

MODEL 2500 or MODEL 2500-I⁽¹⁾ POWER TOOL INSTALLATION DATA

INTRODUCTION

The Model 2500 or 2500-I power tool consists of a grinding drum centrally located between a set of four mandrels. The tool is capable of scarfing 2"-6" CHEM THREAD® and Z-CORE® pipe. The scarfing diameter is factory set. To compensate for wear of the grinding drum, Smith Fibercast provides a thickness adjustment (see Section D).

! **WARNING:** Use caution when operating this tool. Hold pipe firmly. Do not allow machine to turn pipe. Check mandrels often to make sure they are properly tightened.

A. OPTIONAL SHOP VAC CONNECTION

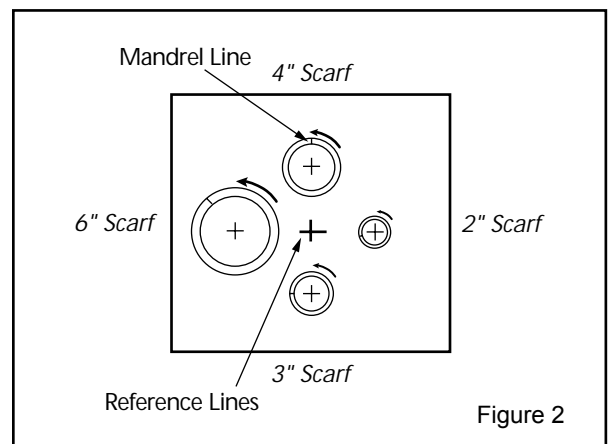
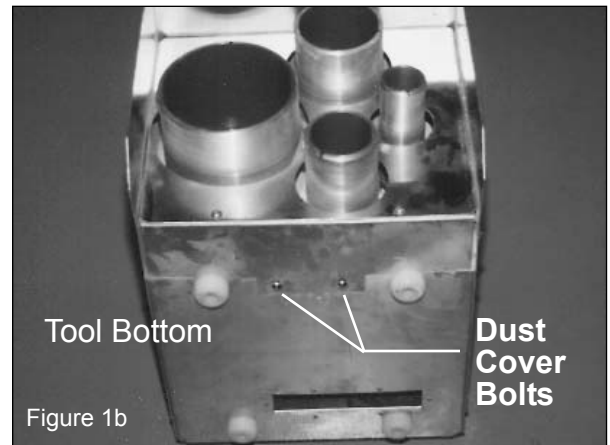
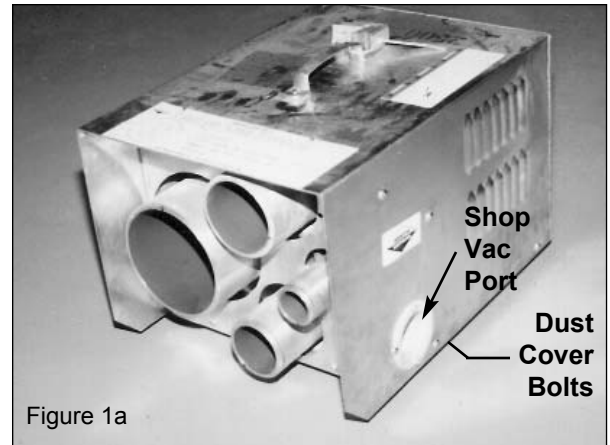
1. Remove cap from the vacuum port as shown in Fig. 1a.
2. Insert standard shop vac hose nozzle into port.
3. Start the vacuum before scarfing the pipe.
4. The vacuum may not remove all the dust. Remove the four bolts holding the dust cover in place and dump the dust from the tool. Replace the dust cover.

B. NON SHOP VAC ASSISTED OPERATION

1. Remove the four bolts holding the dust cover in place. (See Figs. 1a and 1b.)
2. Replace the cap in the vacuum port.

C. TO SCARF

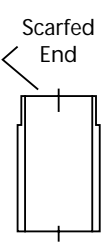
1. Cut pipe ends square ($\pm 1/8"$), and set up tool in either the horizontal or the vertical position.
2. Turn motor on. Allow a few seconds until the motor reaches speed.



⁽¹⁾ The Model 2500-I tool is a 50 cycle, 240 volt unit.

MODEL 2500 or 2500-I Power Tools

3. Slowly insert the pipe onto the mandrel, making sure alignment is as even as possible. Rotate in a counter-clockwise direction until the end of the pipe rests against the back plate. Do not turn the pipe too quickly, as this can stall the motor. If the motor starts to bog down, slow your rotation and insertion, but do not stop. The sound of the motor will indicate whether the motor is bogging down. Keep turning until the pipe is making minimum contact with the grinding drum. Make two to three complete revolutions and retract pipe from the tool while continuing to rotate pipe. Turn motor off. Any remaining gloss on the spigots should be removed by sanding.
4. If the grinding drum locks up on the pipe, turn the motor off immediately and try to wiggle the pipe loose. If this doesn't work, cut the pipe off as near the mandrel as possible, loosen the mandrel (socket head bolt inside of mandrel), remove pipe, and retighten the mandrel.
5. Occasionally check the scarfed pipe by inserting into the socket of a factory fitting.

Pipe Size (In.)	CHEM THREAD & Z-CORE PIPE	
	Scarf Diameter Range (In.)	
2"	2.360 to 2.375	Figure 3
3"	3.485 to 3.500	
4"	4.485 to 4.500	
6"	6.610 to 6.625	

D. TO ADJUST THICKNESS

1. Loosen the 5/16" socket head bolt located in the center of the hollowed out mandrel. A hex key wrench with extensions works well.
2. Adjust machined thickness as follows:
 - a. Rotate mandrel line away from reference line to increase thickness, i.e. to make thicker (see Fig. 2).
 - b. Rotate mandrel line towards reference line to decrease thickness, i.e. to make thinner.
 - c. Tighten the socket head bolt securely.

PRODUCT FEATURES

- Weighs approximately 50 lbs.
- Electrically powered.
- Adaptable to shop vac for dust-free operation.
- Scarfs 2" pipe in just 10 seconds.
- Scarfs 3" pipe in 20 seconds.
- Scarfs 4" pipe in 35 seconds.
- Scarfs 6" pipe in 45 seconds.
- No loose blades, blade holders, or mandrels

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