

Stinger 300

Compensating jaws - correct selection and installation



- Prepare the correct compensating jaws (pos. B fig. 4.3.4.) according to the exact inner diameter of the pipe to be machined. Use the table below to select the correct compensation jaws. For some pipe/pipe diameters it may be necessary to select a combination of compensating jaws and Booster jaws (pos. C fig. 4.3.4.) .
- You will always need three sets of identical jaws per fitting.
- Tighten the compensation jaws (pos. B Fig. 4.3.4.) on the clamping mandrel (pos. A Fig. 4.3.4.) properly using the built-in screws.

Mandrel B (clamping range 36-82 mm / 1.41"-3.22")

Required pipe diameter	Compensation jaw assembly
36 - 44 mm (1.41" - 1.73")	Base mandrel A without compensating jaw
44 - 53 mm (1.73" - 2.08")	Base mandrel A + A-1
53 - 62 mm (2.08" - 2.44")	Base mandrel A + A-2
62 - 71 mm (2.44" - 2.79")	Base mandrel A + A-3
71 - 80 mm (2.79" - 3.14")	Base mandrel A + A-4

Mandrel A (clamping range 82-269 mm / 3.22"-10.59")

Required pipe diameter	Compensation jaw assembly
82 - 100 mm (3.22" - 3.93")	Base mandrel B without compensating jaw
98 - 118 mm (3.85" - 4.64")	Base mandrel B+B-1
115 - 132 mm (4.52" - 5.19")	Base mandrel B+B-2
131 - 154 mm (5.15" - 6.06")	Base mandrel B+B-3
145 - 162 mm (5.70" - 6.37")	Base mandrel B+B-4
158 - 176 mm (6.22" - 6.92")	Base mandrel B+B-5
173 - 192 mm (6.81" - 7.55")	Base mandrel B+B-6
175 - 195 mm (6.88" - 7.67")	Basic mandrel B + B-1 + booster
192 - 209 mm (7.55" - 8.22")	Basic mandrel B + B-2 + booster
208 - 231 mm (8.18" - 9.09")	Basic mandrel B + B-3 + booster
222 - 239 mm (8.74" - 9.40")	Basic mandrel B + B-4 + booster
235 - 253 mm (9.25" - 9.96")	Basic mandrel B + B-5 + booster
250 - 269 mm (9.84" - 10.59")	Basic mandrel B + B-6 + booster

Fig. 4.3.4.

