

2"-6" Tapering Tool Instructions

For SILVER STREAK® Pipe

Read all instructions before beginning operation.

1. The tool should be set upon 1-½ degrees for 2" through 6" Silver Streak pipe. (Note: Actual taper angle for this product is 1-¾ degrees. However, the tool must be set for 1-½ degrees to cut the correct taper.) Do not use dull blades, as this will cause the tool to spring and possibly cause improper tapers. If the tool is not already properly set up, follow these directions:

- Loosen the hex head bolt and the hex nut on the opposite side from the pin.
- Pull the lock pin and turn the angle scale to the desired angle position.
- Reinsert the lock pin and retighten the hex nut. Retighten the hex head bolt by taking out all the slack to snug, then ¼ turn more.

Caution: Do not try to adjust the angle scale without loosening the proper nuts and bolts.

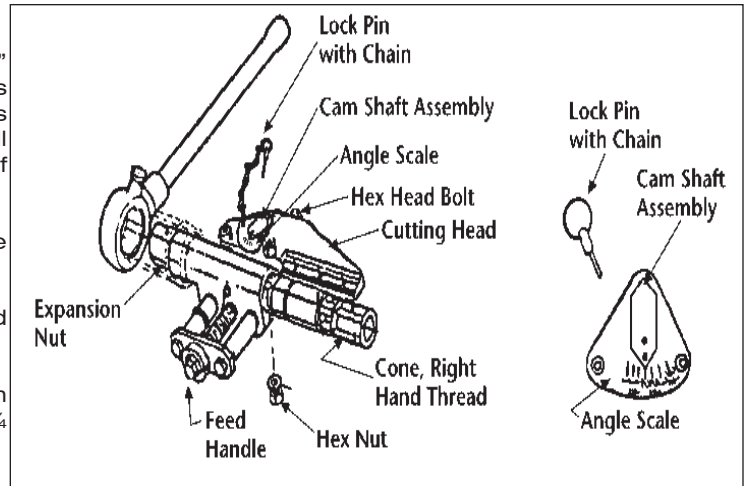
2. Using the handle at the top of the tool (feed handle), back out the cutting head far enough to mount the collets. Stack the collets on top of each other until they reach the size you are tapering.

3. Insert the tool into a **factory-tapered** pipe until the collets are flush with the end of the pipe. Expand the collets by turning the torque knob clockwise. Tighten hand tight for thin wall pipe and hand tight plus ¼ turn for thick-wall pipe. **If the collets slide out during the tapering operation, back out the cutting head, loosen the expansion nut, and repeat step three. DO NOT OVERTIGHTEN.**

4. To set the cutting depth, turn the feed handle in until the blade makes light contact with the factory taper. Move the depth stop (split collar) flush with the cutting head body and tighten using a 3/16" allen wrench. Remove the tool from the factory-tapered pipe. The tool is now ready for tapering.

5. Insert the tool into plain end pipe. Expand the mandrels and move the cutting head down until it makes light contact with the pipe. Begin tapering. Pipe should be tapered clockwise. Be careful that the blade does not peel the glass back. Feed the cutting head slowly and in small increments; do not try to force the cut. When tapering SILVER STREAK pipe, back the cutting head out halfway through the operation, and once again close to the end of the operation. This relieves the tension (spring) in the cutting head and ensures a proper taper. Continue cutting until the tool body is flush with the depth stop (split collar). Let the cutting head make several revolutions after reaching the depth stop for complete clean-up.

6. To check the field taper, dry fit the factory taper into a factory bell and measure the insertion. Dry fit the field taper into the same factory bell and measure the insertion. Compare the two insertions. The field taper must be within +1/8" of the factory insertion. If the taper is out of tolerance, then reset the depth stop and repeat the tapering operation until the taper is within tolerance.



Helpful Hints

A. If the insertion is too long, the pipe does not have to be retapered. Using the recommended cutting equipment, cut back the taper to the acceptable insertion length.

B. When tapering thick-wall pipe, back the cutting head out halfway through the operation, and once again close to the end of the operation. This relieves the tension (spring) in the cutting head and ensures a proper taper.

C. When the cutting head knob becomes increasingly difficult to turn, it is possible that the blade may be getting dull. (See paragraph D below, also.) When this happens, flip the blade over or replace the blade with a new NOV Fiber Glass Systems tapering tool blade. The blade has a wide side and a narrow side; always place the blade with the wide side facing out. If the blade is inserted backwards, the tool will not cut in a clockwise direction. It is critical that the blade be put back in exactly the same position as it was when removed. If the blade has moved one direction or the other, then the depth stop will be off. Should this happen, reset the depth stop.

D. The tool must be cleaned after every use. If dust is allowed to build up in the threaded parts of the tool, the cutting head will be more difficult to turn. Be sure to protect the front and rear post from nicks and scratches.

E. If you experience problems with the tool, refer to the manufacturer's instructions or contact your NOV Fiber Glass Systems representative.



National Oilwell Varco has produced this brochure for general information only, and it is not intended for design purposes. Although every effort has been made to maintain the accuracy and reliability of its contents, National Oilwell Varco in no way assumes responsibility for liability for any loss, damage or injury resulting from the use of information and data herein nor is any warranty expressed or implied. Always cross-reference the bulletin date with the most current version listed at the web site noted in this literature.

www.fgspipe.com

2700 West 65th Street
Little Rock, Arkansas 72209
Phone: 1 (501) 568-4010

25 S. Main Street
Sand Springs, Oklahoma 74063
1 (918) 245-6651

NOV Fiber Glass Systems

©2009, NATIONAL OILWELL VARCO
®Trademark of NATIONAL OILWELL VARCO
F6605 February 2009