

# B-1F Pipe End Preparation Tool

## For Quick-Lock® Bell x Spigot Joints on Jacketed Pipe in 2-6 Inch Diameters

### Introduction

The B-1F Pipe End Preparation Tool is used to produce the straight spigot end on Bondstrand pipe with Passive Fire Protection (PFP) jacketed pipe. The tool is available for all Bondstrand pipe sizes from 2 through 6 inches in diameter. The tool is designed so that all critical dimensions such as spigot length and spigot outside diameter are preset.

The 2-4 inch tools are designed to cut Bondstrand PSX™ •JF pipe in two stages. The tools are delivered with only one cutting insert located on the arm marked Spigot.

### Advantages

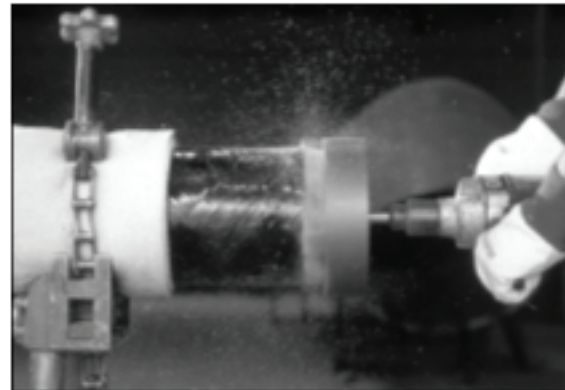
The B-1F tool offers the following advantages over previous end preparation tools.

- Requires no adjustment: spigot length and diameter preset.
- Requires no special tools: uses ordinary power drills with ½-inch chuck
- Compact: can use on installed buried pipe with minimal excavation
- Reduces field labor time
- Requires minimal set-up
- Light weight for ease of use: 4-inch tool weighs only 9 pounds

### Operating Instructions

1. Clean the inside of the pipe to remove all dirt, sand or foreign objects. Clean tool of any large particles or shavings from previous use.
2. Inspect the cutter on tool. If worn, remove and rotate for new cutting edge; replace if all edges are worn. If cutter is loose, tighten with an Allen wrench.

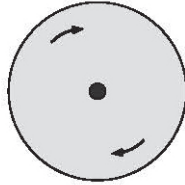
The B-1F tool is available in 2- 6 inch sizes for preparing spigot ends for the Quick-Lock joint. Spigot length and diameter are preset for each pipe size. To use the tool, one need only make sure that the inside of the pipe is clean (left) and then insert the tool (right).



3. For preparing Bondstrand Jacketed pipe, first remove the cutter from the area marked **Spigot** with an Allen wrench and place it on the arm marked **Jacket**. The cutter in this position will remove the external jacket.
4. Mount tool in chuck of ½-inch drill motor and tighten chuck securely. For best results use a drill motor with side handles and a space grip. **Important: The shaft on the B1F tool is round with out flats. The round shaft allows the chuck to rotate on the shaft if the cutters bind. This safety feature should not be modified.**
5. Except when working on installed pipe, hold the pipe securely, preferably in a pipe vise. **Use a ¼-inch thick rubber pad between the clamps and the pipe to protect the pipe. Warning: Avoid inhaling dust produced by cutting. Wear an OSHA-approved dust mask.**
6. Insert the spindle of the tool into the pipe so that the cutter remains away from the end of the pipe. Grip the drill motor firmly and switch to **on**. Slowly feed the tool into the pipe until the tool bottoms. Too fast a feed (on the final spigot cut) can produce high and low spots. Remove the tool from the pipe. **Note: Spindle is held in tool by set screws. If spindle rotates in tool, retighten set screws.**

7. For Bondstrand Jacketed pipe, once the jacket is removed, place the cutter on the arm marked **Spigot** for the final cut. **See note below.**
8. Inspect the cut surface to determine that all “glazed” or resin covered areas have been removed. If such areas remain, sand by hand until the entire surface is without a resin gloss.

**Note:** If several spigots are to be made, it may be more efficient to shave all the jackets first, then shave all the spigots. Two separate tools, one with the cutter on **Jacket** and one with the cutter on **Spigot** may also be used for large installations.



The cutter on the B-1F tool is designed to cut when the tool is rotating in the clockwise direction. Attempts to cut with the tool in counterclockwise rotation will bend the cutter and reduce the effectiveness of the tool. Similarly, when withdrawing the tool after completing a cut, stop the drill motor and simply pull the tool out of the pipe. Do not reverse the drill rotation when withdrawing as this will also tend to bend the cutter.

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