

Universal Jacket Cutter Instructions

For Dualoy™ 3000/LCX Fiberglass Piping Systems



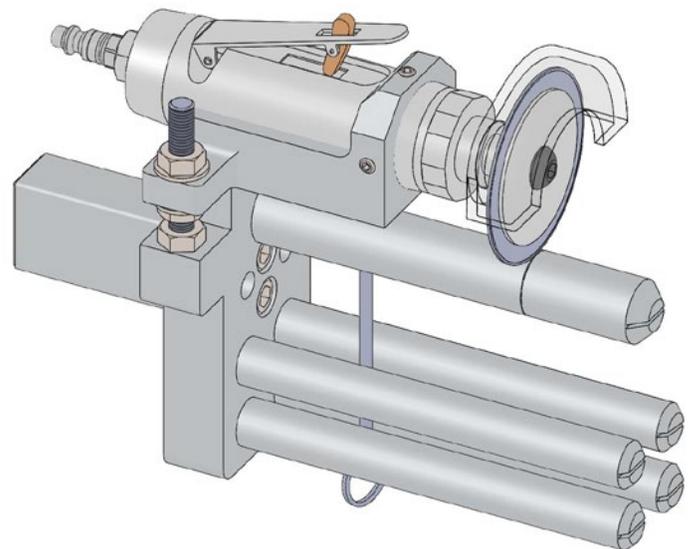
General

The Universal Jacket Cutter is used to quickly remove the containment layer from the end of Dualoy 3000/LCX pipe. The tool makes tapering of the pipe easier, reduces wear on the tapering equipment and provides a square, finished edge to the containment. The tool consists of a pneumatic grinder equipped with a diamond cut off wheel adjustable to be set at the desired height to cut through the containment without any risk of cutting into the primary pipe. The tool can be clamped into a vise or can be hand operated if the pipe is clamped into a pipe vise.

The tool is supplied with multiple guide rods over which the pipe is inserted to position it to assure proper depth of the cut through the containment. The large guide rod is indexed to remove the correct length of containment for each pipe size.

Set-Up Instructions

1. If they are not already in place, thread the 3/4" diameter guide rods into the proper holes for the size pipe(s). Use a large screwdriver in the slot in the end of the rods to loosen or tighten.
2. Insert the Stop Pin into the hole for the desired length of containment to be removed according to the table below. Leave the Stop Pin out to remove the 4.50" length. For 5.75" length, move the motor forward 1.25" by loosening the two set screws.
3. Insert a piece of Dualoy 3000/LCX pipe over the Guide Rods, up to the Grinding Wheel. Check that the depth is set to cut through the fiberglass containment layer but not into the sand layer. This will minimize wear on the Wheel. If the depth needs to be adjusted, turn the Jam Nuts on the-side of the tool to set the depth.



Universal Jacket Cutter

Length of Containment to be Removed

Nominal Pipe Size		Containment Removed To Bond into a fitting		Containment Removed To Bond into an Adapter at end of Pipe Run	
in	mm	in	mm	in	mm
2	50	2.75	70	4.50	114
3	80	2.75	70	4.50	114
4	100	3.50	91	5.75	146

Operating Instructions

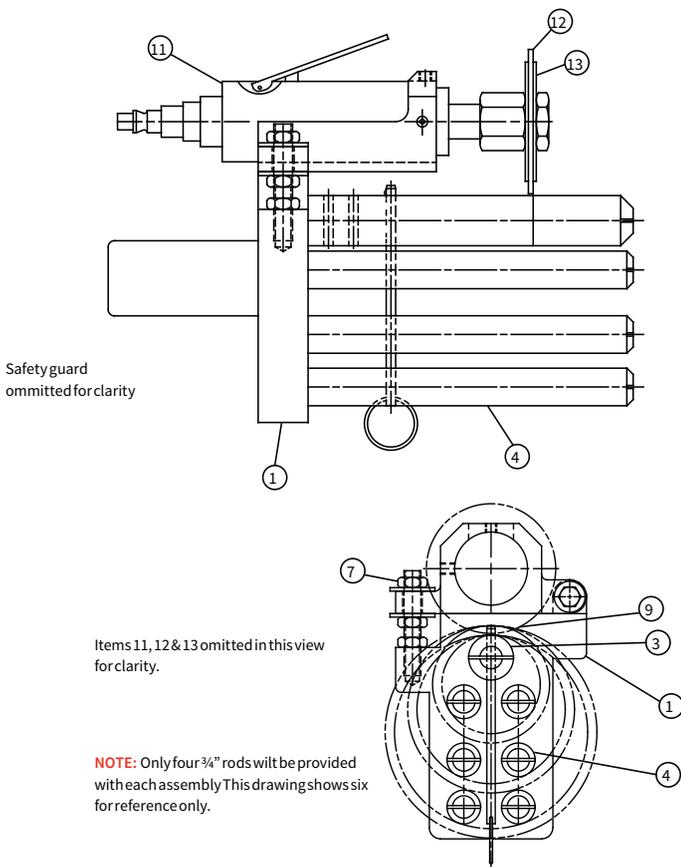
1. Connect the air supply to the Pneumatic Grinder Motor. The air supply should provide 5 cfm at 60-90 psi. Do not use air at pressures above 90 psi.
2. Remove the containment by activating the Pneumatic Grinder and inserting the end of the pipe over the Guide Rods.
3. Push the pipe onto the tool (or vice versa, if the tool is hand-held) which will cut a longitudinal groove in the containment.
4. When the end of the pipe reaches the Stop Pin, rotate the pipe (or grinder), cutting the containment circumferentially. It may be necessary to go around a couple of times to ensure that the containment is cut through completely.
5. Rotate back to the starting position and remove the pipe from the tool.
6. Use a utility knife to cut any uncut fibers and tape.
7. Physically remove the containment layer with a screwdriver by prying the layer open slightly and pulling it off the primary pipe. Use care to not damage the primary pipe during this operation.

NOTE:

- The Grinding Wheel will wear down eventually and may need readjustment to cut through the containment.
- The Pneumatic Grinding Motor will last significantly longer if a drop of oil is applied into the motor between uses.

Item	Commodity Code	Description	Qty
1	2158701	Back Plate	1
2		Tool Holder	1
3	23158701	Stop/Guide Rod	1
4	22158701	Guide Rod (3/4" diameter)	4
5		Roll Pin	1
6		All-Thread. 3/8"-16" UNC x 2 1/4" Long	1
7		Jam Nut, 3/8"-16" UNC	2
8		Set Screw, 1/4"-20" UNC x 1/4" Long Cup Point	2
9		Quick Release Stop Pin, 3/16" diameter x 1" Grip Length	1
10		Lanyard (to attach Item 9)	1
11	15158701	Pneumatic Grinder Motor	1
12	16158701	Diamond Cutoff Wheel, 3" diameter (1 5/8" max. motor body OD)	1
13		Backing Plate, 1116" Thick x 2 3/8" OD	2

Figure 1: Parts List



Safety Recommendations

Engineering Controls:

- A fabrication area should be set up in which to perform as much or the fabrication work as is practical or possible.
- Ventilation of the work area should be controlled. This can be done by means of fans or dust collectors.
- Work area should be kept clean, including floor or other horizontal surfaces. Rinsing with water or sweeping with brushes or brooms (using floor sweep) is recommended. Never use compressed air to clean area or to remove dust for personal cleaning. Brushes should be used to remove residue from tapered surfaces.

Personal Protection:

- Barrier creme should be applied to the skin in areas which may be exposed to shavings prior to beginning work.
- Clean clothes should be worn each day. Do not wear clothing that has not been laundered to begin a work shift. More frequent changing may be required by conditions.
- Long sleeved shirts or work suits should be used. Tape should be used at sleeve opening.
- Cotton or flannel shirts under work shirts may be worn to prevent rubbing of skin at opening of work suit.
- Gloves with elastic cuff should be worn at all times. Replace worn or contaminated gloves as necessary. Gloves with flared, stiff cuffs act as a gathering funnel for shavings.
- Pant legs should be worn outside work boots. If necessary for safety purposes, the pant legs can be taped to fit closely to the boot. Over-the-calf socks can be used to prevent chafing of the boot on the skin.
- Wristbands and watches should be removed to prevent rubbing or accumulation of particles on skin underneath the band.
- Dust masks and face shields should be used as necessary and practical. Contact points with the skin should be kept free of dust to prevent dust from being imbedded into skin from movement of the mask during normal use.

Personal Hygiene:

- Wash exposed skin with soap solution (liquid soap preferred) and cool water.
- Use washcloth with "brushing" motion to remove dust or fibers. Do not scrub the skin. This could result in the fibers being imbedded into the skin.
- Rinse thoroughly with clean, cold water.
- Apply lotion or creme to skin (non-detergent formulas such as baby lotion) to soothe irritation or prevent further immediate irritation.

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.

© 2016 National Oilwell Varco All rights reserved
INS3001ENG February 2016

Fiber Glass Systems

17115 San Pedro Avenue, Ste 200
San Antonio, Texas 78232 USA
Phone : 210 477 7500
Fax : 210 477 7560

