

Fiber Glass Systems™

A Varco Company

Smith Fibercast

DRILL SCARFER Instructions

The 1 ½" Drill Scarfer is designed to cut scarfs on Smith Fibercast Marine-Off Shore Green Thread® 175 and Green Thread 250, Red Thread® II, Green Thread, Chem Thread® and Z-Core® products. Use with any variable speed ½" drill. The drill scarfer is very light and mobile and can be used on the ground or up in pipe racks.



Warning: Drill motors run at very high speeds. Hold drill firmly with both hands at all times. Proceed with caution. Keep all limbs away from rotating arms on tool. It is the responsibility of the end user to operate the tool safely. Smith Fibercast will not be liable for any injuries related to the use of this tool.

- 1 Choose the correct mandrel for the product you are installing from Table 1.

Table 1. Mandrel Selection

Product	Size	Part Number
GT 250	1.5"	Contact SF
GT175 & 250	2"	005990-822-1
GT175 & 250 & Green Thread	3"	005990-823-1
GT175 & 250 & Green Thread	4"	005990-824-1
GT175 & 250 & Green Thread	6"	005990-825-1
Red Thread	3"	005990-823-0
Red Thread	4"	005990-824-0
Red Thread	6"	005990-825-0
Chem Thread & Z Core	1.5"	Contact SF
Chem Thread & Z Core	2"	05990-822-9
Chem Thread & Z Core	3"	05990-823-9
Chem Thread & Z Core	4"	05990-824-9
Chem Thread & Z Core	6"	05990-825-9

- 2 Place the bearing washer over the mandrel to be used.



- 3 Place mandrel into the recess at the center of the tool. Place mandrel bolt through tool and tighten.



- 4 Place drill adapter over the back of the tool and tighten the two ¾" bolts.



- 5 Place scarf gauge over mandrel. Scarf gauges may be made from existing 2000 series power tools or purchased from Smith Fibercast.



- 6 Loosen ¼" socket screw on each blade holder and move blade into contact with the scarfing gauge. Tighten socket screw on blade holders.



- 7 Secure pipe tightly and place tool into pipe end to be scarfed.

- 8 Mark the scarfing depth on the pipe using appropriate installation instructions.



- 9 Bump trigger on the drill until smooth scarfing is achieved. Slowly increase drill speed to a comfortable level. Caution: If the tool is operating too fast and the scarfing blades jam, the drill will continue to rotate resulting in possible injury. DO NOT operate drills at high speeds.



- 10 Remove tool and check scarf dimensions per the installation instructions for that product.

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