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# WELDERS POCKET PAL

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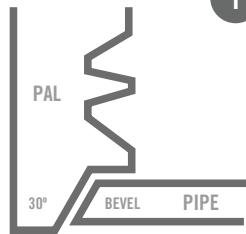
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POCKET PAL™ is a pending trademark of John Livitski Enterprises Inc.  
US Patent Pending.



Thanks for purchasing the pal. It will give you years of help when cutting and welding. One side of the pal is imperial and the other is metric - so use whichever serves you better at that particular job. Also, it's meant for right or left hand use when using the advanced cut.

There's two to choose from - 30 and 33 degree bevels are used for pipeline applications while the 35 and 37.5 degree bevels are usually used for building trade applications. Once you use the Pal you'll always want to keep it in your pocket. **When in doubt take the pal out.**

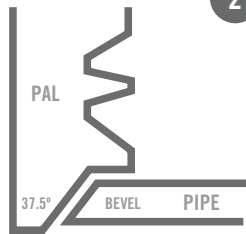
## BEVELED ENDS



1

AFTER CUTTING THE PIPE, CHECK THE BEVEL WITH THE PAL.

**NOTE:** If you see space at the bottom of the pal's bevel, it means that the pipe's bevel is steeper, if there's space on the top, the pipe bevel is longer. Usually 30 to 33 degrees is ideal for welding on the pipeline using the pipeline pal.

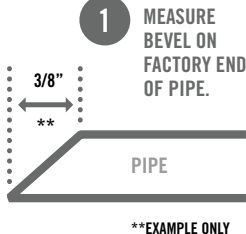


2

AFTER CUTTING THE PIPE, CHECK THE BEVEL WITH THE PAL.

**NOTE:** On the buildings trades pocket pal the 37.5 is usually used for pipe such as chrome. The 35 on the other end of the pal is the degrees of bevel that factory ends are on regular mild steel pipe.

## ADVANCED CUT LINE

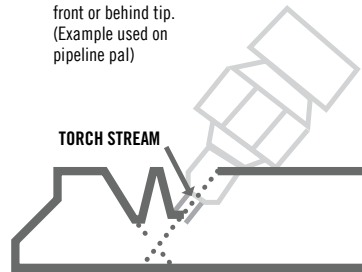


1

MEASURE BEVEL ON FACTORY END OF PIPE.

\*\*EXAMPLE ONLY

**NOTE:** Pal can be in front or behind tip. (Example used on pipeline pal)



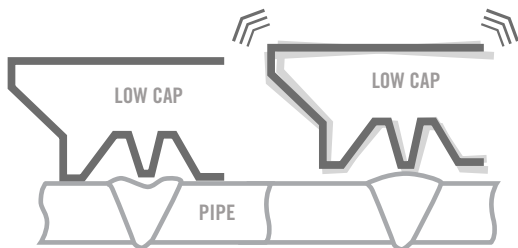
2

SET TORCH HEAD AT DESIRED 30 OR 33 DEGREES AND LINE IT UP WITH ADVANCED CUT LINE OFF CENTRE OF TORCH STREAM CLOSEST TO CRAWLER.

## LOW CAP

**NOTE:** In Canada, cap height is usually 2.5mm under 10mm pipe wall. For over 10mm pipe wall, it's 3.5mm.

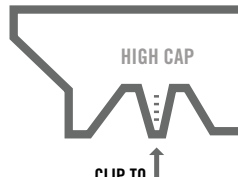
In US, use imperial side of pal.



IF PAL DOES NOT ROCK, MORE WELD REQUIRED.

IF PAL ROCKS, WELD CAP IS OKAY.

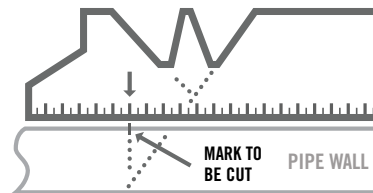
## HIGH CAP



CLIP TO DESIRED HEIGHT

HIGH CAP IS OPPOSITE OF LOW CAP. IF PAL DOES NOT MOVE, THE WELD IS OKAY. IF PAL ROCKS, GRINDING MAY BE REQUIRED TO BRING THE HIGH CAP TO DESIRED HEIGHT.

**NOTE:** High cap requires modification because of the different cap heights on each job. Snip or grind down to desired height. Don't forget to file down any sharp edges.



3

## INSIDE STREAM

WHEN GRINDING A LAND ON IT IS USUALLY 1/32 TO 1/16. YOU CAN TAKE THAT OFF YOUR MEASUREMENT TO BE EXACT.

**NOTE:** Diagram drawn using imperial side of pal. You can use metric side if preferred.

\*\*USED FOR EITHER TOOL  
\*\* EXAMPLE ONLY