

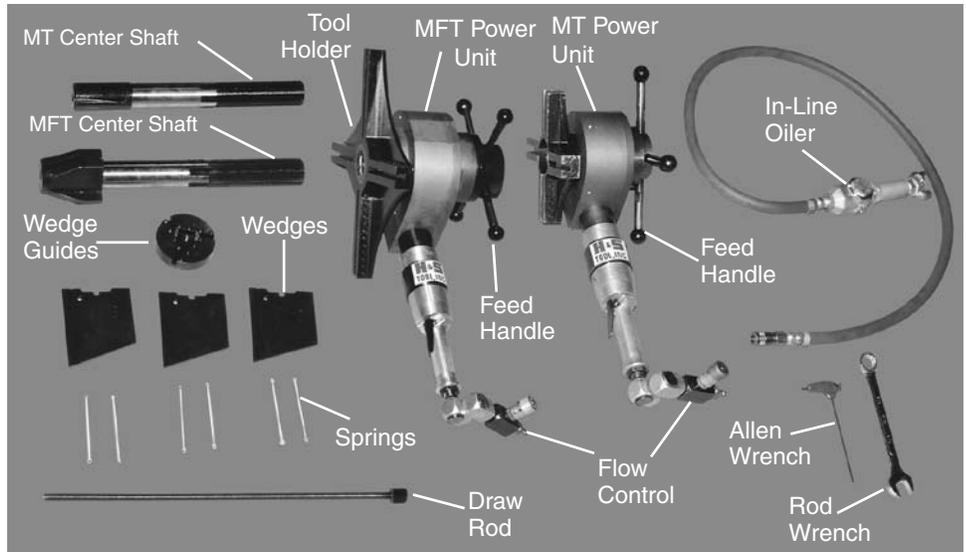


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## OPERATING and MAINTENANCE RECOMMENDATIONS for MODELS MT and MFT

### COMPONENT DESCRIPTION

**READ THOROUGHLY  
 AND UNDERSTAND THIS  
 PUBLICATION BEFORE  
 ATTEMPTING TO OPERATE  
 THE EQUIPMENT.**

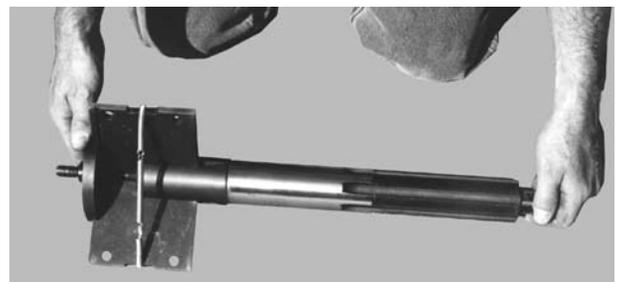
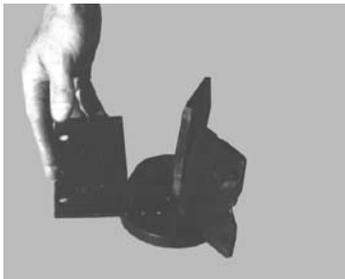


**DANGER!** The application of this product requires an exposed rotating tool holder and cutting blade. It produces HOT, SHARP metal fragments requiring that **eye, ear, and hand protection** along with **other protective clothing** be worn at all times. Do not wear loose fitting clothing that may become entangled with the rotating objects.

### Center Shaft/Locking Wedge Assembly

Both models have a split-design feature for easy handling. The center shaft, wedges and draw rod are assembled into a single unit. To accomplish this, select the appropriate size wedges for the pipe that will be machined. Slide these wedges into the slots in the wedge guide. Once in position, the proper number of springs are joined together to hold the wedges in position.

The wedge guide/plate assembly slides onto the center shaft (center shaft ends are different on the two models). The draw rod is placed through the center shaft and then threaded into the wedge guide plate.



## Tool Position and Machine Operation



For O.D. machining, the center shaft and wedge assembly should be positioned where the end of the wedge plate is between 1" and 2" (25 mm and 51 mm) from the edge of the pipe to be machined. **For I.D. beveling, the wedge plates must be at least 1" (25 mm) deeper than the tip of the blade at completion of the cut.**

Once the shaft is locked in position, the power unit

can be installed by placing it on the center shaft and turning the feeder handle.

With the machine securely locked in the pipe, connect the air hose to the handle end of the machine. An in-line oiler must be used for proper motor operation and reliability.



A variety of standard tooling is available to perform I.D. and O.D. beveling, squaring and J-beveling. Custom designs are also available to match your specific requirements. The blades are "SM" type, resharpenable. The same tooling is used for both models.

The tool holder has four slides to allow tool placement at the desired position. Several different tool designs can be placed in the holder to perform a combination of tasks at the same time (i.e. bevel and square). Simply position the tool and tighten the set screws with the allen wrench provided.

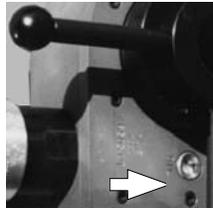
The four-flute tool holder has two T-slots and two straight slots. The straight slots are designed for use with tapered-shank blades. Make sure that the tool is not in contact with the pipe before starting the motor.



Squeeze the throttle handle and slowly feed the tool into the pipe by turning the feed handle clockwise. Once the tools are engaged, maintain constant pressure until the required machining is complete. Keep tools turning until they are again clear of the pipe.



A flow control valve is provided to adjust the machine RPM. Adjusting the speed can greatly reduce blade chatter for a cleaner, more accurate machined surface. Turning the knob clockwise slows the cutting blade speed.

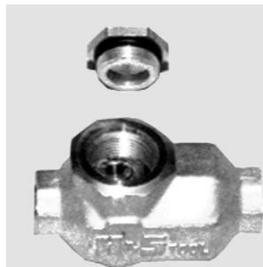


**Maintenance:** The gear case has a drain/filler plug just under the feed handle. This level should be checked daily and changed every 40 hours of operation. The level is checked when the tool is laying level on the tool holder. Use only 90W gear oil.

**In-Line Filter/Oiler:** If the tool is losing power and the air supply is functioning properly, the in-line filter may require cleaning. Disassemble the filter assembly and remove the sintered bronze element. Clean it thoroughly with an approved solvent, blow dry with compressed air and reassemble.



The in-line oiler fluid level should be checked regularly through the sight glass. If low, fill it with air tool oil or good SAE 10W by removing the hex cap. Once filled, place a sheet of paper or other light colored material near the exhaust port of the tool. Start the tool and observe the amount of oil expelled. If the material shows a slight gray mist, the correct amount of oil is being used. If there is oil running down the outside of the motor housing, too much oil is being introduced. If there is no oil visible, not enough oil is being used.



To adjust, remove the hex cap from the reservoir. A slotted screw adjustment will be exposed. Turning the screw counterclockwise increases the oil supply. Clockwise rotation reduces the amount of oil introduced into the supply. This should be done each time the type or make of oil is changed.