





SD374

START THE DRIVE MOTOR AND THE TUBE CUTTER SHOULD ROTATE FREELY IN THE TUBE. THE CUTTER WHEEL SHOULD NOT BE IN CONTACT WITH THE TUBE AT THIS TIME. TO ENGAGE THE CUTTER WHEEL, GRASP THE ALUMINUM FEED WHEEL SO THAT IT DOES NOT ROTATE. THIS CAUSES THE ALUMINUM WHEEL TO TRAVEL DOWN THE LEFT HAND THREAD OF THE DRIVE FEED SCREW. THIS ACTION CAUSES THE CUTTER WHEEL CARRIER TO SLID UP THE TAPERED FEED WEDGE, CAUSING THE CUTTER WHEEL TO EXPAND. THE FEED RATE OF THE CUTTER WHEEL IS CONTROLLED BY THE OPERATOR. TO STOP THE EXPANDING OF THE CUTTER WHEEL, RELEASE THE ALUMINUM FEED WHEEL AND ALLOW IT TO ROTATE FREELY WITH THE DRIVE FEED SCREW.

AFTER THE TUBE HAS BEEN CUT OFF, STOP THE DRIVE MOTOR AND THREAD THE ALUMINUM FEED WHEEL OUT TO RETURN THE CUTTER WHEEL TO ITS MINIMUM POSITION ( THE DRIVE FEED SCREW SHOULD BE IN AS FAR AS POSSIBLE ). THIS ALLOWS THE TUBE CUTTER TO BE REMOVED FROM THE TUBE, READY TO BE INSERTED INTO ANOTHER TUBE.

NOTE : THE CUTTER WHEEL EXPANSION IS LIMITED BY AN INTERNAL FEED STOP. DO NOT USE EXCESSIVE FORCE WHEN HOLDING THE ALUMINUM FEED WHEEL STATIONARY AS THIS COULD CAUSE THE CUTTER WHEEL CARRIER TO DAMAGE THE INTERNAL FEED STOP.

#### MAINTENANCE INSTRUCTIONS :

BEFORE EACH USE, INSPECT THE DRIVE FEED SCREW THREADS TO ASSURE THAT THE ALUMINUM FEED WHEEL ROTATES FREELY.

INSPECT THE PRONG GUARD ASSEMBLY TO SEE THAT THE GUARD ROTATES FREELY.

INSPECT THE CUTTER WHEEL AND CUTTER WHEEL CARRIER TO ASSURE THAT BOTH MOVE FREELY. DULL CUTTER WHEELS SHOULD BE REPLACED. SEE THE INSTRUCTIONS BELOW.

LUBRICATE CUTTER WHEELS, CUTTER WHEEL CARRIERS, AND DRIVE FEED SCREW THREADS LIGHTLY WITH A LIGHT GRADE OIL SUCH AS WD40. LUBRICATE THE BEARING IN THE PRONG GUARD ASSEMBLY WITH A LIGHT COATING OF GREASE. WIPE ALL EXCESS LUBRICANTS OFF SO THAT DIRT WILL NOT COLLECT ON THESE PARTS.



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MONITOR THE FOLLOWING PARTS FOR NORMAL WEAR :

PRIMARY WEAR ITEMS

CUTTER WHEEL  
CUTTER WHEEL PIN

SECONDARY WEAR ITEMS

CUTTER CARRIER  
FEED WHEEL NUT  
FEED WEDGE

INSTRUCTIONS FOR REPLACING THE CUTTER WHEEL ARE AS FOLLOWS :

LOCATED ON THE FRAME, IN THE AREA BETWEEN THE PRONGS OF THE PRONG GUARD, THERE IS A SHORT BUSHING ( METAL SLEEVE ) THAT IS HELD IN PLACE BY A RETAINING RING. REMOVE THIS RETAINING RING AND SLIDE THE SHORT BUSHING TO THE REAR OF THE CUTTER ( AWAY FROM THE CUTTER WHEEL ). THIS WILL EXPOSE THE STOP PIN WHICH SHOULD BE REMOVED. BY PULLING THE DRIVE FEED SCREW BACK, THE CUTTER CARRIER WILL RISE UP AND OUT OF THE FRAME. REMOVE THE CUTTER WHEEL PIN FROM THE CUTTER CARRIER AND REPLACE THE CUTTER WHEEL AND CUTTER WHEEL PIN. ( NOTE THAT THE CUTTER WHEEL PIN IS A PRESS FIT AND MUST BE DRIVEN OUT OF THE CUTTER CARRIER ) LOWER THE CUTTER CARRIER BACK INTO THE FRAME, MAKING CERTAIN THAT THE LIP OF THE CUTTER CARRIER ENGAGES IN THE SLOT OF THE FEED WEDGE WHEN YOU PUSH THE DRIVE FEED SCREW FORWARD. REPLACE THE STOP PIN, REPOSITION THE SHORT BUSHING, AND REFASTEN THE RETAINING RING INTO THE SLOT IN THE FRAME. MAKE SURE ALL PARTS MOVE FREELY BEFORE USING.

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