

**OPERATION MANUAL**  
**WHEELER / REX 6790 (N100A)**  
**Blade type cutter**  
Ref. No. 199810

**Important**

For your own safety, best performance and a long tool life, read this Operation Manual carefully and completely before assembling and operating this unit.

Study the operation, application and potential hazards peculiar to this unit.

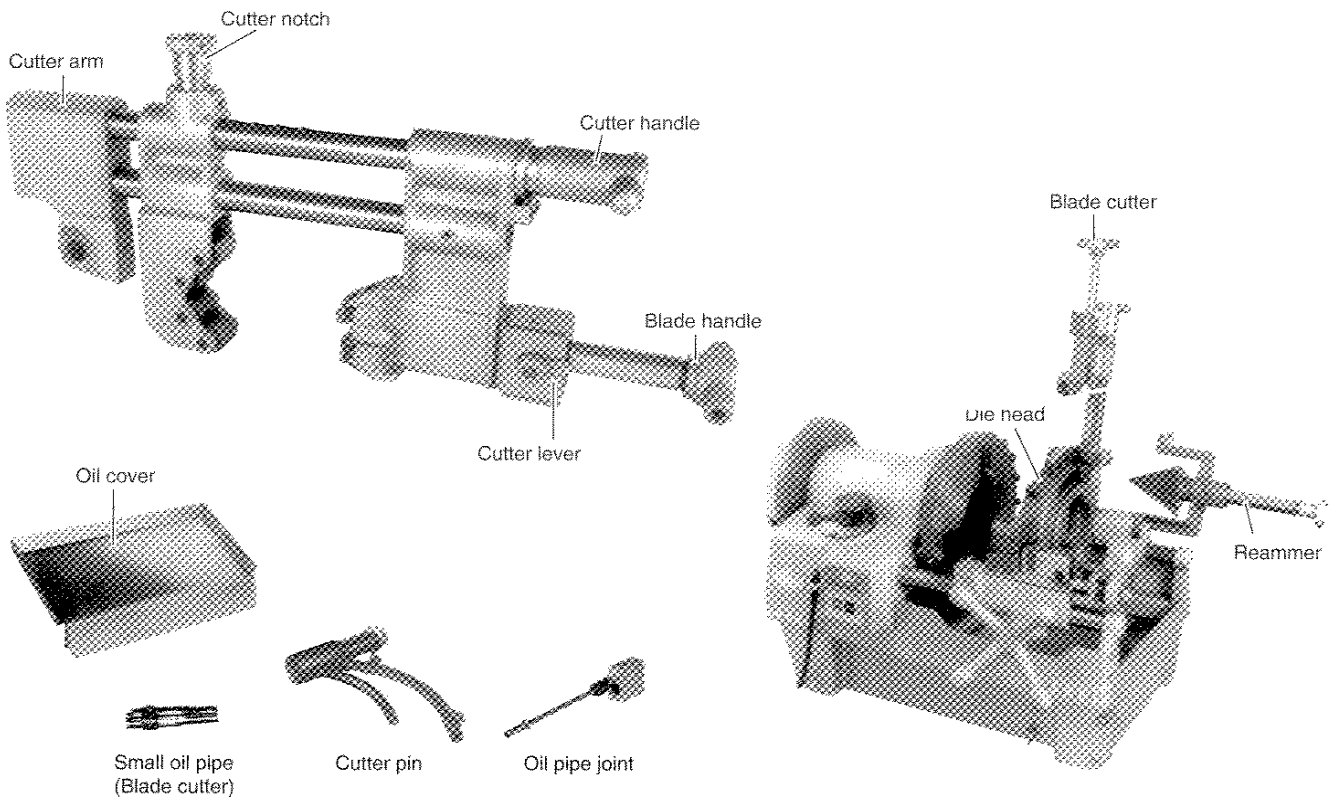
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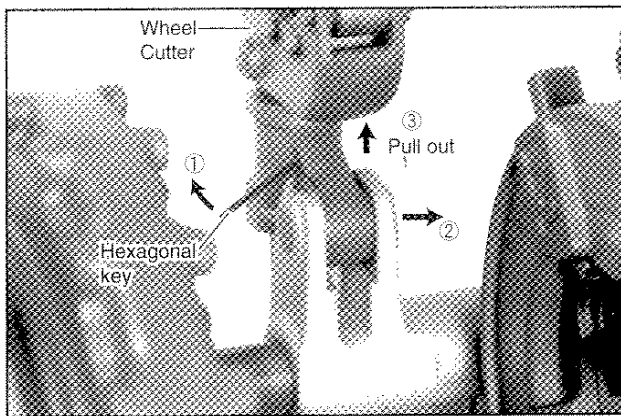
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# WHEELER / REX 6790 Blade Cutter Main Parts



1

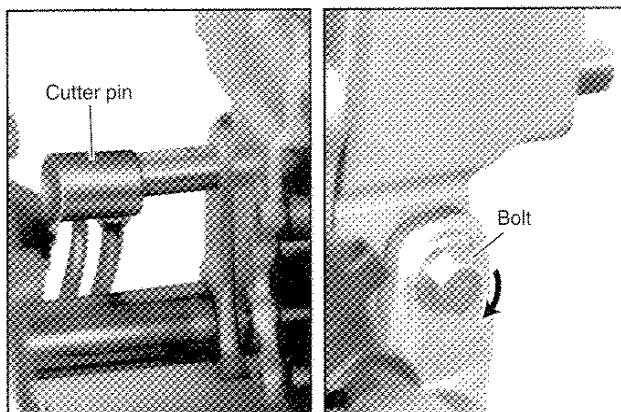
## How to Replace an Ordinary Cutter with a Blade Cutter



1. Pull out the cutter arm pin, take out the wheel-type cutter, then put in the blade cutter.

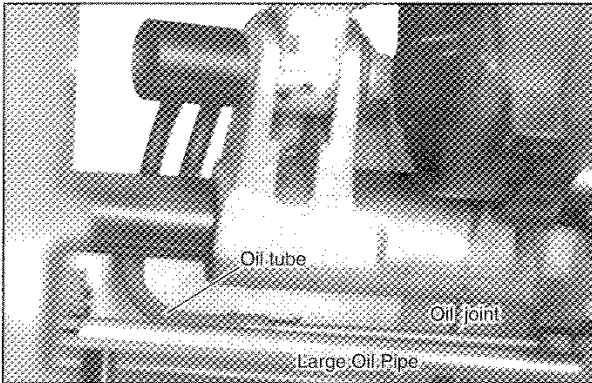
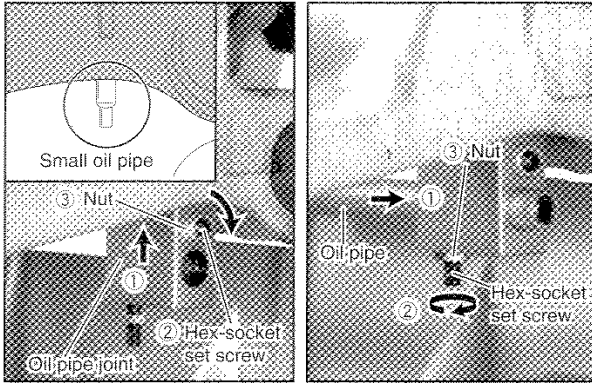
**Note:**

Mark on the cutter arm pin should be upper most.



2. Do not over-tighten the hex, head screw, as this will make the "T-shaped head" too heavy to move freely.

2



3. Loosen the hex-socket set screw screwed in the oil pipe connector, and remove the oil pipe connector from the oil pipe (small).

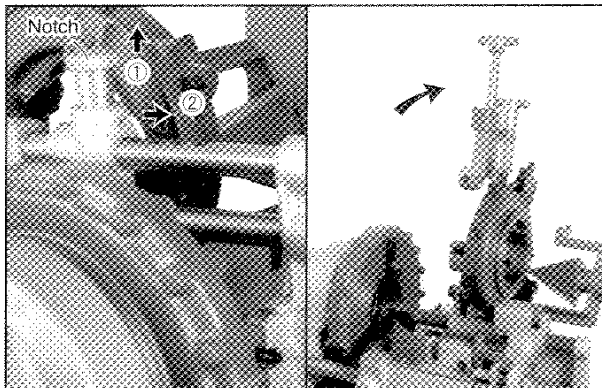
Pull out the small oil pipe (J142), then put in the small oil pipe (J248) for blade cutter.

4. Insert the oil pipe (large) into the oil joint, and fix with the hex-socket set screw.

5. Fix the oil joint for the blade type cutter with the hex-socket set screw to the oil pipe (small) attached in the carriage.

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## Pipe Cutting

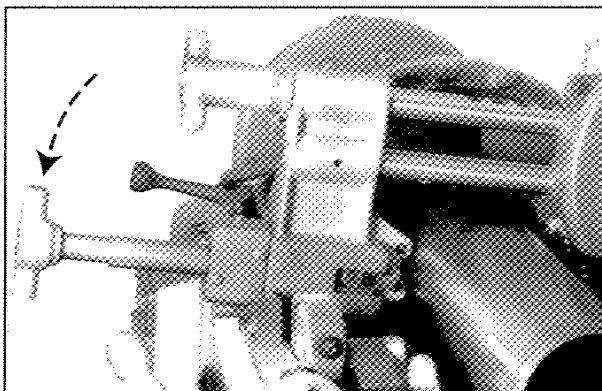


For cutting or reaming set the speed change lever to the fast (Rabbit) position.

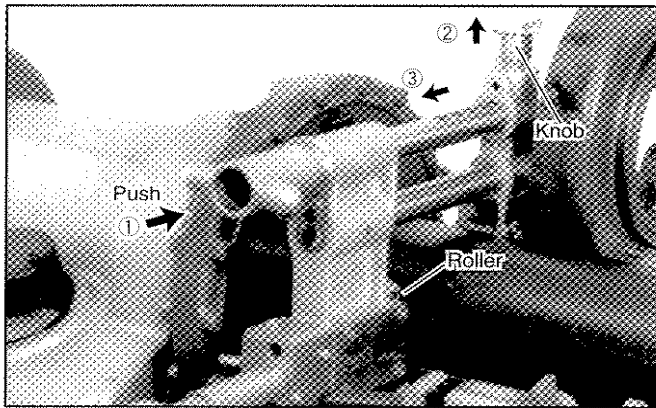
### Cutting Pipe

1. Raise the die head and reamer out of the way. Release the guide setting knob and engage in the last notch as shown in figure ①.

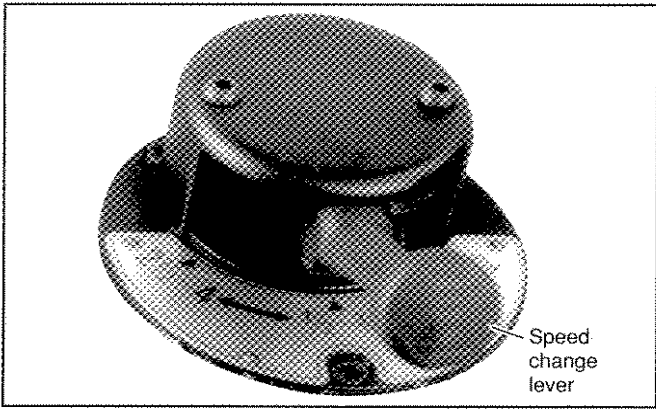
2. Check that the blade is fully opened and lower the cutter onto the pipe.



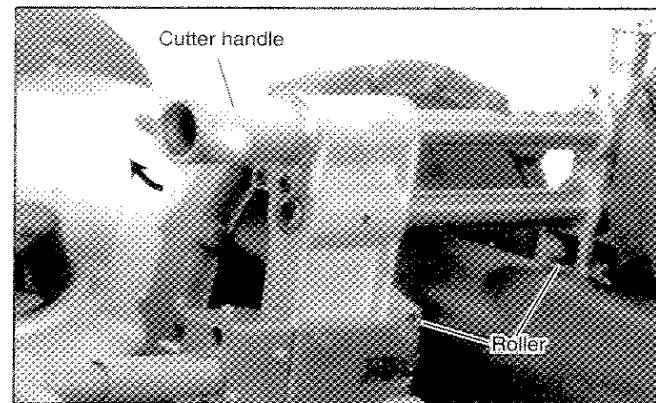
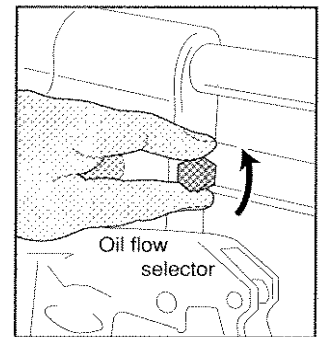
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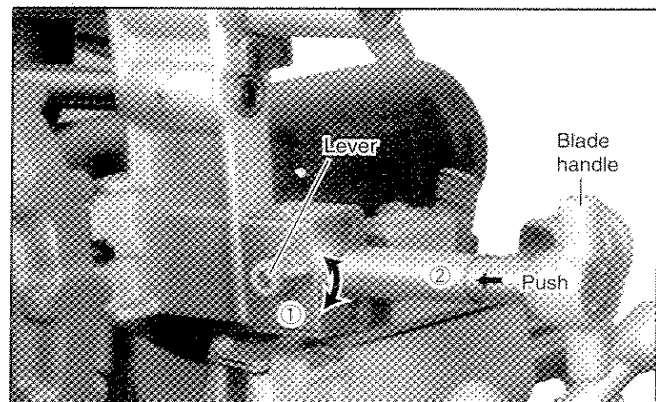
3. Push the frame to bring the rollers into contact with the pipe.  
Set the guide in the cutter support bar to match the pipe size.  
Check that the knob is firmly engaged. If the guide doesn't engage, turn the cutter handle to the left to open the cutter wider than the diameter of the pipe and reset correctly.



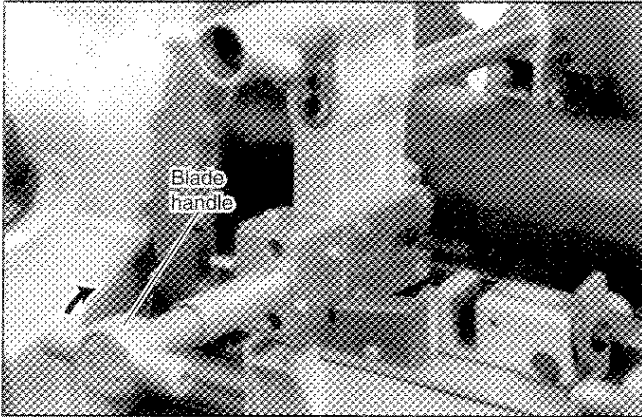
4. Switch the unit on and set the speed change lever to the " $\frac{1}{2}$ ~ $\frac{3}{4}$ " position.  
To adjustable oil flow, turn the knob in the opposite direction.



5. Tighten the cutter handle so that the rollers grip the pipe firmly.

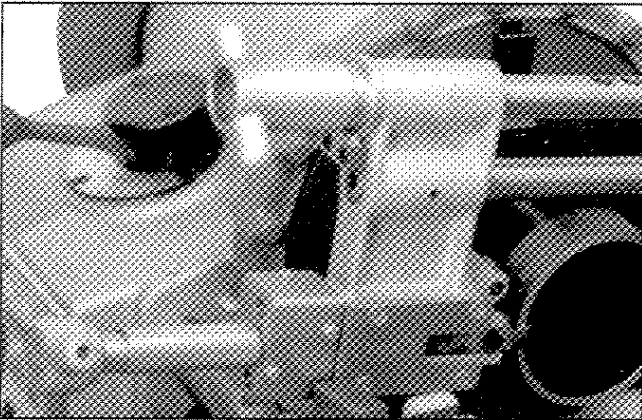


6. Depress lever until it is parallel with the blade handle.  
Keep one hand on the lever while you push the blade handle gently, until the cutter is almost touching the pipe.



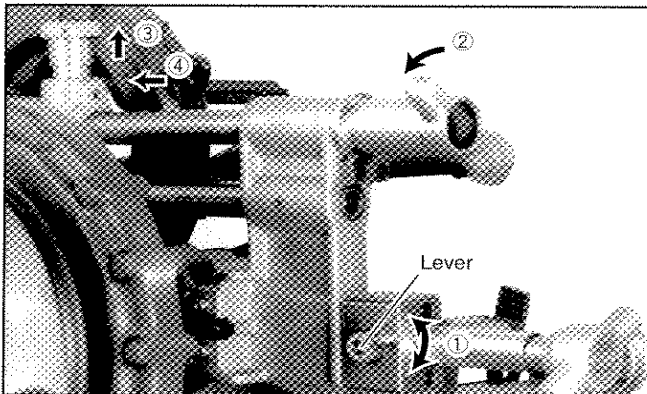
7. While the pipe is turning, turn the handle 1/4 of a revolution for every single revolution of the pipe being cut.

Continue to turn the handle 1/4 of a revolution for each subsequent revolution of the pipe being cut until the pipe is completely cut.



8. Don't be tempted to speed up advancement of the blade when the pipe is almost cut through, irregularities in the inner diameter of the pipe may damage the blade.

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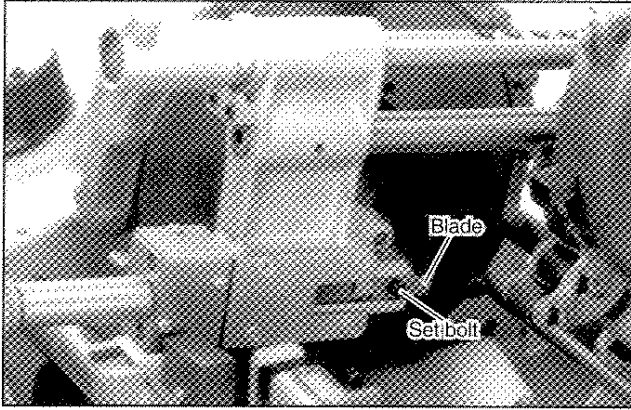


9. After pipe has been cut, depress lever, and the cutter will return to its starting position.

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## Replacing the Blade

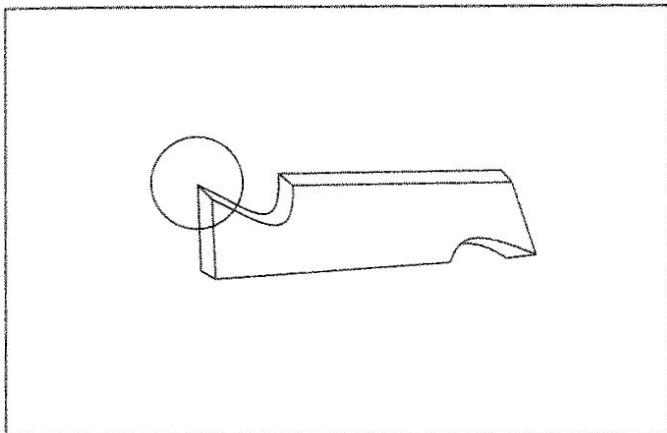
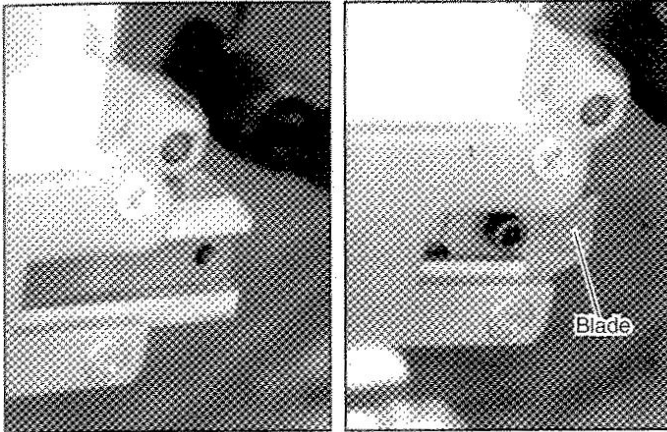
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### WARNING

Sharp blades can be dangerous.

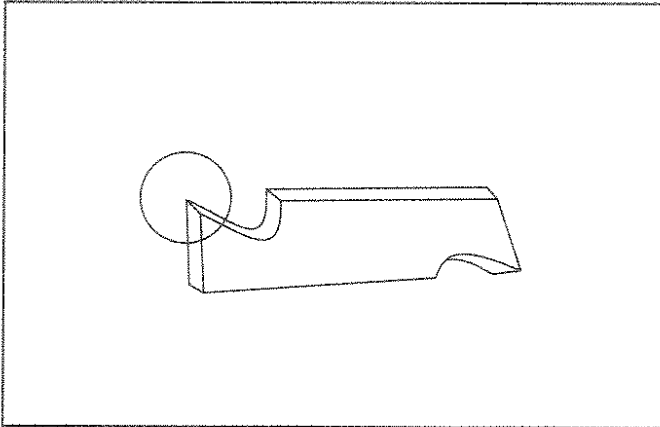
Slacken the blade set bolt and remove the blade. Insert new blade, tighten blade set bolt, and new blade is ready for use.



### NOTE

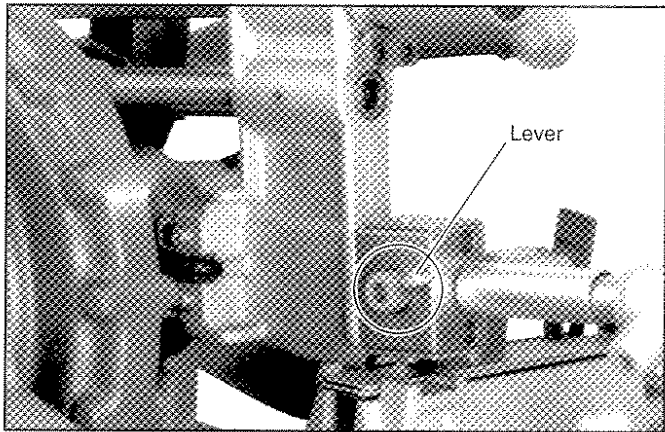
Each blade has two cutting edges, so check the other edge before replacing a used blade with a new one. When replacing a blade, be sure to insert it with the tooth facing in towards the cutter support bars.

# Reasons for Imperfect Cutting of Pipe



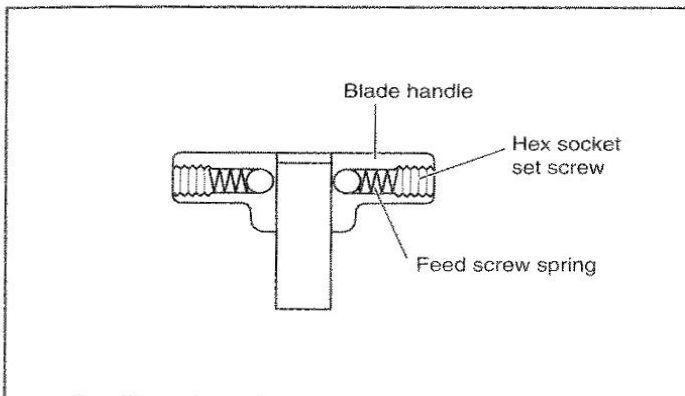
Turning of the handle does not produce a cutting of the pipe because:

1. The blade is blunt.



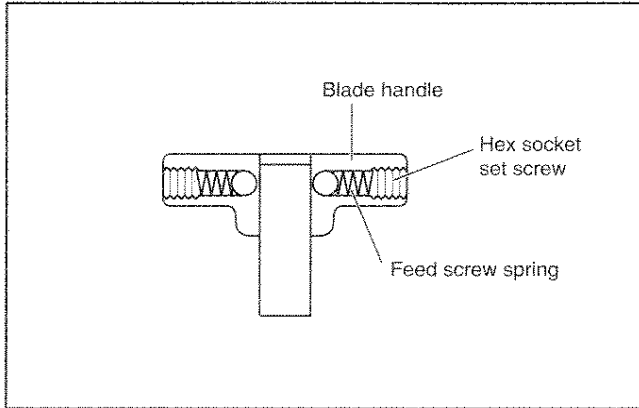
2. Lever is not in correct position.

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3. The steel ball inside the handle is out of position, causing the 'T-shaped head' to revolve whilst the 'long' part of the handle remains stationary.

## Adjustment of Handle



The handle is automatically set to move only a 1/4 of a revolution for every complete revolution of the pipe. Should the handle move less than a 1/4 of a revolution, turn the hexagonal key clockwise in the handle once or twice, and check if the handle again moves a 1/4 of a revolution.

It may be necessary to repeat this process a few times before the handle moves the correct 1/4 of a revolution.

**(Note:** Should the handle move more than a 1/4 of a revolution, turn the hexagonal key anti-clockwise in the handle once or twice, and check if the handle again moves a 1/4 of a revolution.)

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