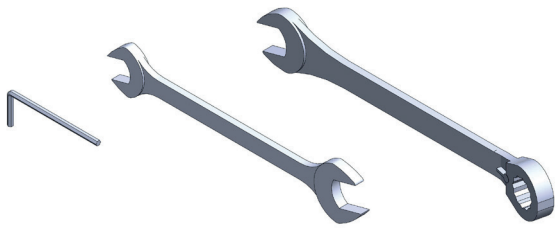
PREP 2 TECHNICAL FEATURES

DESCRIPTION	MEASUREMENT	PNEUMATIC	ELECTRIC	BATTERY
Part Number	n/a	TP2P / TP2PALL	TP2E110 / TP2E220	TP2B110 / TP2B220
Locking tube range	mm (i/d)	23 - 42 mm optional from 12.5	23 - 42 mm optional from 12.5	23 - 42 mm optional from 12.5
Locking tube range	inch (i/d)	0.9 - 1.5" optional from 0.5"	0.9 - 1.5" optional from 0.5"	0.9 - 1.5" optional from 0.5"
Idle speed	rpm	5 - 215	5 - 250	80 / 120 / 160
Torque	N m	56	50	60
Length of axial feed	mm	24	24	24
Maximum operating temperature	°C	55	55	55
Maximum acoustic radiation	dB	75	75	75
Pneumatic motor power	hp	0.7	n/a	n/a
Air consumption	cfm / l/min.	28 / 800	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	720	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	4.8 / 10.6	5.5 / 12	5.7 / 12.5
Packing dimensions	mm	545 x 400 x 120	545 x 400 x 120	560 x 570 x 120
Packing weight	kg / lbs	13.5 / 30	14.5 / 32	15.5 / 34

Our group policy is one of continuous improvement. Products and data tables are subject to change and may vary from those illustrated.

7 - MACHINE STANDARD EQUIPMENT

SERVICE TOOLS



METAL CASE

INSTRUCTION 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.

STEP 1

Fig. 1

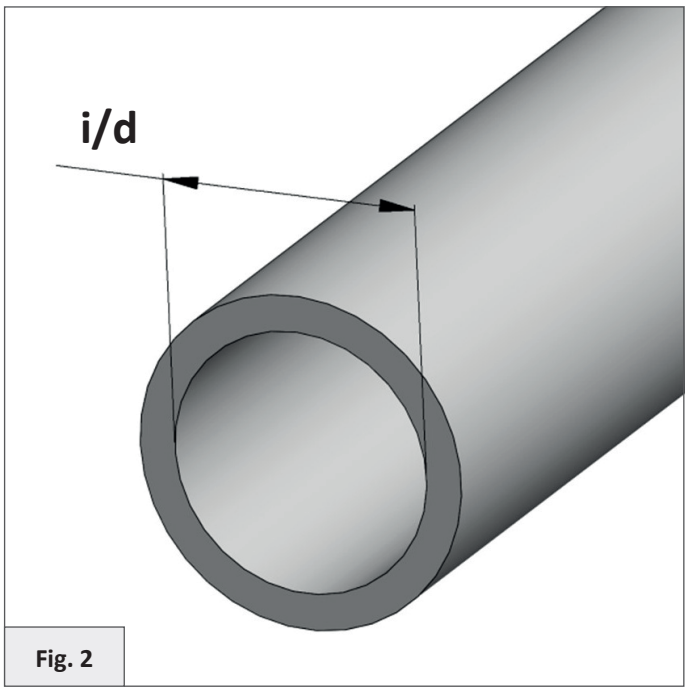


Fig. 2

STEP 2

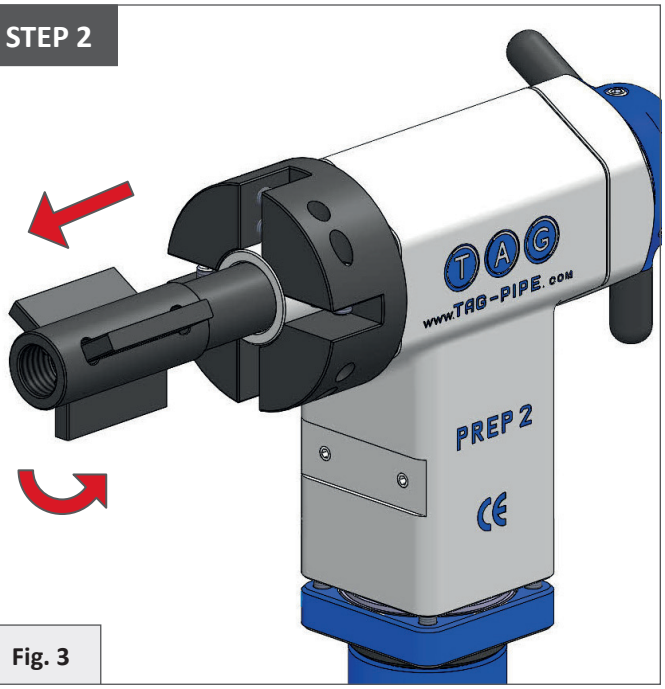


Fig. 3

Unscrew the shaft end nut anti-clockwise.

STEP 3

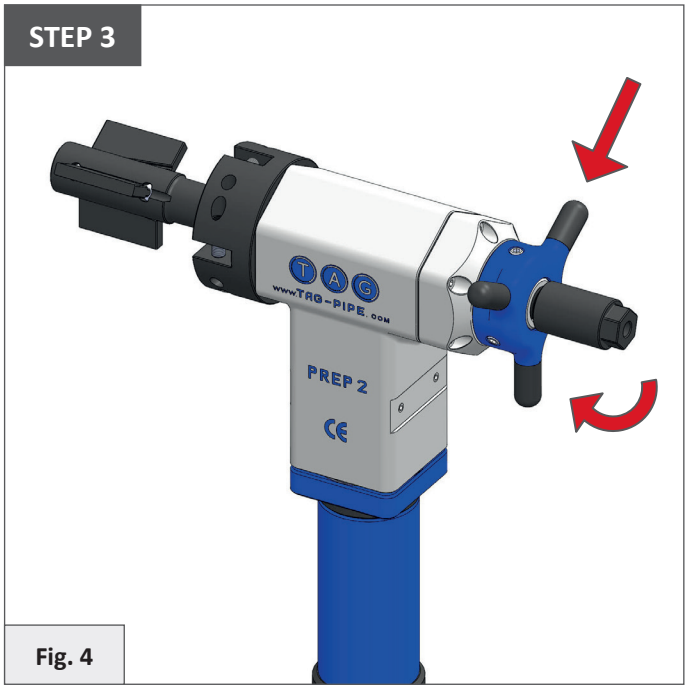


Fig. 4

Turn the lock/unlock nut clockwise to the maximum expansion.

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

STEP 4

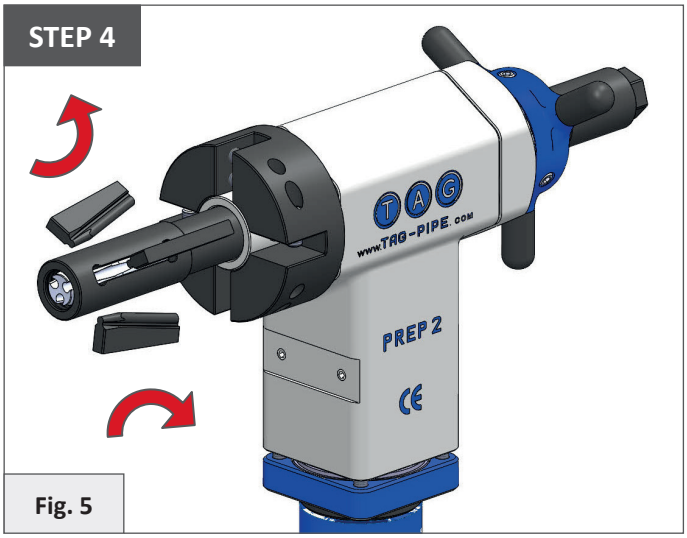


Fig. 5

Remove the locking jaws.

STEP 5

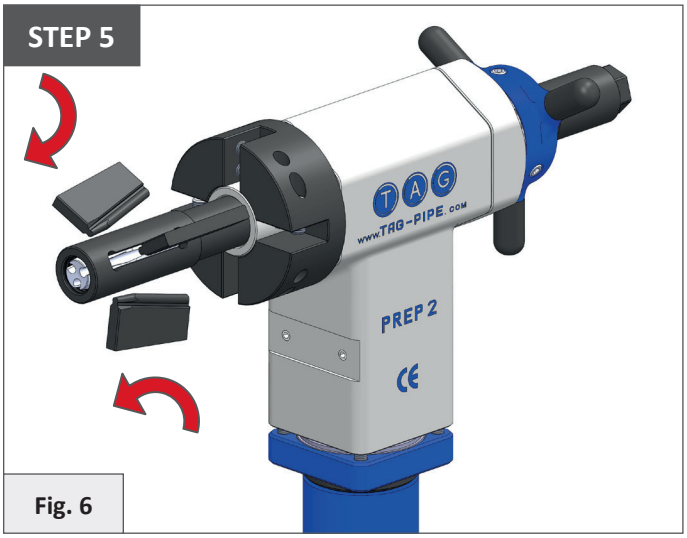


Fig. 6

Select the locking jaws according to the diameter of the pipe and install them on the inside shaft as shown (Fig. 6).

STEP 6

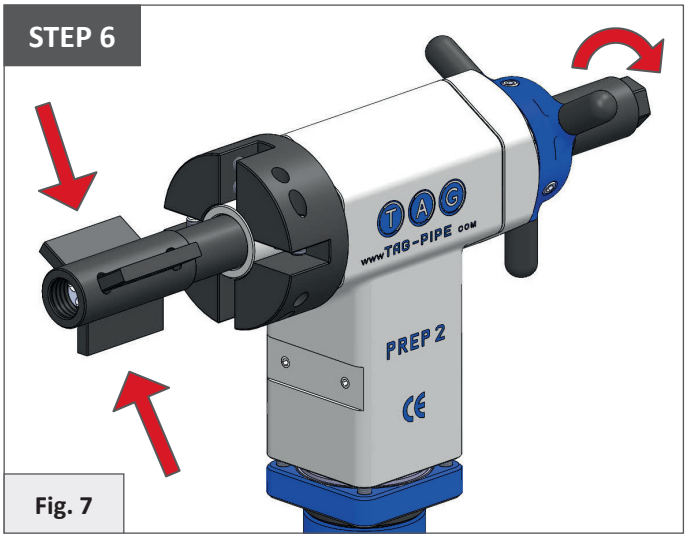


Fig. 7

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

STEP 7

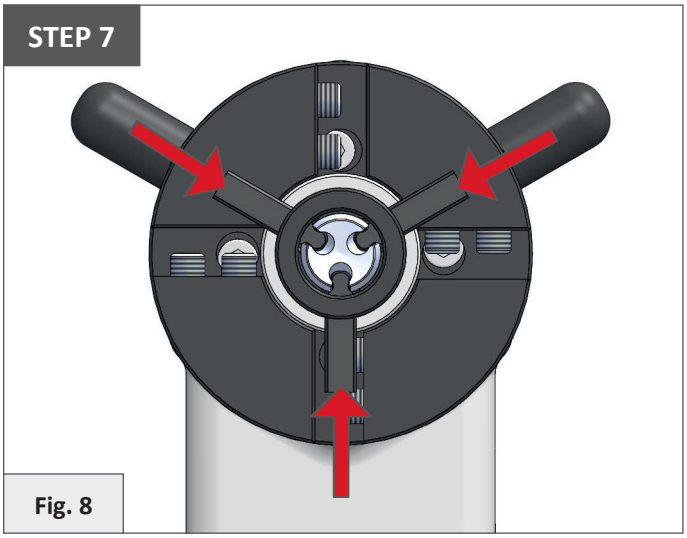


Fig. 8

If the procedure is correctly made, the locking jaws should have a bit of play/movement.

STEP 8

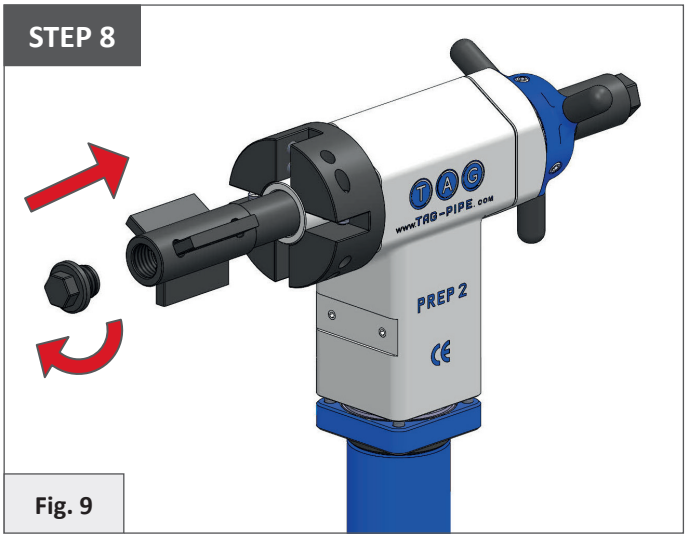


Fig. 9

Screw on the shaft end nut in a clockwise direction.

STEP 9

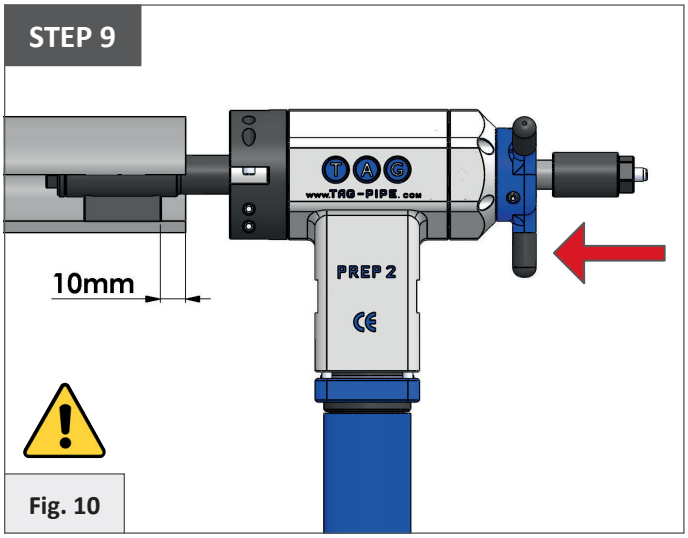
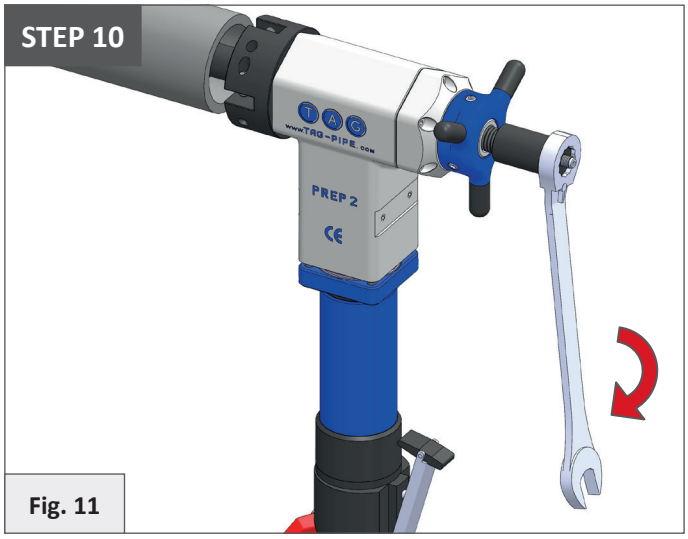


Fig. 10

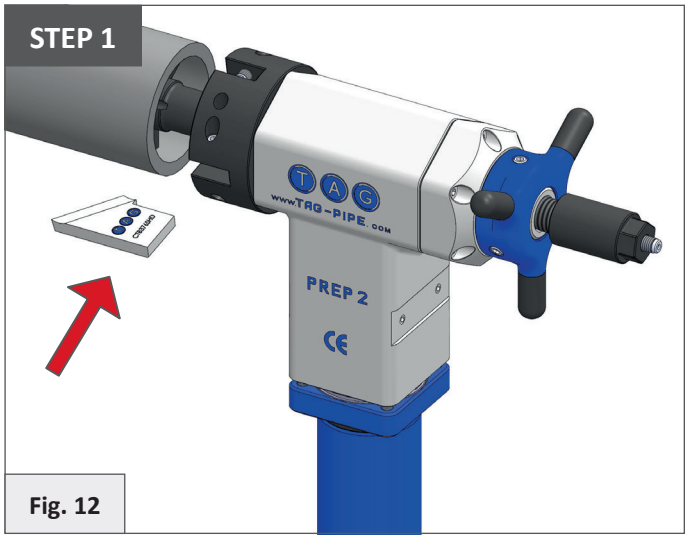
WARNING - In order to achieve the perfect positioning and locking, the jaws have to be inserted 10 mm minimum, into the i/d of the pipe as shown (Fig.10).

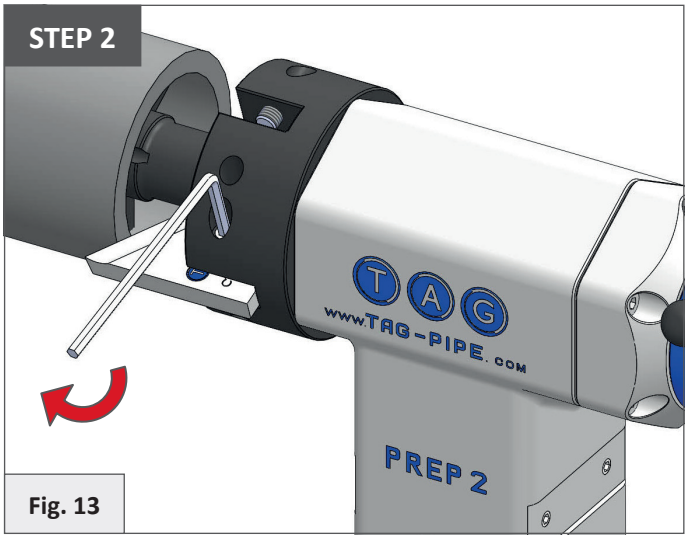


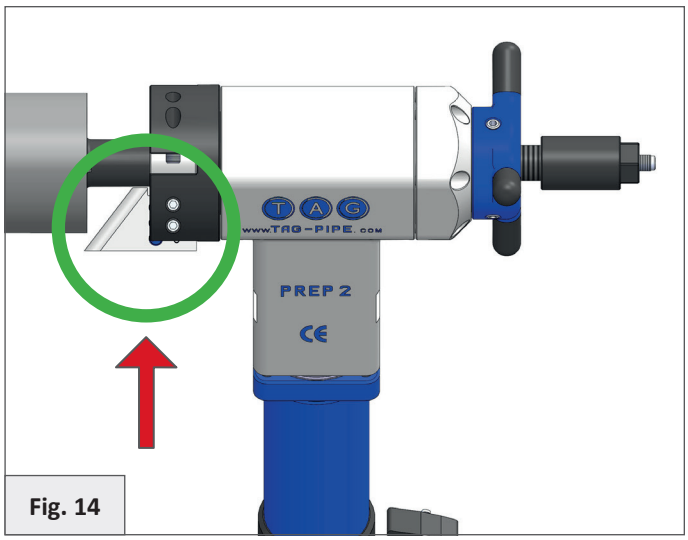
Keep the machine aligned with the axis of the pipe and fasten the jaw lock/unlock nut tightly by turning it clockwise using the 17 mm wrench.

8.2 - TOOLS SETUP

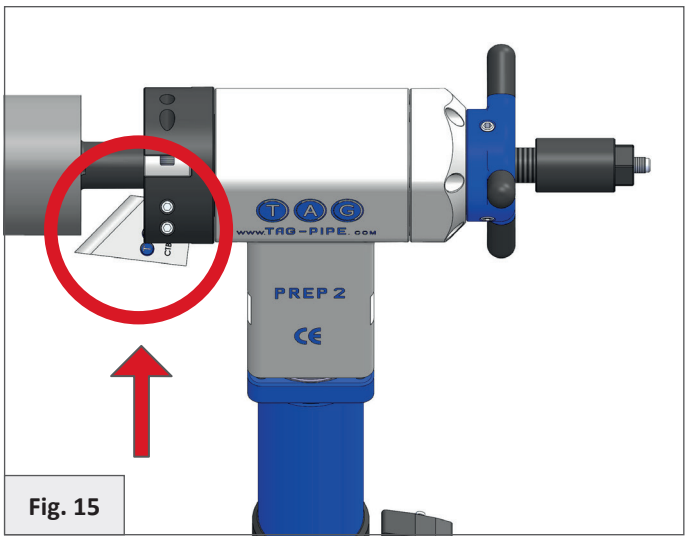
Select the bevelling tool in regard to the bevel you need to perform, and insert it on the chuck, locking it with the grub screws by using the Allen key. You will need to use paired cutting tools and one facing tool when required.







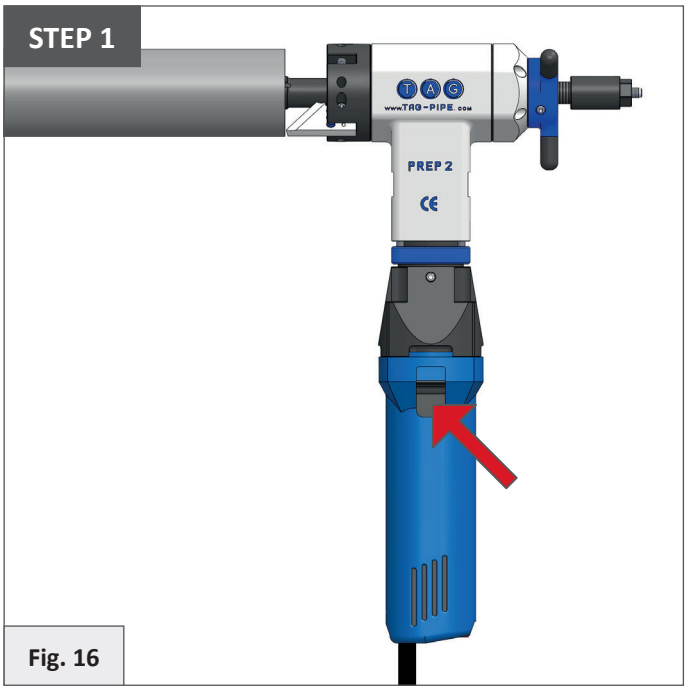
YES

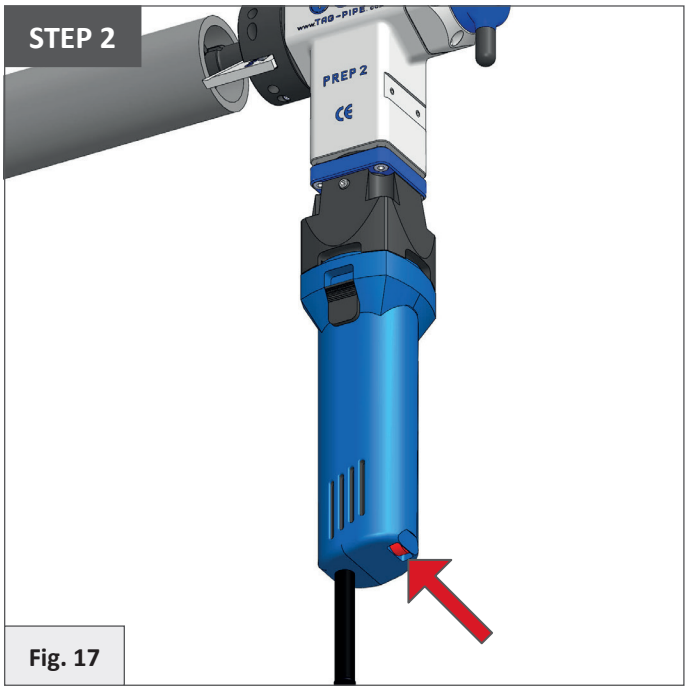


NO

8.3 - OPERATION

ELECTRIC MODEL

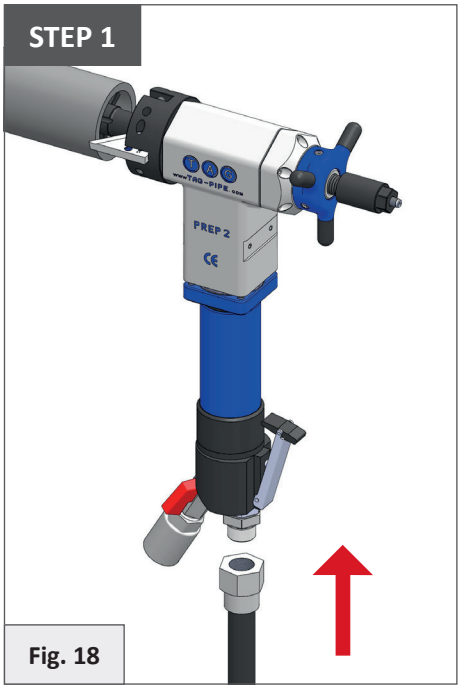


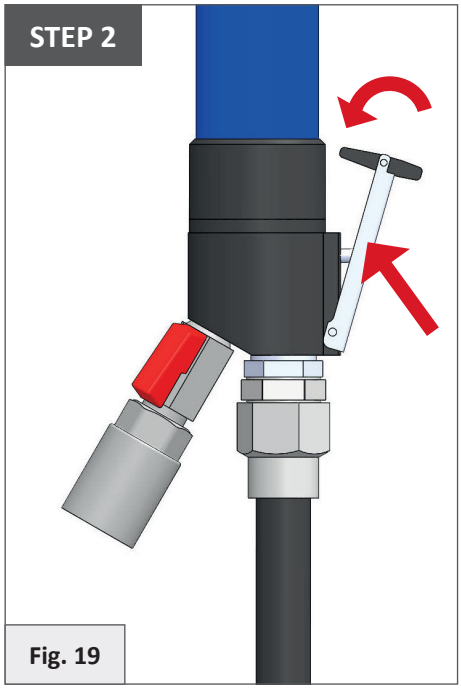


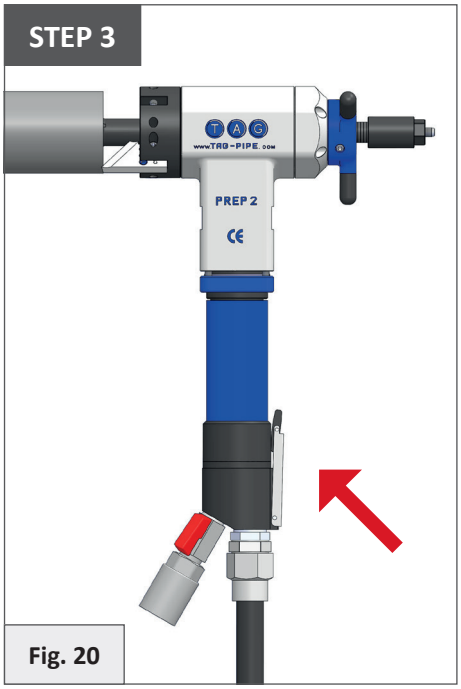
Connect the 220V/110V plug into the correct mains supply and actuate the machine by pressing the switch shown by the arrow (Fig. 16). On the bottom of the electric motor (Fig. 17) there is the speed control to regulate the rpm on the chuck.

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

⚠ **WARNING** - Size of air hole ½" and air consumption 28 cfm or 800 l/min. air working pressure 90 PSI or 6,5 BAR.







Actuate the machine by pressing the lever as shown by the arrows (Fig. 19).

STEP 4

Fig. 21

The machine feeding is achieved by rotating the hand wheel (Fig. 21) in a clockwise direction. For a perfect result it is important to maintain a constant feeding rate.

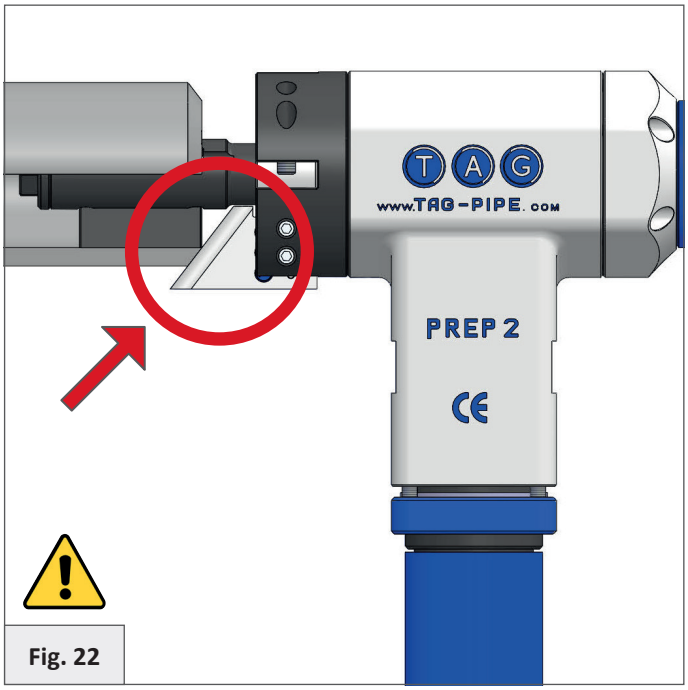


Fig. 22

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

STEP 5

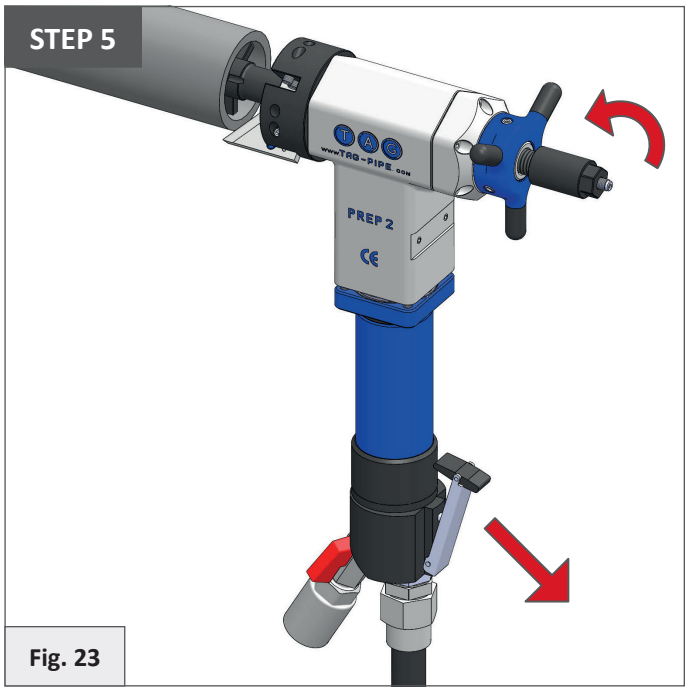


Fig. 23

When the job is finished, rotate the hand wheel anti-clockwise enough so that the cutting tool is away from the pipe. Then release the lever and the machine will automatically stop.

STEP 6

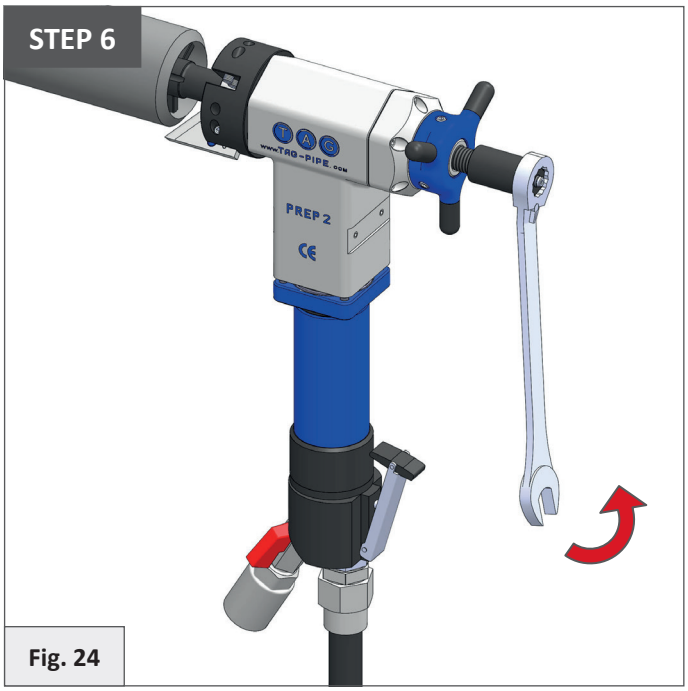


Fig. 24

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

8.4 - REDUCED SHAFT ASSEMBLY KIT

⚠ **WARNING - DO NOT MOVE THE INSIDE SHAFT**

Beware - The inside shaft position can be lost when turning the unlock/lock nut without locking jaws in the shaft.

STEP 1

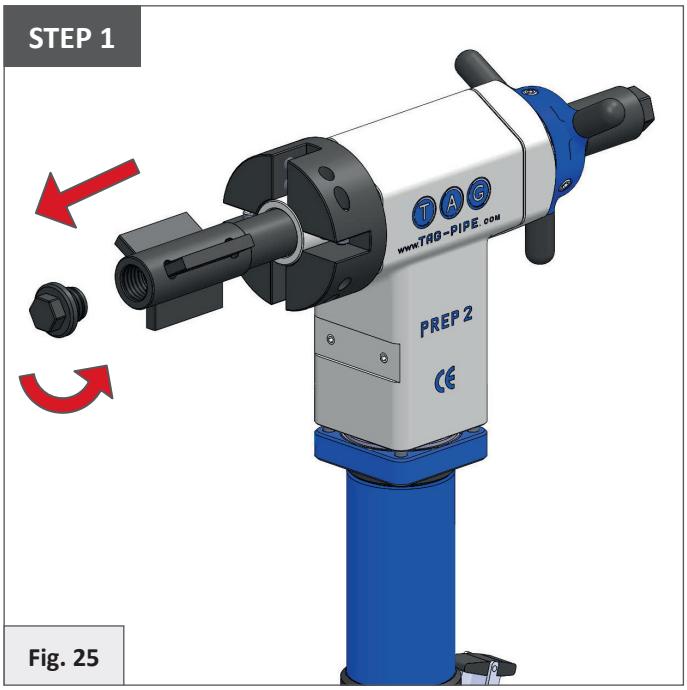


Fig. 25

Unscrew the shaft end nut anti-clockwise.

STEP 2

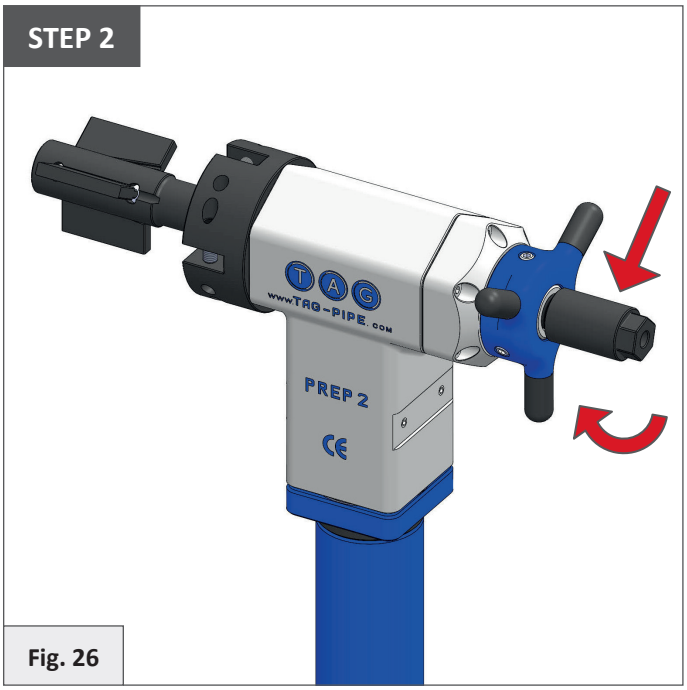


Fig. 26

Turn the jaw lock/unlock nut in a clockwise direction to achieve the maximum expansion.

STEP 3

Fig. 27

Remove the locking jaws.

STEP 4

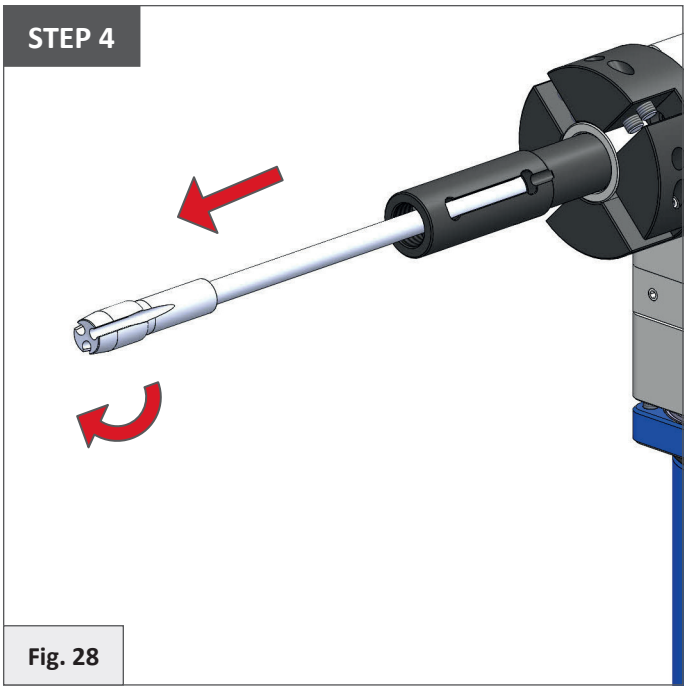


Fig. 28

By using some long nose pliers, rotate the inside shaft in a clockwise direction, until its fully unthreaded and can be removed.

STEP 5

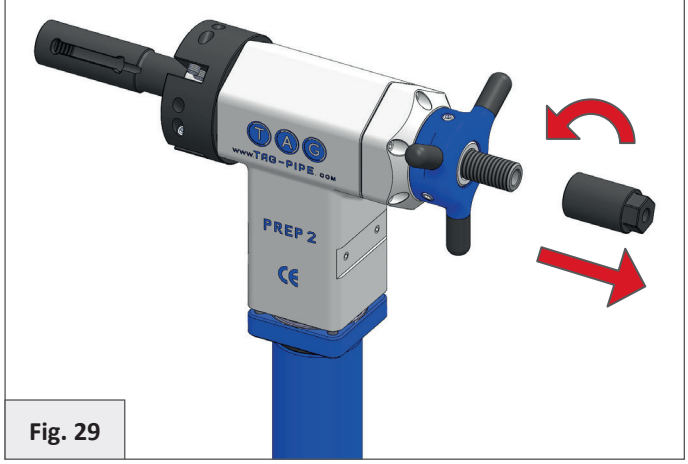


Fig. 29

Rotate the jaw lock/unlock nut anti-clockwise and remove.

STEP 6

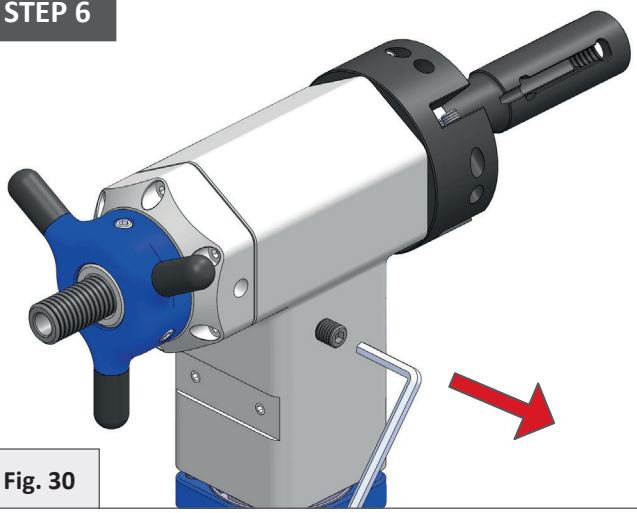


Fig. 30

Remove the first outside grub screw.

STEP 7

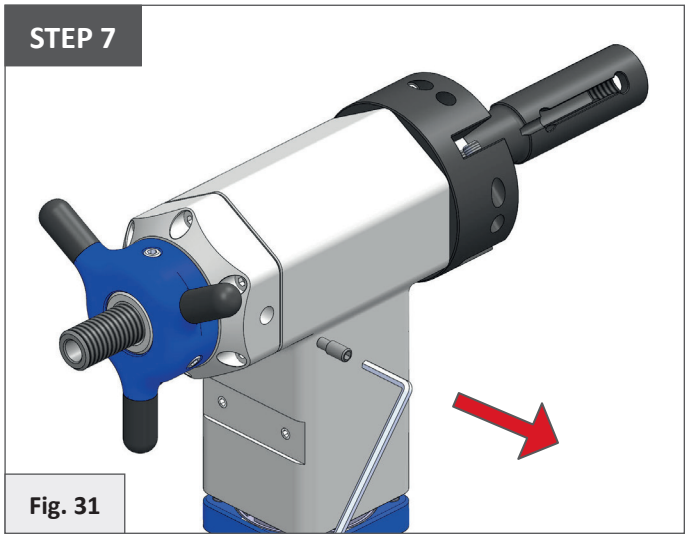


Fig. 31

Then the second stop grub screw.

STEP 8

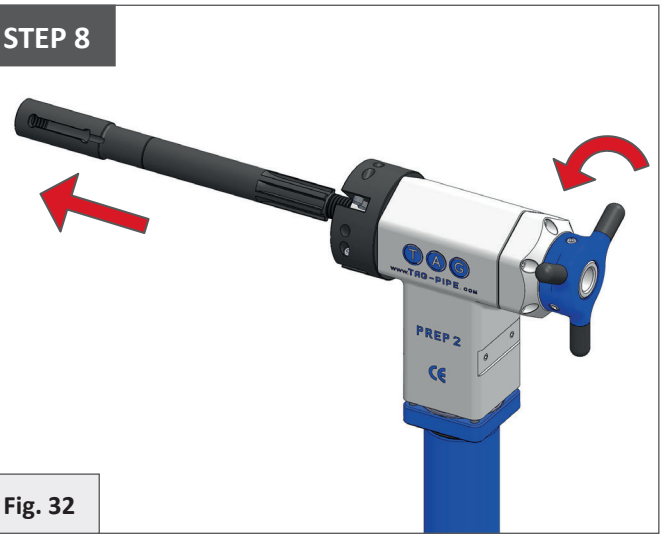


Fig. 32

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

STEP 9

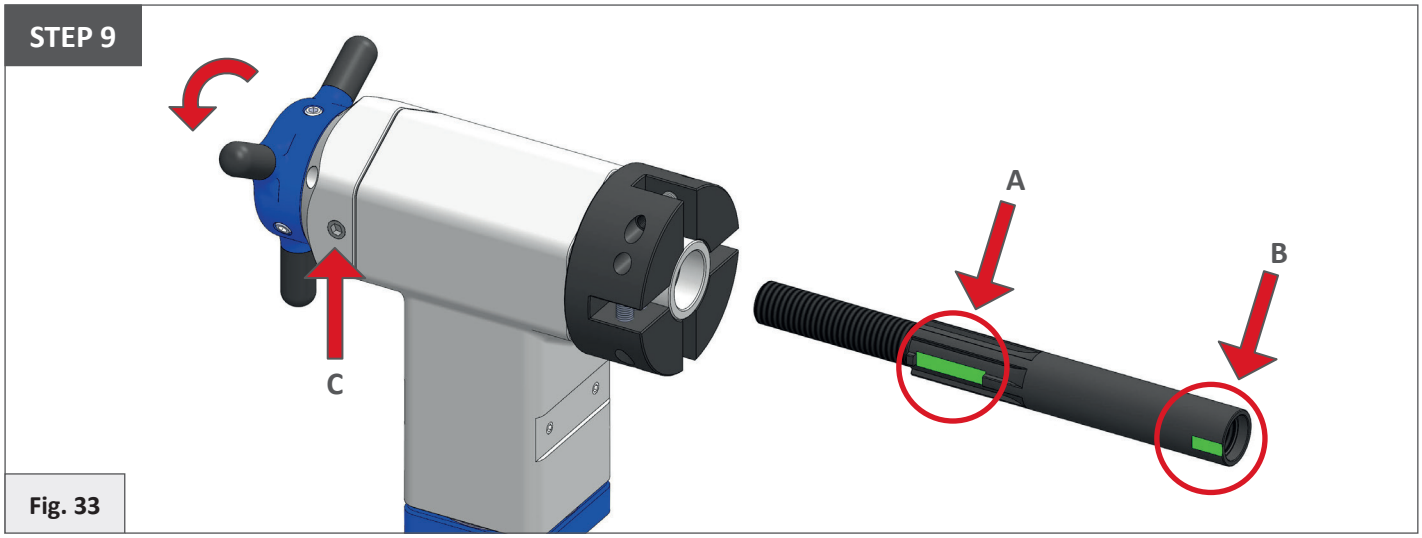


Fig. 33

Take the outside shaft from the reduced shaft kit and mark the groove of the lap joint (arrow A) as well as the far end of the shaft (arrow B) as shown in Fig. 33. Insert the outside shaft and align the lap joint mark (arrow A) with arrow C, and using feed wheel rotate anti-clockwise to screw in the shaft.

STEP 10

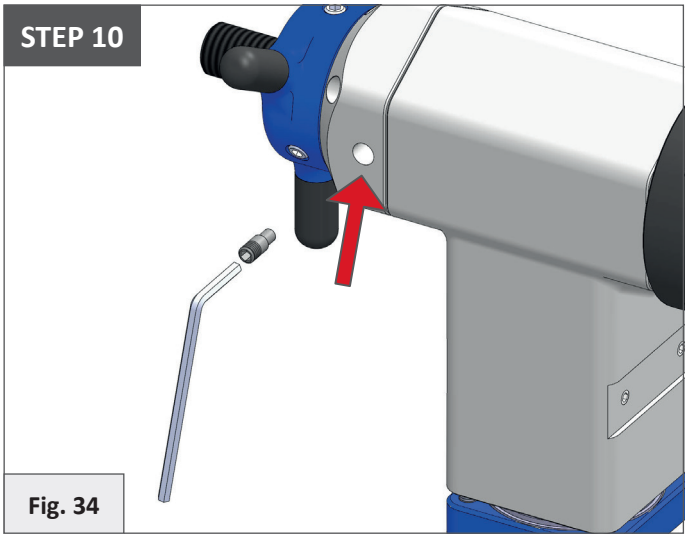


Fig. 34

Re-assemble the stop grub screw.

STEP 11

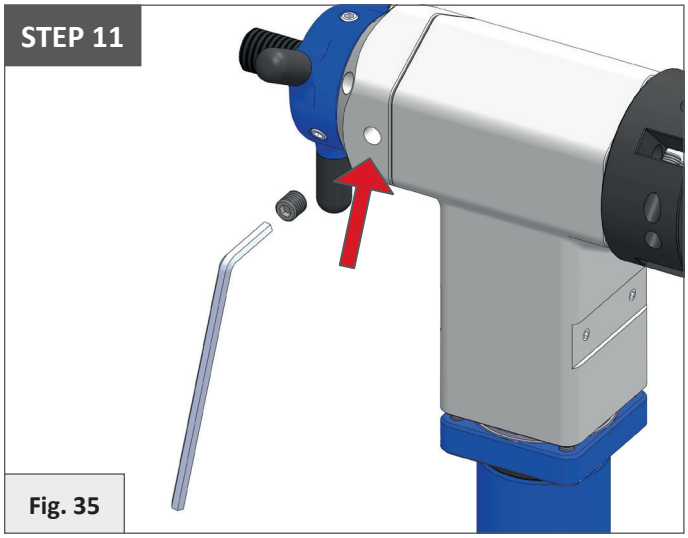


Fig. 35

Then the outside grub screw. Then lock.

STEP 12

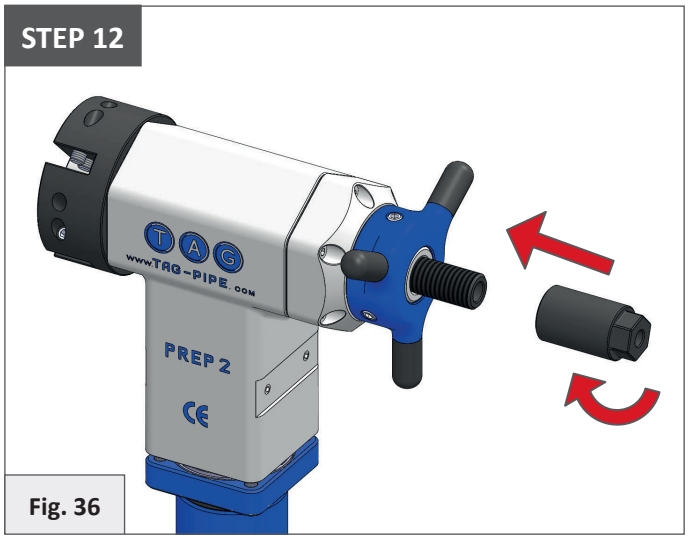


Fig. 36

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

STEP 13

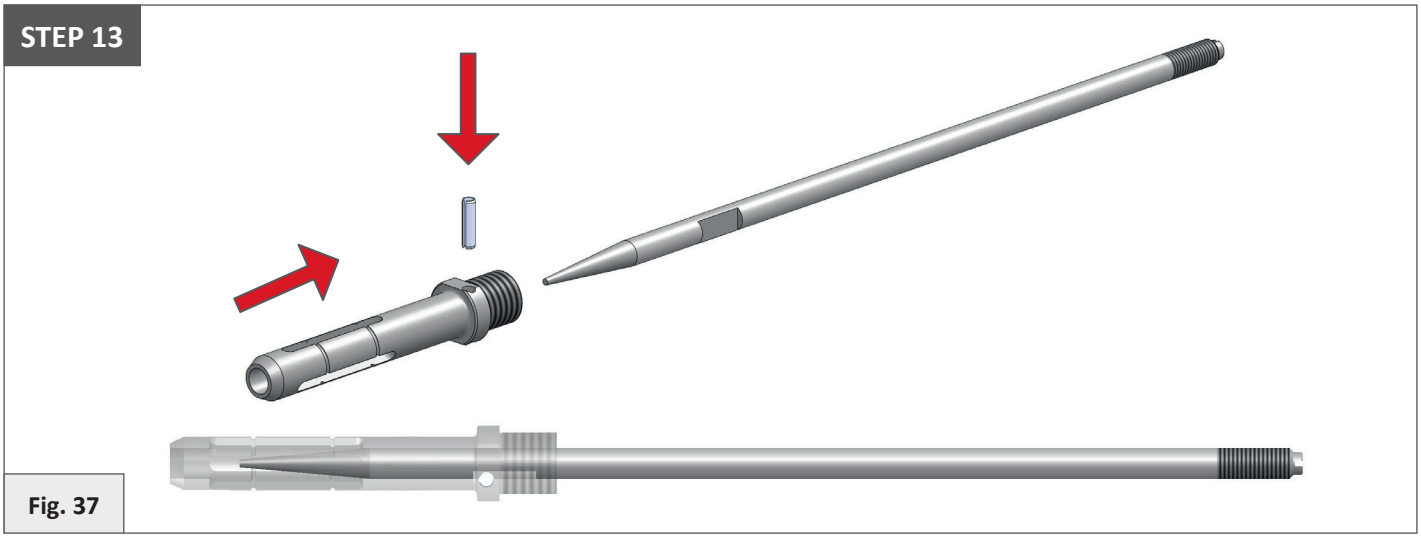


Fig. 37

According to the pipe diameter use one of the heads on the kit, assemble it with the inside shaft and elastic dowel pin.

STEP 14

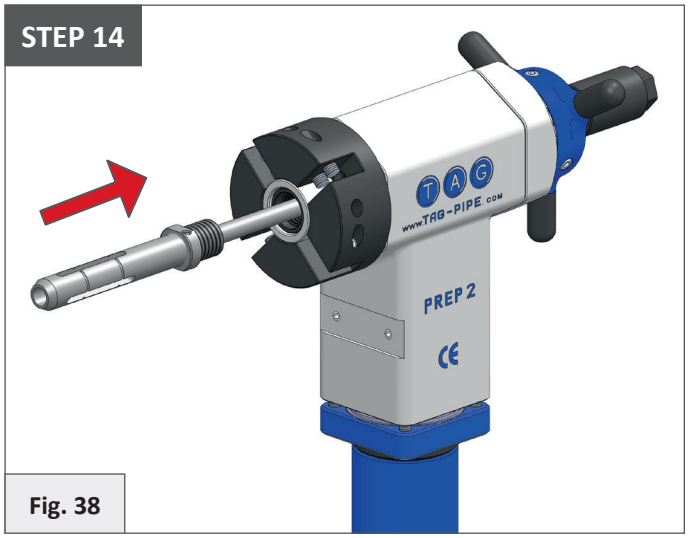


Fig. 38

STEP 15

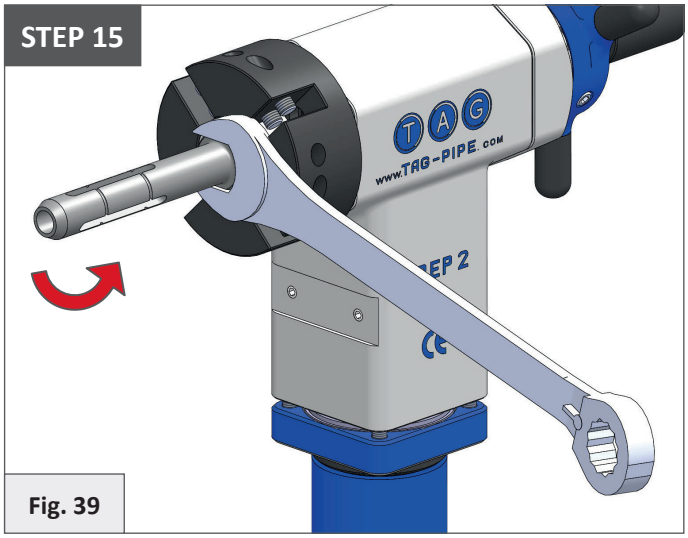


Fig. 39

By using the 17 mm wrench tighten the head anti-clockwise (left thread).

STEP 16

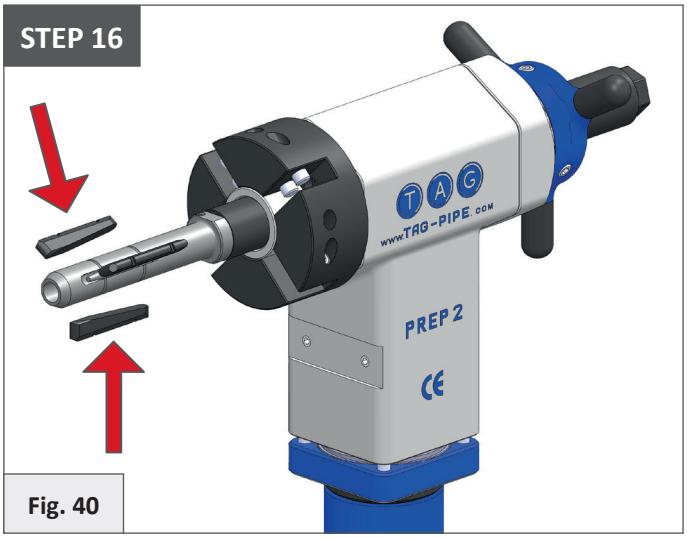


Fig. 40

According to the pipe inside diameter, insert the three locking jaws as shown (Fig. 40).

STEP 17

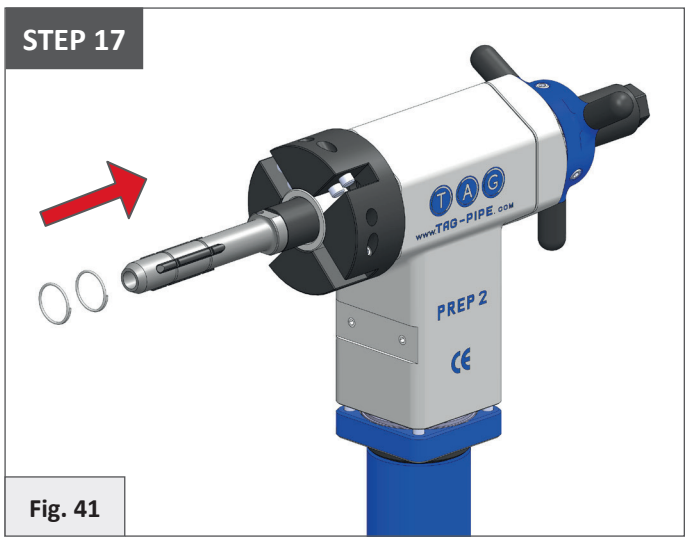


Fig. 41

STEP 18

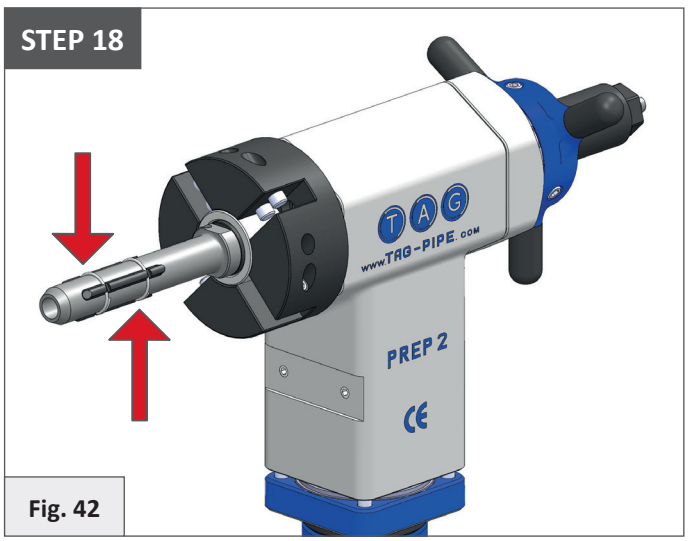


Fig. 42

By using a screwdriver or a similar tool, slide the springs to find the right position.

8.5 - STANDARD SHAFT ASSEMBLY KIT

STEP 1

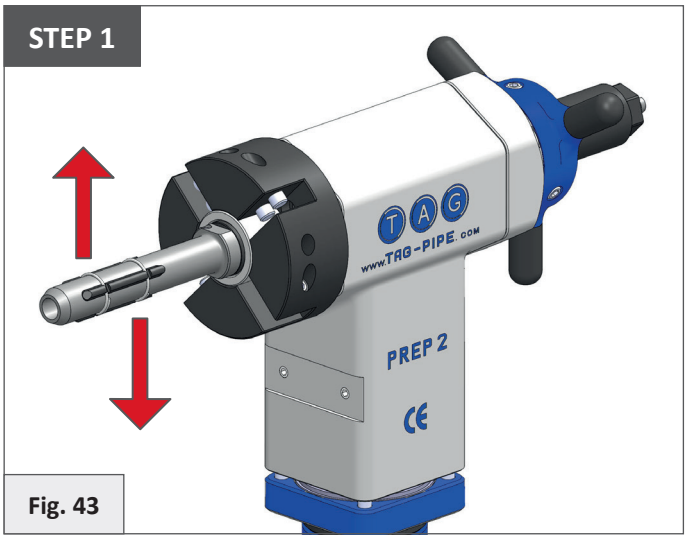


Fig. 43

STEP 2

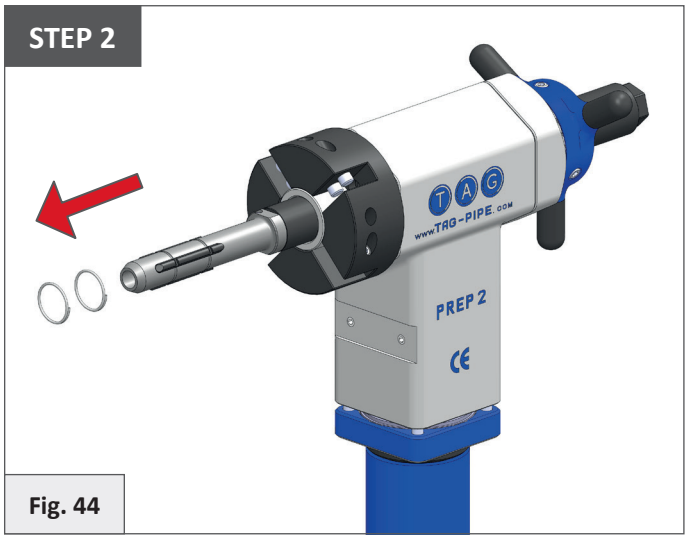


Fig. 44

By using a screwdriver or a similar tool, slide the springs out and remove.

STEP 3

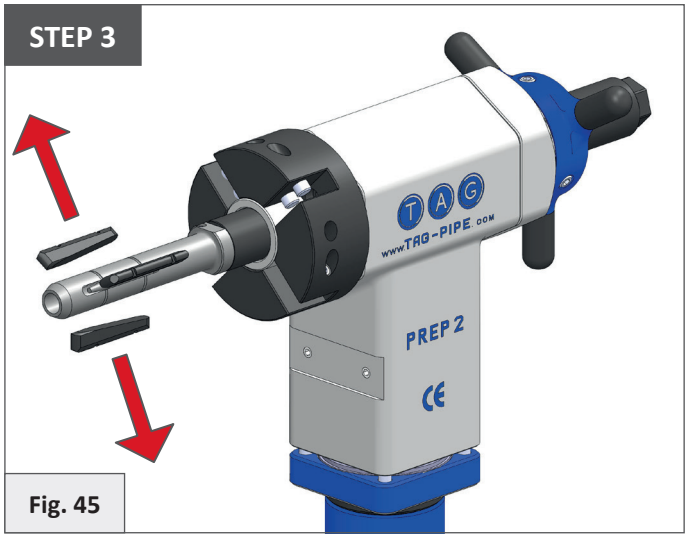


Fig. 45

Remove the locking jaws.

STEP 4

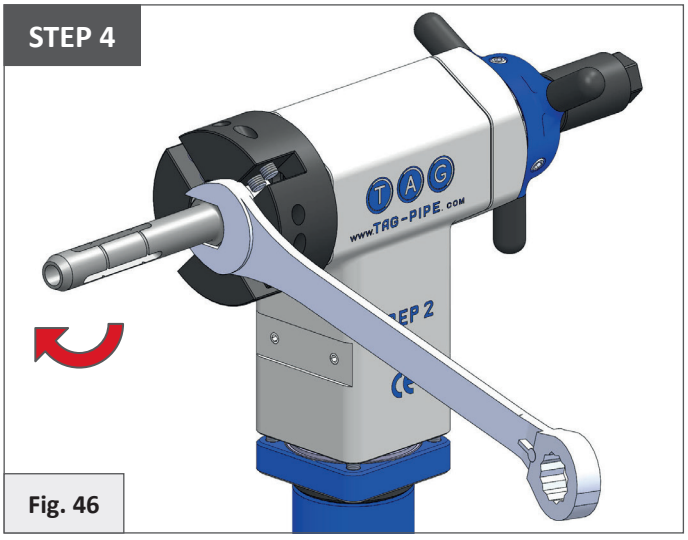


Fig. 46

STEP 5

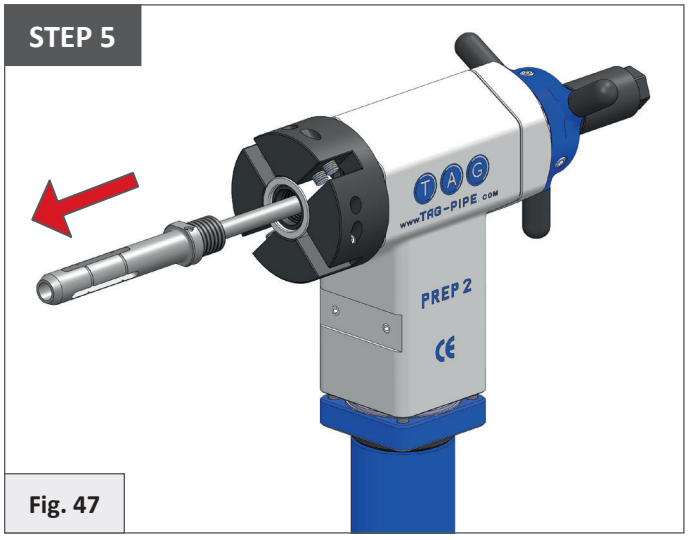


Fig. 47

By using the 17 mm wrench unscrew the head clockwise (left thread).

STEP 6

Fig. 48

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

STEP 7

Fig. 49

Remove the first outside grub screw.

STEP 8

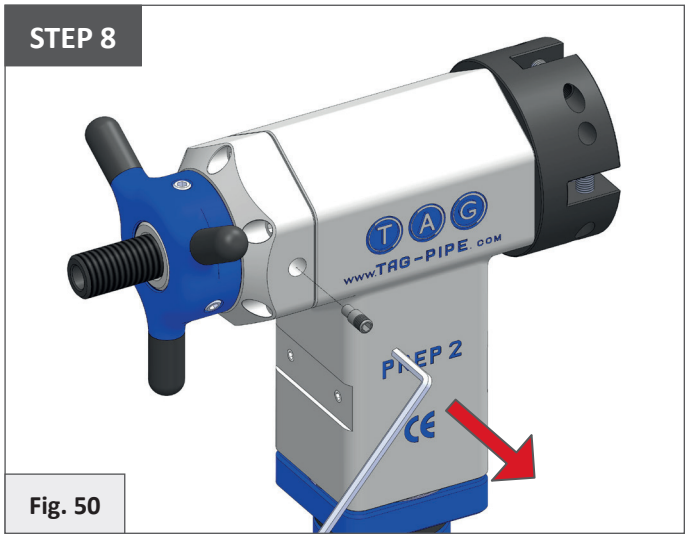


Fig. 50

Then the second stop grub screw.

STEP 9

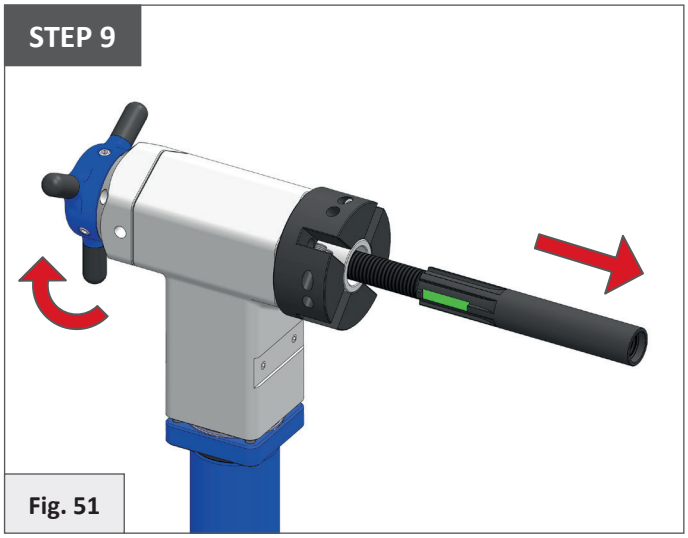


Fig. 51

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

STEP 10

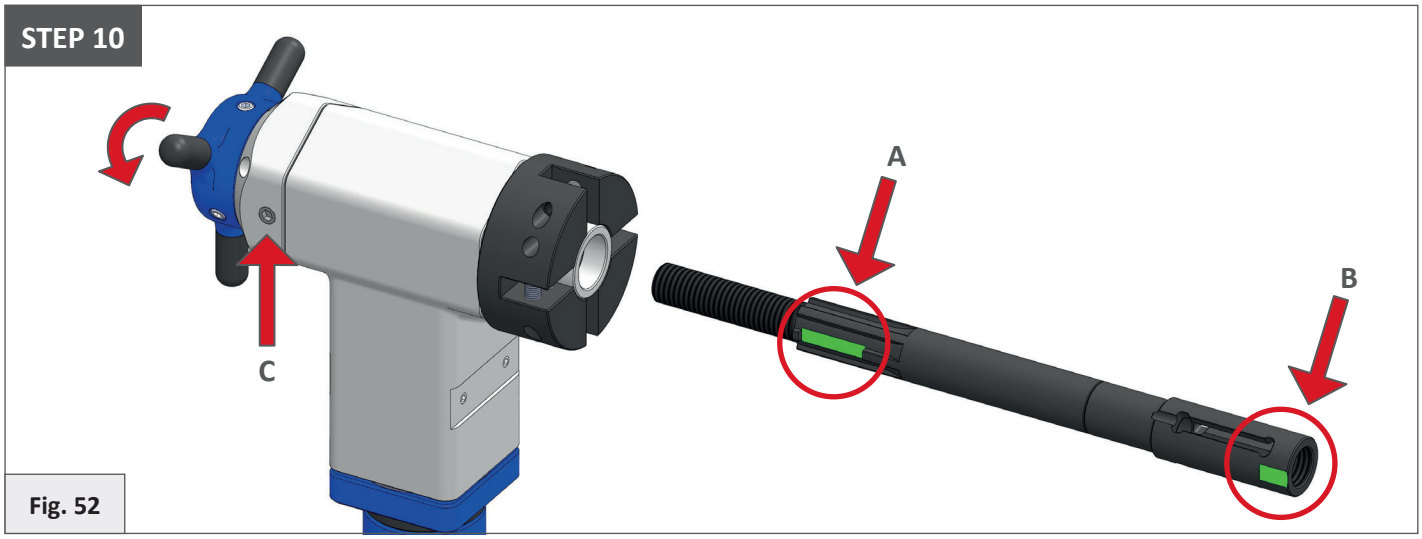


Fig. 52

Take the standard outside shaft and mark the groove of the lap joint (arrow A) as well as the far end of the shaft (arrow B) as shown in Fig. 50. Insert the outside shaft and align the lap joint mark (arrow A) with arrow C, and using feed wheel rotate anti-clockwise to screw in the shaft.

STEP 11

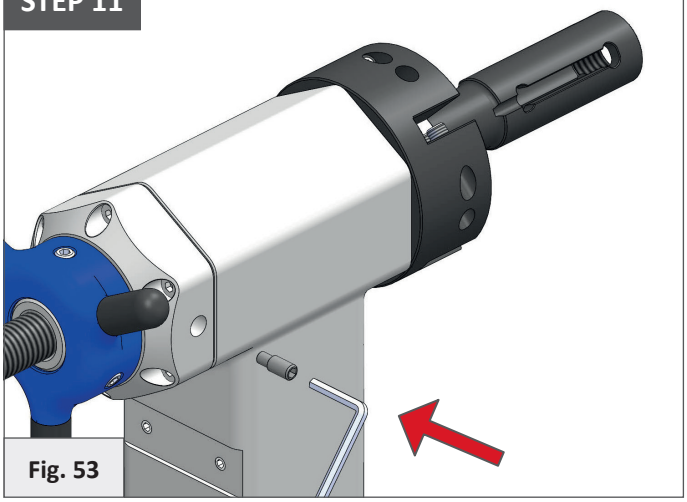


Fig. 53

Re-assemble the stop grub screw.

STEP 12

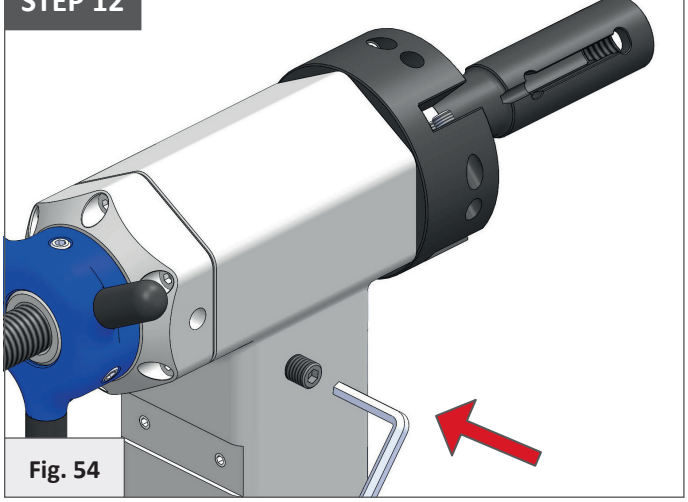


Fig. 54

Then the outside grub screw. Then lock.

STEP 13

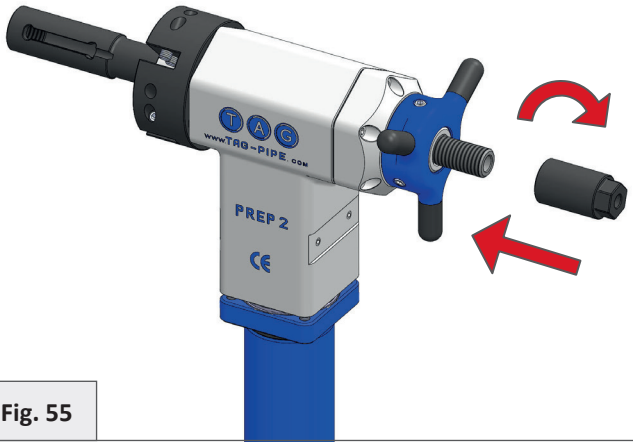


Fig. 55

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

STEP 14

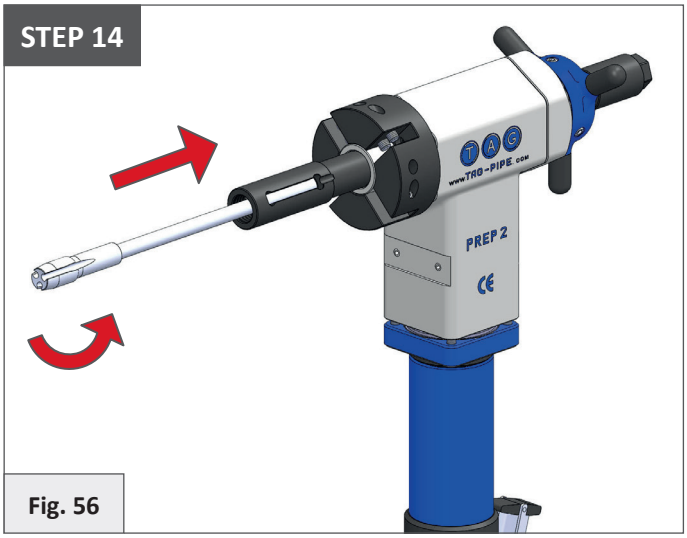


Fig. 56

STEP 15

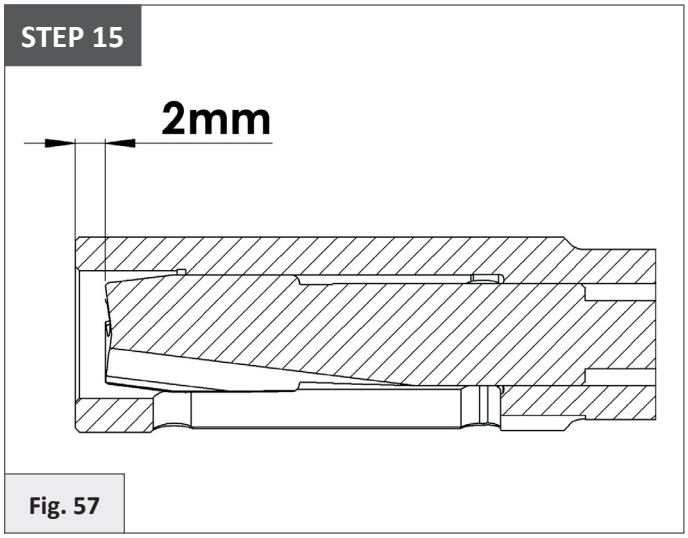


Fig. 57

By using long nose pliers, rotate the inside shaft anti-clockwise until there
is a 2 mm gap between the shaft as shown in the picture (Fig. 57).

⚠ **WARNING - DO NOT MOVE THE INSIDE SHAFT**

Beware - The inside shaft position can be lost when turning the jaw lock/unlock nut without locking jaws in the shaft.

STEP 16

Fig. 58

Select the locking jaws according to the diameter of the pipe and install them on the inside shaft as shown in Fig. 58.

STEP 17

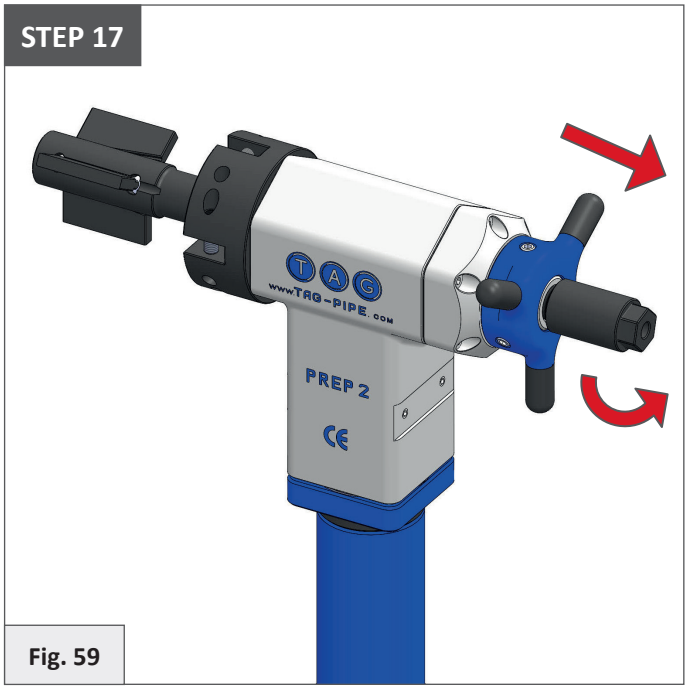


Fig. 59

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

STEP 18

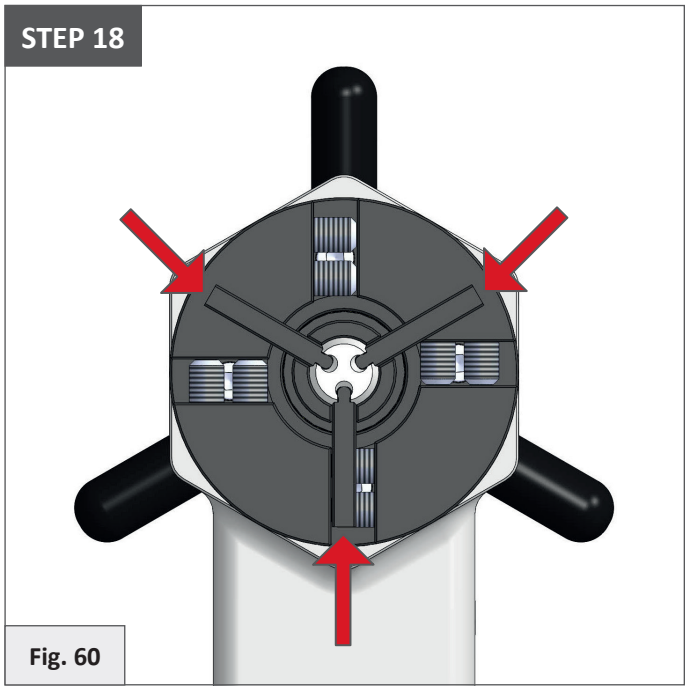


Fig. 60

If the procedure is correctly made, the locking jaws should have a bit of play/movement.

STEP 19

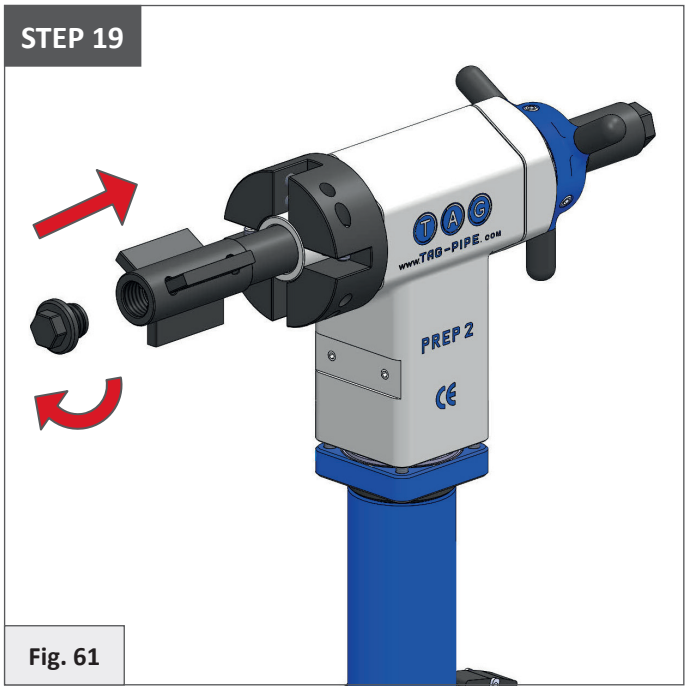


Fig. 61

Screw on the shaft end nut in a clockwise direction.

8.6 - ELBOW SHAFT ASSEMBLY KIT

⚠ **WARNING - DO NOT MOVE THE INSIDE SHAFT**

Beware - The inside shaft position can be lost when turning the jaw lock/unlock nut without locking jaws in the shaft.

STEP 1

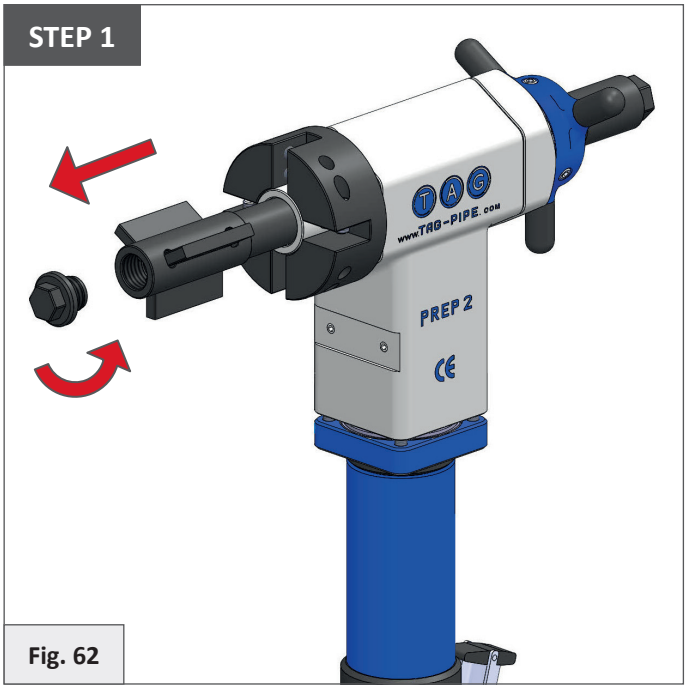


Fig. 62

Unscrew the shaft end nut anticlockwise.

STEP 2

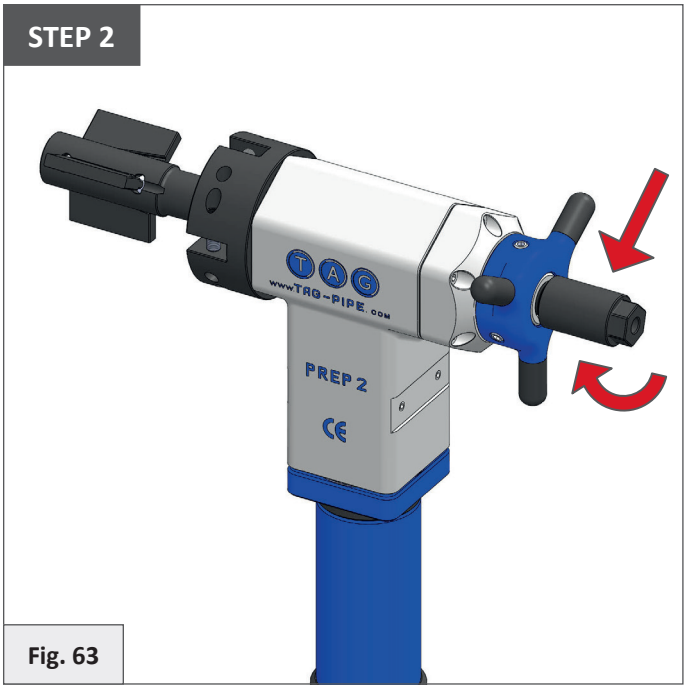


Fig. 63

Turn the jaw lock/unlock nut clockwise to the maximum expansion.

STEP 3

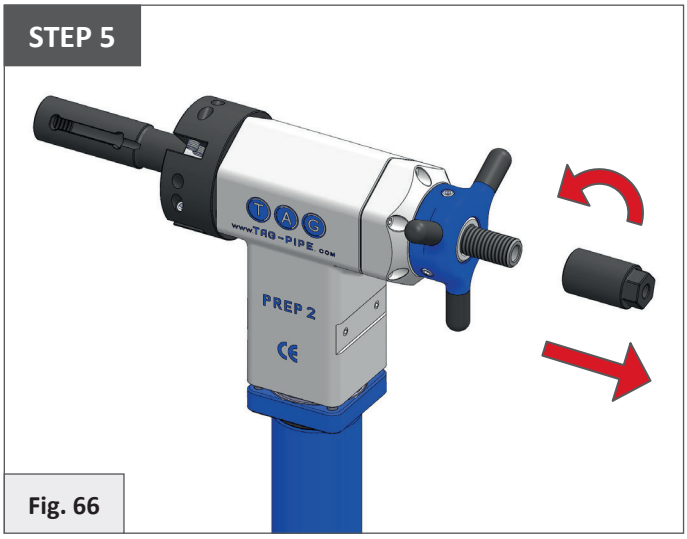
Fig. 64

Remove the locking jaws.

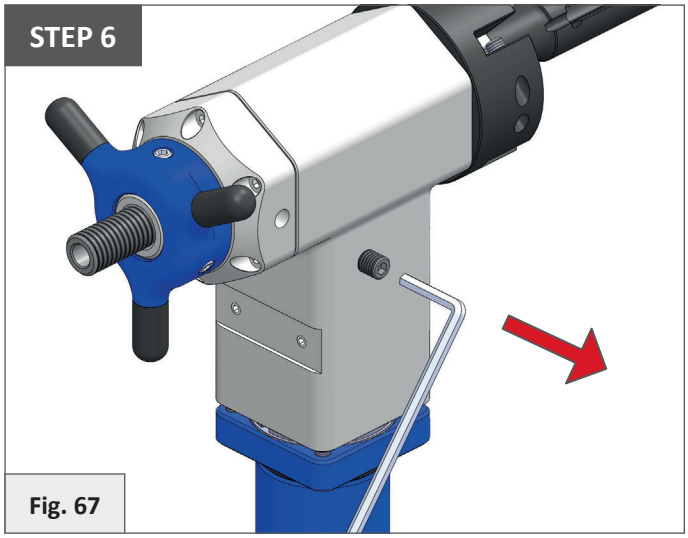
STEP 4

Fig. 65

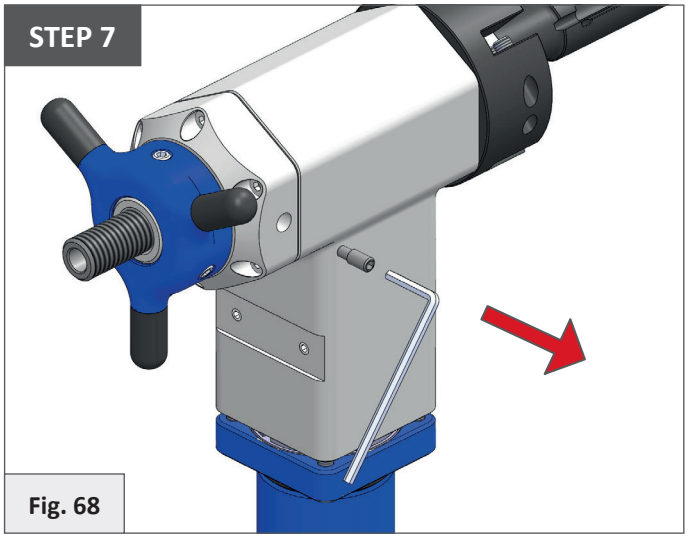
By using some long nose pliers, rotate the inside shaft in a clockwise direction, until its fully unthreaded and can be removed.



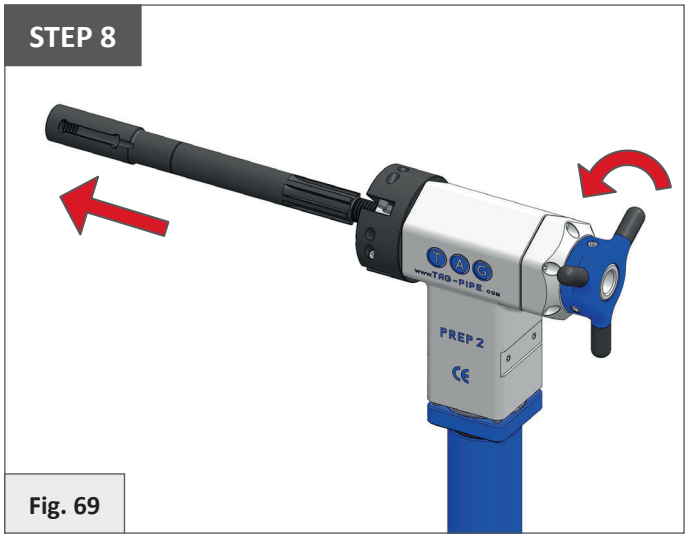
Rotate the jaw lock/unlock nut anti-clockwise and remove.



Remove the first grub screw from the cover.



Then the second stop grub screw.



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

STEP 9

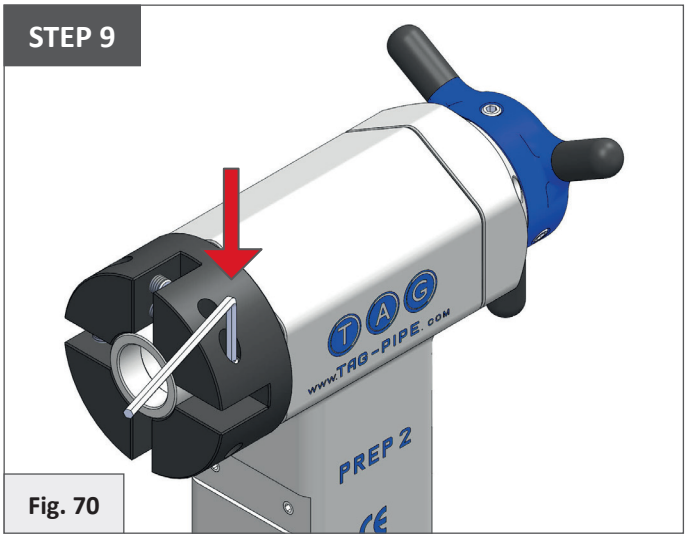


Fig. 70

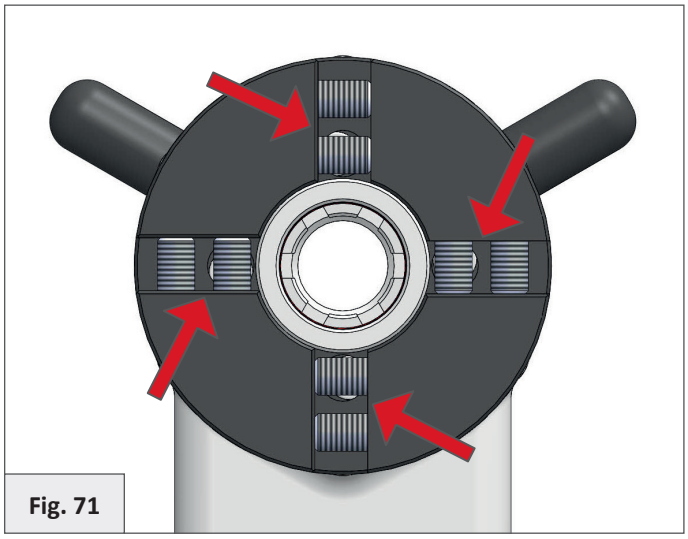


Fig. 71

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

STEP 10

Fig. 72

Remove the bush.

STEP 11

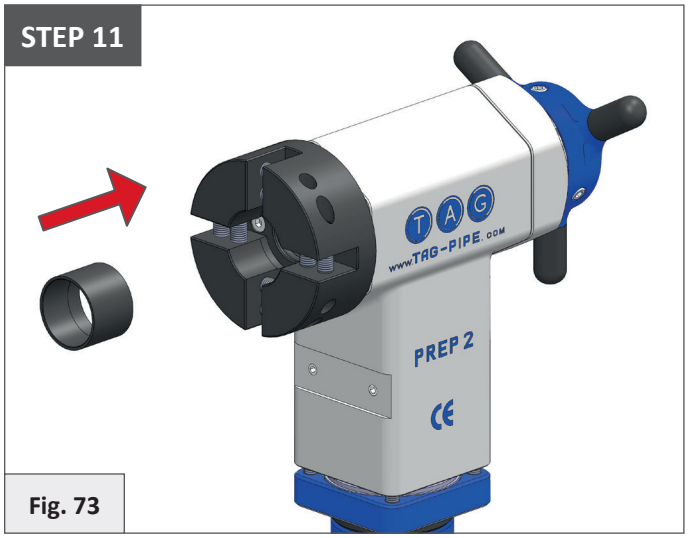


Fig. 73

Replace with the new bush from elbow kit.

STEP 12

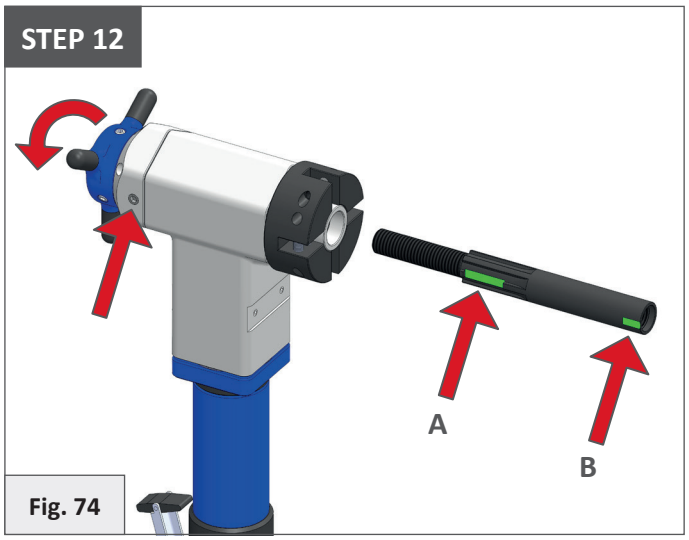


Fig. 74

Take the elbow outside shaft from the elbow shaft kit and mark the groove of the lap joint (arrow A) as well as the far end of the shaft (arrow B) as shown in Fig. 74.

STEP 13

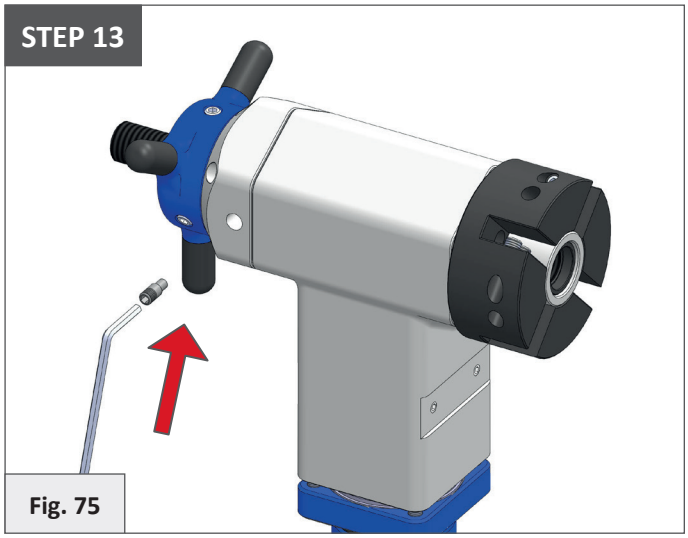


Fig. 75

Re-assemble the stop grub screw.

STEP 14

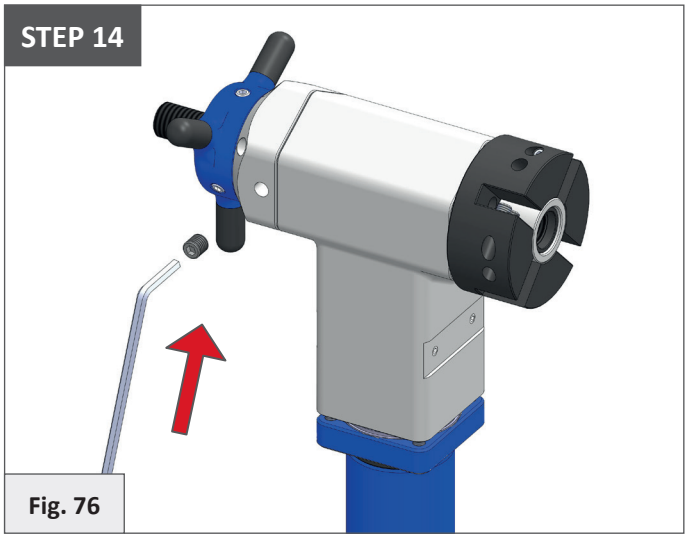


Fig. 76

Then the outside grub screw to the cover.

STEP 15

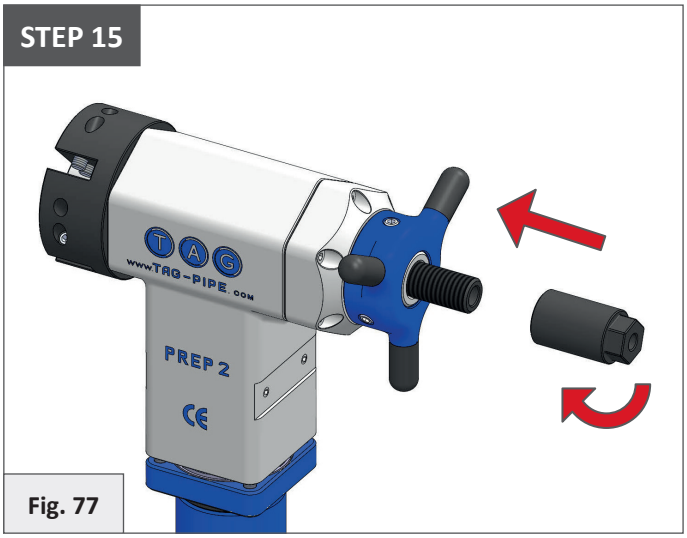


Fig. 77

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

STEP 16

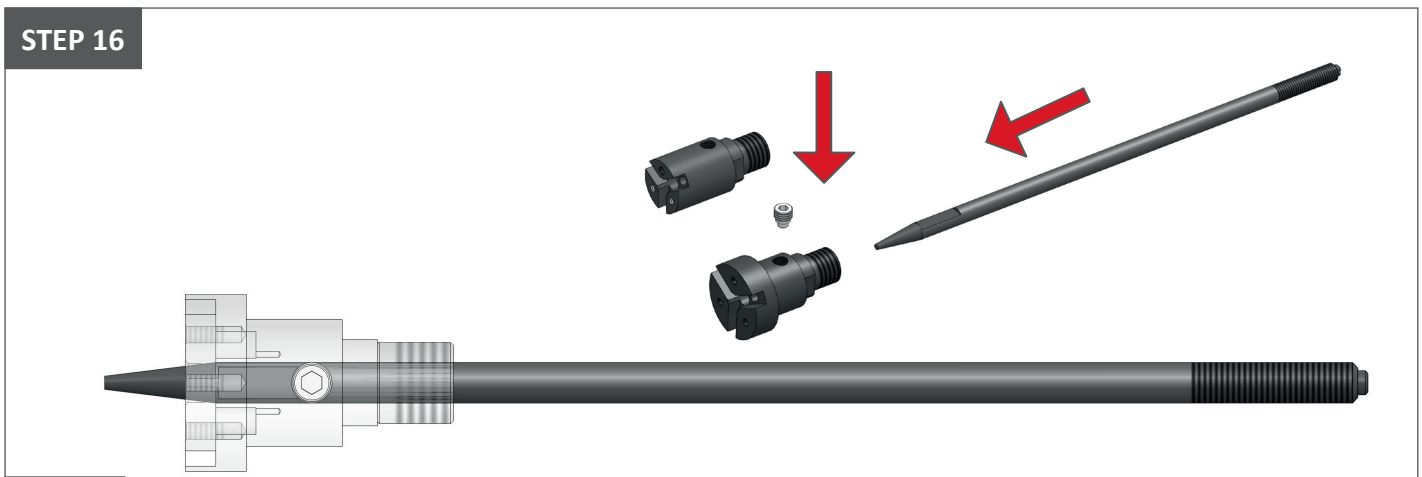


Fig. 78

According to the pipe diameter use one of the heads on the kit, assemble it with inside shaft and Allen screw.

STEP 17

Fig. 79

STEP 18

Fig. 80

By using the 17 mm wrench tighten the head anti-clockwise (left thread).

STEP 19

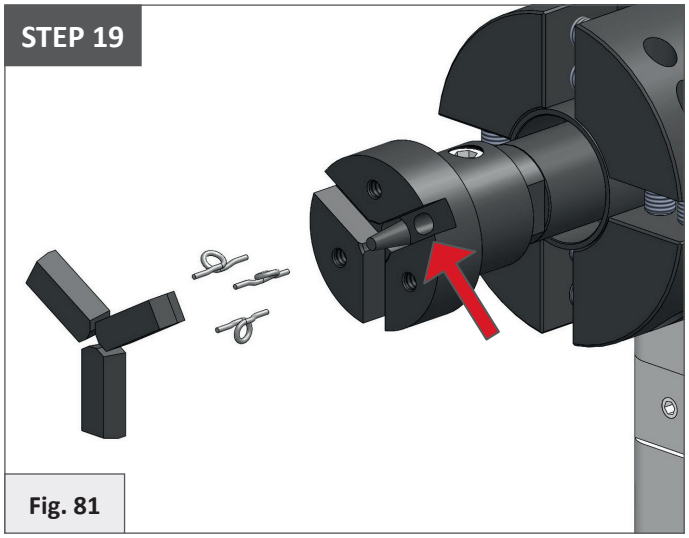


Fig. 81

Insert the springs and locking jaws at the required size.
Slot jaws into groove on outside shaft.

STEP 20

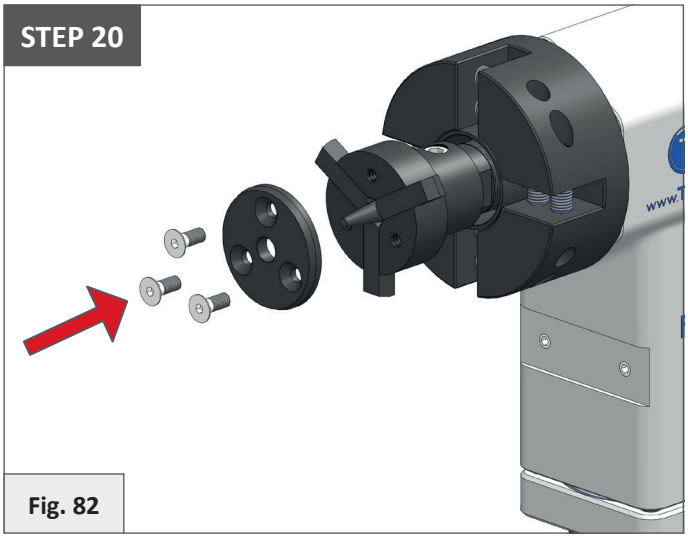


Fig. 82

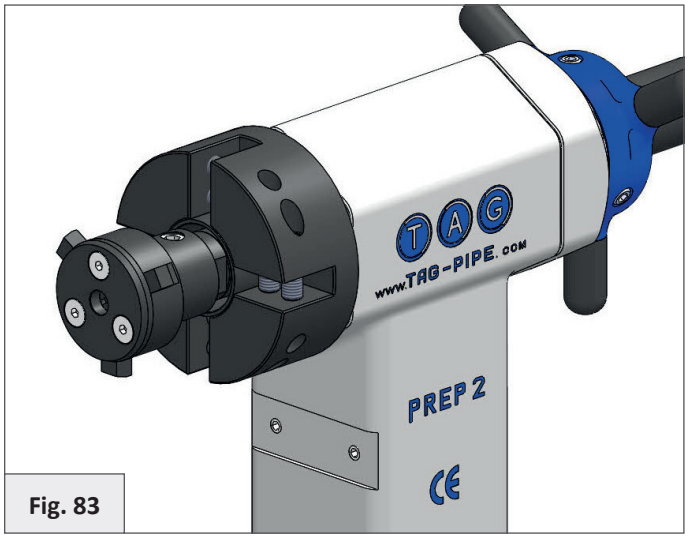


Fig. 83

Place the locking jaws securing cap on and tighten the 3 screws (Fig. 82).

STEP 21

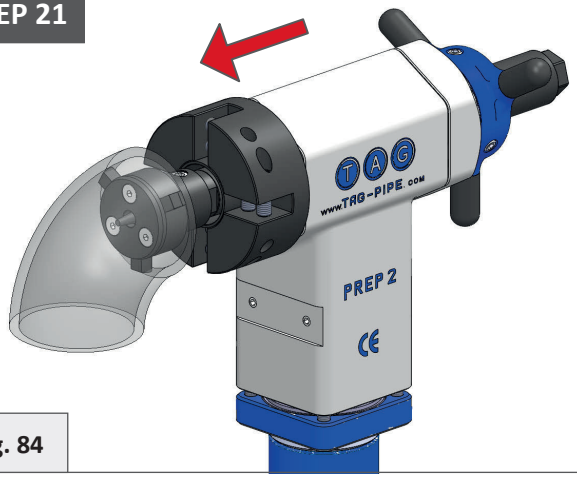


Fig. 84

Place machine into elbow.

STEP 22

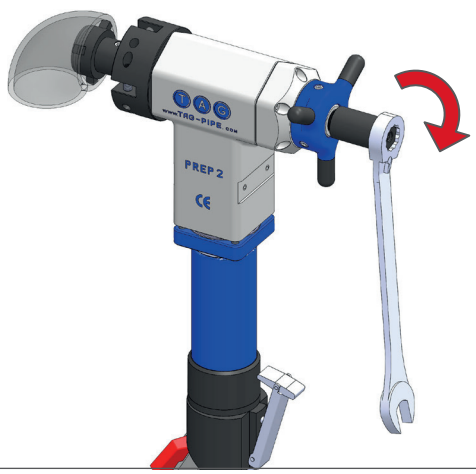


Fig. 85

Loosely lock clockwise.

STEP 23

Fig. 86

Insert the elbow positioner between the elbow and the chuck.

STEP 24

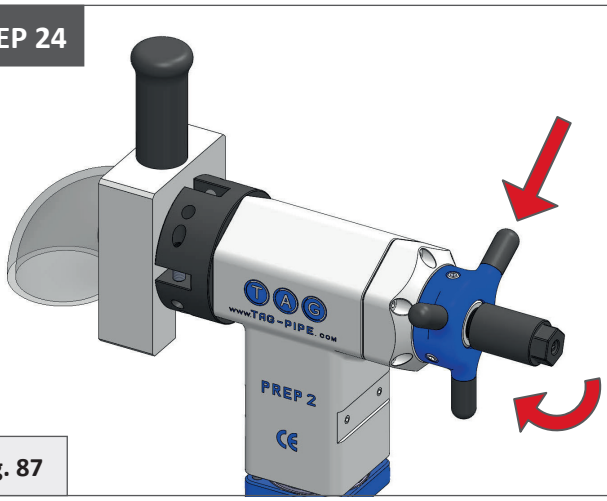


Fig. 87

Turn the feed wheel clockwise to tighten the elbow positioner in between the elbow and the chuck, and then lock the locking jaws in the elbow.

STEP 25

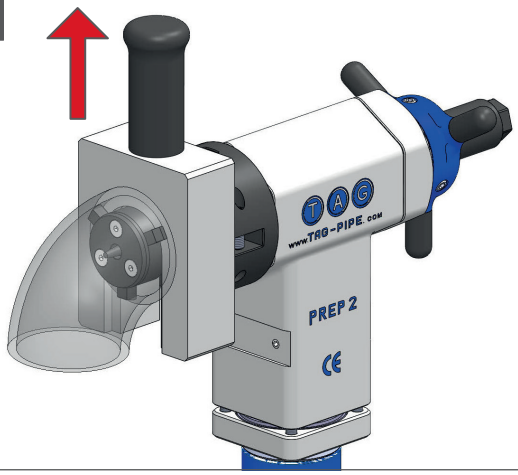


Fig. 88

Fig. 89

Turn the feed wheel anti-clockwise and remove elbow positioner.

⚠ **WARNING** - Now you can set up the cutting tools as shown in Fig. 12.

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.

STEP 1

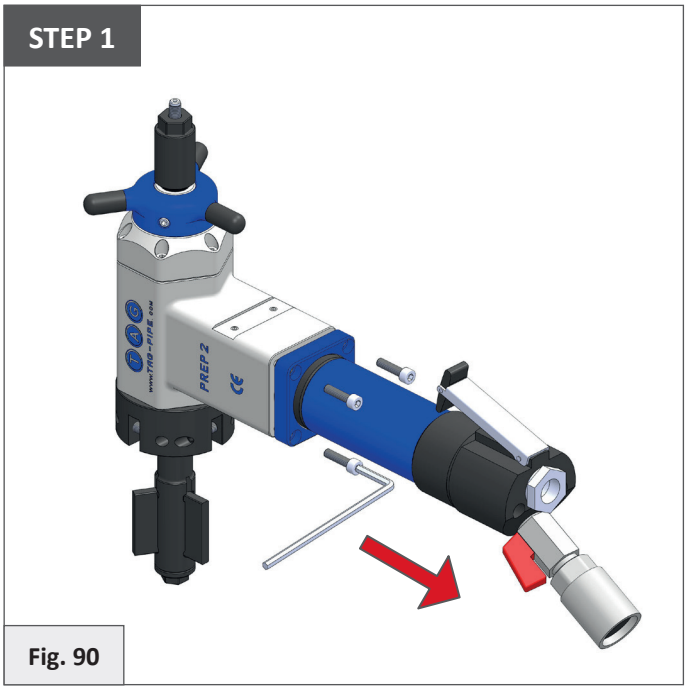


Fig. 90

Remove the 4 screws as shown.

STEP 2

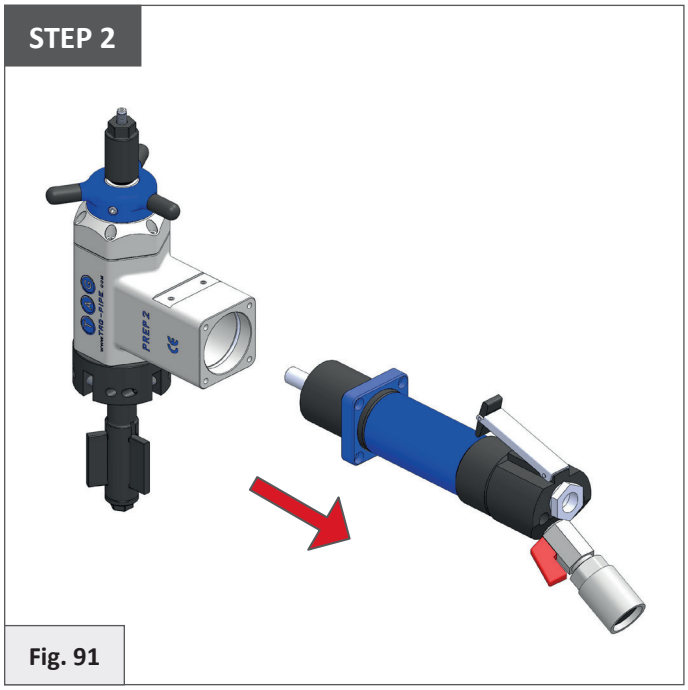


Fig. 91

Remove the pneumatic conversion kit.

STEP 3

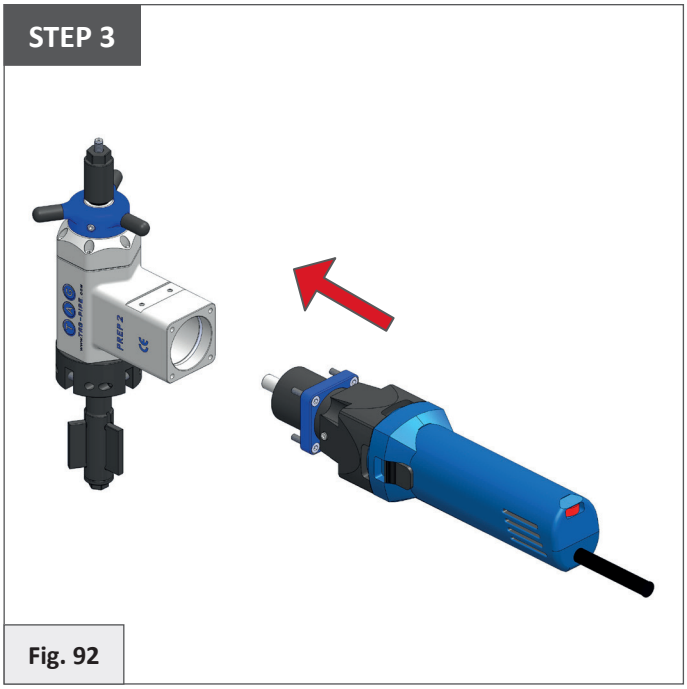


Fig. 92

Insert the electric conversion kit.

STEP 4

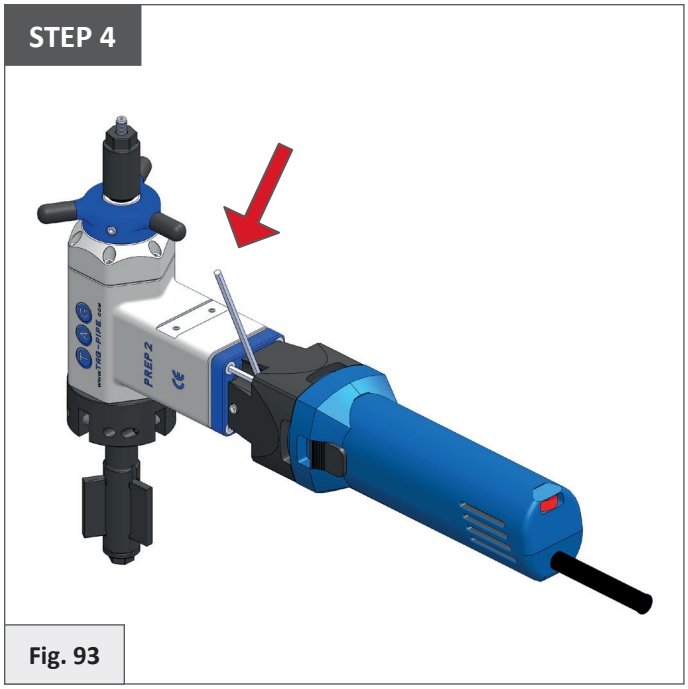


Fig. 93

Screw in the 4 screws.

8.8 - AUTOMATIC LOCKING DEVICE KIT

⚠ **WARNING - DO NOT MOVE THE INSIDE SHAFT**

Beware - The inside shaft position can be lost when turning the jaw lock/unlock nut without locking jaws in the shaft.

STEP 1

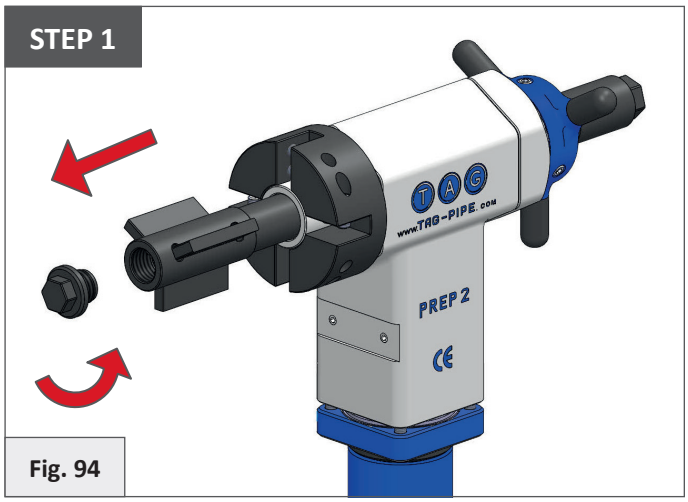


Fig. 94

Unscrew the shaft end nut anti-clockwise.

STEP 2

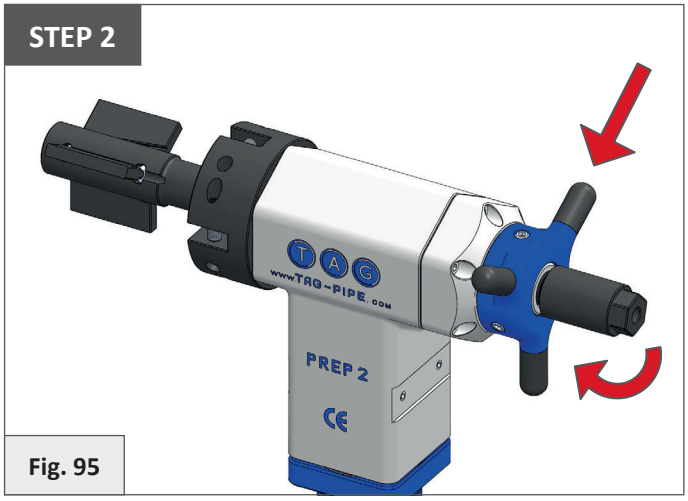


Fig. 95

Turn the jaw lock/unlock nut clockwise to the maximum expansion.

STEP 3

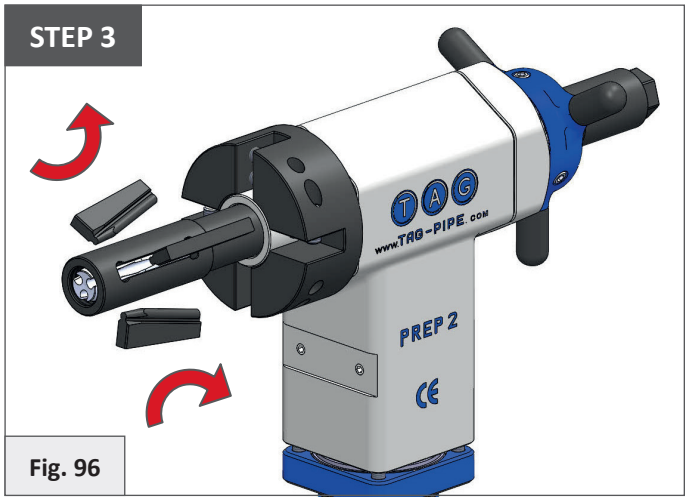


Fig. 96

Remove the locking jaws.

STEP 4

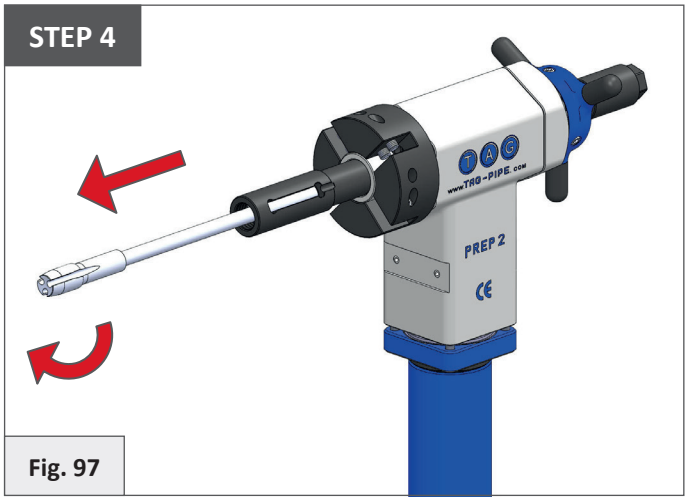


Fig. 97

By using some long nose pliers, rotate the inside shaft in a clockwise direction, until its fully unthreaded and can be removed.

STEP 5

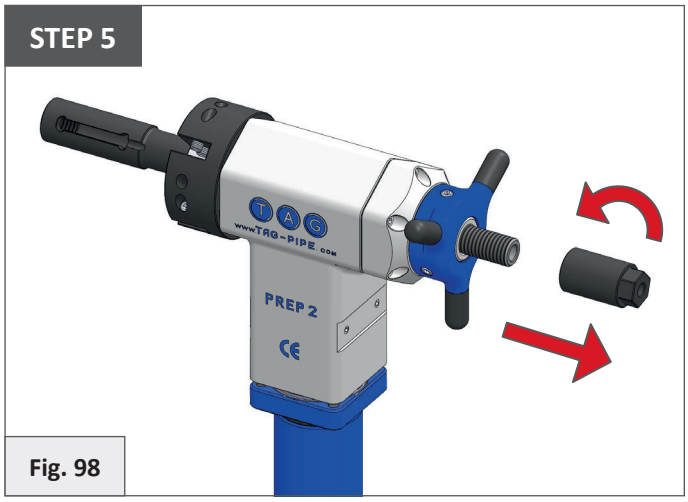


Fig. 98

Rotate the jaw lock/unlock nut anti-clockwise and remove.

STEP 6

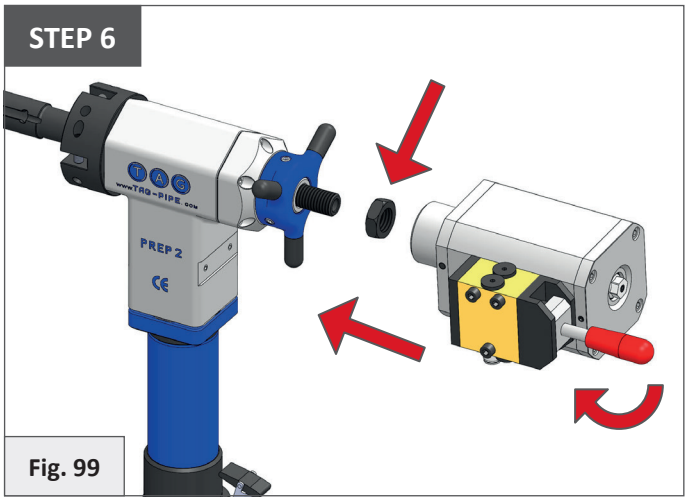


Fig. 99

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

STEP 7

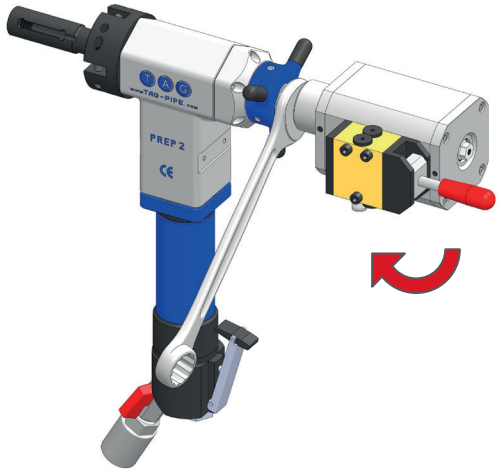


Fig. 100

STEP 8

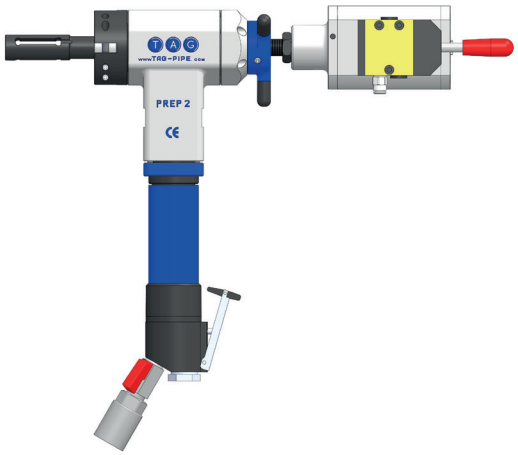


Fig. 101

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

STEP 9

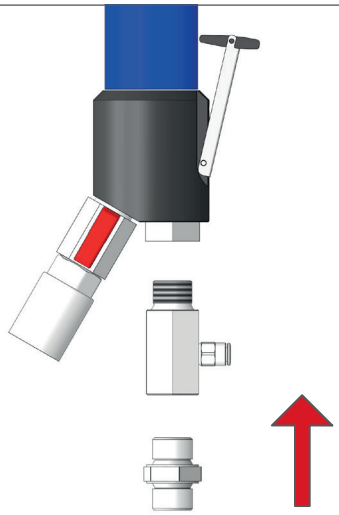


Fig. 102

Screw in the special connection as shown (Fig. 102).

STEP 10

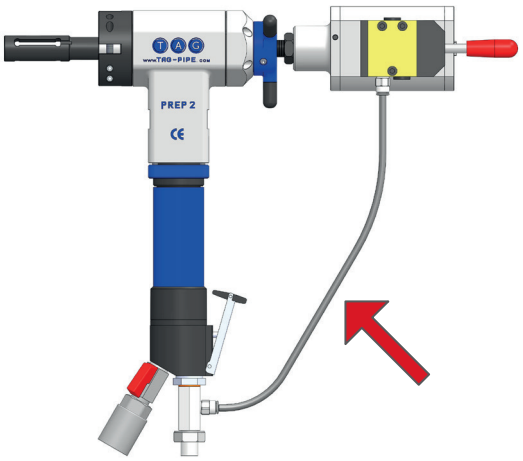


Fig. 103

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

STEP 11

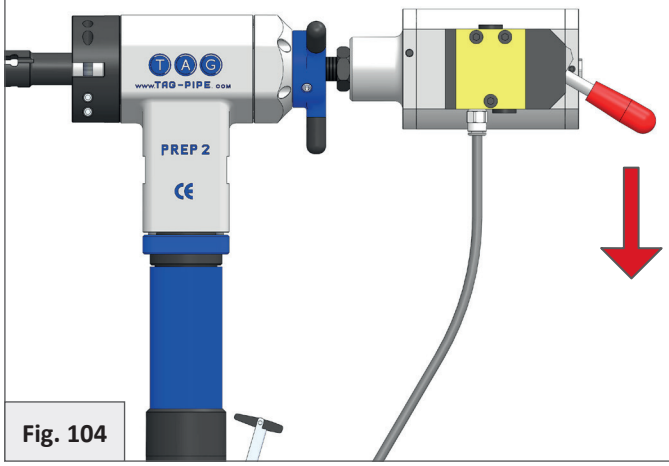


Fig. 104

Connect the air and move the lever down, to move the piston to its maximum forward position.

STEP 12

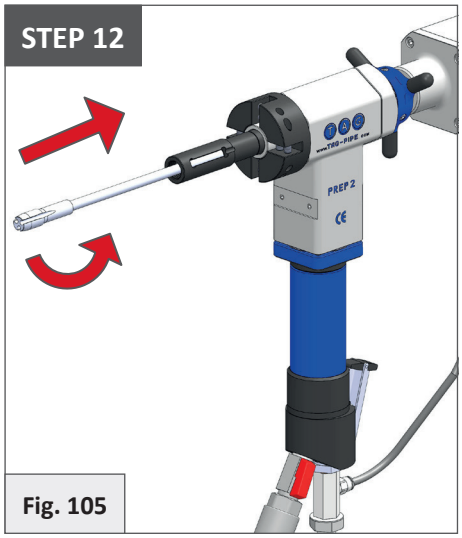


Fig. 105

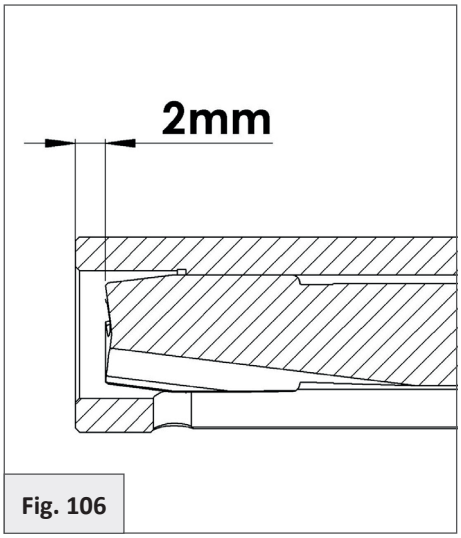


Fig. 106

Insert and screw in an anti-clockwise direction until there is a 2 mm gap between the shafts as shown in Fig. 106.

STEP 13

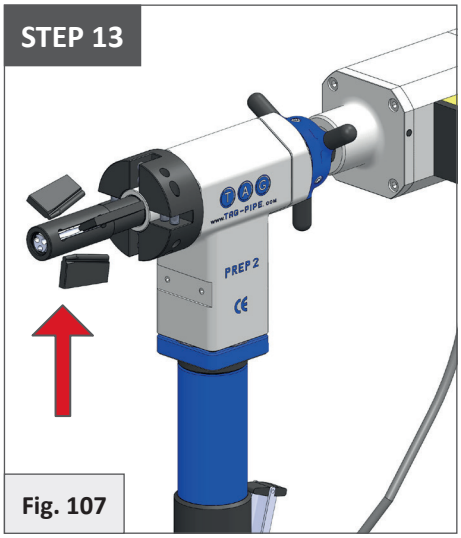


Fig. 107

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

STEP 14

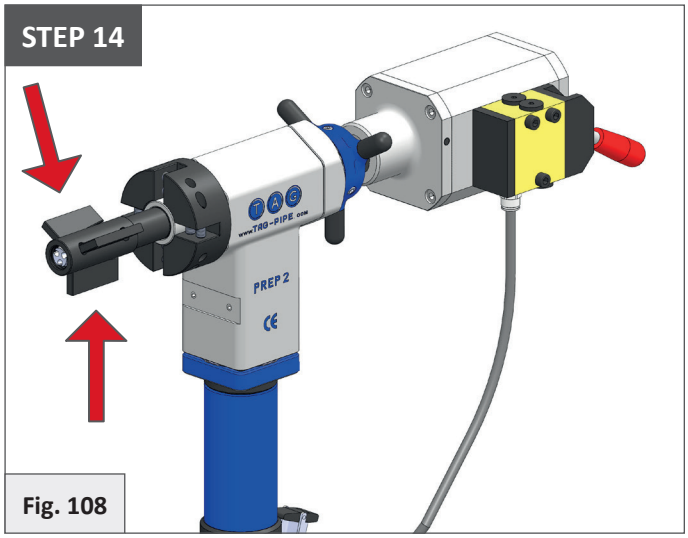


Fig. 108

STEP 15

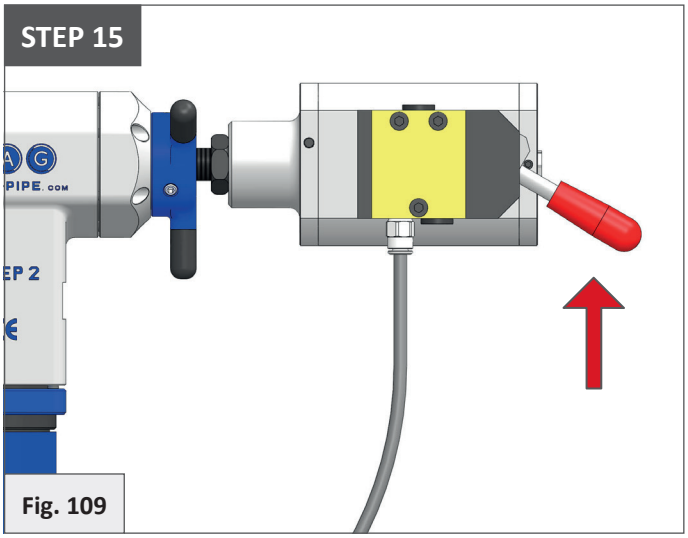


Fig. 109

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

STEP 16

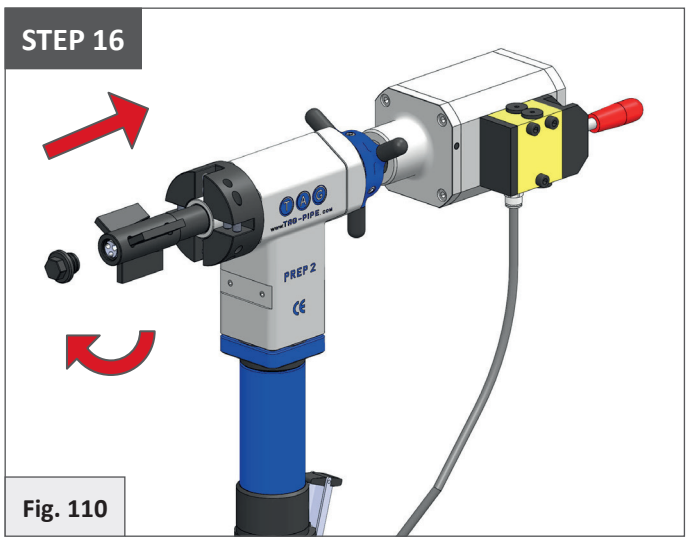


Fig. 110

Screw the shaft end nut back on in a clockwise direction.

STEP 17

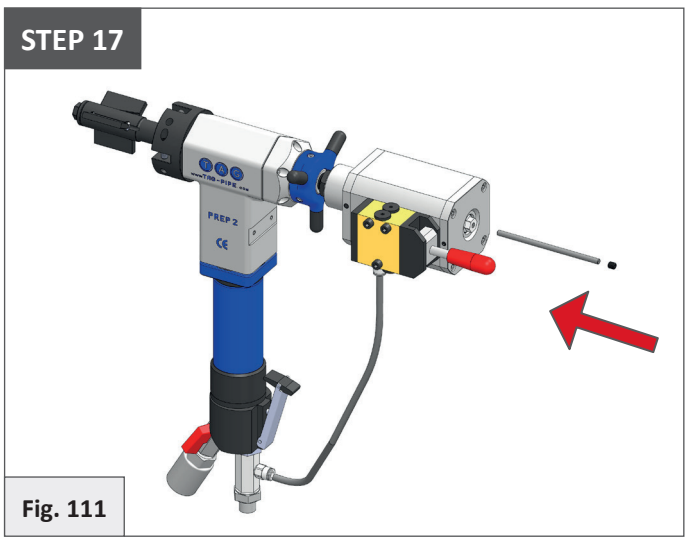


Fig. 111

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

8.9 - AUTOMATIC LOCKING DEVICE KIT WITH REDUCED SHAFT

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

STEP 1

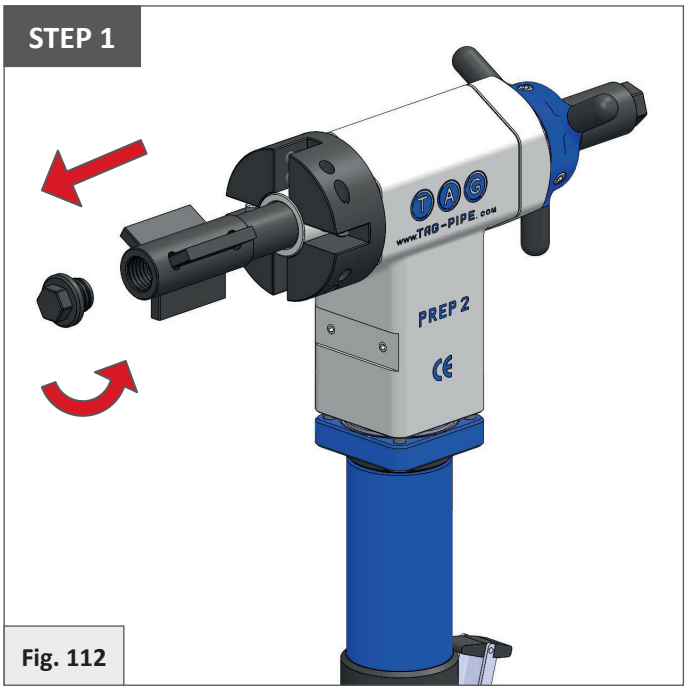


Fig. 112

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

STEP 2

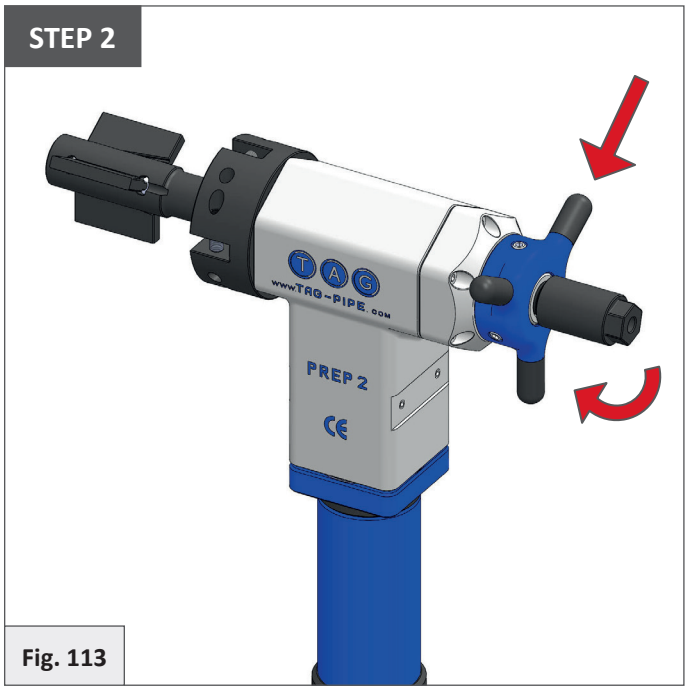


Fig. 113

Turn the unlock/lock nut clockwise to the maximum expansion.

STEP 3

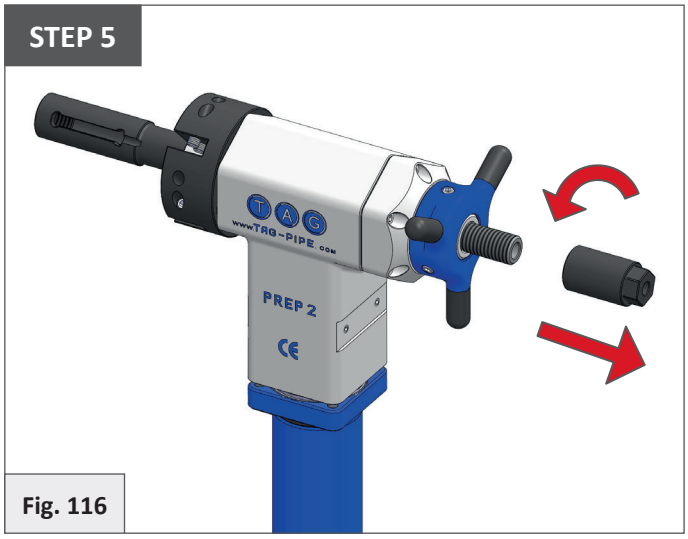
Fig. 114

Remove the locking jaws.

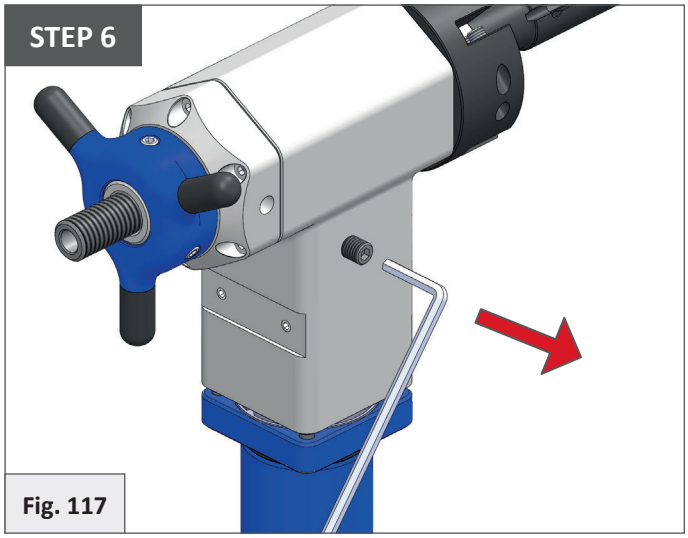
STEP 4

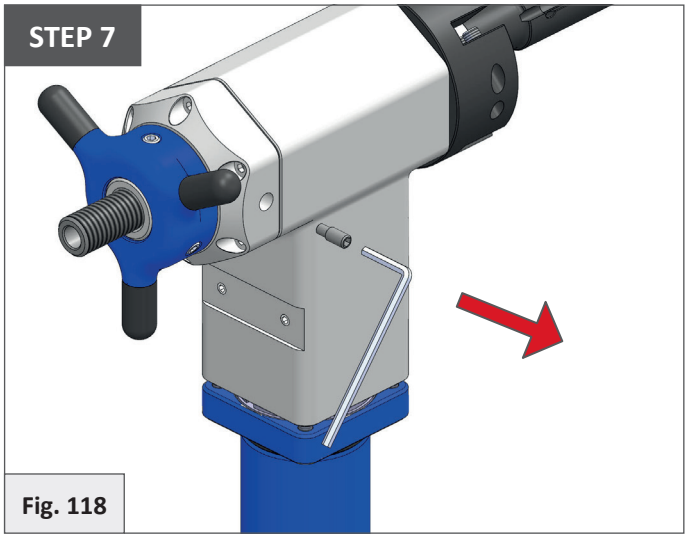
Fig. 115

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

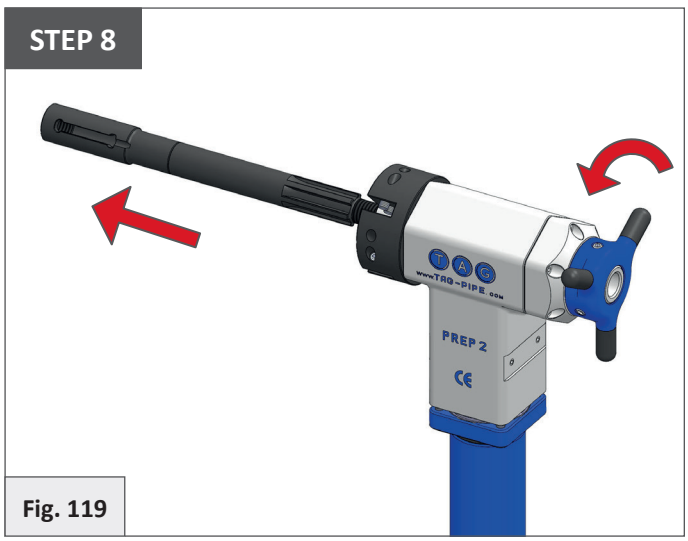


Rotate the lock/unlock nut anti-clockwise.

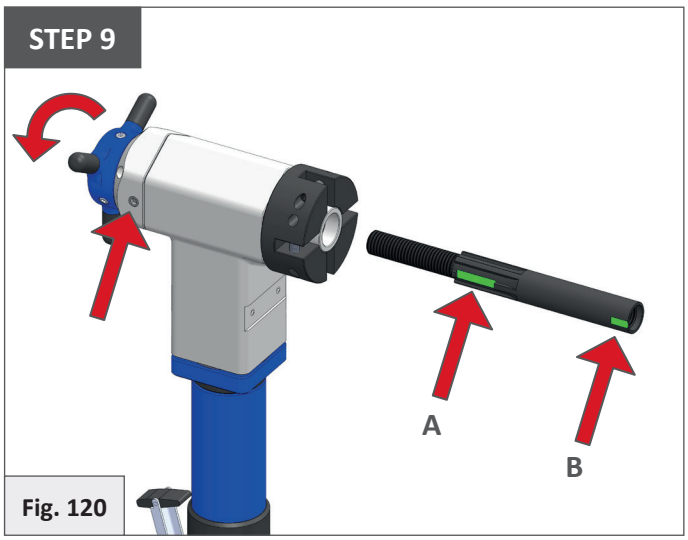




Remove the grub screw and then stop grub screw from the cover.



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



Take the outside shaft from the reduced shaft kit and mark the groove of the lap joint (arrow A) as well as the far end of the shaft (arrow B) as shown in Fig. 120.

STEP 10

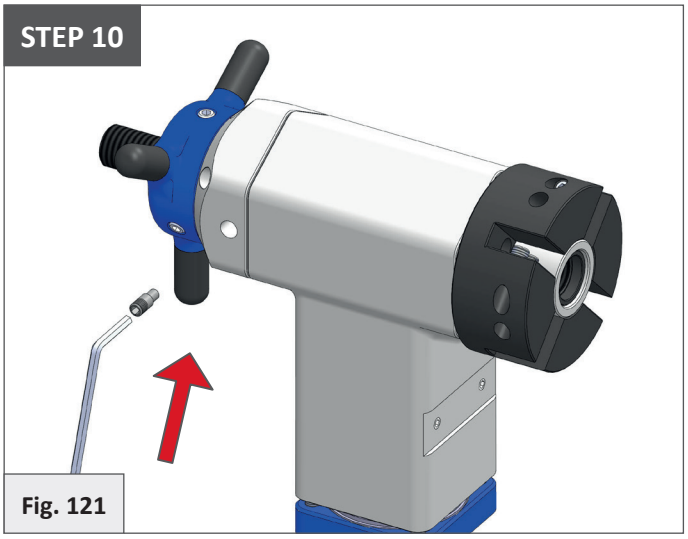


Fig. 121

STEP 11

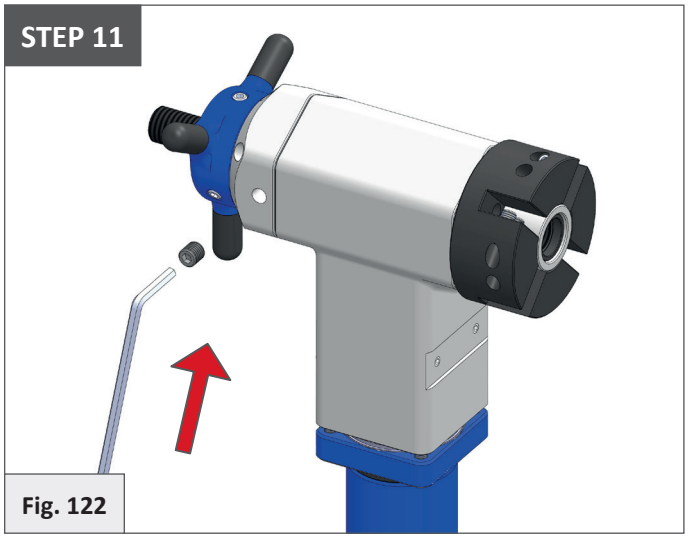


Fig. 122

Re-assemble screw stop cover and grub screw and lock.

STEP 12

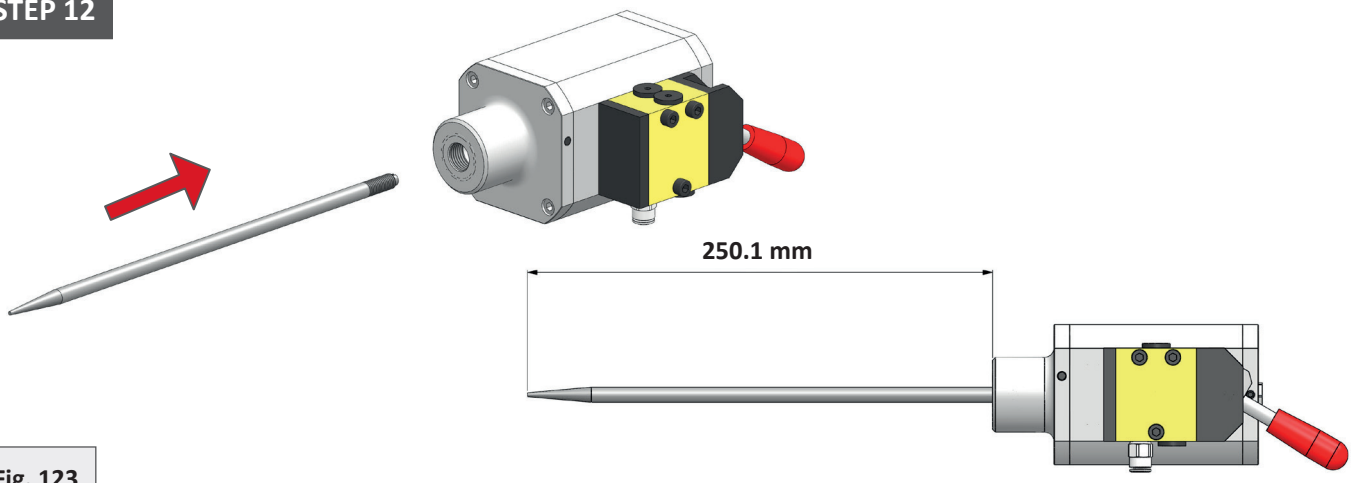


Fig. 123

Insert reduced inside shaft and screw anti-clockwise up to 250.1 mm dimension in Fig. 123 (left thread).

⚠ **WARNING** - The piston of locking device it must be maximum position

STEP 13

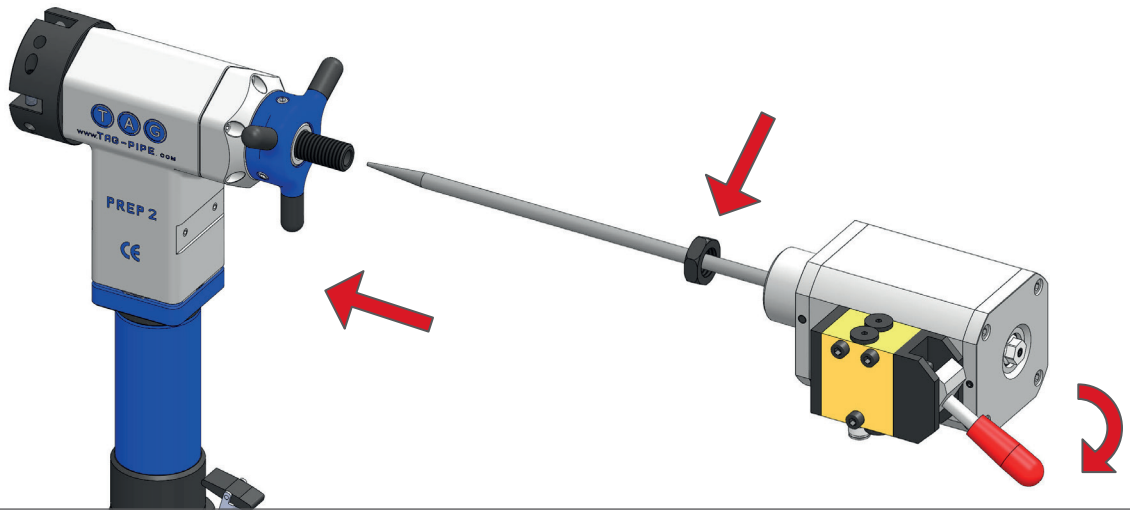


Fig. 124

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

STEP 14

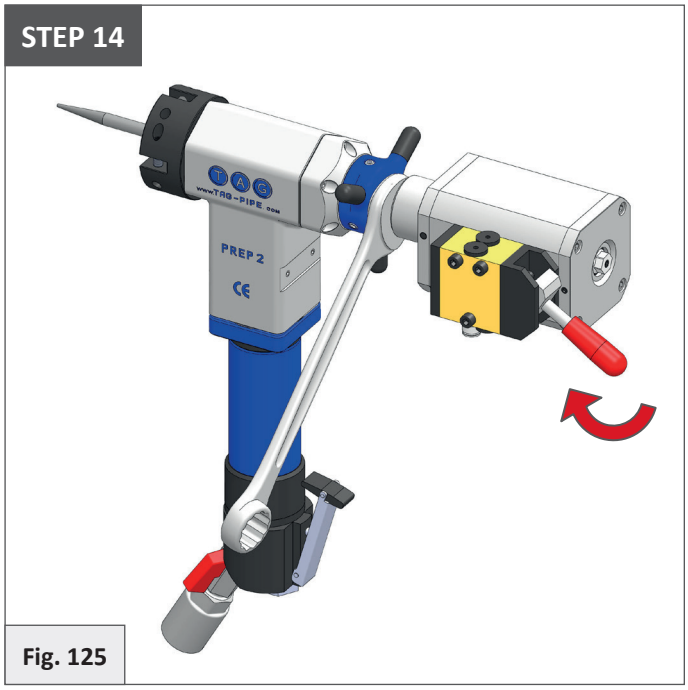


Fig. 125

STEP 15

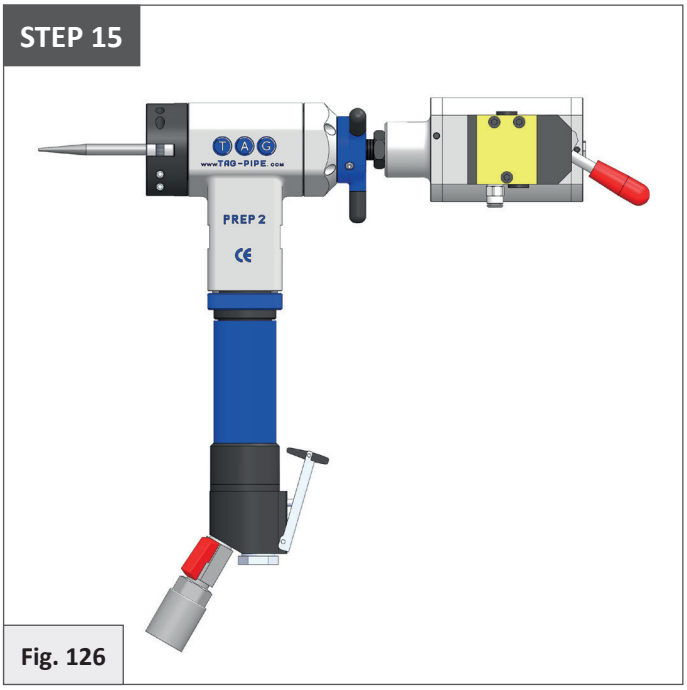


Fig. 126

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

STEP 16

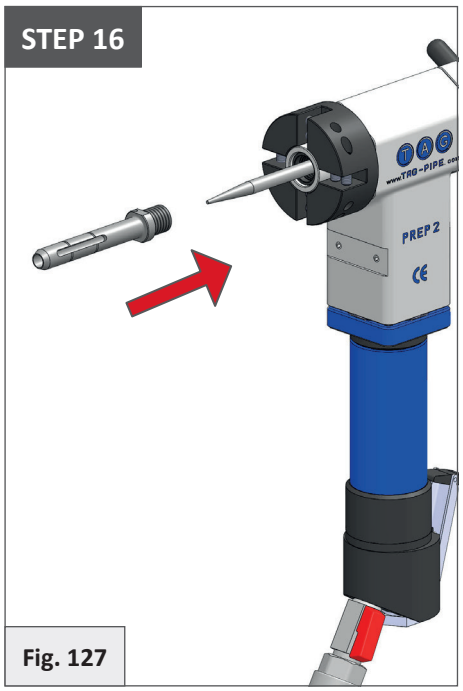


Fig. 127

STEP 17

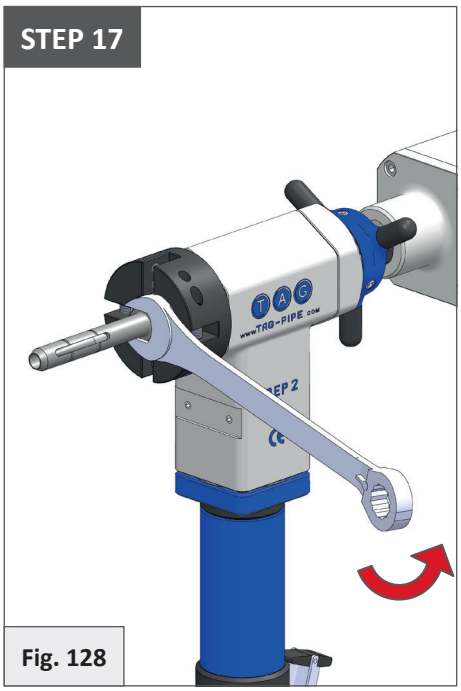


Fig. 128

STEP 18

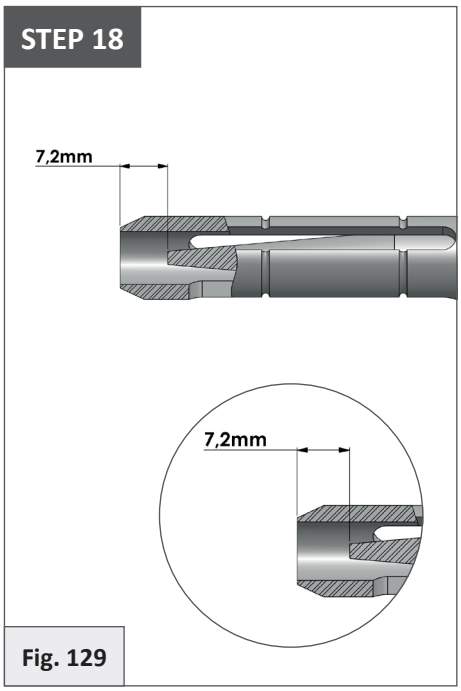


Fig. 129

By using the 17 wrench tighten the head anti-clockwise (left thread).
At the maximum expansion double check the measurement shown in the picture (Fig. 129).

⚠ **WARNING** - Verify that the reduced inside shaft is positioned as in the picture

STEP 19

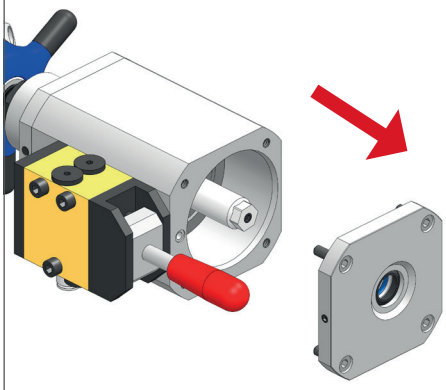


Fig. 130

Remove locking device back cover.

STEP 20

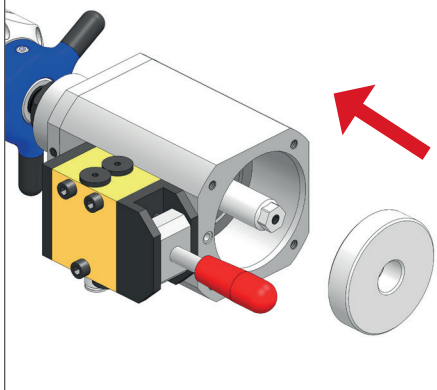


Fig. 131

Insert the spacer.

STEP 21

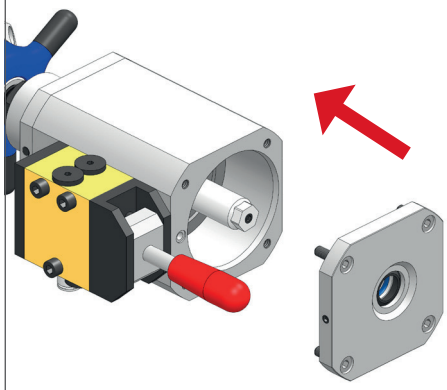


Fig. 132

Re-assemble the locking device back cover.

STEP 22

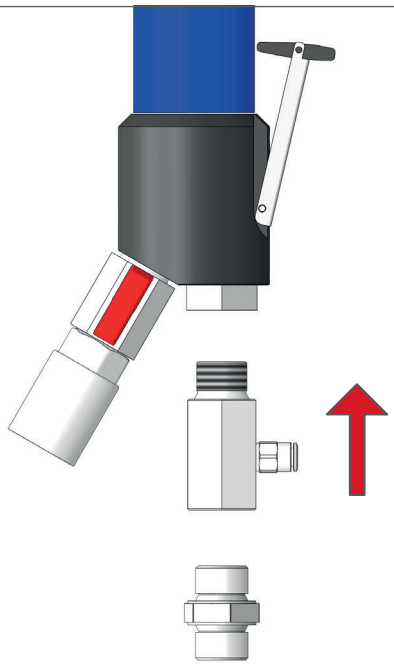


Fig. 133

Screw in the special connection as shown in the picture.

STEP 23

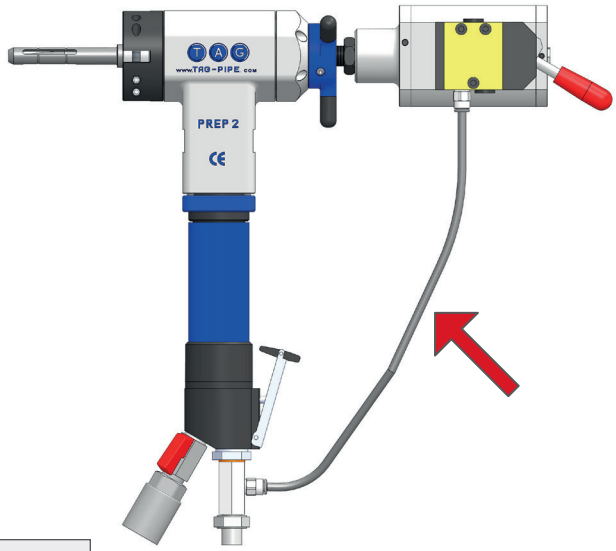


Fig. 134

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

STEP 24

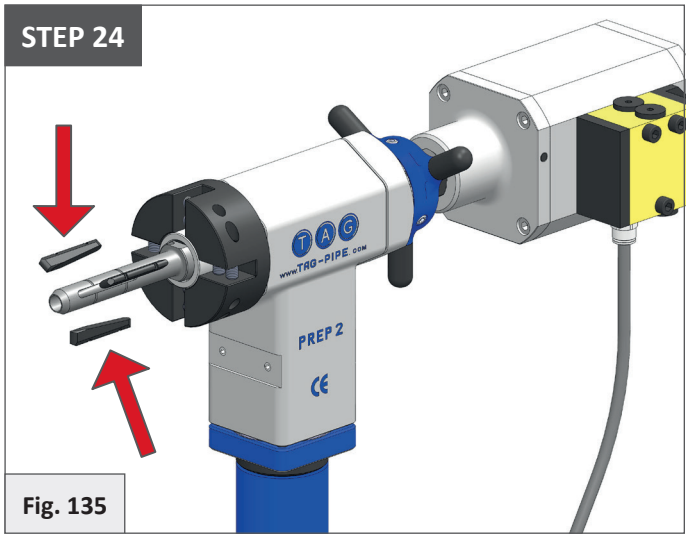


Fig. 135

According to the pipe inside diameter insert the three locking jaws as shown in the picture.

STEP 25

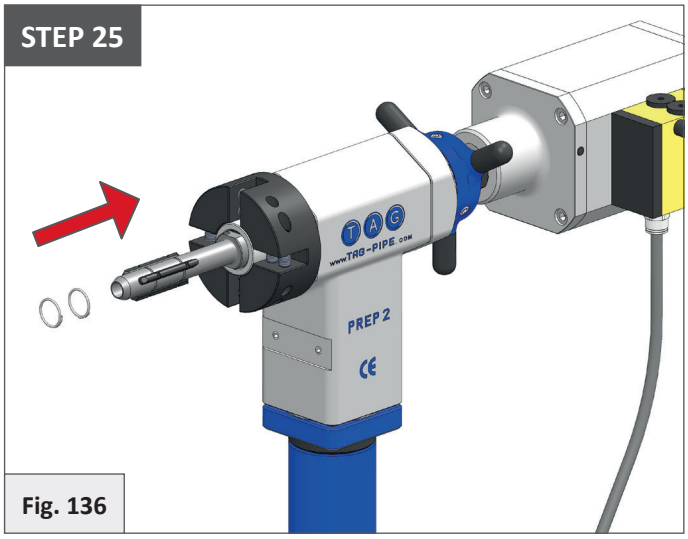


Fig. 136

By using a screwdriver or something similar, slide the springs to find the right position.

STEP 26

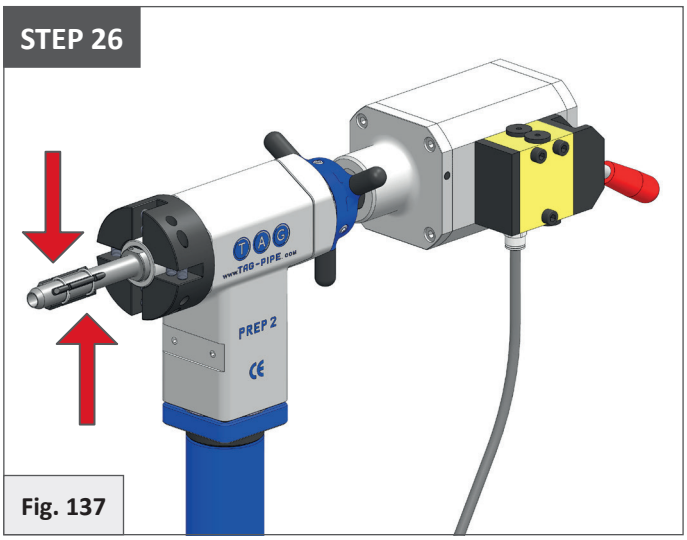


Fig. 137

STEP 27

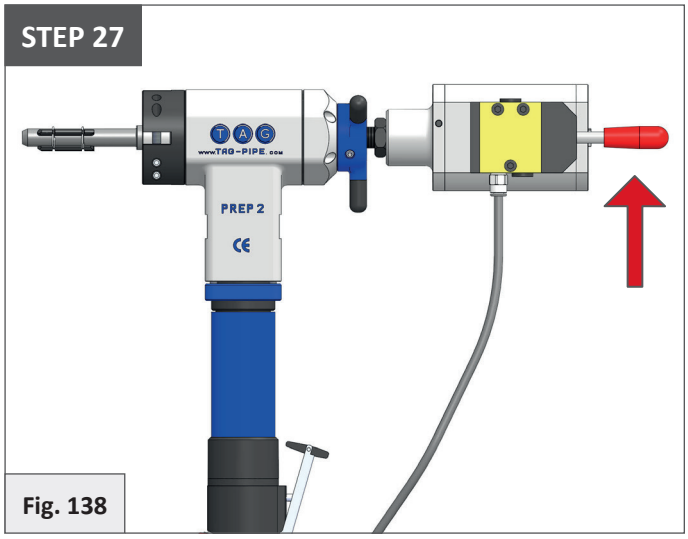


Fig. 138

Move the lever up to achieve the backward position of inside shaft.

STEP 28

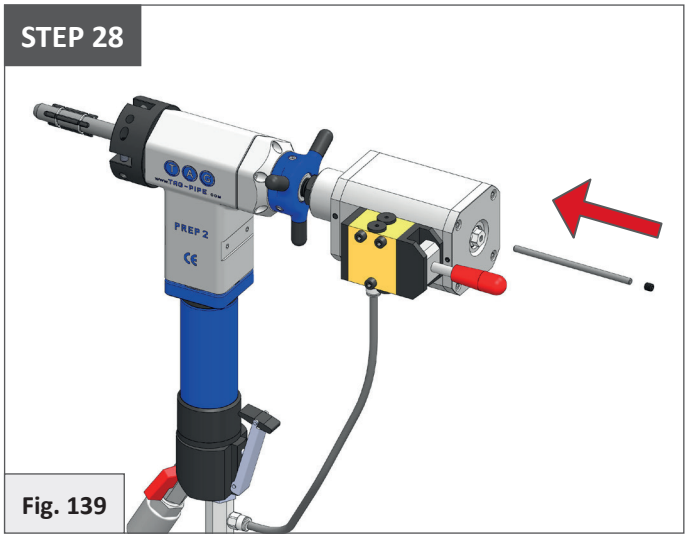


Fig. 139

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 S.F.E. Group or an S.F.E. Group authorised partner. All spare parts used during repair activities should be genuine TAG PREP 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 S.F.E. Group or an S.F.E. Group authorised partner.

10 - DELCARATION OF CONFORMITY

PIPE EQUIPMENT SPECIALISTS

PART OF SFE SPECIALIZED FABRICATION EQUIPMENT GROUP

Declaration of conformity

SFE GROUP
330B Route de Portes les Valence
26800 – Etoile Sur Rhône, France
Standard : +33 (0)4 75 57 50 70

Déclaration de conformité
Declaration of conformity
EG-Konformitätserklärung
Declaración de conformidad
Dichiarazione di conformità

CE

produit suivant: The following product: Die Bauart der Maschine: El producto siguiente: Il seguente prodotto:	**TP8E220** **Pipe bevelling machine** Including all compatible accessories.	Année : Year : Baujahr : Año :Anno : **2022**
Numéro de série: Series number: Seriennummer: Número de serie: Numero di serie:	**XXXXX**	

Déclare que le produit désigné ci-dessus est conforme aux dispositions des directives : et aux règlementations nationales les transposant. Declare that the product specified above is in accordance with the provisions of directives: and to national regulations transposing it. Erklärt, dass die vorstehend beschriebenen Produkt entsprechen den Bestimmungen der Richtlinien : und dazu gehörigen nationalen Vorschriften. Declara que el producto designado arriba se ajusta a la disposiciones de las directivas : y reglementos nacionales las transponen. Dichiara che il prodotto designato sopra è conforme alle disposizioni delle direttive : è alle normative nazionali che le recepsiono.	**2006/42/CE** **2014/35/UE** **2014/30/UE**
Personne autorisée à constituer le dossier technique : Person authorised to compile the technical file: Bevollmächtigte Person für die Zusammenstellung der technischen Unterlagen: Persona facultada para compilar el expediente técnico: Persona autorizzata a costituire il Fascicolo Tecnico:	Francesco TANTIMONACO TAG 26800 – Etoile Sur Rhône, France

At Etoile Sur Rhône
The 04/10/2023

Francesco TANTIMONACO
Technical Manager

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330B Route de Portes les Valence
26800 – Etoile Sur Rhône, France
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UK CA

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At Etoile Sur Rhône
The 04/10/2023

Francesco TANTIMONACO
Technical Manager

SPECIMEN

GLOBAL LEADER IN SPECIALIZED MACHINING, WELDING AND FABRICATION EQUIPMENT

SPECIALIZED FABRICATION EQUIPMENT GROUP

Contact Americas
sales@sfe-brands.com

Contact International
sales-int@sfe-brands.com

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