

3000/3000L and 3106 Series Power Tools

for Dualoy™ 3000/L-A and 3000/LCX-A products



Introduction

The model 3000/3000L and 3106 power tools consist of a grinding drum centrally located between a set of mandrels. The 3000 and 3000L tools are for tapering and scarfing Dualoy 3000/LCX-A pipe and tapering Dualoy 3000/L-A pipe.

The model 3106 will taper 2" – 6" 3000/L-A pipe.

WARNING

When rotating the pipe to taper a short section, **DO NOT** place a hand over the end of the pipe as this could cause serious injury. The proper procedure is to firmly grip the pipe with both hands while rotating the pipe counterclockwise to taper.

To Taper Pipe

1. Pipe end must be cut square. For Dualoy 3000/LCX-A pipe, the containment jacket must be cut to the proper length before tapering. The jacket cutting instructions are in the pipe Installation Manual and must be followed. The orientation of the tool may be either horizontal or vertical, whichever is more convenient for the operator. The tool has legs that allow it to be bolted to a table top or a truck bed.
2. Turn electric motor on allowing a few seconds until the motor reaches a constant speed.
3. While gripping the pipe firmly with both hands, slowly rotate the pipe counter clockwise while sliding the pipe onto the mandrel. Continue rotating and sliding the pipe onto the mandrel until the pipe bottoms out on the mandrel depth stop. A firm grip on the pipe must be maintained at all time during this operation.
4. Continue rotating the pipe until there is no significant grinding resistance which indicates the taper has been completed. If the motor starts to bog down or labor during the tapering process, reduce the load on the grinder by slowing the pipe rotation and/or insertion speed. (Failure to maintain a firm grip on the pipe may cause the grinder drum to grab the pipe and spin it backwards. The pipe may become locked up or jammed against the grinding drum. If the grinding drum locks up, turn the motor off immediately and move the pipe back and forth to free the pipe. If this does not loosen the pipe, cut the pipe off near the end of the mandrel then loosen the mandrel adjustment bolt using the supplied T-Allen head wrench. The pipe should now be easily removed from the mandrel by hand. The mandrel should be repositioned and the adjustment bolt tightened.)
5. The thin "leading" feather edge of the completed pipe should compare to a factory taper. The taper lengths should be approximately 1½" for 2" pipe, 1¾" for 3" pipe, 1 ⅞" for 4" and 2 ¾" for 6".



3000 Series Power Tool

Scarfing Pipe

A special set of required spacers are provided with the tool kit to scarf the Dualoy 3000/LCX-A coaxial containment jacket. Four unique spacer rings are supplied, two per secondary containment pipe diameter sizes which are 2" and 3". One spacer ring is used when scarfing for a coupling and the second for use with all other fittings. The scarf length for a termination fitting does not require the use of a spacer ring. If a spacer ring is lost a replacement may be made from a piece of a primary pipe. The table below provides spacer lengths for the various fittings per pipe size.



Spacers

Pipe Size		Secondary Containment Fitting Type	Factory Spacer Marking	Spacer Length	
in	mm			in	mm
2	50	Coupling	Coupling	1	25
		Fittings	Fittings	1 1/16	42
		Termination Fitting	Not Required	-	-
3	80	Coupling	Coupling	1 3/8	35
		Fittings	Fittings	1 7/8	48
		Termination Fitting	Not Required	-	-

Adjusting Taper or Scarf Depth

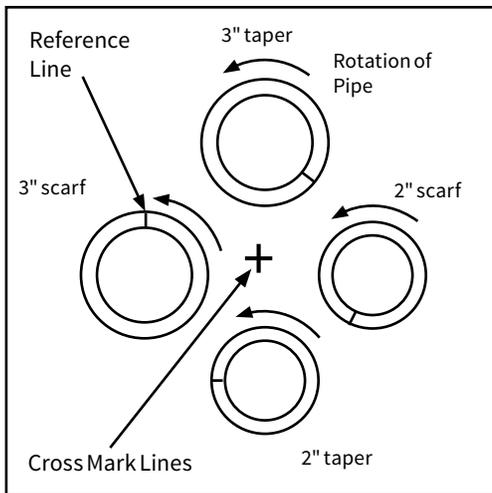
The taper and the scarf depths are preset at the factory. The tool may be field adjusted if necessary to compensate for drum wear or the occasional resetting due to rough use or handling. There are cross hair lines centered between the mandrels on the face of the tool body and a reference mark line on each mandrel. These lines are used as adjustment references. To make adjustments, use the supplied T-Allen head wrench to loosen the mandrel which is causing out-of-tolerance tapers.

- To produce a shorter taper length or lesser scarf depth, rotate the mandrel to move the reference line away from the cross-marks on the tool body.
- To produce a longer taper length or greater scarf depth, rotate the mandrel to move the reference line toward the cross-marks of the tool body.

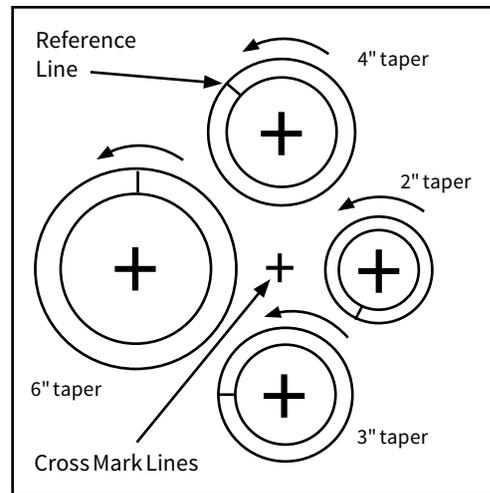


T Allen head wrench

3000/3000L



3106



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