

BUCK-ON MACHINE
 MODEL 8000 & 8100
 OPERATING INSTRUCTIONS.

STEP 1 WIRING - 220 Volt 3 PH 10 AMP Circuit
 Air - 1/4" Line Min 90 PSI.

NOTE: Install air line first. Then connect 3 Ph power. Because of 3 Ph wiring, drive motor can turn in either direction upon initial hook-up. Stepping on footswitch, accuating air clamp and pushing cycle start button, spindle will rotate. Make sure that spindle is rotating counterclockwise. If it is not reverse any two power leads. Spindle Must Be Rotating Counterclockwise.

STEP 2 Adjusting Buck-On Chuck - With a 3/16 allen wrench, adjust the chuck opening so that the largest part of the fitting will slide in freely and snuggly all the way to the chuck face. Turn the allen wrench counterclockwise to loosen the two clamping screws, allowing the clamp to slide up or down for the appropriate size of fitting to be bucked-on. Now tighten the clamp screws by turning clockwise. If the chuck opening is set too freely for the particular size fitting being bucked-on, the chuck may slip on the fitting. Opening size should be so that the fitting just fits into the jaws. (DO NOT TIGHTEN JAWS ON FITTINGS.)

STEP 3 ADJUSTING MOVABLE CLAMP JAW. - Movable clamp jaw must be set for each different size pipe 1, 1-1/4, 1-1/2, 2". Loosen the knurled ring on the clamp jaw threaded shaft. Then turn the knob to set the pipe size to be bucked-on. Size mark the jaw to line up with the line on the gibb. When the two marks line up, lock the knurled ring so that the clamp jaw cannot move.

STEP 4 LEVELING PIPE SUPPORT - With pipe clamped in jaws, slide pipe support up so that it just contacts pipe. Tighten with 3/4" wrench. After finishing a size run loosen the support allowing the support to drop to the largest size which is 2". By doing this procedure you will not have the support set too high for larger size pipe.

STEP 5 SIZE CONTROL PRESSURE SETTING - After the chuck and the pipe support has been set, we must now set the pressure for the proper torque on the size of pipe being bucked-on.

SIZE	PRESSURE SETTING
1	24
1-1/4"	30
1-1/2"	42
2"	60

NOTE: Above settings are based on LaCo. "Slic-Tight". Using different pipe joint compounds you may have to vary the pressure settings to have two to three threads showing.

- STEP 6 Coat pipe threads with compound - Hand start fitting.
- STEP 7 Place pipe on pipe support and slide fitting into chuck jaw until fittings bottoms in chuck jaw.
- STEP 8 Step on footswitch, clamp jaw will close. (IMPORTANT - HANDS MUST NOT BE WITHIN SIX INCHES FROM CLAMP JAWS.)
- STEP 9 PUSH CYCLE START BUTTON - Chuck will start to rotate. When chuck stops rotating the proper torque has been reached.

NOTE: Safety interlock cycle start button must be pushed down for entire cycle. If not cycle will stop upon release. Foot switch must also be held for entire cycle. If not, cycle will stop upon release.

- STEP 10 When chuck has stopped rotating release cycle start button, and remove foot from footswitch. You now may remove finished product from machine. You are ready for production.

MAINTENANCE

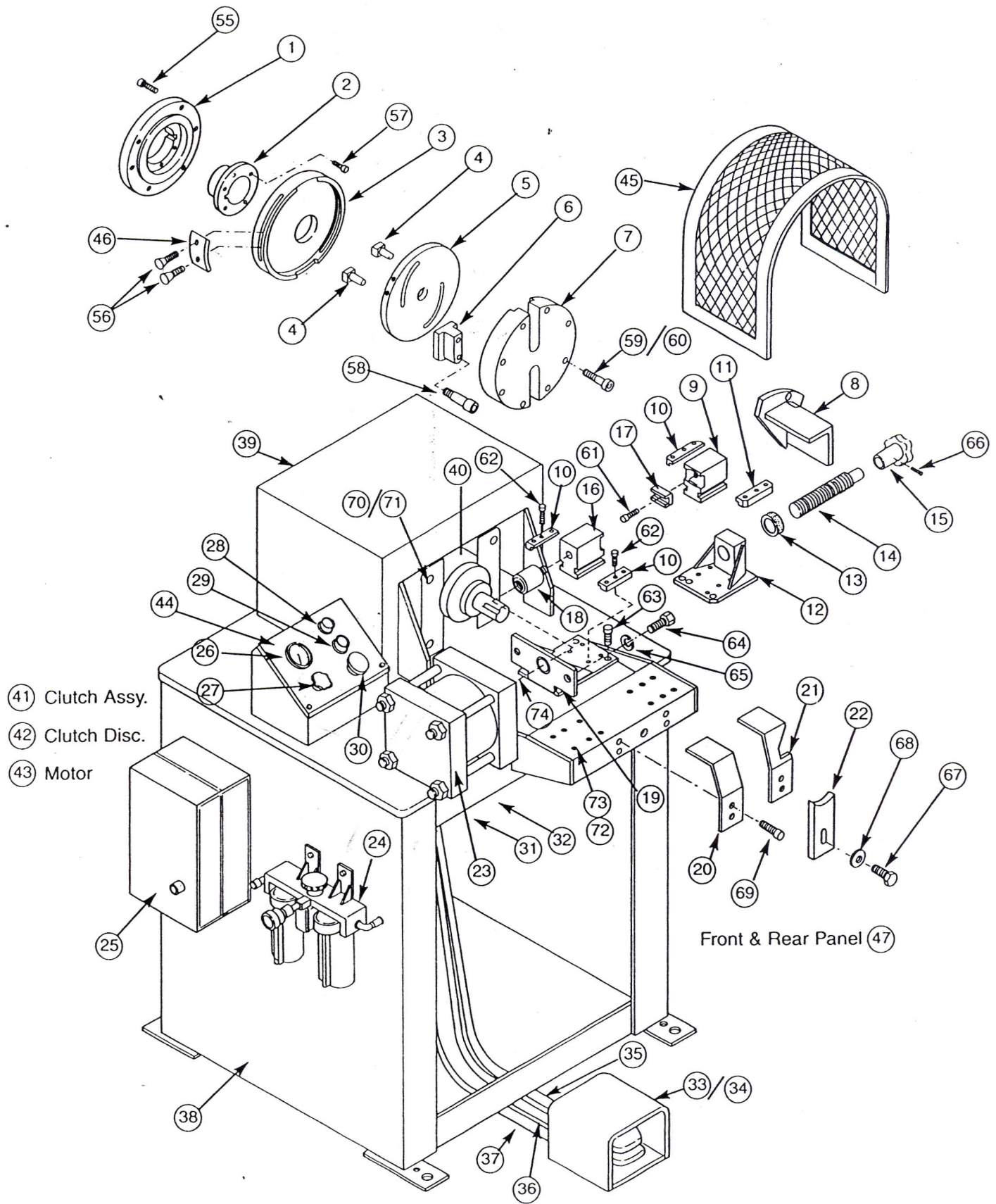
ONCE A WEEK

Check that chuck jaw bolts are tight.

ONCE EVERY SIX MONTHS.

Grease fitting on top of gear box, which is located under top machine cover.

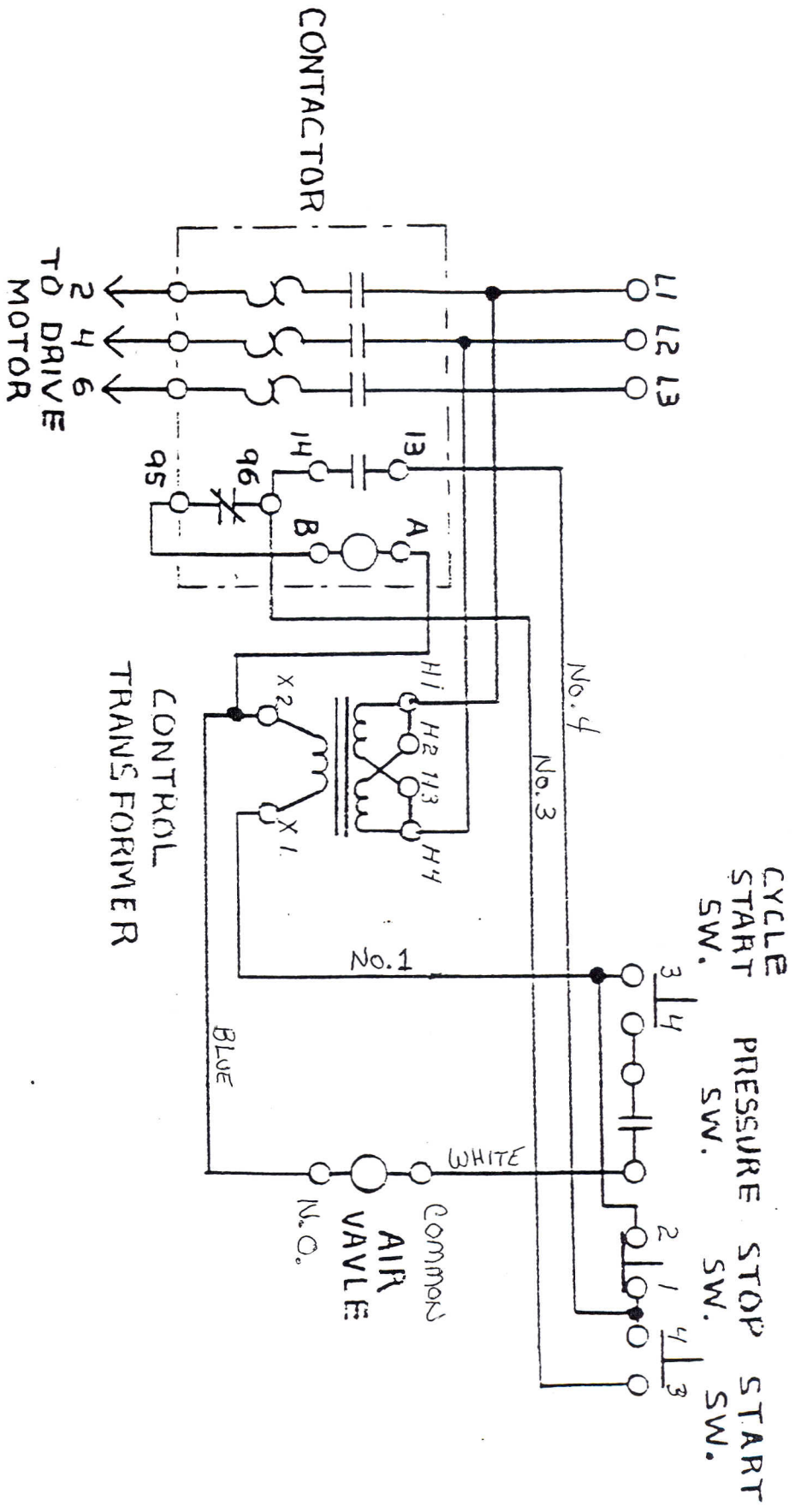
MODEL 8100 BUCK-ON



Model 8100 Buck-On Parts List

4-1-08

Pace		Quantity	Pace		Quantity
Part #	Description	Per Machine	Part #	Description	Per Machine
1	8110	Mounting Plate	1		
2	8111	Lock Hub	1		
3	8112	Chuck Housing-Back Half	1		
4	8113	Cam Followers	2		
5	8114	Chuck Scroll Plate	1		
6	8115	Chuck Jaw Slide	2		
7	8116	Chuck Face	1		
8	8117	Box Jaw	2		
9	8118	Stationary Pipe Clamp Jaw	1		
10	8119	Gibbs	3		
11	8120	Gibb - Size Control	1		
12	8121	Bracket-Stationary Jaw	1		
13	8122	Knurled Lock Ring	1		
14	8123	Adjustment Screw	1		
15	8124	Hand Knob	1		
16	8125	Moveable Clamp Jaw	1		
17	8126	1/2"-3/4" Pipe Inserts	2		
18	8127	Air Cylinder Adaptor	1		
19	8128	Air Cylinder Mounting Bracket	1		
20	8129	Left Jaw Guard	1		
21	8130	Right Jaw Guard-w/window	1		
22	8131	Pipe Support	1		
23	8132	Air Cylinder	1		
24	8133	Filter-Lubricator-Regulator	1		
25	8134	Electrical Control Panel	8		
26	8135	Pressure Gage	1		
27	8136	Size Control Valve	1		
27	8156	Size Control Valve (High Pressure)	Opt.		
28	8137	Start Button	1		
29	8138	Stop Button	1		
30	8139	Cycle Start Button	1		
31	8140	Air Flow Control	1		
32	8141	Pressure Switch	1		
33	5300	Air Foot Switch	1		
34	5303	Air Switch Replacement Valve	1		
35	8142	Hose-Clamp 36"	1		
36	8143	Hose-Pressure 32"	1		
37	8144	Hose-Unclamp 40"	1		
38	8145	Base Cabinet	1		
39	8146	Gear Box Cover	1		
40	8147	Gear Box	1		
41	8148	Clutch Assembly	1		
42	8149	Clutch Disc			
43	4138	Motor	1		
44	8150	Air Solenoid	1		
45	8151	Chuck Safety Guard	1		
46	8152	Fitting Size Clamp	1		
47	8153	Front & Rear Panels	2		
48	8157	Hose Clamp-cyl pipe clamp 7 1/2"	1		
49	8158	Hose Unclamp-cyl pipe clamp 5 1/2"	1		
50					
51					
52					
53					
54					
55				Hardware	
56				3/8-16 x 1" SHCS	6
57				5/16-18 x 1 1/4" FHSC	2
58				1/2 x 3/4 Shoulder Bolt	4
59				1/4-20 x 1 1/2" SHCS	6
60				1/4-20 x 1 1/4" SHCS	2
61				5/16-18 x 1/2" SHCS	2
62				1/4-20 x 1" SHCS	12
63				5/16-18 x 1" SHCS	6
64				1/2-13 x 1 1/4" HHCS	2
65				1/2" Lockwasher	6
66				1/8 x 1 1/4" Roll Pin	1
67				1/2-13 x 1 1/4" HHCS	1
68				1/2" Flat Washer	1
69				1/4-20 x 1/2 BHCS	4
70				1/2-13 x 1 1/2" HHCS	4
71				1/4-20 x 3/4" FHCS	4
72				1/4" Lockwasher	4
73				1/4-20 Hex Nut	4
74				8-32 x 1/4" Ph Pan Head	22
75				10-32 x 1/2" Ph Pan Head	3
76				1/2-13 1" HHCS	1
77				1"-14 Hex Jam Nut	1
78				3/8-24 x 3/8" Dog Set Screw	1
79				3/8-24 Hex Nut	1
80				5/16-18 / 5/16-24 Stud	2
81				5/16-24 Top Lock Nut	2
82				#2 x 1/4" Type U-Drive Screws	2
83				Name Plate	1
84					
85					
86					
87					
88					
89					
90					
91					
92					
93					
94					
95					
96					
97					
98					
99					
100					
				Friction Facing Kit (930272)	1



PACE MACHINERY

SCALE: NONE		APPROVED BY:	
DATE: 3-10-91		DRAWN BY: <i>NMF</i>	
MODEL 8000, BUCK-ON		REVISED	

ELECTRICAL WIRING

DRAWING NUMBER