You know how great HDPE pipe is. We make it even better!

No additional tools or equipment needed
Power loaded cutter tracking system
Quick & positive bead engagement
10 seconds or less removal time
250' reach & longer capability
Terminated bead retractors
Pipe sizes from 3” to 24”
Shippable via courier
Quick to assemble
Easy to operate
CCTV capability

Proud to be AMERICAN MADE

R&L Manufacturing Inc.
Ph/Fax 1-360-833-9194
www.beadtrimmer.com
Operational Theory

The Bead Trimmer II system has an adjustable cutter that is designed to operate in a range of pipe sizes. The Bead Trimmer II head is powered by a manual Tee-handle system.

It is most productive to remove the fusion bead during the cooling stage of the Fusion Process.

The use of these tools is very simple and straightforward. It requires no additional tools for complete assembly, operation, and disassembly.

The torque tube assembly can be made up in lengths to match the job at hand, by adding more torque tubes. This system has been used to retrieve internal beads at a distance of over 250'.
51’ Torque Tube Assembly

This is the standard tee-handle set which is designed to be assemble into multiple lengths up to 51 feet. Additional sets can be added for extended reach.

- 6 each 7’9” Anodized Aluminum Torque Tubes
- 1 each 4’6” Anodized Aluminum Torque Tube
- 1 each 3’ Anodized Aluminum Torque Tube
- 1 each 18” Anodized Aluminum Torque Tube
- 7 each Torque Tube Unions w/locking Pins
- 1 each Tee-Handle Head
- 1 each Shipping/Storage Canister
52’ Manhole Torque Tube Assembly

- 14 each 3’6” Anodized Aluminum T-handle Tube
- 1 each 3’ Anodized Aluminum T-handle Tube
- 1 each 18” Anodized Aluminum T-handle Tube
- 1 each T-handle Head
- 14 each Torque Tube Unions W/Locking Pins
- 1 each Shipping/Storage Canister

This unit is designed to be assembled in space restricted locations.
Bead Trimmer II Head

1 each  Bead Trimmer II Head  
(sizes from 3” to 24”)

1 each  Torque Tube  
Centralizing Disk

1 each  Shipping/Storage  
Canister

The Bead Trimmer II Head is adjustable to match the inside diameter of a given range of pipe sizes.
Centralizing Disk

The torque tube centralizing disk is slipped over the torque tubes approximately 10 feet from the Bead Trimmer head. Its purpose is to keep the cutter head in a vertical alignment with the bead that is being removed.
Cutting Blade Assembly
Head Assembly

- Finger Hook
- Adjustment Wheel
- Index Wheel
Head Setup

The Bead Trimmer Head is placed into the pipe and adjusted to the inside diameter of the pipe as follows:

1. Hold the Bead Trimmer Head inside the end of the pipe.
2. Position the index wheels so that they contact the inside diameter pipe wall.
3. Turn the adjustment wheel until the cutter blade is compressed 1/16” to 1/8” from its full open position.
Head Setup Continued

4. After adjustment has been achieved, fold down the cutting blade and engage the locking pin.

**Caution:** The cutting blade is very sharp! Be aware of this when handling this unit.
Operation

Removing the fusion bead during the cooling stage of welding the pipe is recommended for best efficiency.

1. As the pipe lies in the fusion machine and before making the fusion weld slide the Bead Trimmer into the pipe stopping 6” away from the pipe end so that you could see that the head is properly positioned.

2. Make sure that the two indexing wheels are aligned horizontal across the bottom of the pipe and that the cutter blade is in the closed position.

3. Clear away any debris that may have accumulated in front of the head.
4. After completion of the fusion joint and allowing enough time for the fusion bead to setup and harden, slide the Bead Trimmer unit the remaining distance to the fusion bead. The index wheels will stop the head in position on the fusion joint.
5. Stop the Bead Trimmer against the bead. Slowly rotate the tee-handle $\frac{1}{2}$ turn counter clockwise. This will activate the cutter assembly.

6. After the cutter is activated, change the direction of rotation to clockwise for one full revolution. At this time you will feel the cutting action occur. The terminated bead will be trapped by the finger hooks and will pull out along with the Bead Trimmer head.
Operation Continued

**Important:** While the cutter is being engaged with the bead, there must not be any movement pushing the head inward or outward of the pipe during the head rotation. Doing this will result in unsatisfactory bead removal.

Do not cut the bead when the material is still soft from the fusion process. The bead will not have enough body to effect the alignment needed for the cutter to track the bead, and a soft bead will not cut properly. It is required to wait till the bead has set up and has hardened prior to removal. Cutting off the bead while it is warm will make the bead removal operation easier.
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