

ACTS12301 MiniMc Adjustment Kit

MiniMc fusion units require periodic adjustment to maintain the tolerances necessary to assure proper alignment when fusing pipe.

This kit consists of two sizing mandrels and an alignment tool. The alignment tool is used to measure how much misalignment a MiniMc unit has. The larger of the two mandrels is used to adjust the fit between the body and the barrel. If this initial adjustment is not sufficient to align the unit, the smaller mandrel is used.

TX00150-6-1-93

Measuring Deflection

Measure the MiniMc's misalignment using the alignment tool supplied in the kit to determine if realignment is necessary. Securely fasten the tool in the inner jaw of the MiniMc unit.

Manipulate the fusion unit in such a way as to create the largest amount of deflection possible. If the misalignment reading exceeds .007", the unit must be realigned.

TX00151-5-24-93

Disassembling the MiniMc

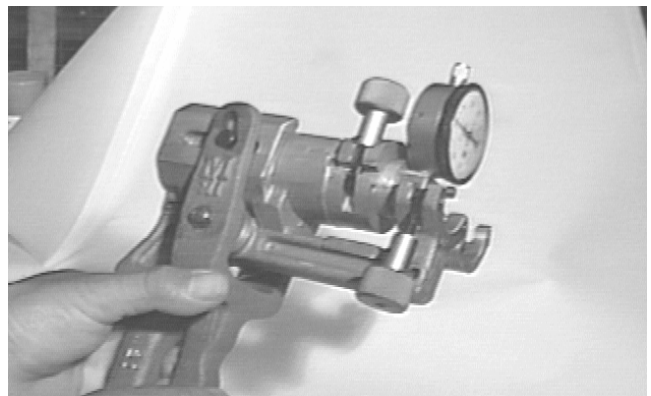
Realignment is accomplished by resizing the body of the fusion unit using a mandrel and a bench vise. Before the body can be resized, the unit must be disassembled.

Start by removing the modified shoulder screws (5) that hold the trigger (8) and barrel (2) to the body (1). Take care when disassembling the unit as to not to misplace the spacer rollers that are around the shoulder screws. Remove the barrel from the body after taking note of the fit.

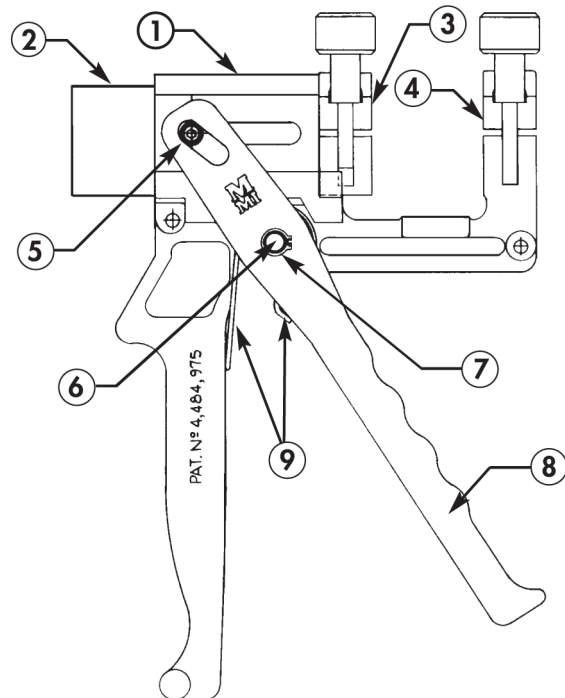
Remove the retaining ring (7) from the pivot pin (6) that attaches the trigger (8) and torque spring (9) to the body (1) of the unit.

- | | |
|-----------------------------|-------------------|
| 1. Body | 6. Pivot Pin |
| 2. Barrel | 7. Retaining Ring |
| 3. Inner Jaw | 8. Trigger |
| 4. Outer Jaw | 9. Torque Spring |
| 5. Modified Shoulder Screws | |

TX00152-6-14-93



PH00131-5-24-93



PH02225-9-5-01

Resizing the Body

Clean the mandrels of any oil that has been applied for corrosion protection.

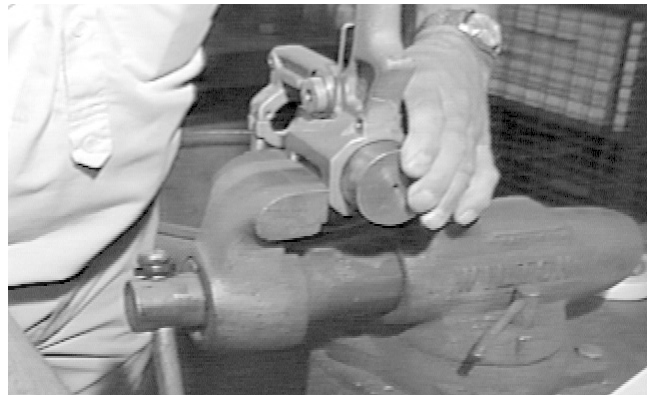
Place the larger mandrel into the body of the unit where the barrel would normally be installed.

Place the body of the unit (with the mandrel in place) into a bench vise.

Apply firm, but not excessive, pressure to the vise. This resizes the body to the size of the mandrel.

IMPORTANT: Do not apply excessive force with the vise as it is possible to break the body. Apply only enough force to cause the body to conform to the mandrel.

TX00153-6-3-93



PH00137-5-24-93

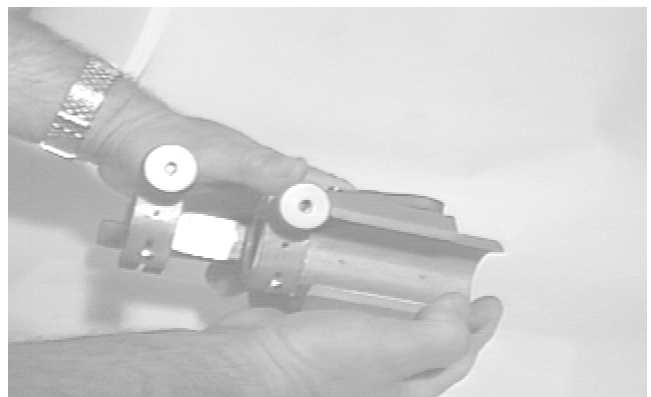
Check Fit

Remove the mandrel from the body, and test fit the barrel into the body using the alignment tool.

If the fit between the pieces has less than .007" deflection and has very little wobble, reassemble the unit.

If the fit between the parts appears to be marginal, resize the body using the smaller mandrel.

TX00154-6-14-93



PH00143-5-24-93

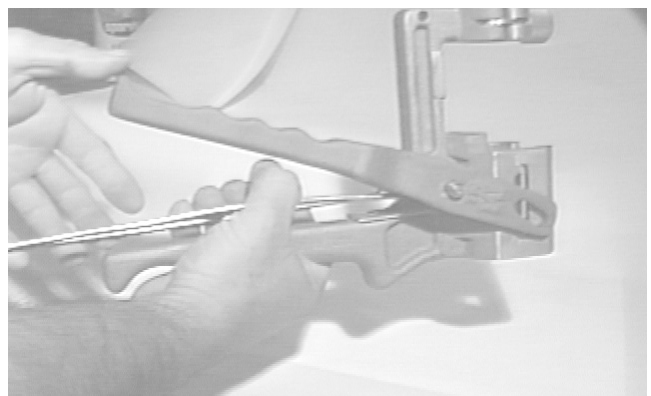
Reassembling the MiniMc

Tension the torque spring so the trigger can be reattached.

Reattach the pivot pin and trigger to the body of the unit. Replace the retaining ring.

Place the barrel into the body of the unit and reinstall the shoulder screws with the spacer rollers in place.

TX00155-6-4-93



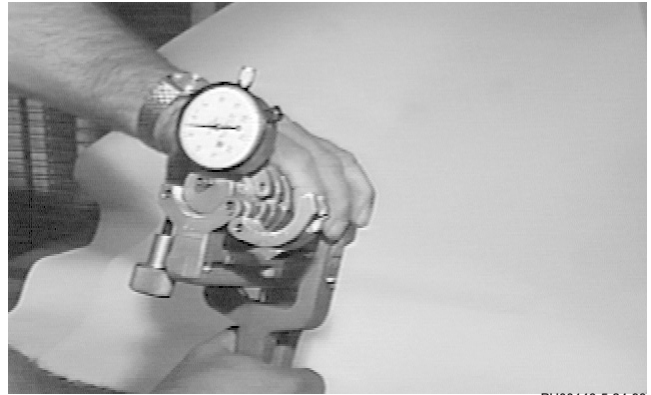
PH00141-5-24-93

Check Operation

Having reassembled the unit, retest the unit using the same procedure that was used when starting this realignment.

If the amount of misalignment is greater than .007", repeat this entire procedure using the smaller of the two mandrels.

TX00156-5-4-93



PH00146-5-24-93

Storing Mandrels

Apply a light coat of lubricating oil to the mandrels to prevent corrosion. Avoid excess oil application as this could contaminate the MiniMc unit the next time the kit is used.

TX00167-6-1-93

INSTRUCTION SHEET REVISION HISTORY LISTING

PART NO: CTS1230101

DESCRIPTION: Mini-Mc® ADJUSTMENT KIT

ORIGINATOR:

CHECK:

APPRV'D:

RELEASED: 10/99

<u>CHK/APR</u>	<u>REV</u>	<u>DATE</u>	<u>BY</u>	<u>DESCRIPTION OF REVISION</u>
LAA	B	2/11/03	BWW	REMOVED CTS01308 SPRING PRELOAD TOOL WHICH WAS FOUND TO BE UNNECESSARY.
JBC/JBC	C	2/6/24	RBS	CORRECTED TO ADD ITEM 5 (MODIFIED SHOULDER SCREW), CORRECTED PIVOT PIN FROM ITEM 2 TO ITEM 6 & UPDATED TO CURRENT SHEET FORMAT.