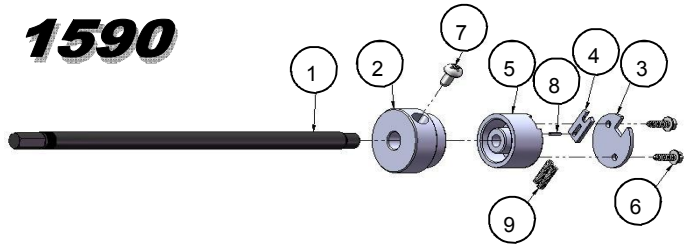


Internal Pipe Cutter - Parts and Operation

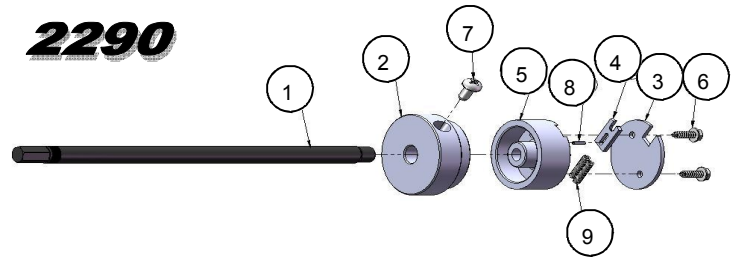
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	2295	DRIVE SHAFT	1
2	1294	FLANGED DRUM	1
3	1291	RETAINER PLATE	1
4	1293	BLADE	1
5	1295	CUTTER DRUM (MACHINE)	1
6	275427	#10-24 x 5/8" SLTD HX WSHR HD, TYPE F	2
7	275432	1/4-20 x 1/2" FILLISTER HEAD, PHILLIPS	1
8	275143	3/32" DIA x 5/16" ROLL PIN	1
9	275482	SPRING	2

1590



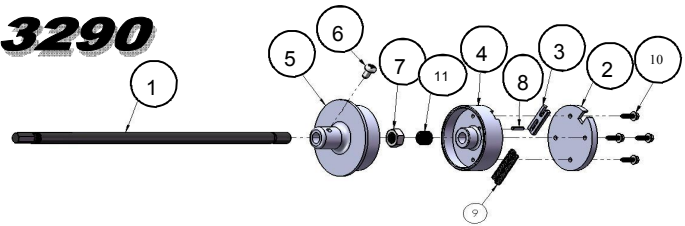
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	2295	DRIVE SHAFT	1
2	2294	FLANGED DRUM	1
3	2291	RETAINER PLATE	1
4	1293	BLADE	1
5	2293	CUTTER DRUM (MACHINED)	1
6	275427	#10-24 x 5/8" SLTD HX WSHR HD, TYPE F	2
7	275432	1/4-20 x 1/2" FILLISTER HEAD, PHILLIPS	1
8	275143	3/32" DIA x 5/16" ROLL PIN	1
9	275482	SPRING	2

2290



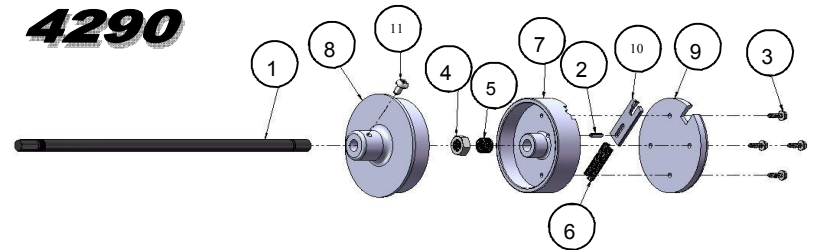
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	3296	DRIVE SHAFT	1
2	3291	RETAINER PLATE	1
3	3293	BLADE	1
4	3294	CUTTER DRUM ASSEM	1
5	3297	FLANGED DRUM	1
6	275432	1/4-20 x 1/2" FILLISTER HEAD, PHILLIPS	1
7	4117	1/2"-20 HEX JAM NUT	1
8	275428	5/32" DIA x 1/2" ROLL PIN	1
9	275429	Spring 1/4" DIA x 2 1/2" LONG	2
10	275427	#10-24 x 5/8" SLTD HX WSHR HD, TYPE F	4
11	275774	HELICOIL INSERT 1191-8CN-0500	1

3290



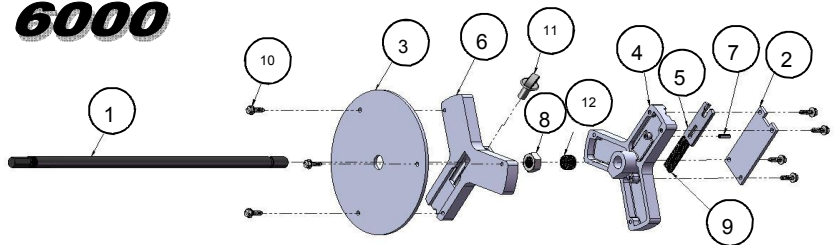
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	3296	DRIVE SHAFT	1
2	275428	5/32" DIA x 1/2" ROLL PIN	1
3	275427	#10-24 x 5/8" SLTD HX WSHR HD, TYPE F	4
4	4117	1/2"-20 HEX JAM NUT	1
5	275774	HELICOIL INSERT 1191-8CN-0500	1
6	275429	Spring 1/4" DIA x 2 1/2" LONG	2
7	4294	CUTTER DRUM ASSEM	1
8	4297	FLANGED DRUM	1
9	4291	RETAINER PLATE	1
10	4293	CARBIDE TIPPED BLADE	1
11	275432	1/4-20 x 1/2" FILLISTER HEAD, PHILLIPS	1

4290

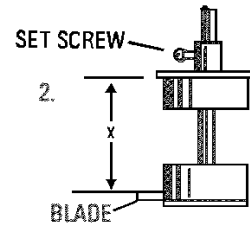
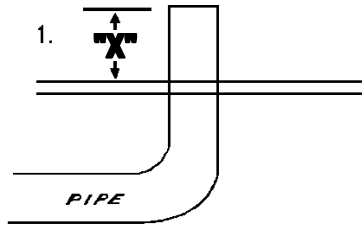


ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	3296	DRIVE SHAFT	1
2	700076	BLADE COVER	1
3	700025	GUIDE PLATE	1
4	700085	CUTTER DRUM (MACHINED)	1
5	4293	CARBIDE TIPPED BLADE	1
6	700084	DEPTH GAGE (MACHINED)	1
7	275428	5/32" DIA x 1/2" ROLL PIN	1
8	4117	1/2"-20 HEX JAM NUT	1
9	275429	Spring 1/4" DIA x 2 1/2" LONG	2
10	275427	#10-24 x 5/8" SLTD HX WSHR HD, TYPE F	7
11	275707	5/16-18 x 1" THUMBSCREW	1
12	275774	HELICOIL INSERT 1191-8CN-0500	1

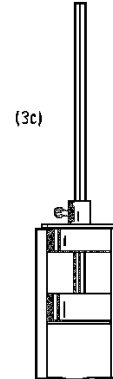
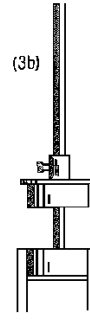
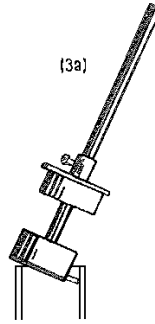
6000



1. Measure desired "X" depth.
2. Set "X" cutting depth and tighten set screw securely to avoid any change in the "X" depth while cutting.

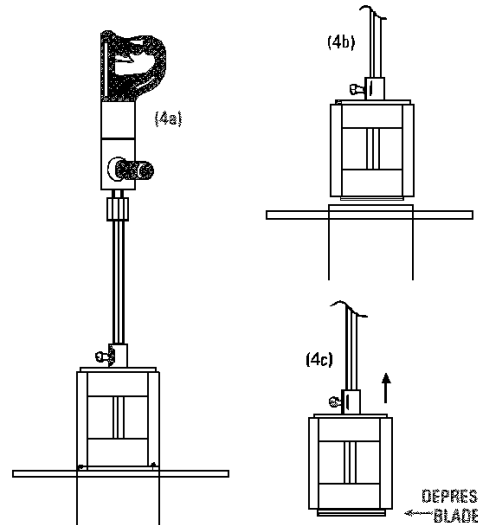


- 3a. Tip at a shallow angle so that the blade is inside of the pipe.
- 3b. Push to depress blade until blade drum will enter the pipe.
- 4a. Chuck shaft in HD 1/2" drill motor, 1/2" capacity, 350-450rpm, 4.5-6 amps. Keep flange in contact with the end of the pipe and turn on drill motor. Be sure rotation is clockwise (normal forward). The blade will self feed until the cut-off is complete.



NOTE: Hold trigger grip and side handle securely to control torque reaction.

- 4b. The cut-off portion will remain on the tool.
- 4c. Depress the blade, flush with cutter drum and pull tool out of cut-off portion of pipe.



When the blade is cutting properly, there is a noticeable torque load which will slow the drill down to about 2/3 of its no-load RPM. Under these conditions, a fast cut with very little heat will result.

If the drill is running at or near its no-load RPM, the blade is NOT cutting a positive chip and will generate excessive heat which will soften the plastic and result in a slow cut.

This can be caused by:

1. A dull blade
2. Hot chips clogging the blade

If this happens DO NOT continue running the drill at constant speed. Stop for about 30 seconds so the plastic can cool. Now operate the drill in short pulses. This will avoid excessive heat and will usually result in a positive cutting action.

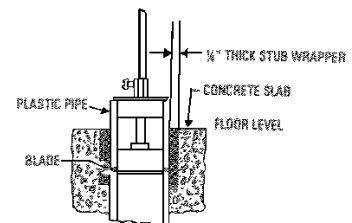
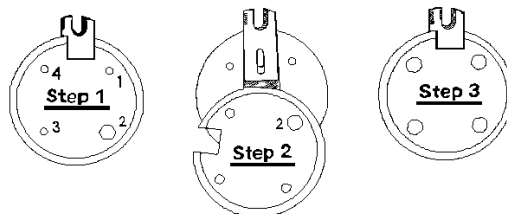
Blade replacement instructions

Step 1. Remove screws 1, 3, 4

Loosen screw 2 - 1/2 to 3/4 turn

Step 2. Swivel retainer plate counterclockwise (left) until it just clears the end of the blade, NO FURTHER, to prevent springs from popping out of tool. Lift out old blade and place new blade in the tool as show. If blade is in backwards, the tool will not cut. Lubricate the blade, blade cavity and spring cavity with powered graphite.

Step 3. Swivel retainer plate back into place, replace and tighten all four screws.



CAUTION: Do Not attempt to cut-off below floor level without a 1/2" thick, soft stub wrapper or equal clearance around the outside of the pipe. The blade will be **severely damaged** if it contacts the concrete slabs or other hard floor materials.

