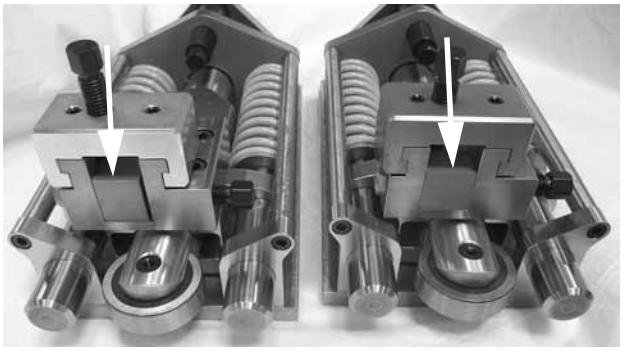
MDSF Positioning

For the standard tooling configuration—with one of the parting tools mounted in the low (0.92”) position)—mount the MDSF on the pipe so that the top surface of the rotating ring is 3.5” from the cut line.

(See the setup instructions in Chapter 4 of the DynaPrep MDSF User’s Manual, and the operating envelope drawing in Chapter 6.)

Offset Parting Setup

- Use a parting tool in each slide, with the large spacer blocks to mount the tools at offset positions.
- Set the spacer block in the **high** orientation (1.00”) in the first slide. Tighten the spacer block screw.
- Set the spacer block in the **low** orientation (0.92”) in the other slide. Tighten the spacer block screw.



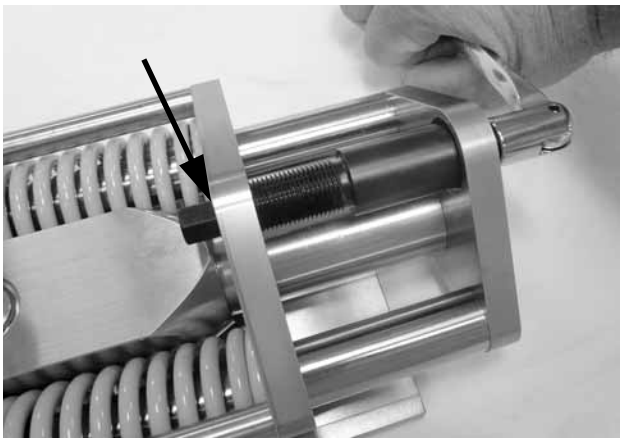
- Insert a parting tool in each slide on top of the spacer block. Tighten the screws in the tool covers.
- Turn the starwheel on both slides clockwise to fully retract the slides.

Parting-Bevel Setup

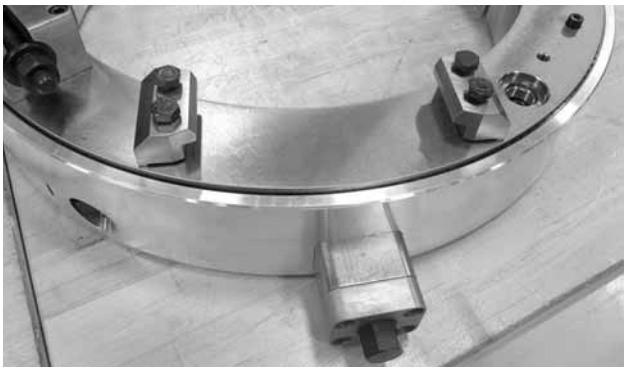
- Use a parting tool in one slide, and a beveling tool in the other slide.
- For the parting tool, set the spacer block in the **low** orientation (0.92”) in the first slide. Tighten the spacer block screw.
- Insert a parting tool on top of the spacer block. Tighten the screw in the tool cover.
- For the beveling tool, leave the tool holder without a spacer in the other slide.
- Insert a beveling tool in the tool holder and tighten the screw in the tool holder.
- Turn the starwheel on both slides clockwise to fully retract the slides.

Mounting the Slides to the MDSF

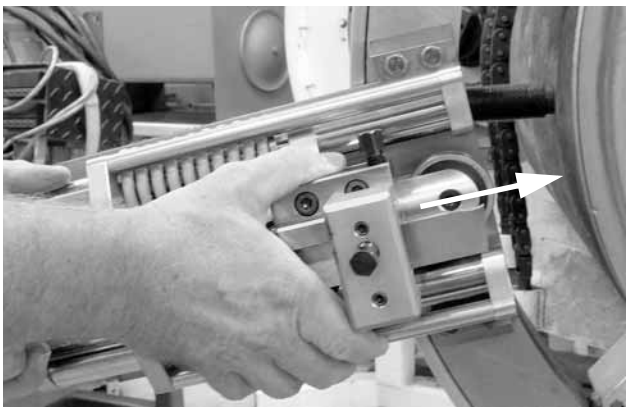
- On both slides, turn the jacking screw counter-clockwise until the end plate just reaches the end of the threads.



- Insert the mounting blocks at both slide locations on the MDSF rotating ring, as shown. Leave the screws loose so that the slide baseplates will fit under the blocks.



- Mount the slides to the MDSF by sliding the base plates beneath the mounting blocks.
- Push the slide forward until the tracking wheel is against the pipe surface.



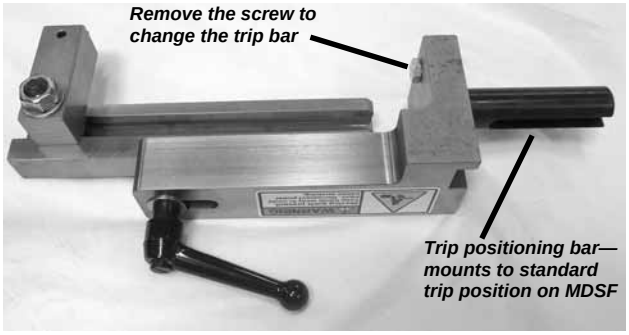
- Snug the screws in the mounting blocks—just tight enough to keep the slides in place.
- Operate the MDSF slowly through one complete rotation. The pipe surface will push the slide back so that it is in position to contact the pipe at the high point (the location where the clearance is least).
- Securely tighten the screws in the slide mounting blocks to hold the slides in position.

- Turn the jacking nuts on both slides clockwise all the way to release the springs for operation. The tracking wheels will be against the pipe.
- Loosen the tool set screws in both slides, and move the tools forward until they are about 1/16” from the pipe. Tighten the set screws.

Mounting the Trip

You can mount 1 or 2 trip assemblies. Using 2 trips doubles the feed rate.

- Install trip positioning bar 69-0083-00 for MDSF sizes 12” to 24”.
- Install trip positioning bar 69-0239-00 for MDSF sizes 28” to 60”.



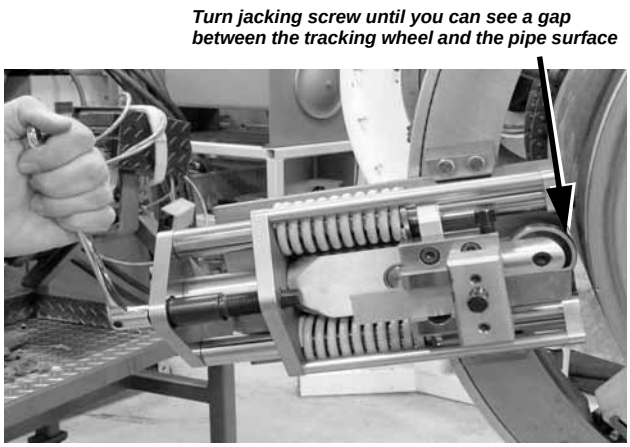
- Mount the trip assembly to the mounting location on the stationary ring.
- Loosen the trip lock lever, and push the trip all the way in against the machine. Tighten the trip lock lever.
- Using the drive motor, rotate the frame to position one of the starwheels over the trip assembly.
- Loosen the trip adjustment knob, and slide the trip toward or away from the frame to position it beneath the starwheel. Tighten the trip adjustment knob.
- Loosen the trip lock lever to release the slide to the disengaged position. (The slide is spring-loaded and will disengage when the lever is loosened.)
- Tighten the trip lock lever. Leave the trip disengaged until you are performing the cut.

Operating the MDSF

- Connect the power source to the drive motor: air, hydraulic, or electric.
- Using a wrench on the starwheels, feed the slides to position the tools close to the workpiece.
- Make sure the trips are in the disengaged position. Set the motor control to the slowest speed, and operate the DynaPrep MDSF slowly through one rotation while checking for clearance.
- Set the motor control to the desired operating speed. Start the machine.
- Engage the trip.
- As you cut, monitor cutting performance. Adjust motor speed as necessary.
- If the machine starts to bind or chatter, you can disengage the trips for a few rotations to allow chips to clear.
- When the cut is close to complete, make sure you are clear of any fall-off pieces. Support the fall-off piece if necessary.
- When the cut is complete, disengage the trip and operate the machine through one or more complete rotations to clean up the cut surface.
- Shut off the drive motor and disconnect the power source.

Removing the Slides from the MDSF

- Turn the starwheels on both slides clockwise to retract the slides.
- Turn the jacking screws on both slides counter-clockwise to compress the springs until there is a gap between the pipe surface and the tracking wheels.



WARNING: Do not loosen the mounting block screws or try to remove the slides when the tracking wheels are under spring pressure against the pipe. The spring pressure will “pop” the slide away from the pipe. Serious injury or damage to the equipment can result.

- Loosen the screws in the mounting blocks to remove the slides from the machine.
- Remove the mounting blocks from the rotating ring.
- Remove the trip assembly from the machine.
- Remove the drive motor from the machine.
- Remove the machine from the workpiece. If the workpiece is open-ended, you can loosen the clamp legs and remove the entire ring from the workpiece.