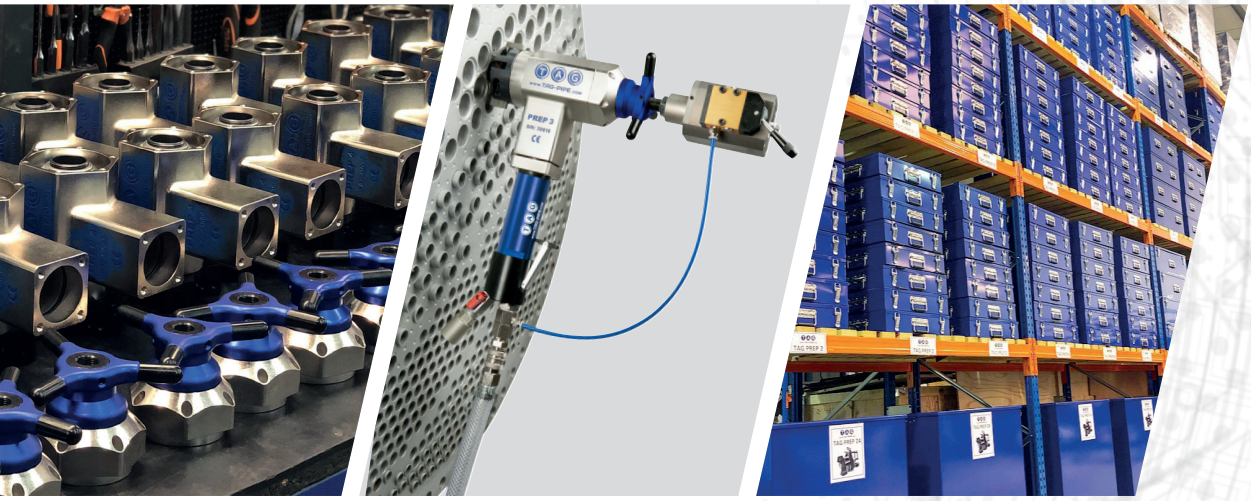
PREP 3 PORTABLE PIPE BEVELLING MACHINE

1.1 - 2.99" i/d / 28 - 76 mm i/d

(optional from 0.8" i/d / 20 mm i/d)

ORIGINAL INSTRUCTIONS / NOTICE ORIGINAL



INSTRUCTION MANUAL

www.TAG-PIPE.com

TAG

PIPE EQUIPMENT SPECIALISTS

AN SPE GROUP BRAND

*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.*

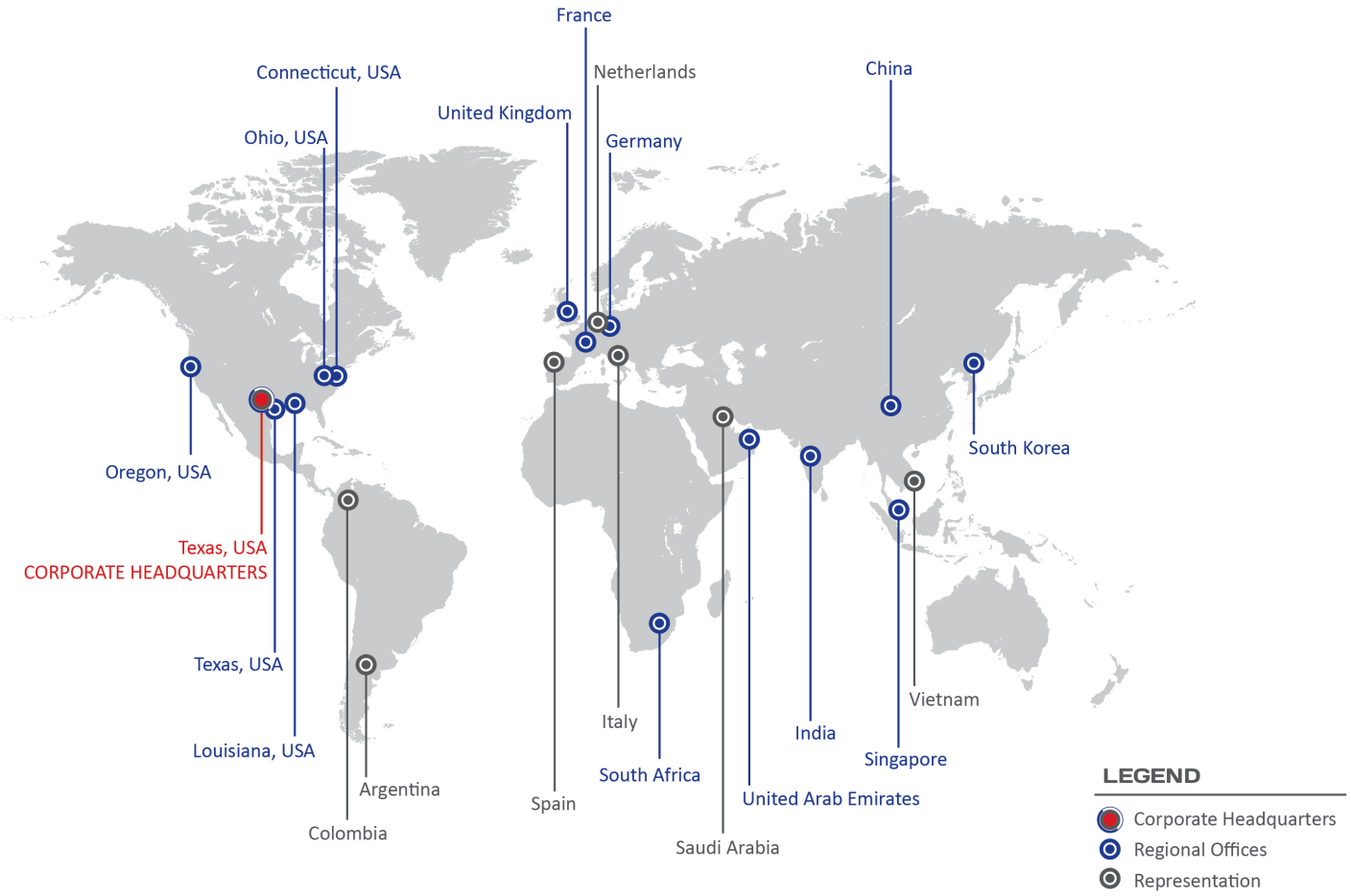
*Leveraging over 200 years of combined experience in engineering, manufacturing, and field applications, the **S.F.E. Group** is committed to driving innovation. Through continuous product development and strategic acquisitions, the **S.F.E. Group** is actively growing its portfolio and expanding its 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


CHEMISTRY


INFRASTRUCTURE


MANUFACTURING & FABRICATION


NUCLEAR


OIL & GAS


POWER GENERATION

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

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.

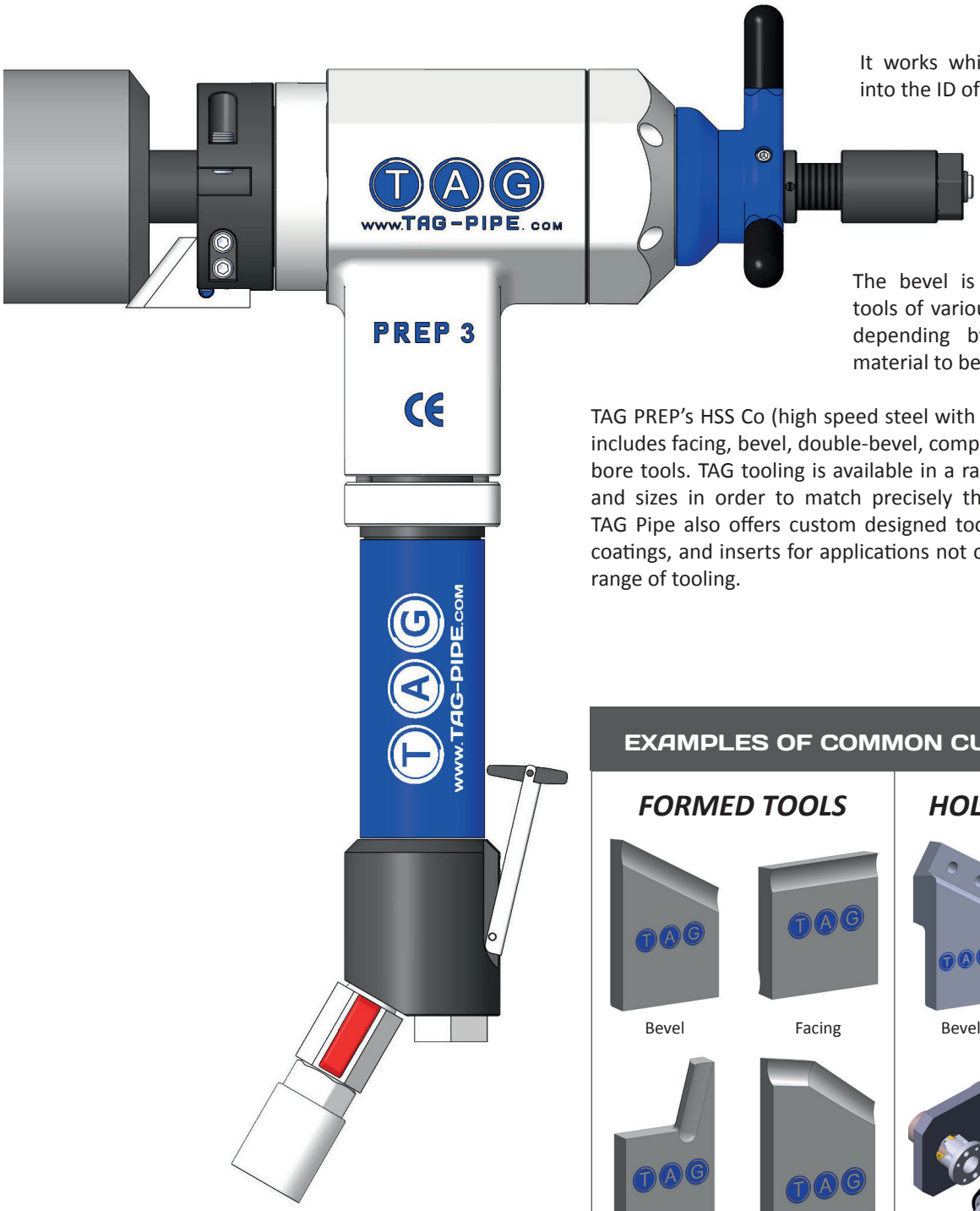
4 - SPECIFIC INSTRUCTIONS

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



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

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

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

EXAMPLES OF COMMON CUTTING TOOLS

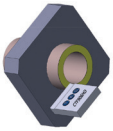
FORMED TOOLS

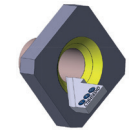
Bevel

Facing


Internal


J-weld removal

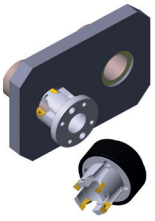




HOLDER / INSERT


Bevel


Facing




Insert

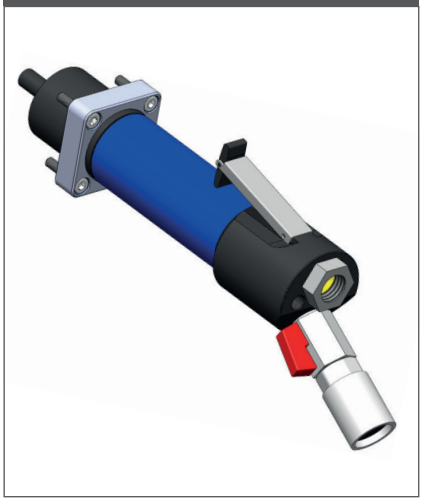
All shapes, sizes and angles available

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 3 can be equipped with the following motor types:

PNEUMATIC



ELECTRIC

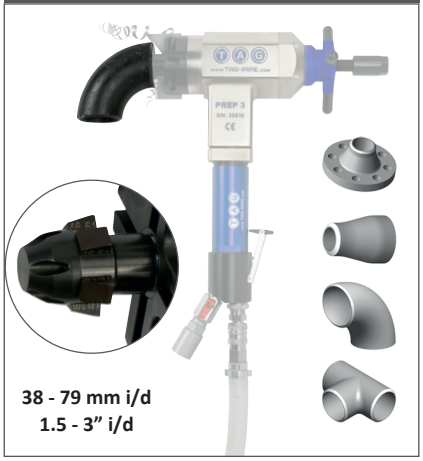
BATTERY

The TAG PREP 3 can be equipped with optionals:

REDUCED SHAFT

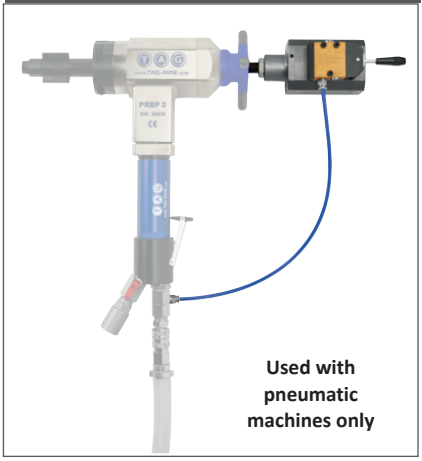
20 - 30 mm i/d
0.8 - 1.2" i/d

ELBOW / FITTINGS SHAFT



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

AUTO LOCK

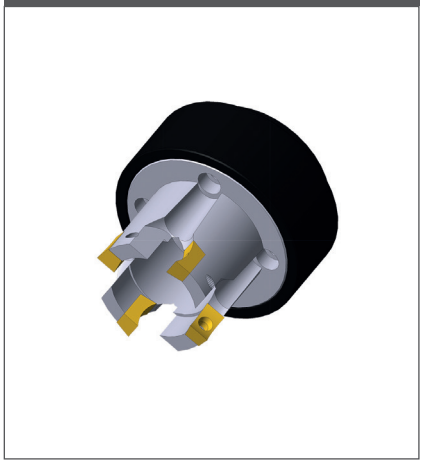


Used with pneumatic machines only

RATCHET HANDLES

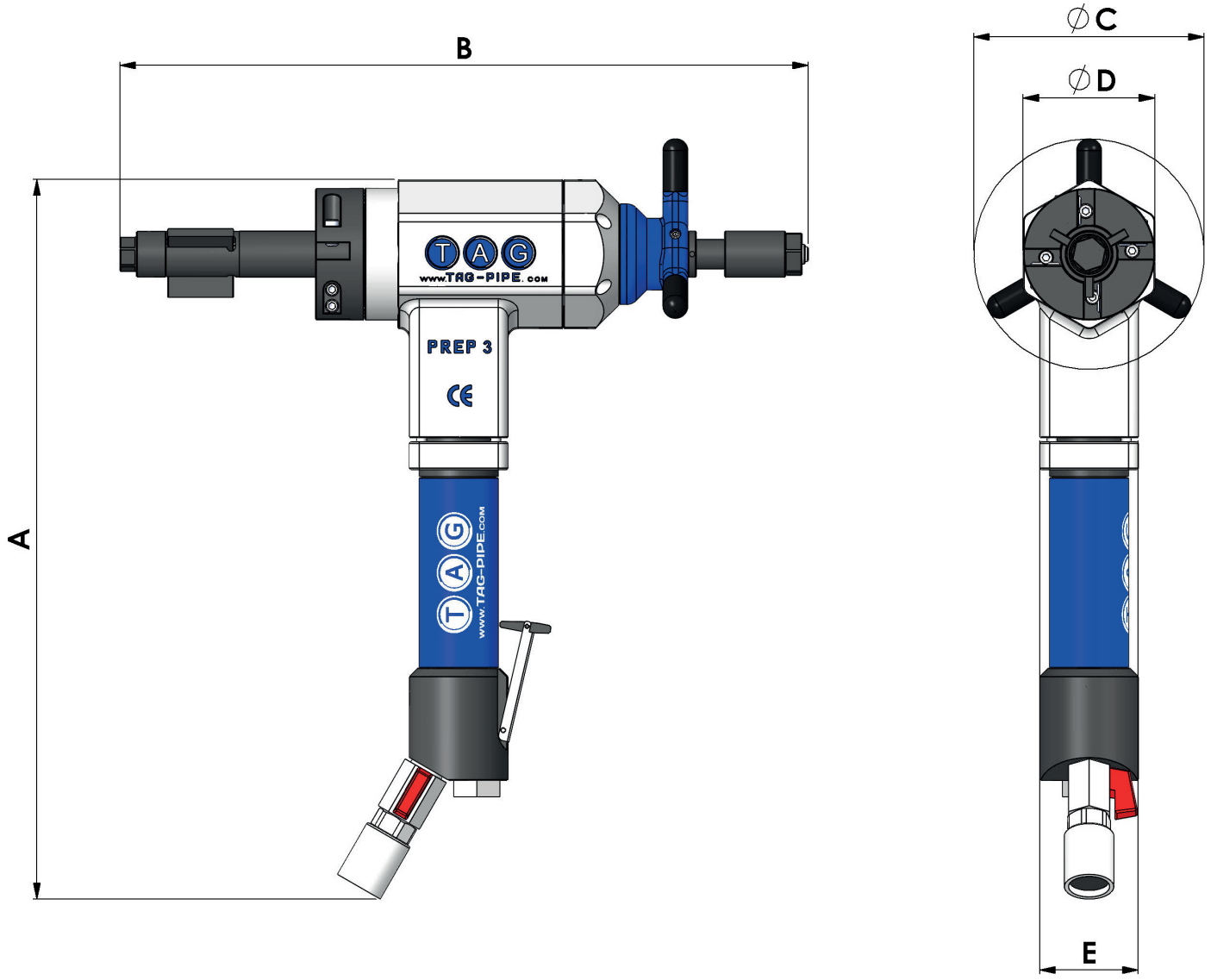
FEED STOPPER

MILLING HEADS



6 - MACHINE TECHNICAL DATA

The TAG PREP 3 dimensional specifications.



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

PREP 3 TECHNICAL FEATURES

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

Our group policy is one of continuous improvement. Products and data tables are subject to change 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

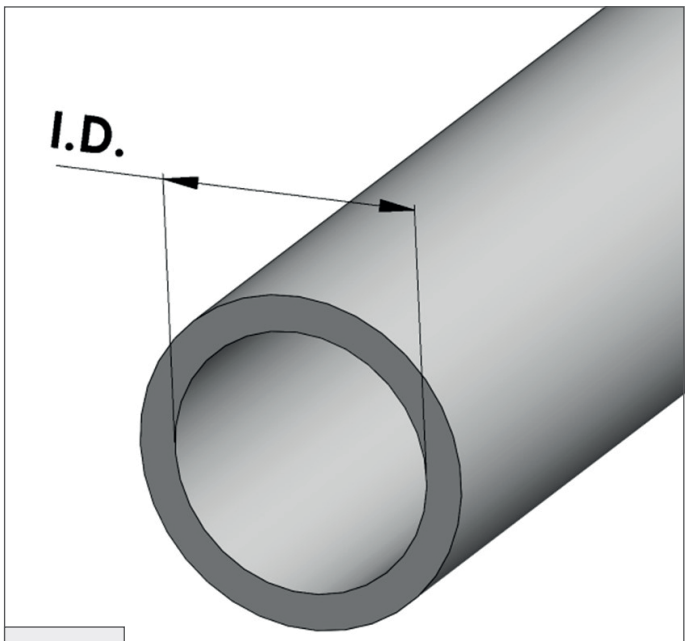


Fig. 2

STEP 2

Fig. 3

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

STEP 3

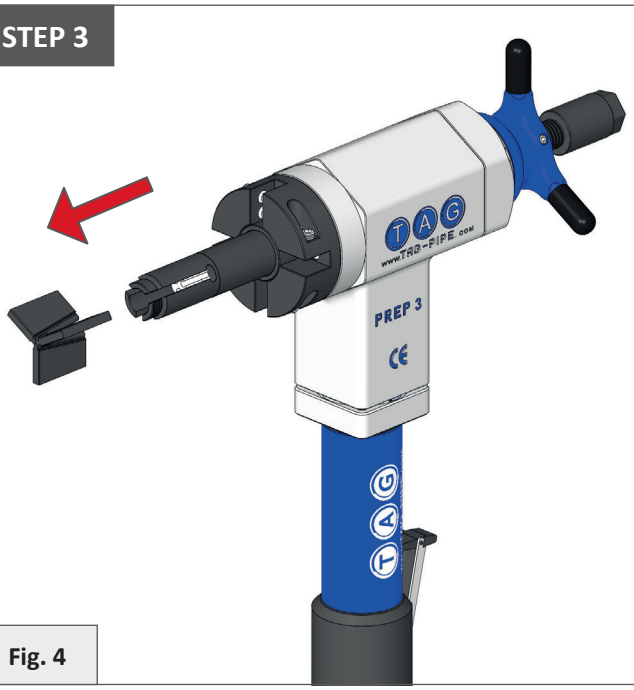


Fig. 4

Remove the locking jaws you want to replace.

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

STEP 4

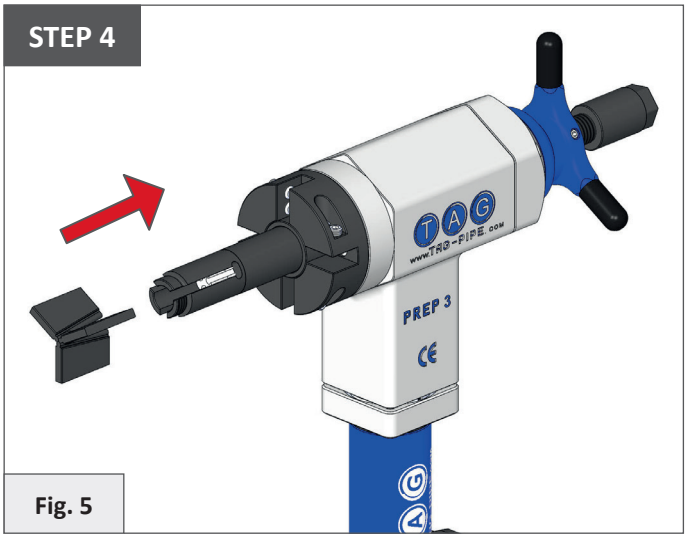


Fig. 5

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

STEP 5

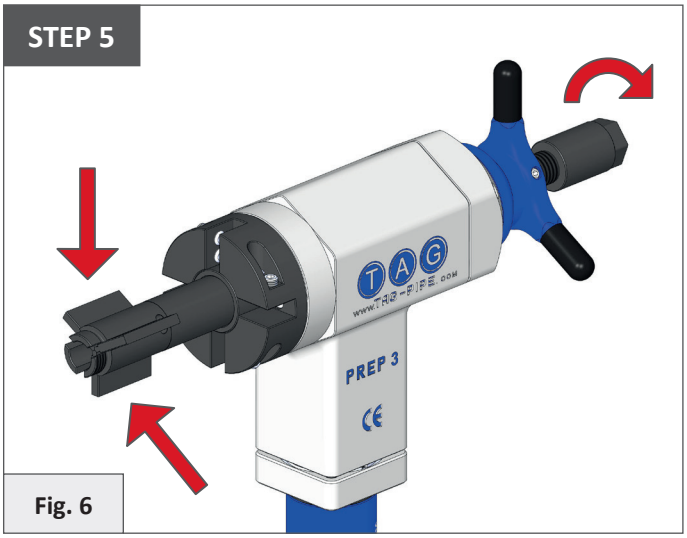


Fig. 6

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

STEP 6

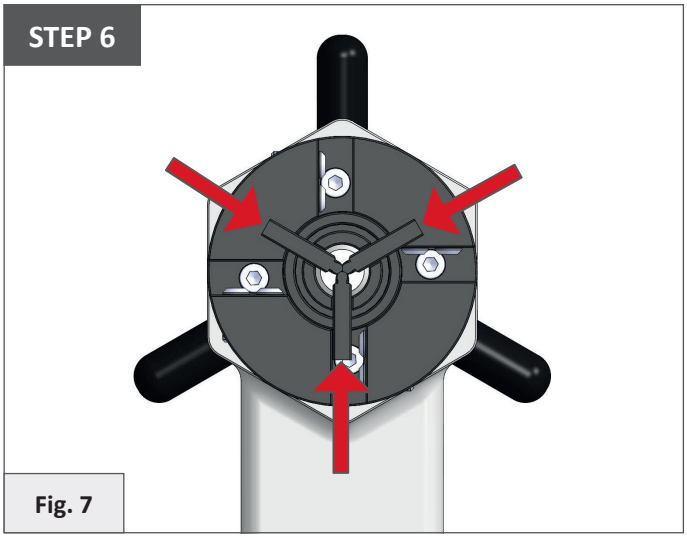


Fig. 7

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

STEP 7

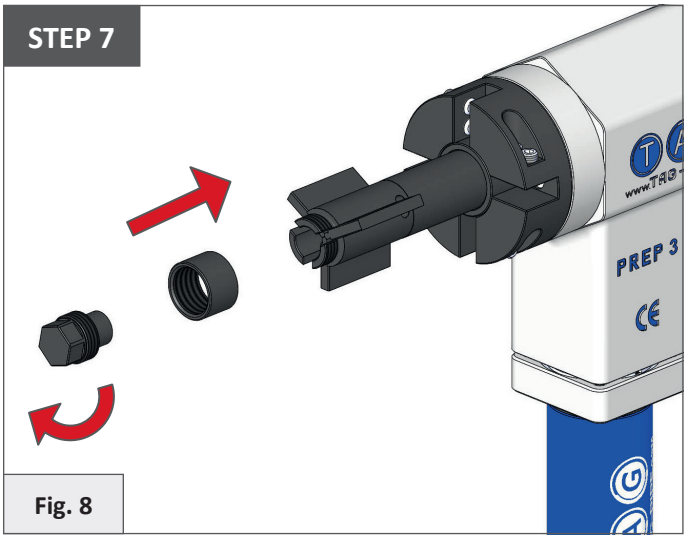


Fig. 8

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

STEP 8

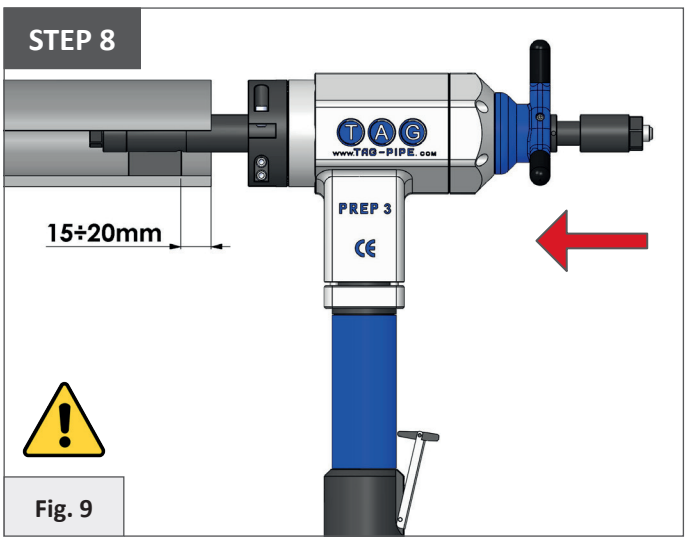


Fig. 9

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

STEP 9

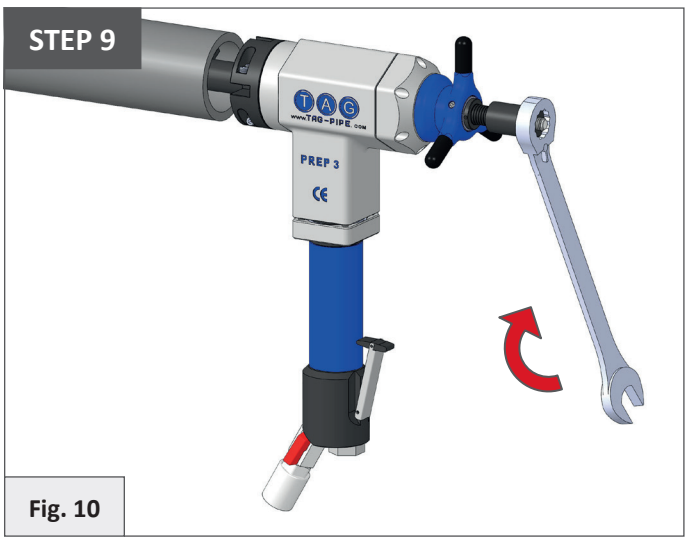


Fig. 10

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

8.2 - TOOLS SETUP

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

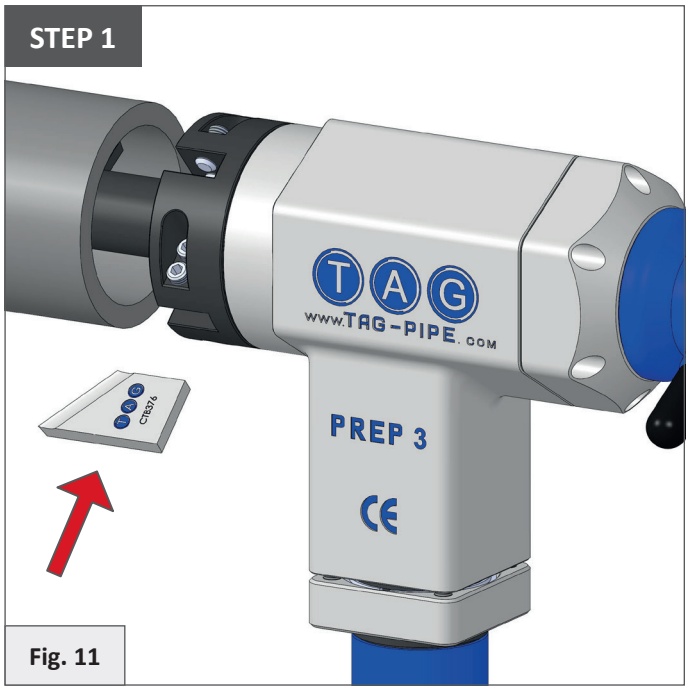


Fig. 11

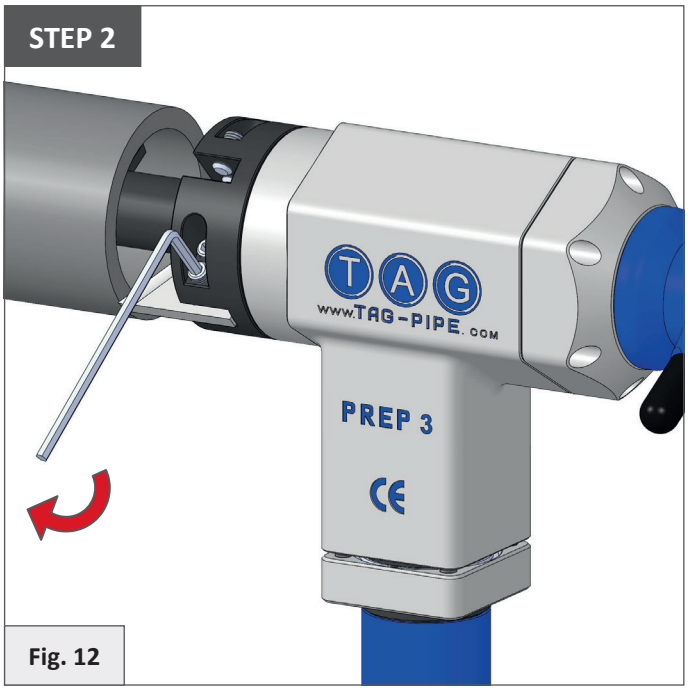


Fig. 12

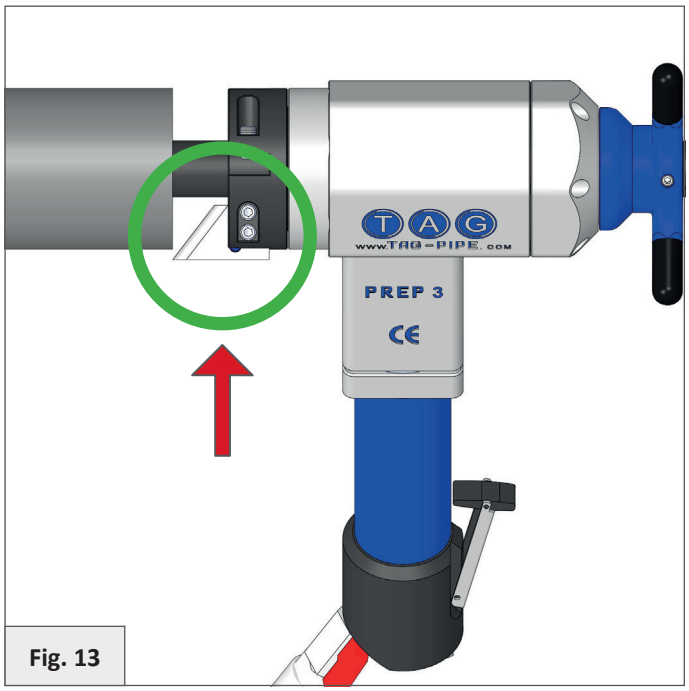


Fig. 13

YES

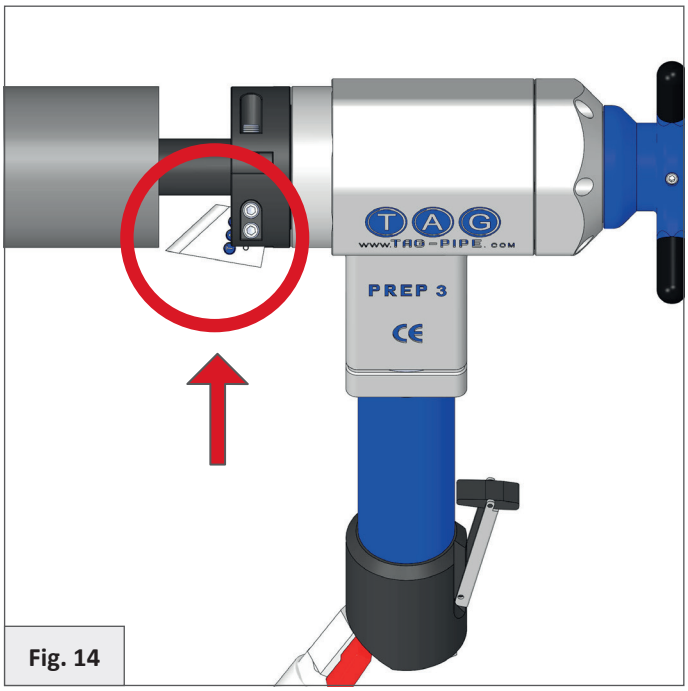


Fig. 14

NO

8.3 - OPERATION

ELECTRIC MODEL

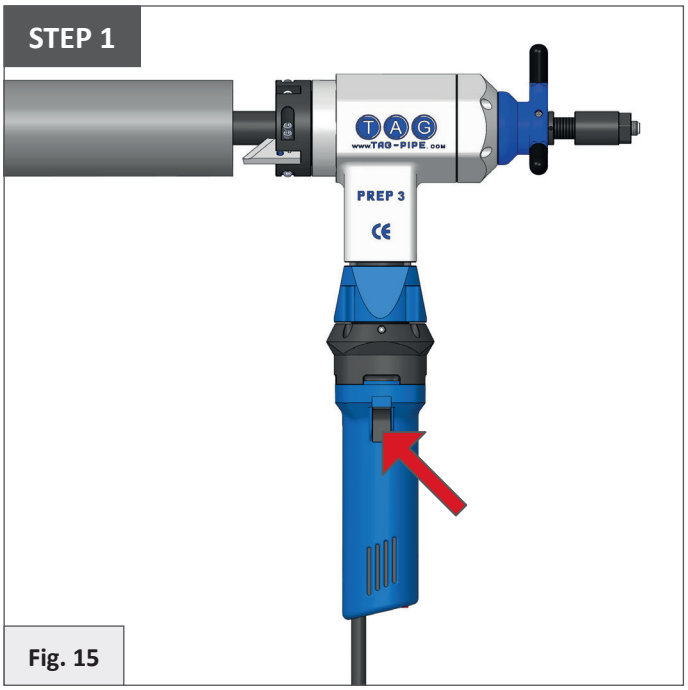


Fig. 15

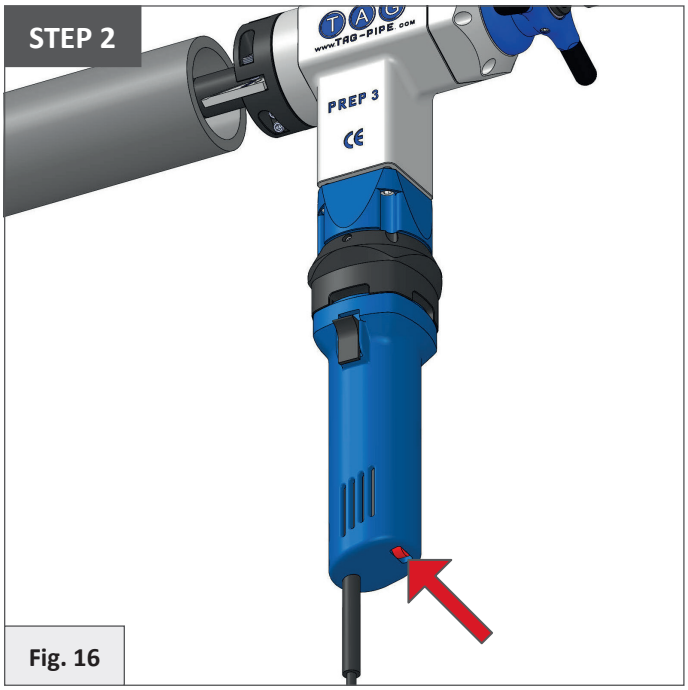


Fig. 16

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

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

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

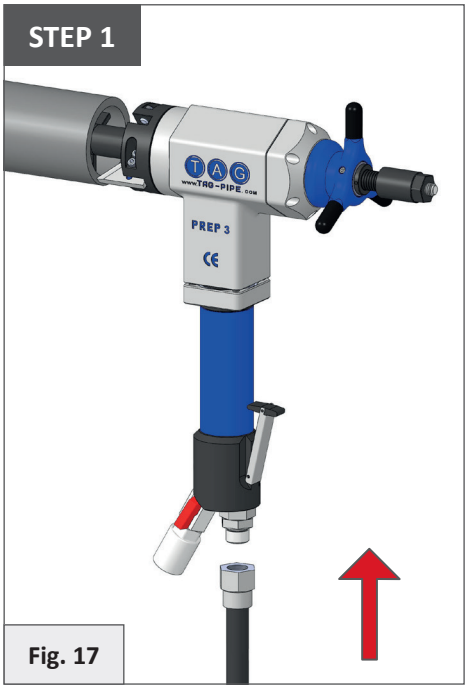


Fig. 17

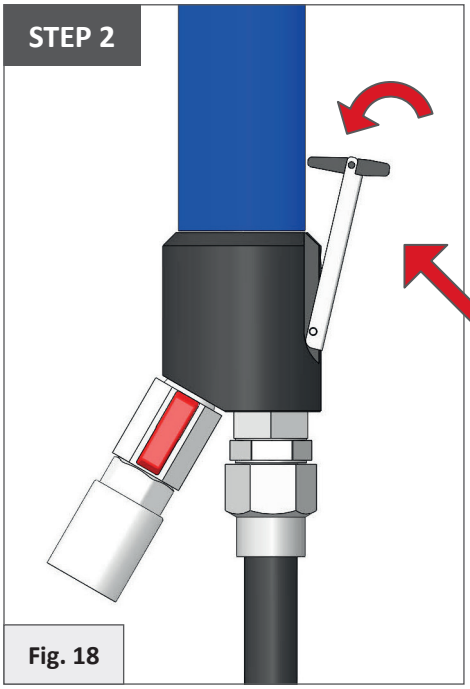


Fig. 18

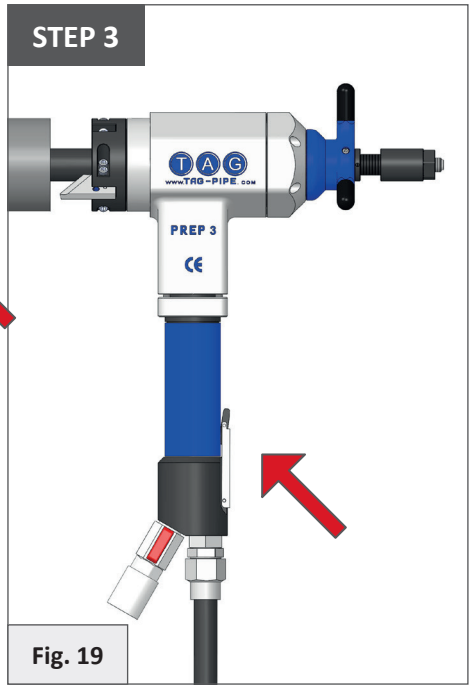
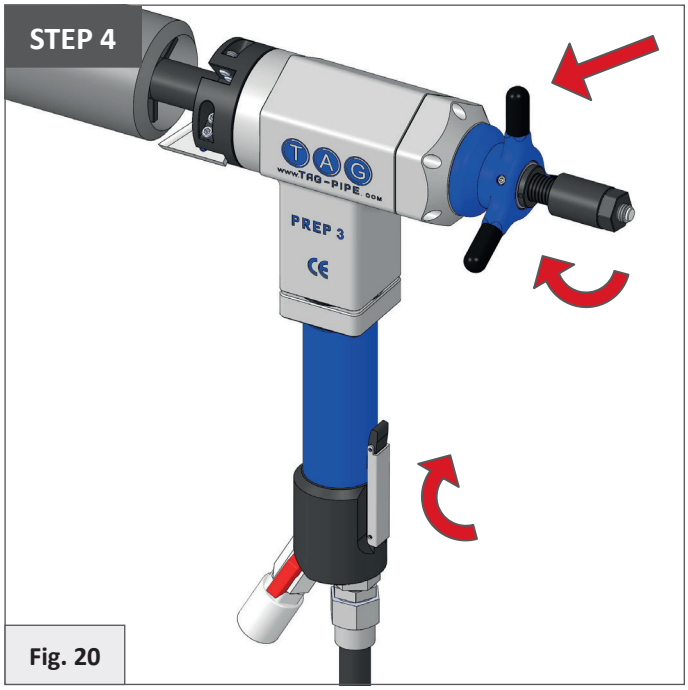
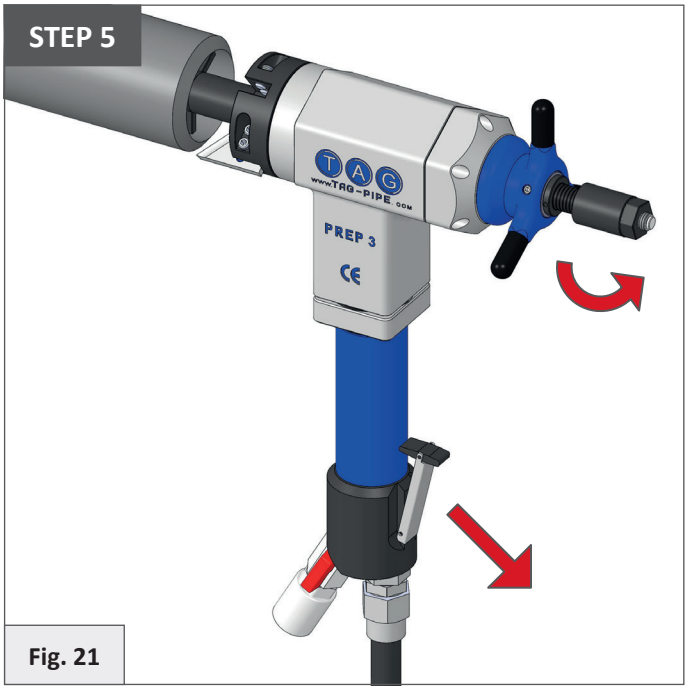


Fig. 19

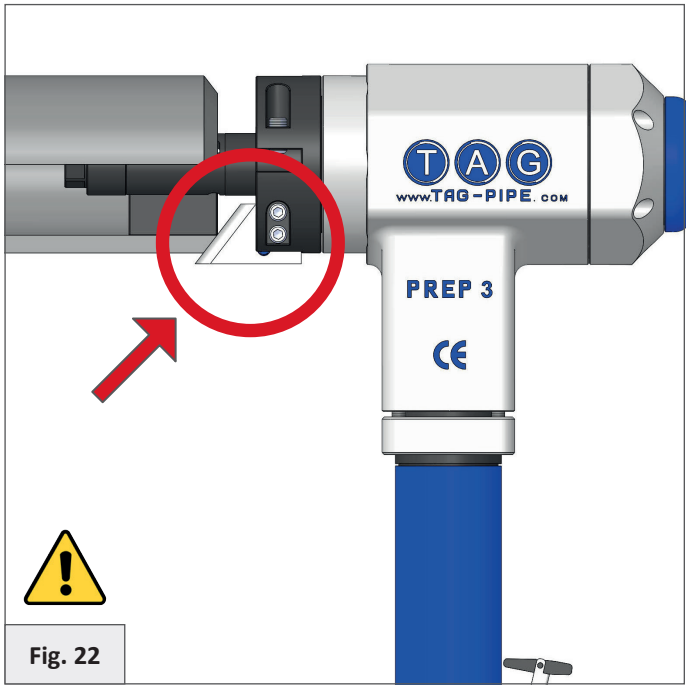
Actuate the machine by pressing the lever as shown by the arrows (Fig.18).



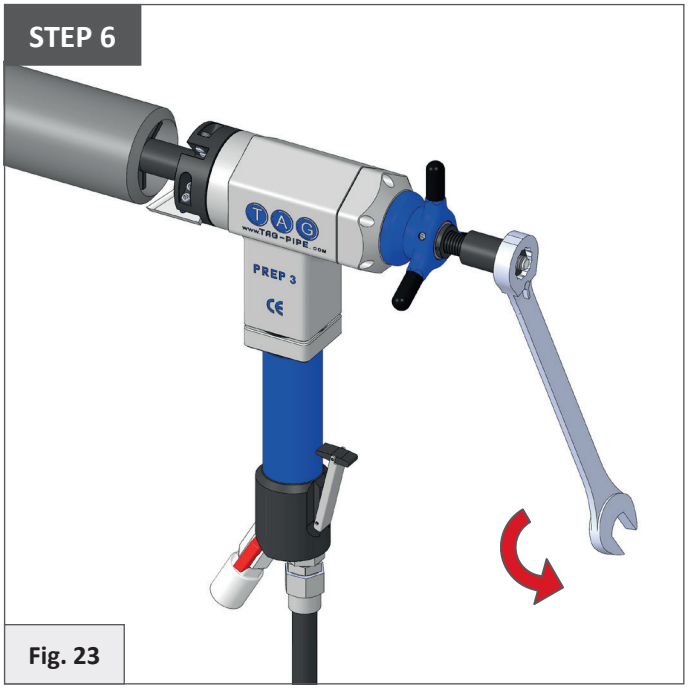
The machine feeding is achieved by acting on the hand wheel as shown in the picture (Fig. 20). For a perfect result it is important that you maintain a constant feeding rate.



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



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



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

8.4 - REDUCED SHAFT ASSEMBLY KIT

STEP 1

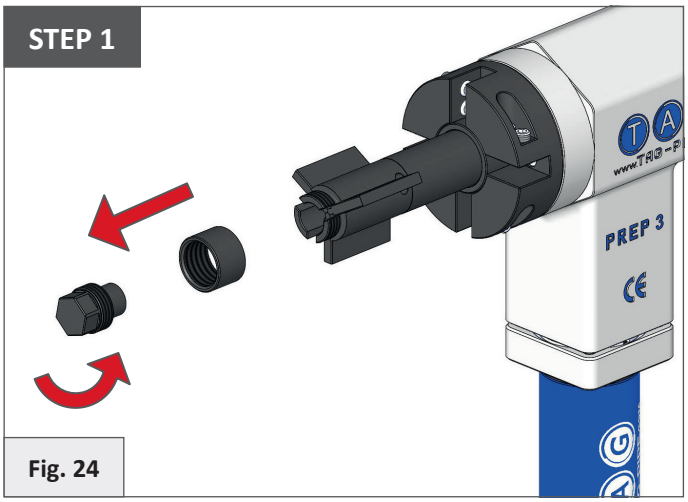


Fig. 24

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

STEP 2

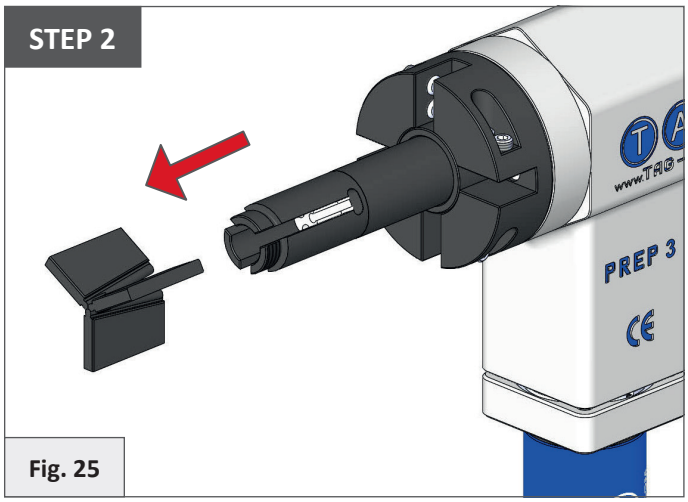


Fig. 25

Remove the locking jaws.

STEP 3

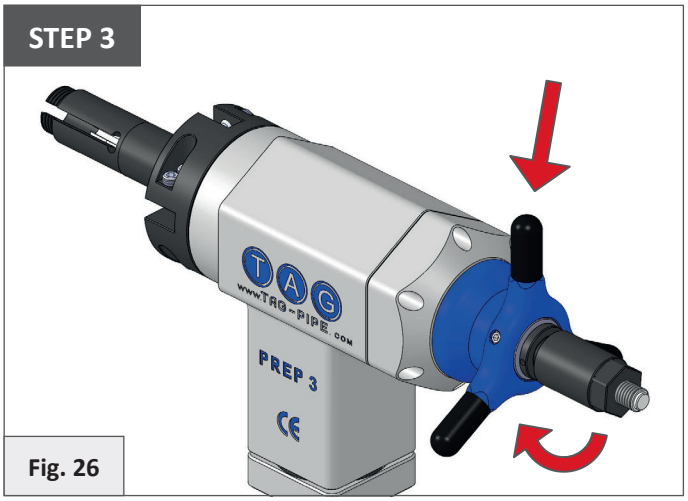


Fig. 26

Rotate the lock/unlock nut in clockwise direction.

STEP 4

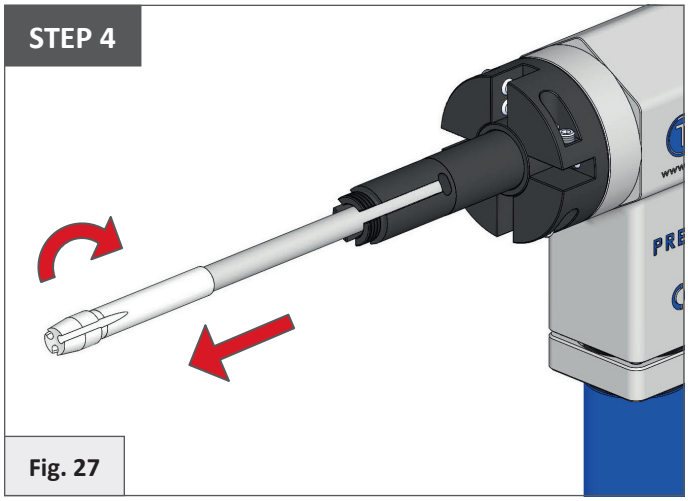


Fig. 27

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

STEP 5

Fig. 28

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

STEP 6

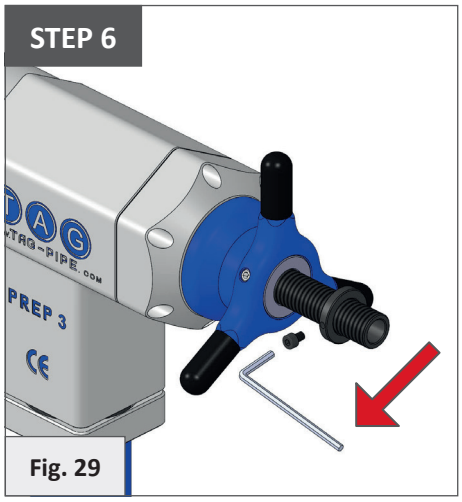


Fig. 29

STEP 7

Fig. 30

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

STEP 8

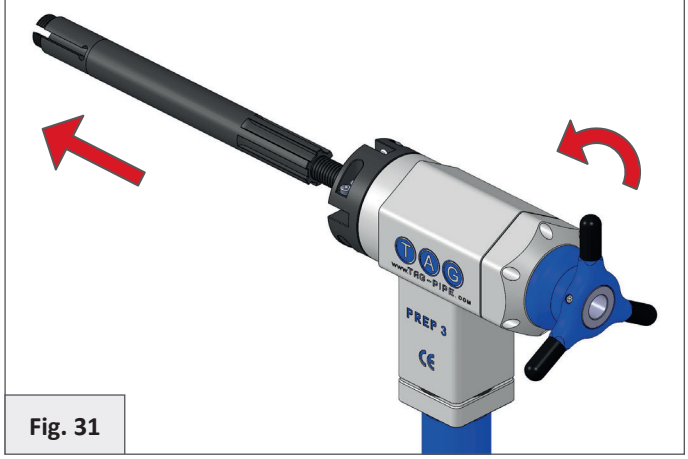


Fig. 31

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

STEP 9

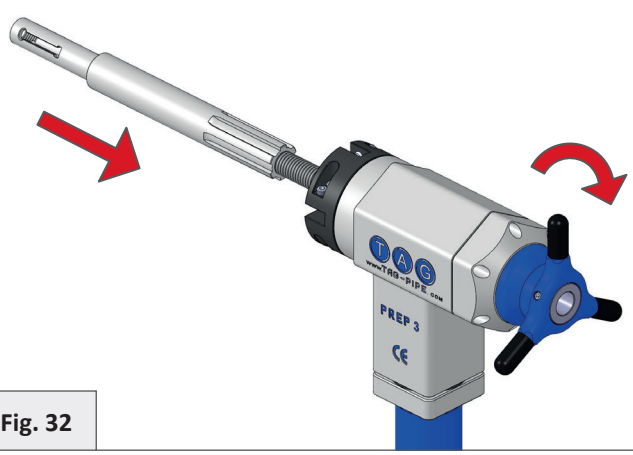


Fig. 32

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

STEP 10

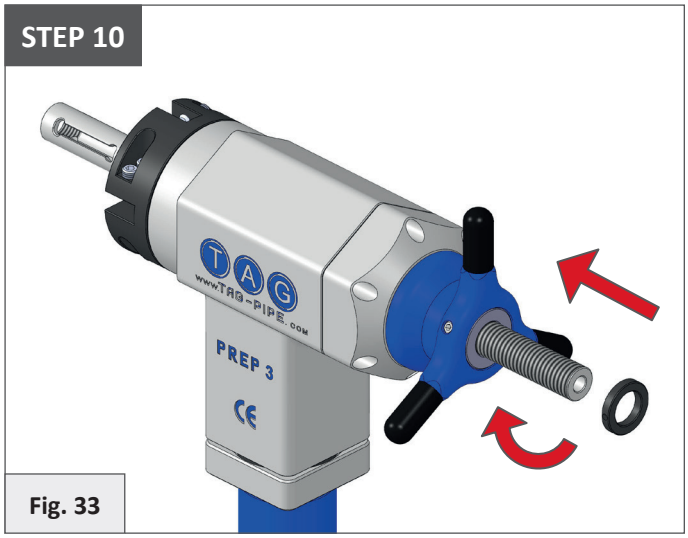


Fig. 33

STEP 11

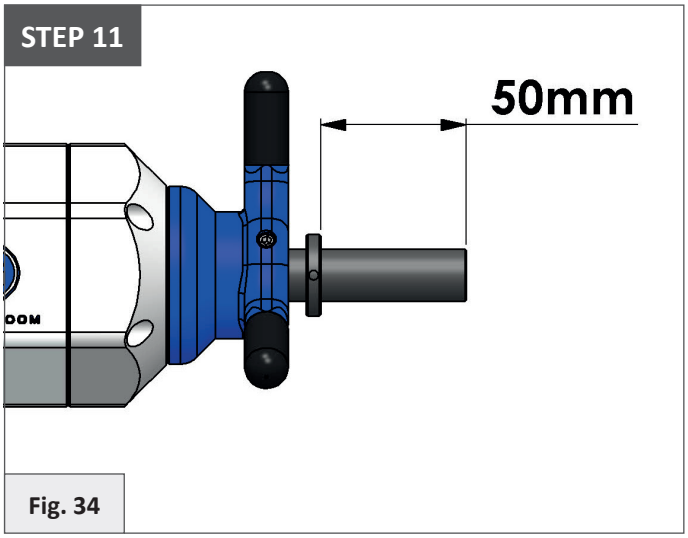


Fig. 34

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

STEP 12

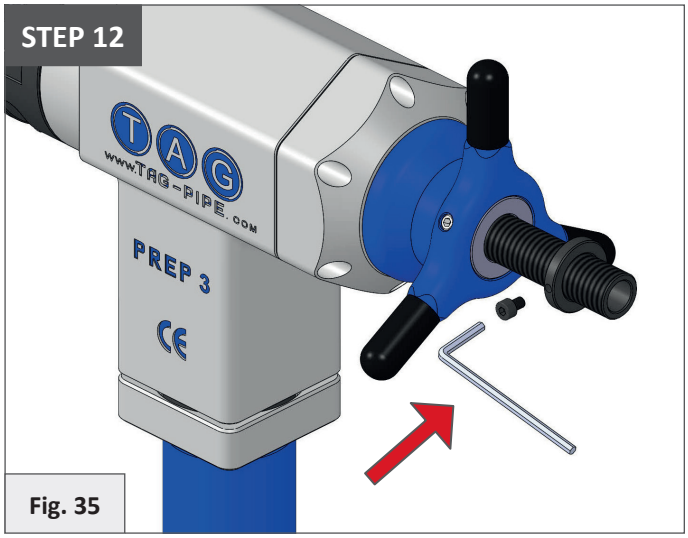


Fig. 35

Lock the ring by screw and Allen key.

STEP 13

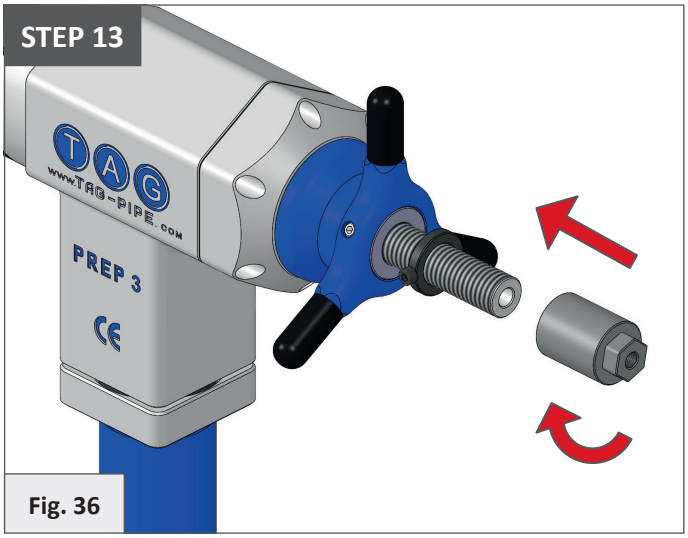


Fig. 36

Screw the lock/unlock nut all the way down.

STEP 14

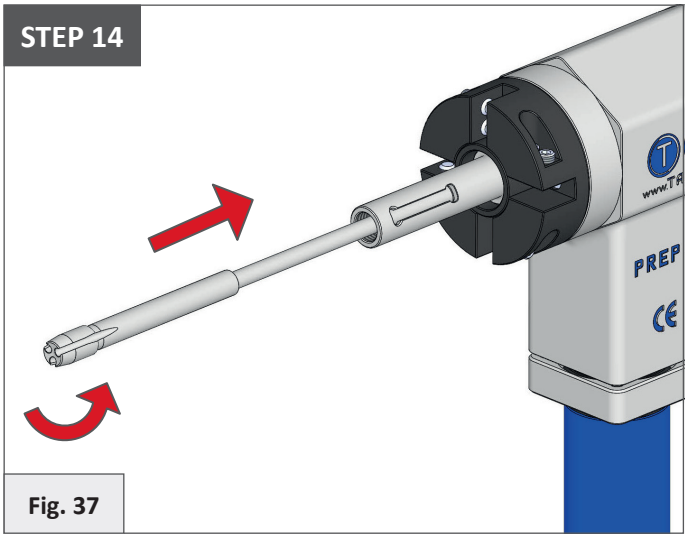


Fig. 37

STEP 15

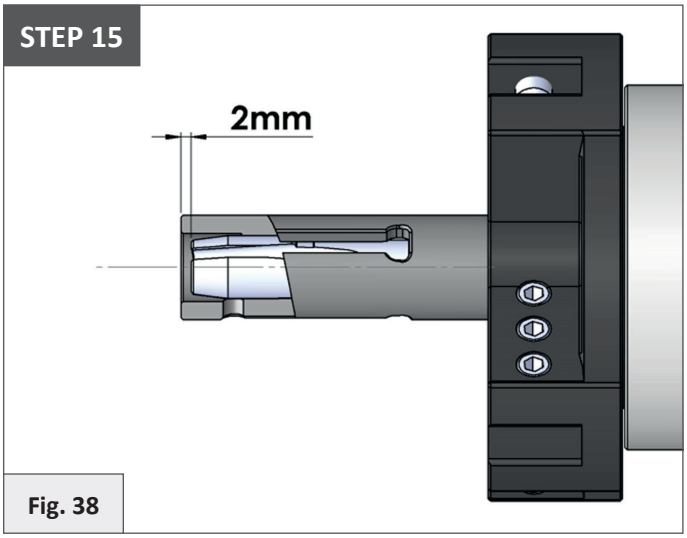


Fig. 38

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

STEP 16

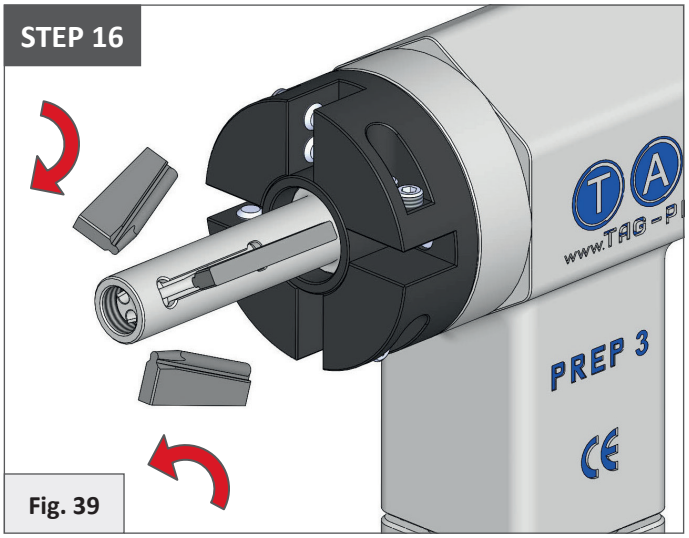


Fig. 39

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

STEP 17

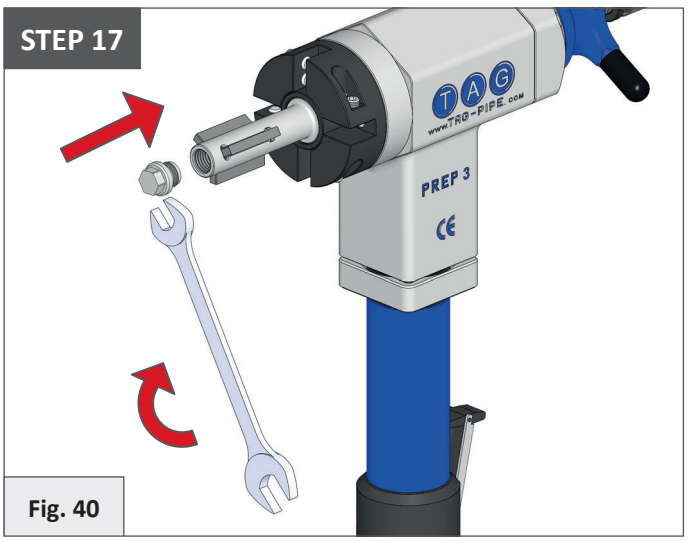


Fig. 40

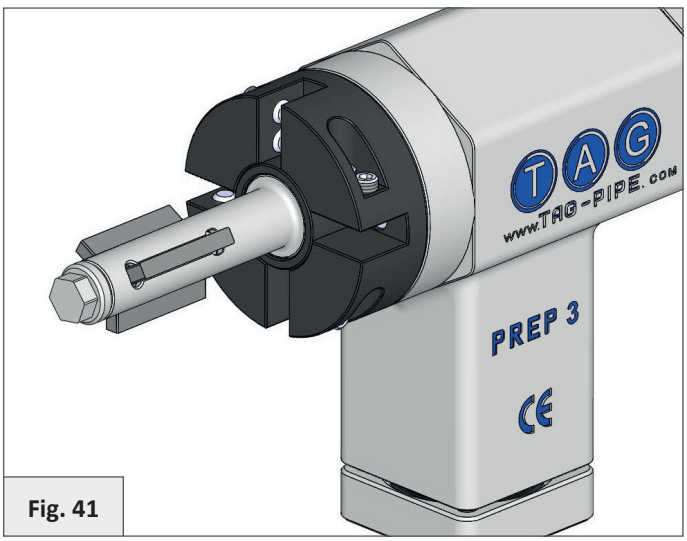


Fig. 41

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

8.5 - ELBOW SHAFT ASSEMBLY KIT

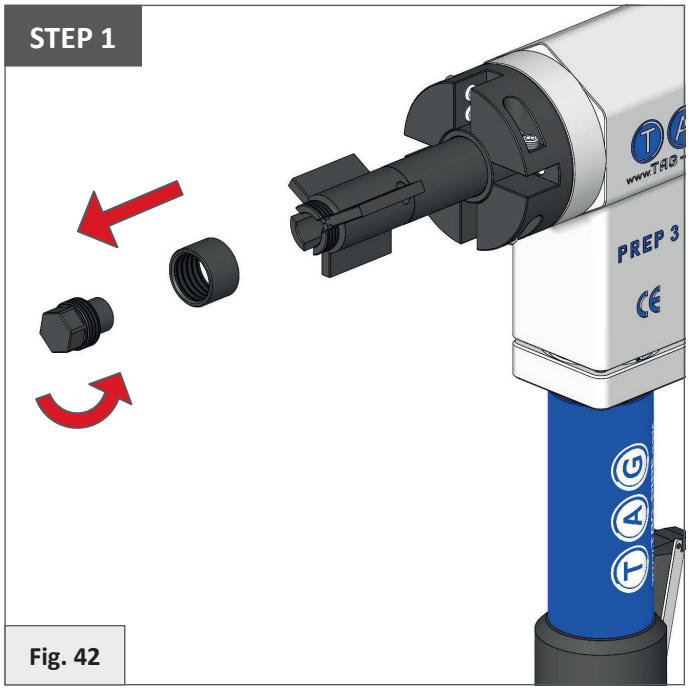


Fig. 42

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

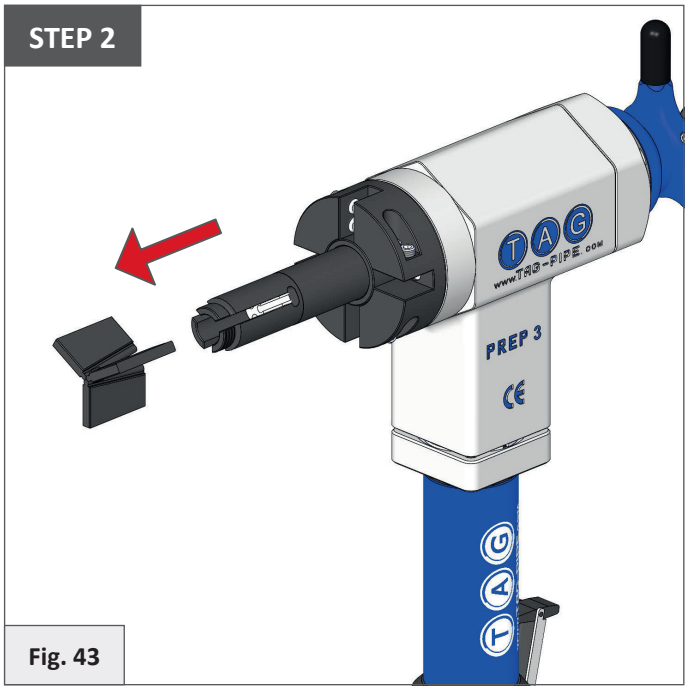


Fig. 43

Remove the locking jaws.

Fig. 44

Rotate the lock/unlock nut in clockwise direction.

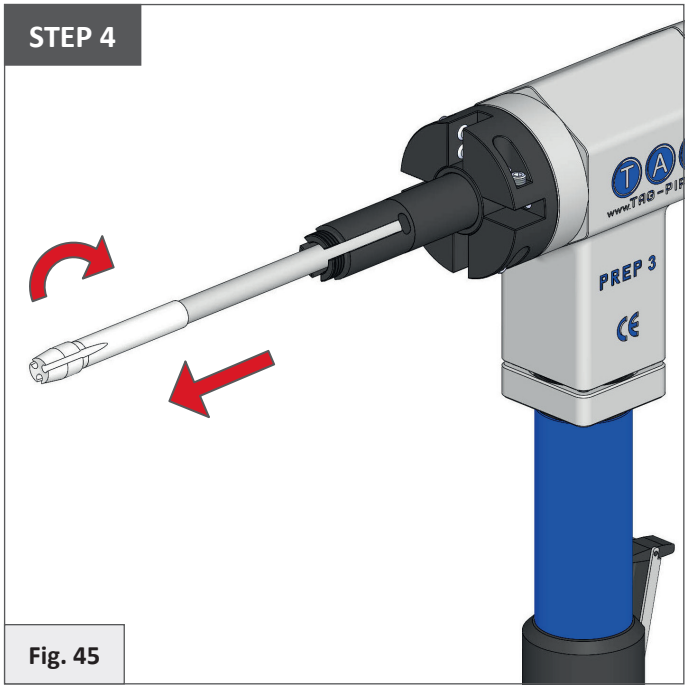


Fig. 45

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

STEP 5

Fig. 46

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

STEP 6

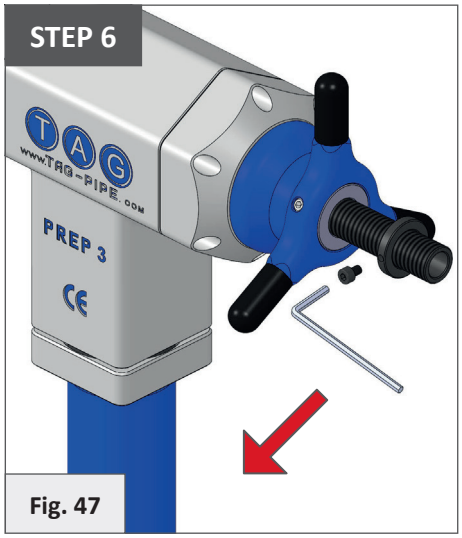


Fig. 47

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

STEP 7

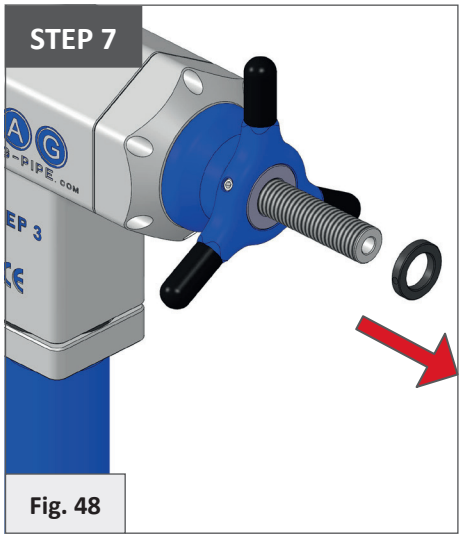


Fig. 48

STEP 8

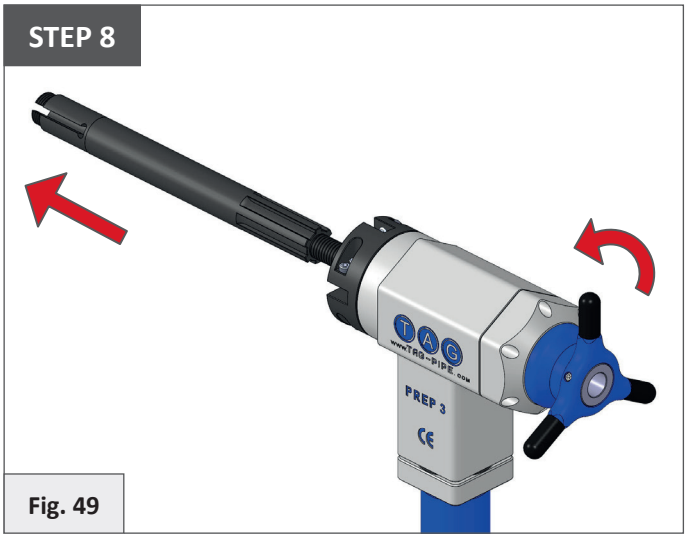


Fig. 49

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

STEP 9

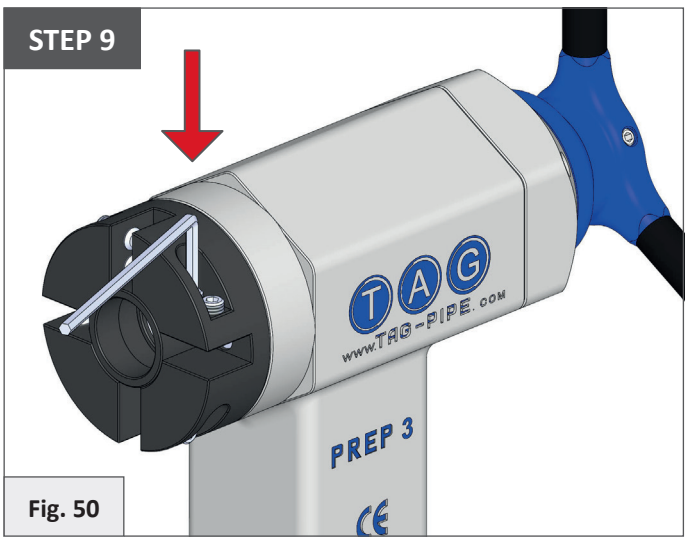


Fig. 50

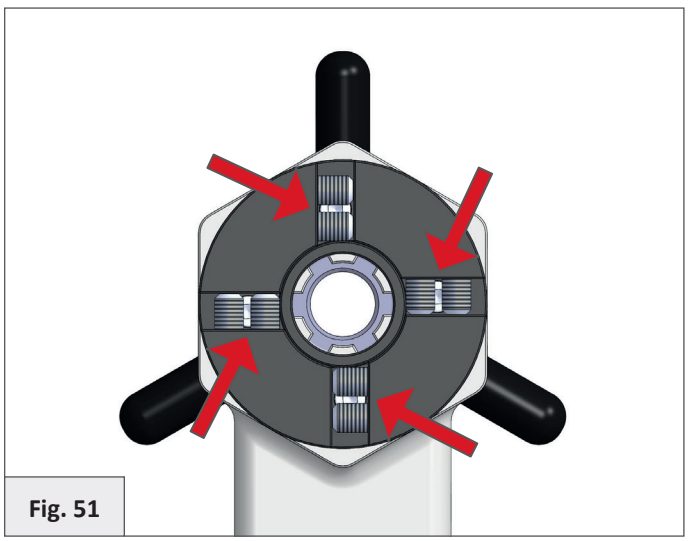


Fig. 51

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

STEP 10

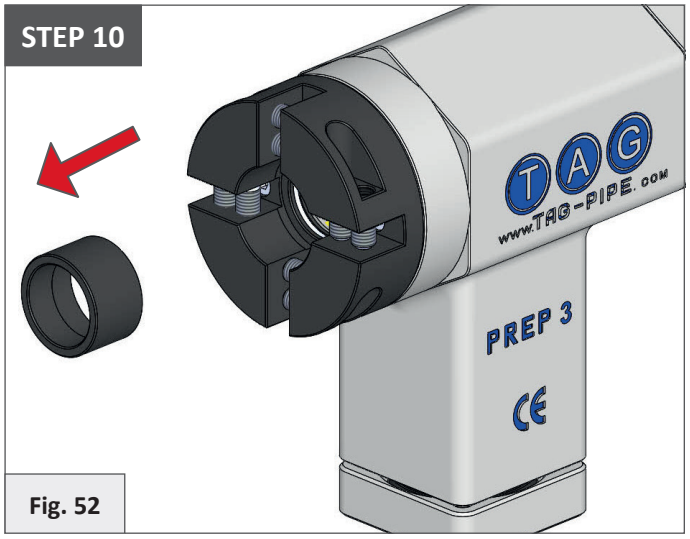


Fig. 52

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

STEP 11

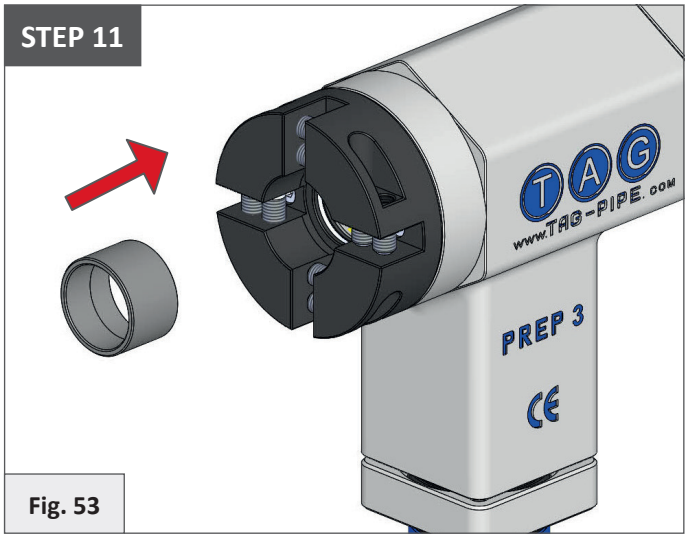


Fig. 53

Put in the new bush from elbow kit.

STEP 12

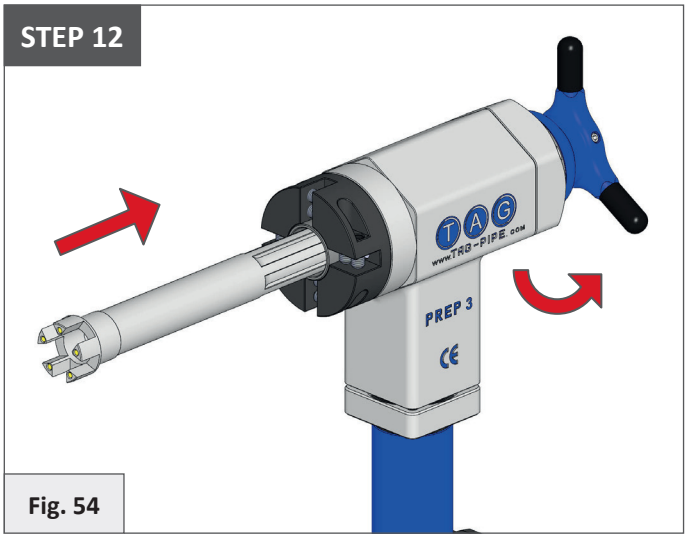


Fig. 54

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

STEP 13

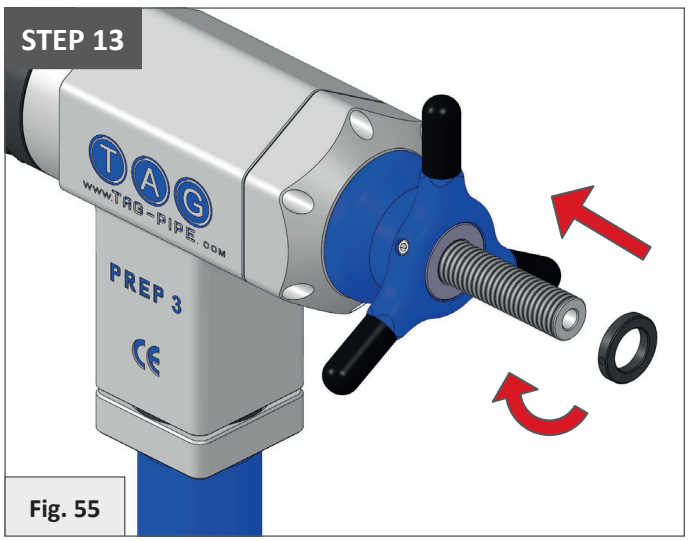


Fig. 55

STEP 14

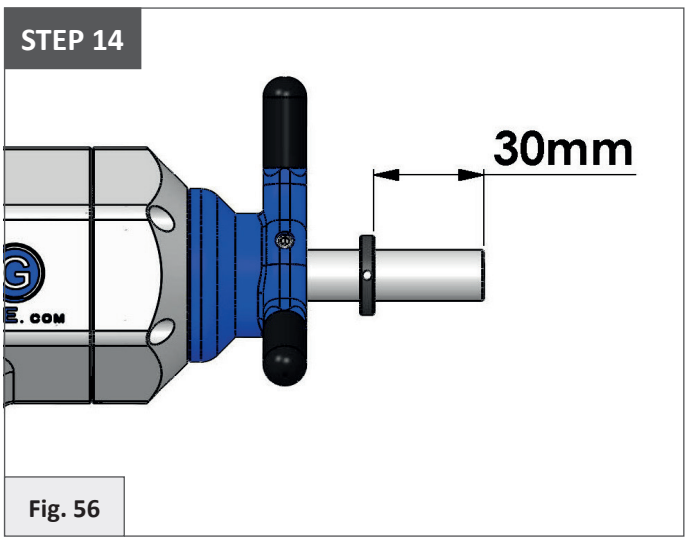


Fig. 56

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

STEP 15

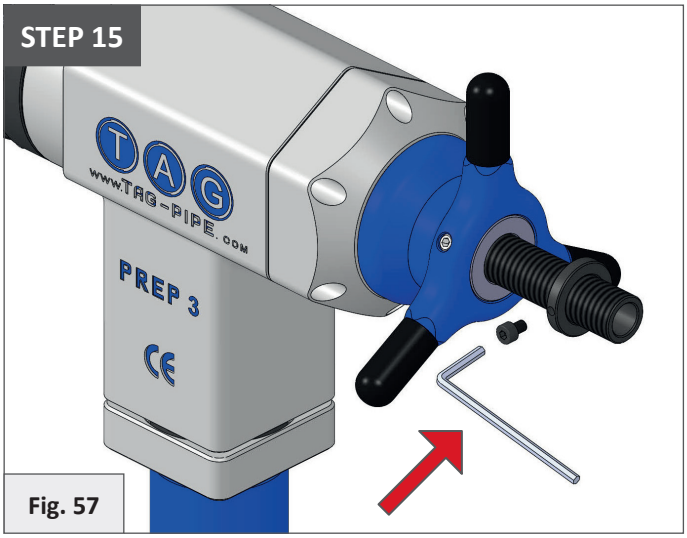


Fig. 57

Lock the ring by screw and Allen key.

STEP 16

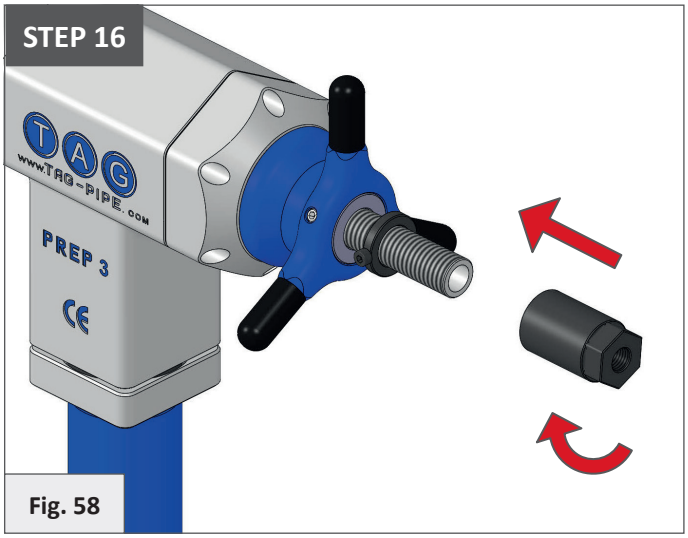


Fig. 58

Screw on the jaws lock/unlock nut 24 mm.

STEP 17

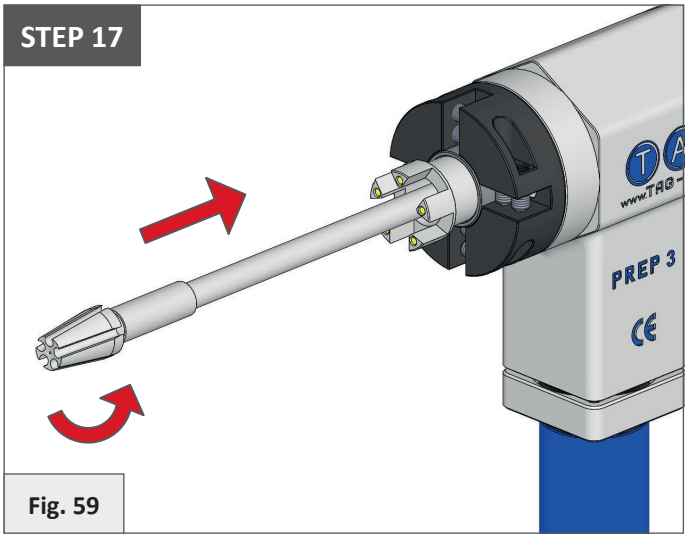


Fig. 59

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

STEP 18

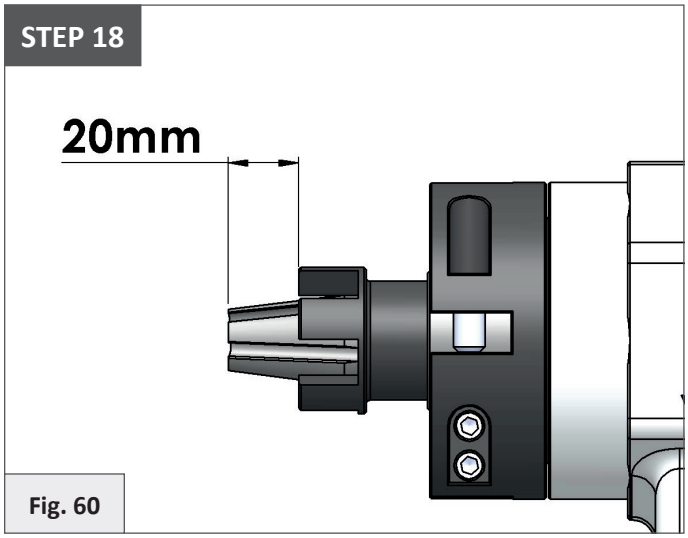


Fig. 60

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

STEP 19

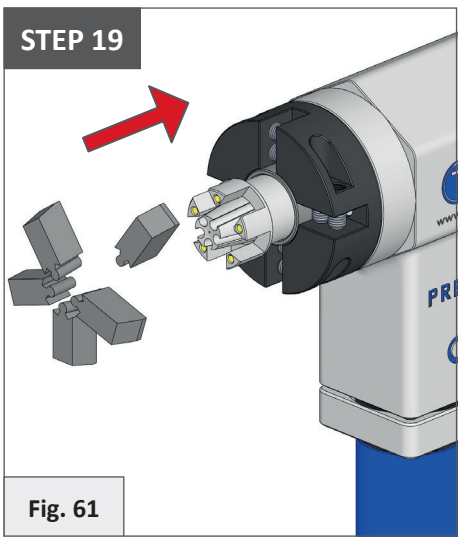


Fig. 61

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

STEP 20

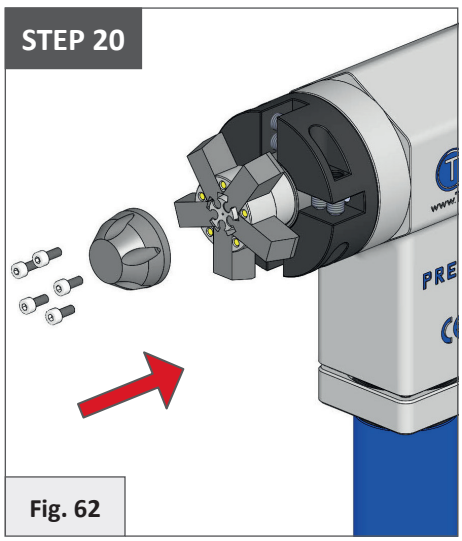


Fig. 62

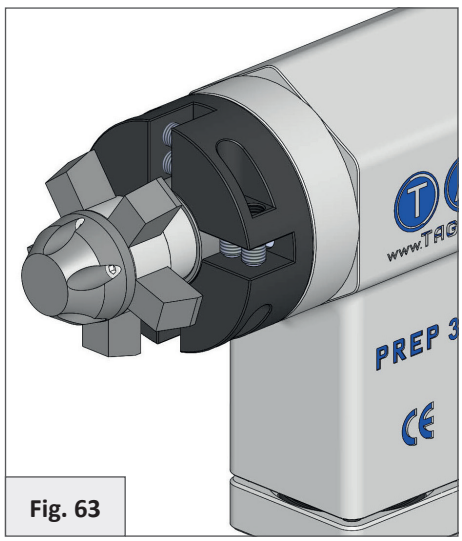


Fig. 63

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

STEP 21

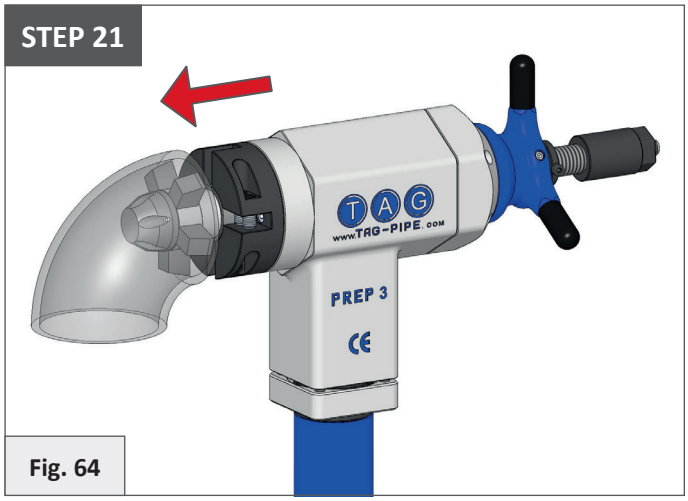


Fig. 64

STEP 22

Fig. 65

Place the machine into the elbow and loosely lock clockwise.

STEP 23

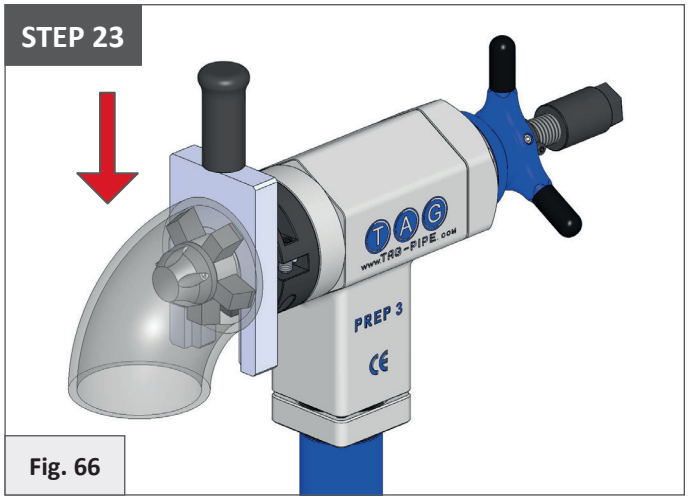


Fig. 66

STEP 24

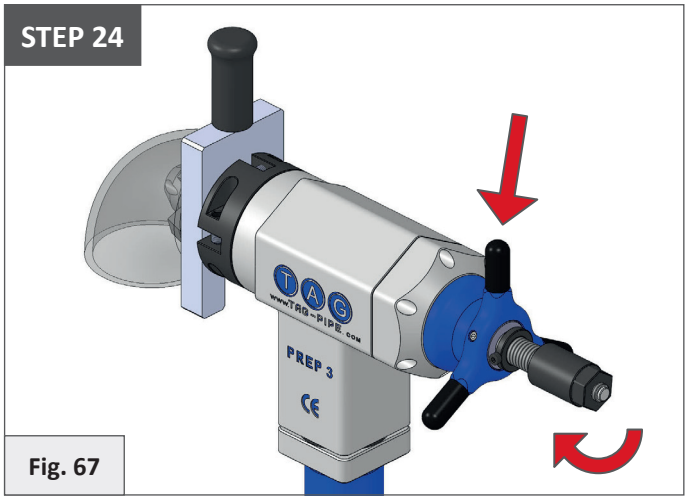


Fig. 67

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

STEP 25

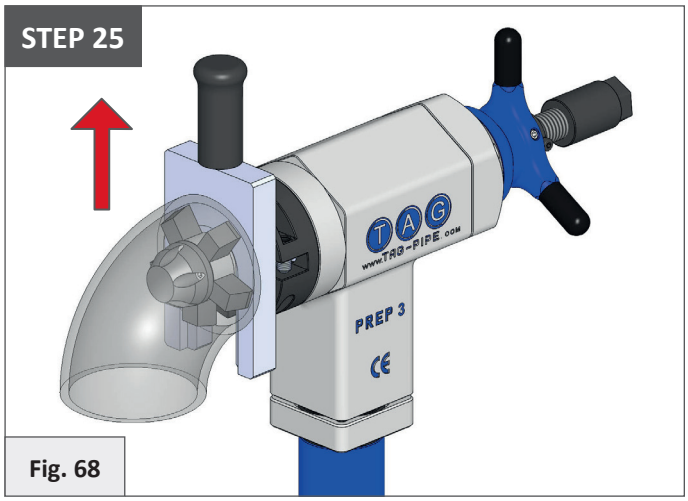


Fig. 68

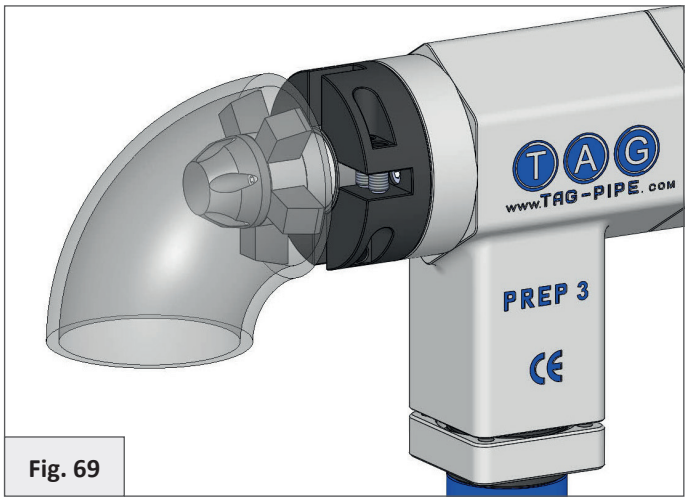


Fig. 69

Loosen the feed wheel then remove elbow positioner.

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

STEP 1

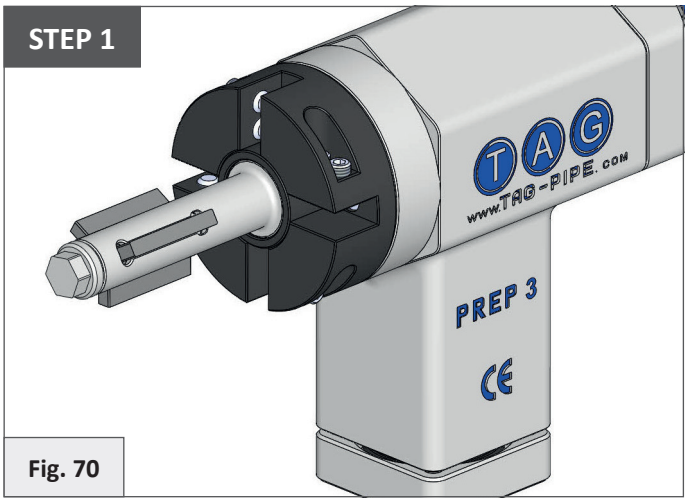


Fig. 70

STEP 2

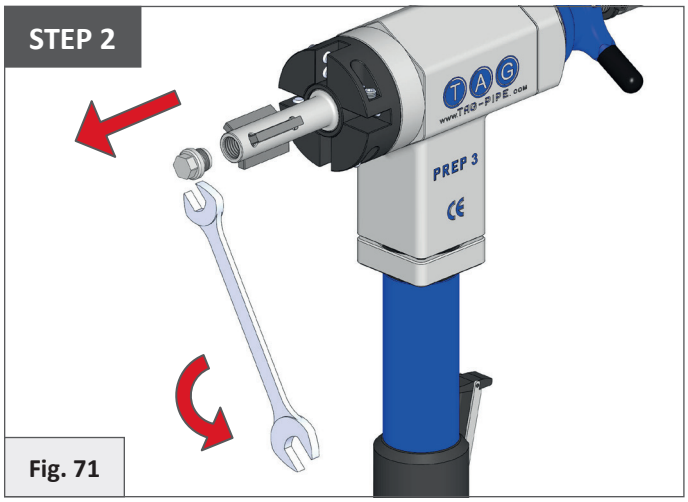


Fig. 71

Unscrew the shaft stop nut anti-clockwise.

STEP 3

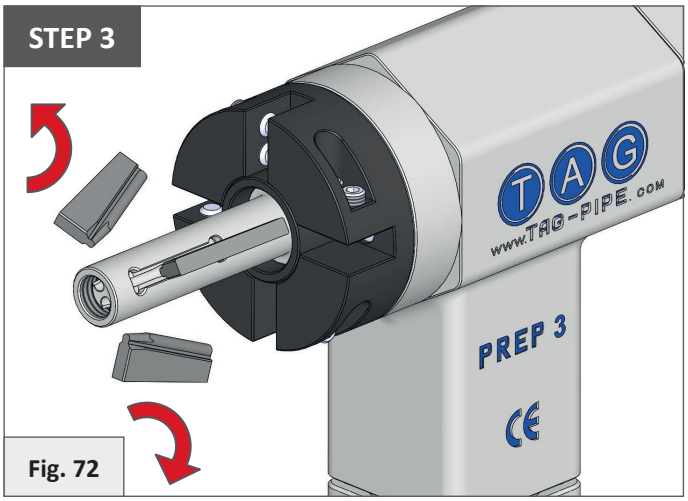


Fig. 72

Remove the locking jaws.

STEP 4

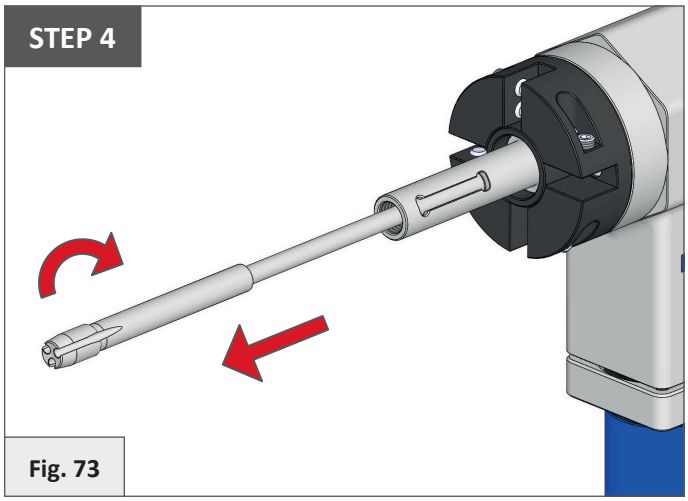


Fig. 73

Remove the reduced inside shaft.

STEP 5

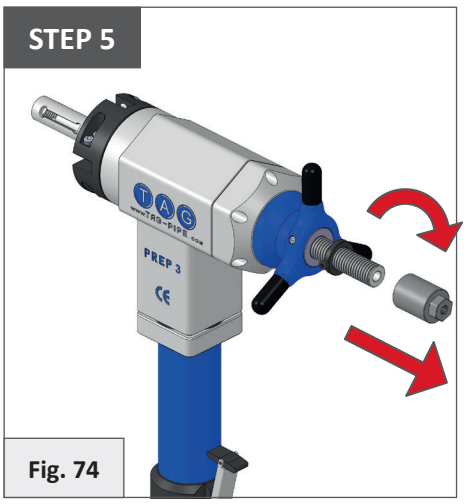


Fig. 74

Unscrew the lock/unlock nut.

STEP 6

Fig. 75

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

STEP 7

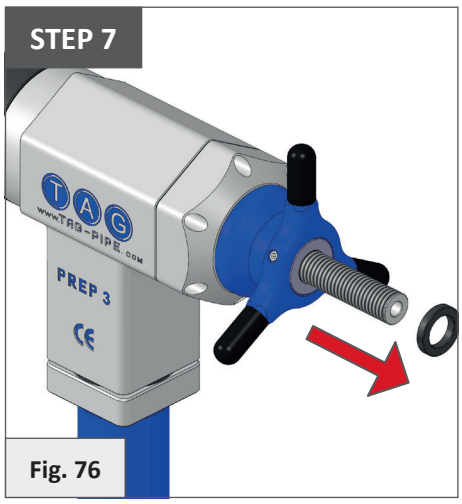


Fig. 76

STEP 8

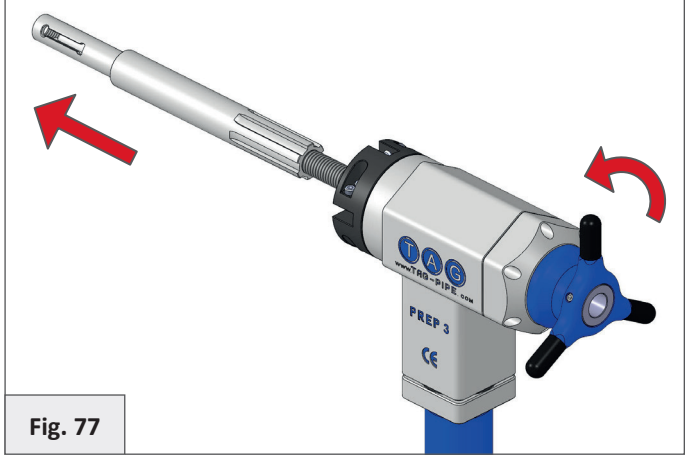


Fig. 77

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

STEP 9

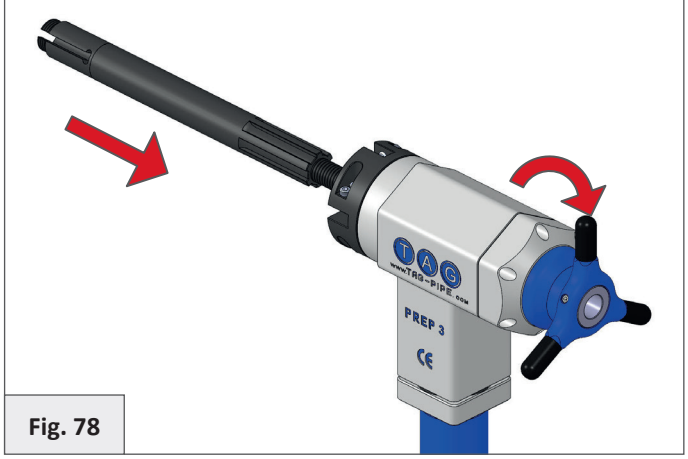


Fig. 78

Insert the outside shaft by rotating the feeding wheel clockwise.

STEP 10

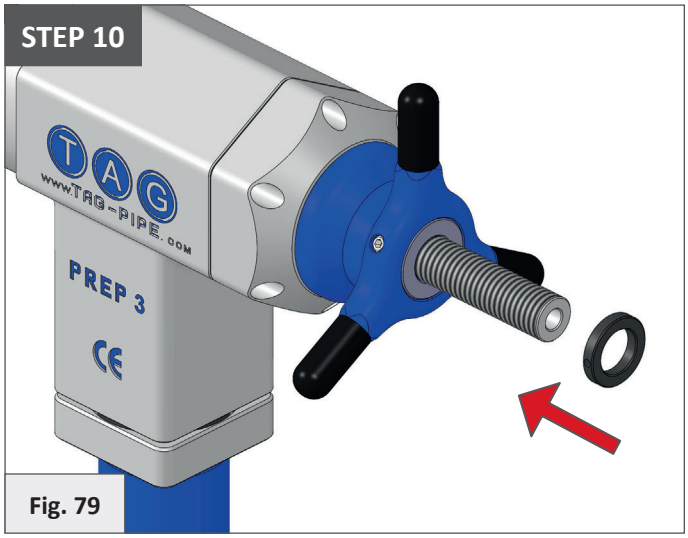


Fig. 79

STEP 11

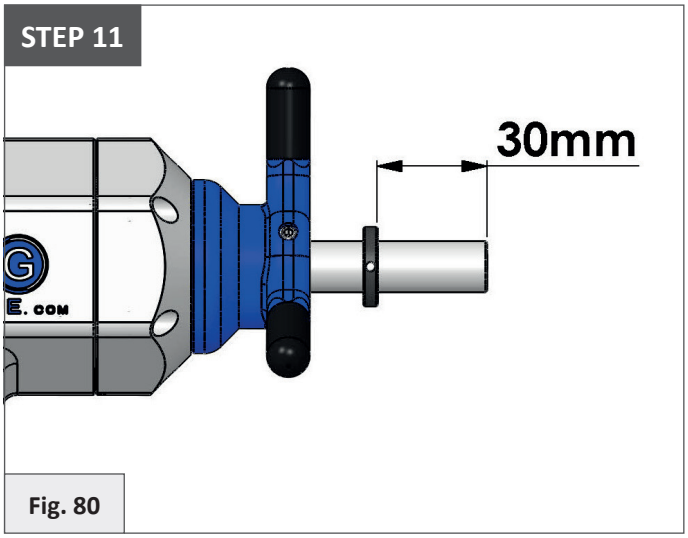


Fig. 80

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

STEP 12

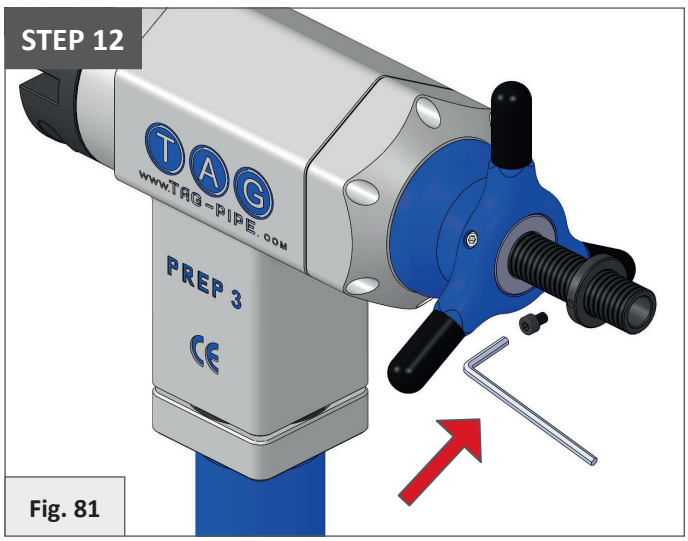


Fig. 81

Insert the Allen screw on the ring.

STEP 13

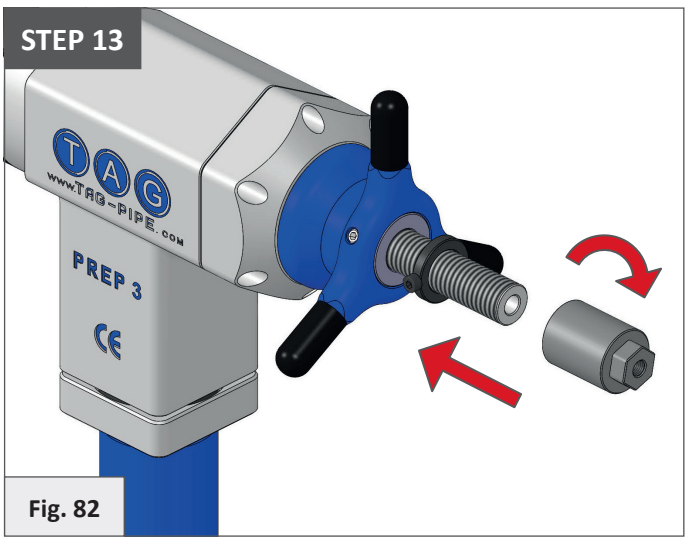


Fig. 82

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

STEP 14

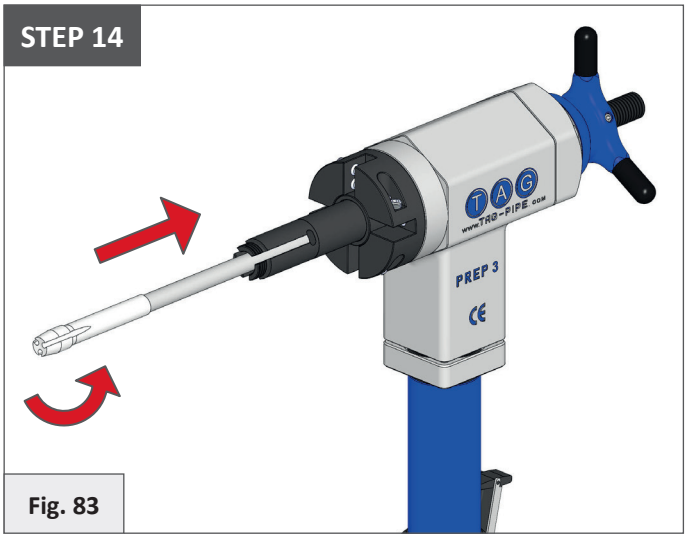


Fig. 83

STEP 15

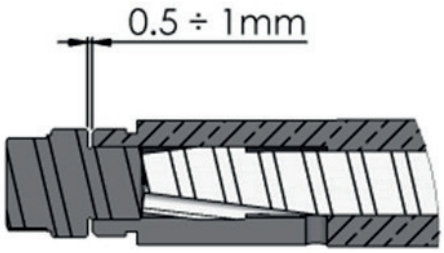


Fig. 84

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

STEP 16

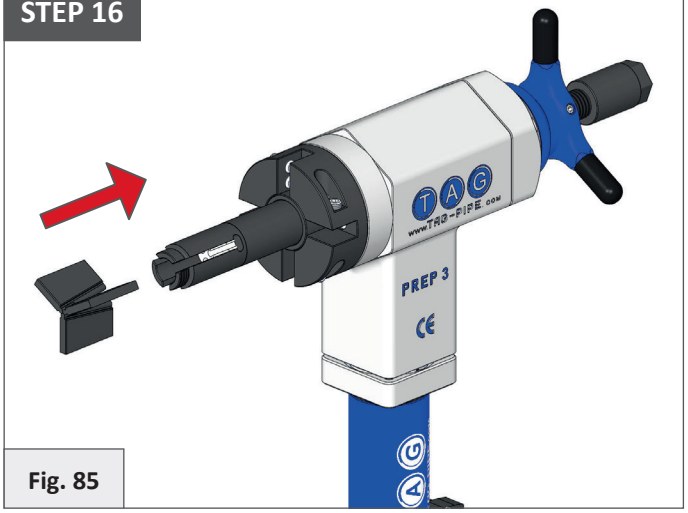


Fig. 85

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

STEP 17

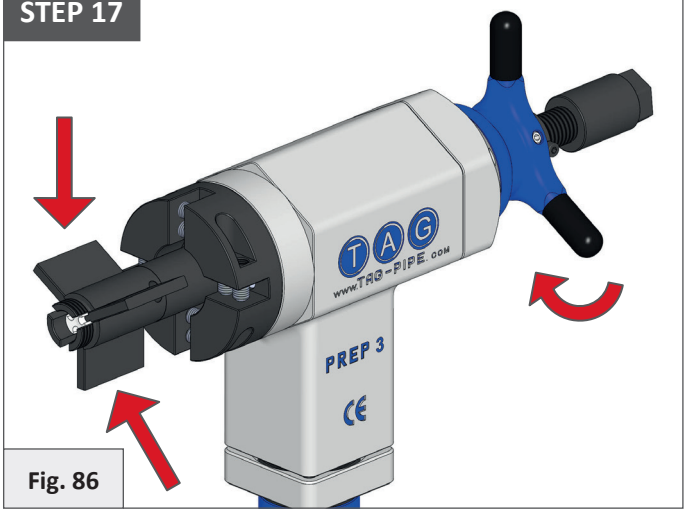


Fig. 86

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

STEP 18

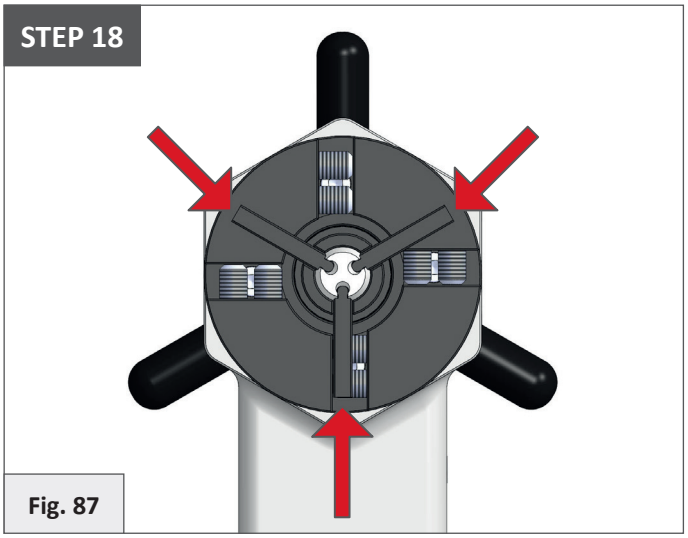


Fig. 87

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

STEP 19

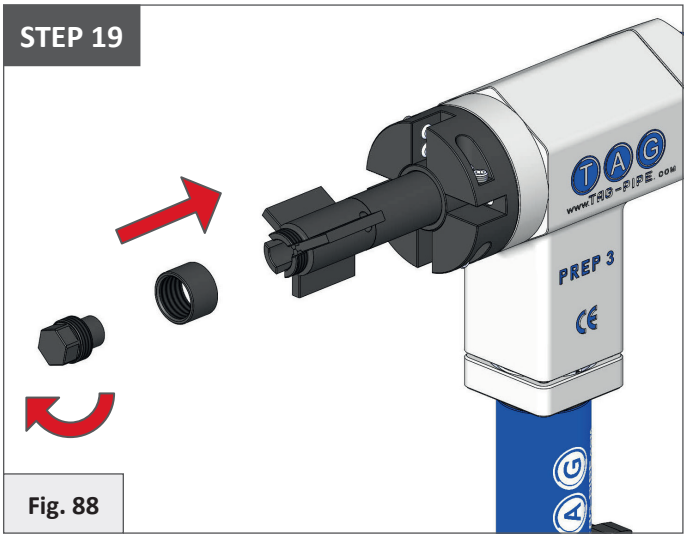


Fig. 88

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

8.7 - DRIVER KIT REPLACEMENT

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

STEP 1

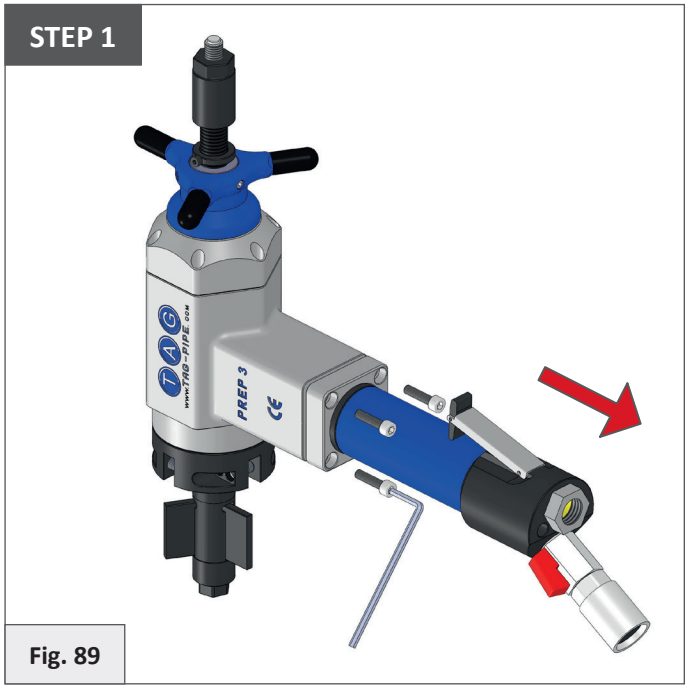


Fig. 89

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

STEP 2

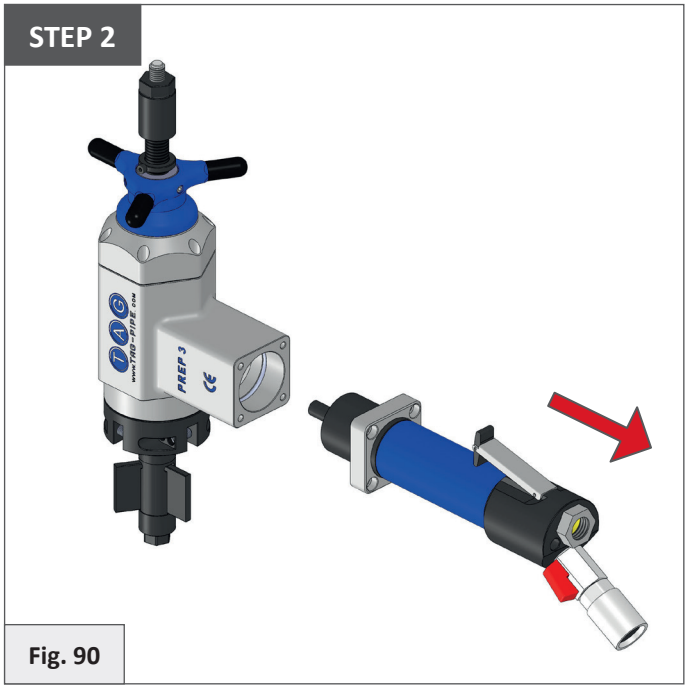


Fig. 90

Remove the pneumatic transmission kit.

STEP 3

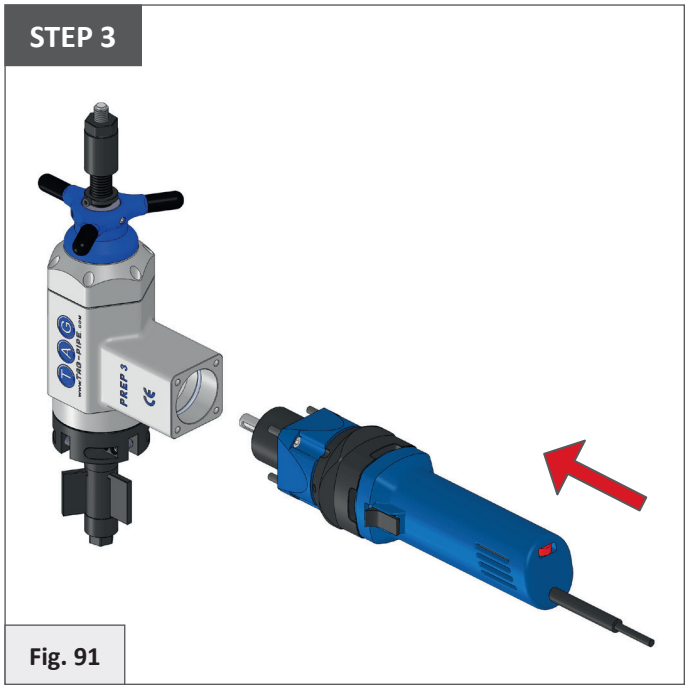


Fig. 91

Insert the electric transmission kit.

STEP 4

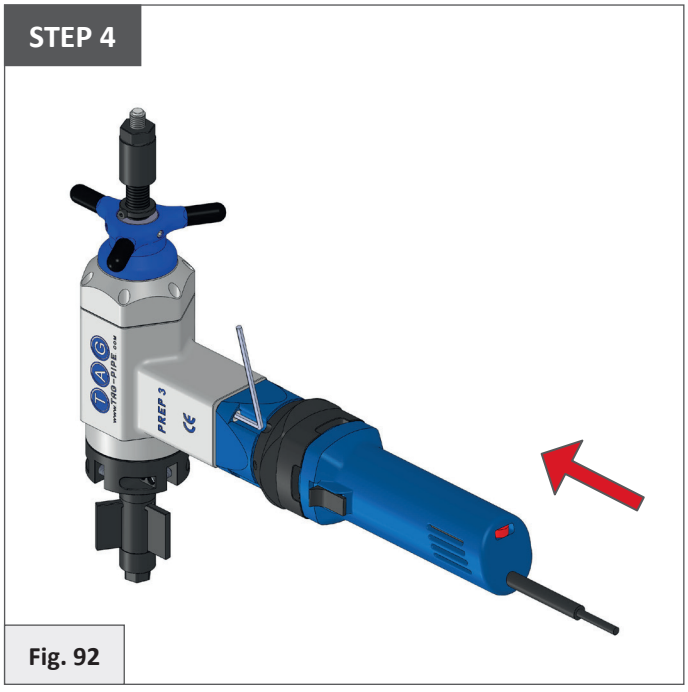
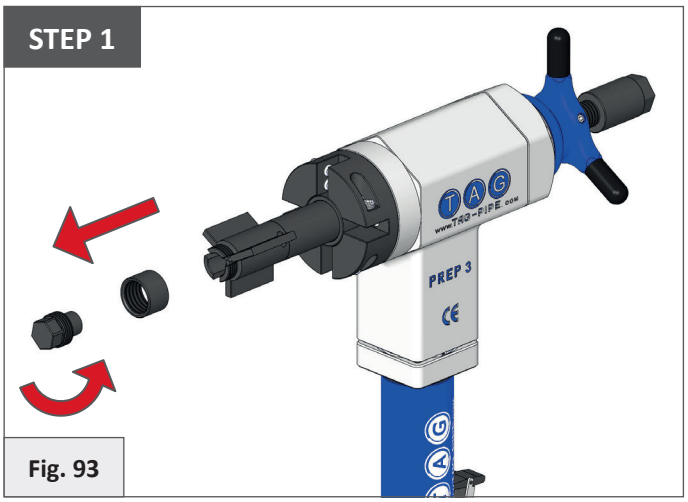


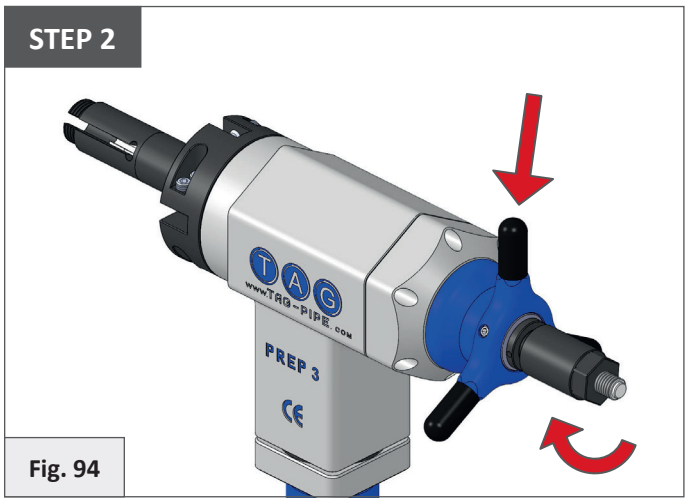
Fig. 92

Screw in the 4 screws.

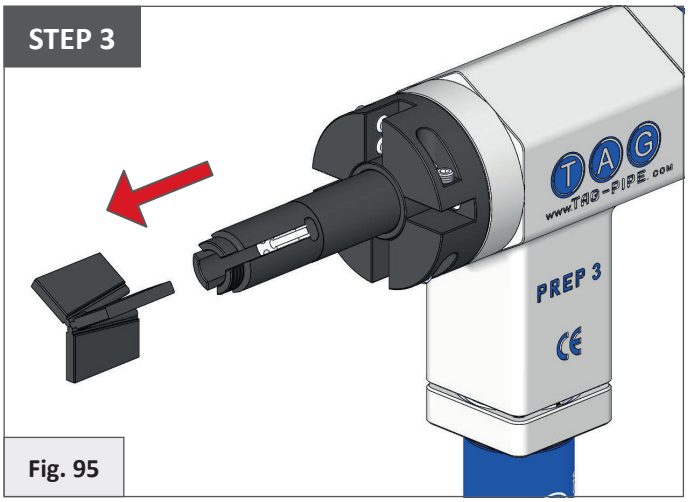
8.8 - AUTOMATIC LOCKING DEVICE KIT



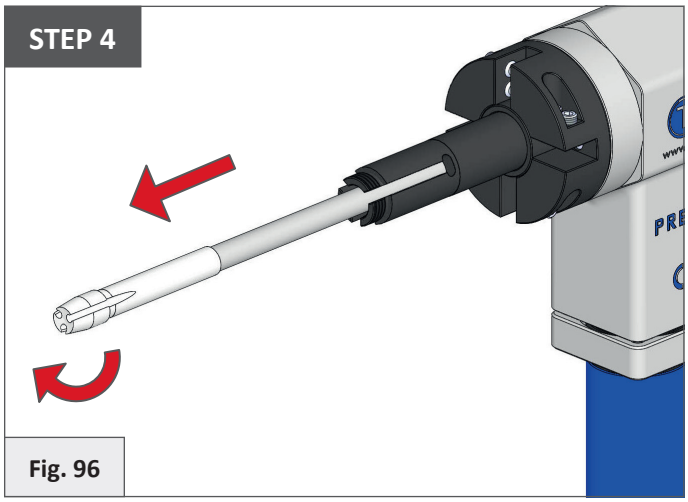
Unscrew the shaft end nut and the shaft ring anti-clockwise.



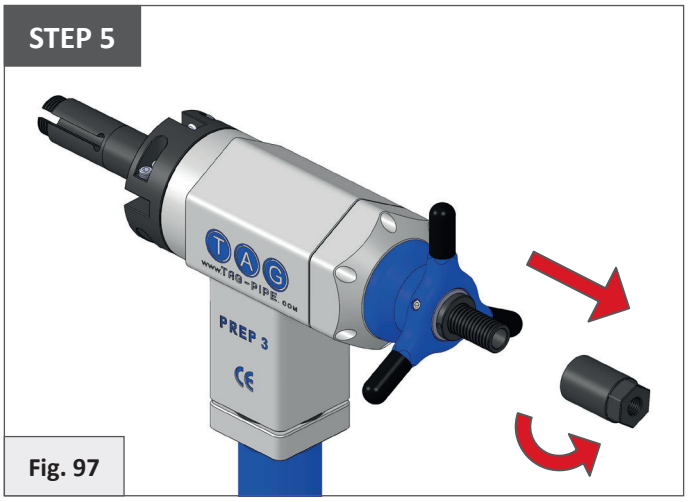
Rotate the lock/unlock nut in clockwise direction.



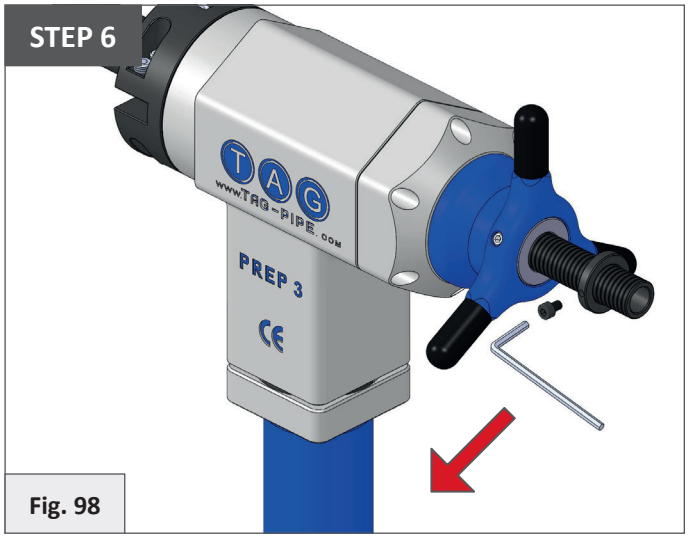
Remove the locking jaws.

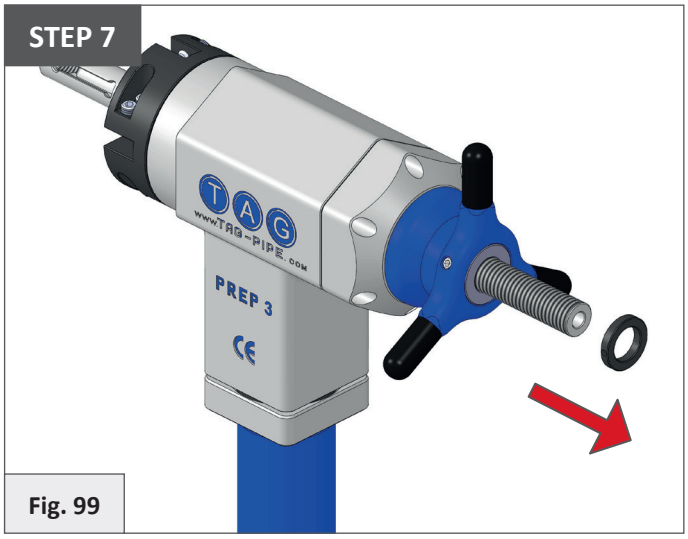


By using long nose pliers rotate the inside shaft clockwise until it comes out.

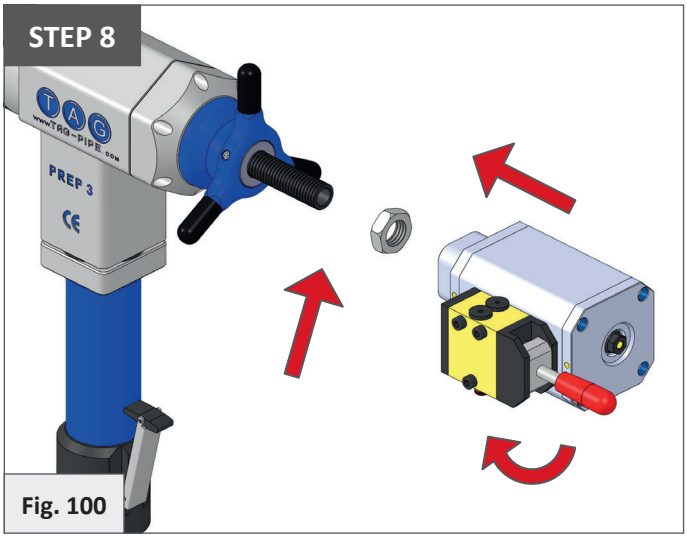


Rotate the lock/unlock nut in anti-clockwise direction.

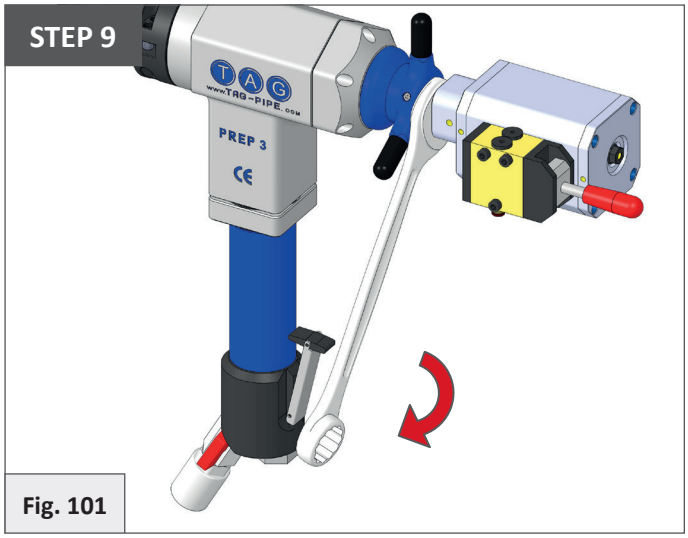


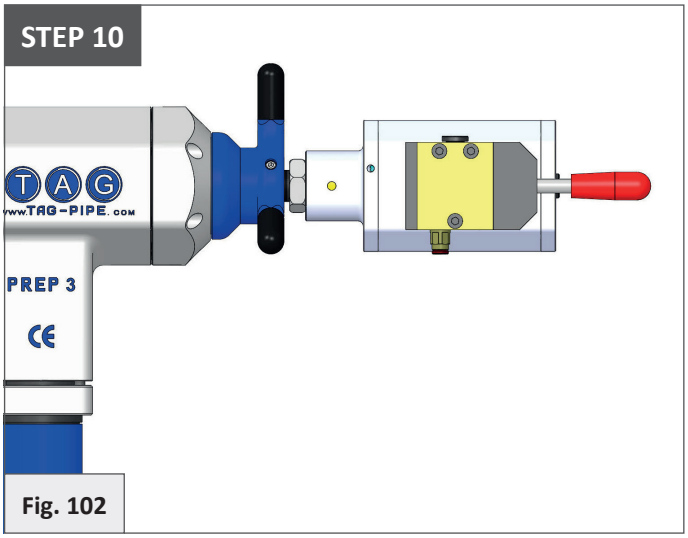


Remove the Allen screw from the ring and remove stop ring.



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





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

STEP 11

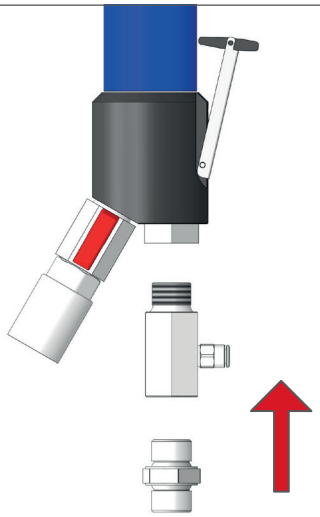


Fig. 103

Screw in the special connection as shown in the picture.

STEP 12

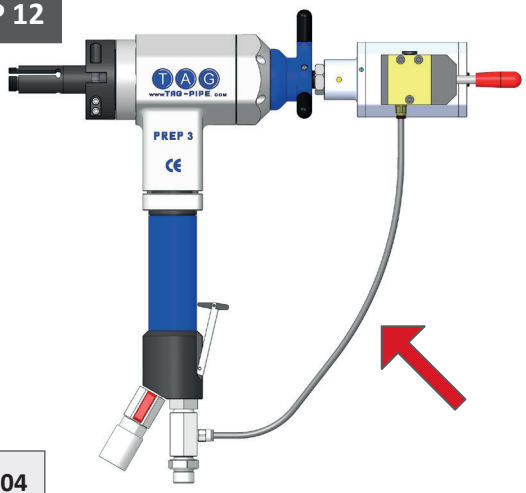


Fig. 104

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

STEP 13

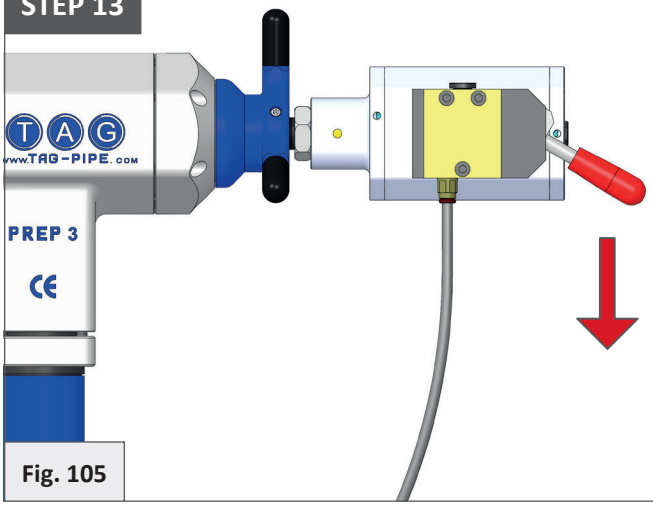


Fig. 105

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

STEP 14

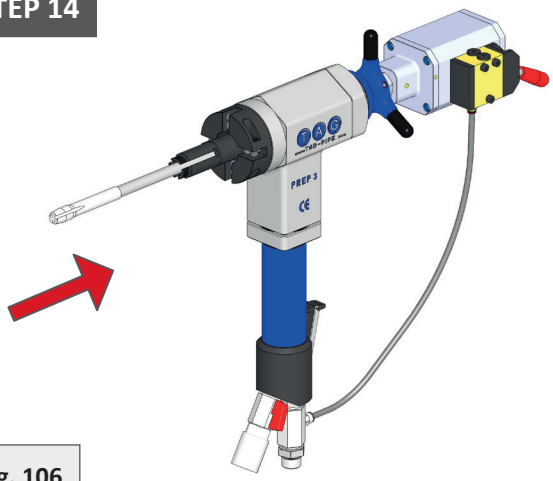


Fig. 106

STEP 15

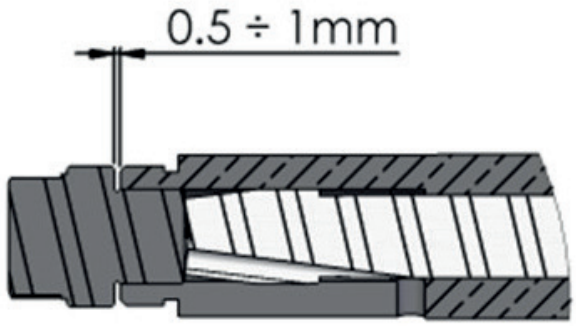
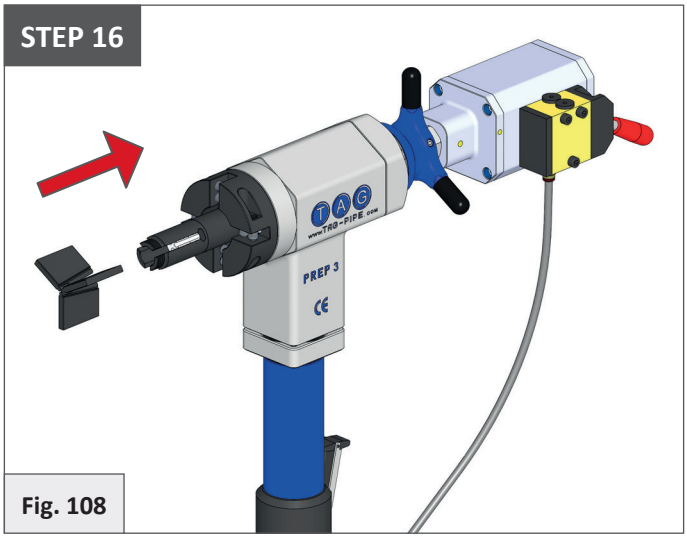
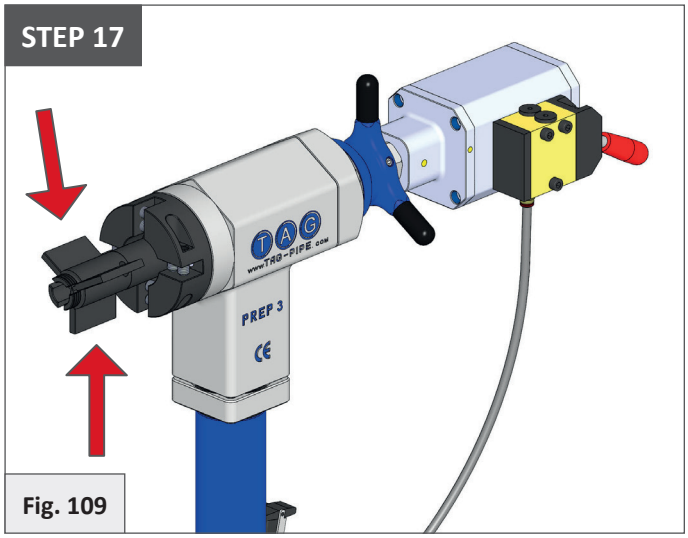


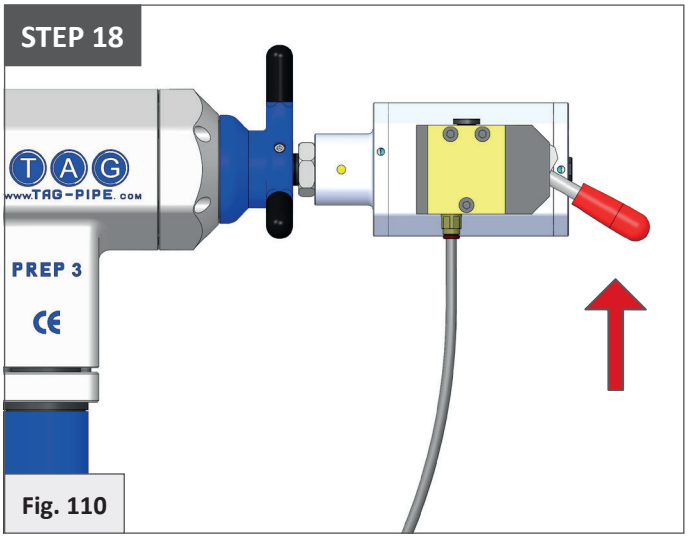
Fig. 107

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

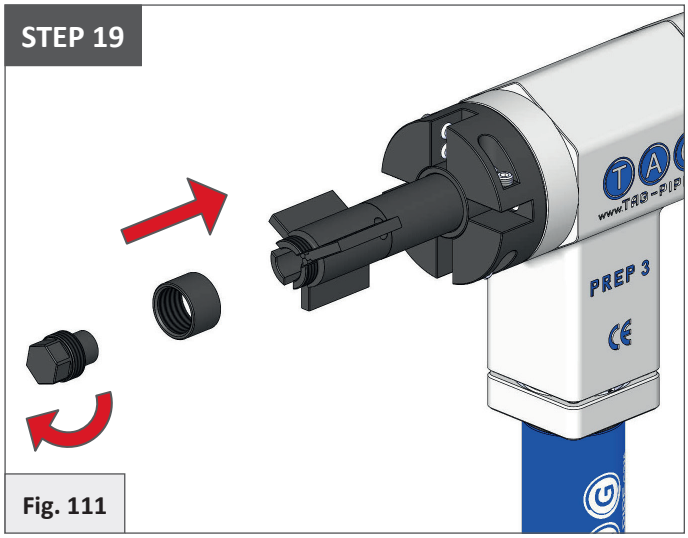


Select the locking jaws according to the diameter of the pipe and install them on the inside shaft as shown in the picture.

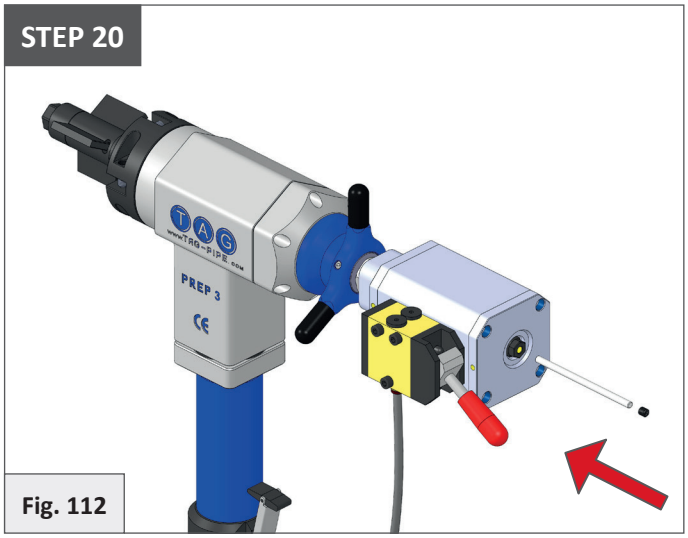




Connect the air and with your hand hold the jaws in position, move the lever up to achieve the backward position of inside shaft.



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



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

9 - PERIODIC MAINTENANCE AND REPAIR

Continued safe operation of the equipment depends on regular maintenance and testing of its operating and protective controls. The equipment should only be inspected, tested and maintained by qualified trained personnel. Should any test indicate that the equipment being tested or observed is not in good operating condition, it should be repaired immediately. Record and maintain records of repairs or changes so that a complete record will be available for review at any time.

It is advisable to regularly check the machine for any deficiencies; in case of non-conformities, do not use the equipment and initiate repair activities. Any repair should be conducted 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

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 disposciones 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

SPECIMEN

At Etoile Sur Rhône
The 04/10/2023

Francesco TANTIMONACO
Technical Manager

PIPE EQUIPMENT SPECIALISTS

Declaration of conformity

SFE GROUP
330B Route de Portes les Valence
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Déclaration de conformité
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UK CA

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**
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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

SPECIMEN

At Etoile Sur Rhône
The 04/10/2023

Francesco TANTIMONACO
Technical Manager

GLOBAL LEADER IN SPECIALIZED MACHINING, WELDING AND FABRICATION EQUIPMENT

SPECIALIZED FABRICATION EQUIPMENT GROUP

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