PIPE TOOLS & VISES
SINCE 1896

HERRAMENTAS PARA TUBOS Y PRENSAS
DESDE 1896

ROHRWERKZEUGE & SCHRAUBSTÖCKE
SEIT 1896

OUTILLAGE POUR TUBES ET ÉTAUX
DEPUIS 1896

Operating Instructions

Low Clearance Rotary™ Cutters

For cutting steel, ductile iron and cast iron pipe

Cortatubo Rotary™

Para cortar en espacios reducidos

Rotary™ Rotationsschneider

für beengte Einsatzbereiche

Coupes tuyaux Rotary™ pour espaces restreints

Pour découper les tuyaux d'acier, de fonte et de fonte ductile.

Catalog No.	Item Code	Pipe Capacity			Length		Weight	
		Steel	Cast Iron & Ductile	Actual Ø mm	in	mm	lbs	kg
LCRC8S	03309	6" - 8"		159 - 246	58	1473	52	24
LCRC8I	03308		6" - 8"	159 - 246	58	1473	52	24
LCRC12S	03313	10" - 14"		266 - 358	61	1549	60	27
LCRC12I	03312		10" - 12"	266 - 358	61	1549	60	27
LCRC16S	03317	16" - 18"		368 - 462	66	1664	72	33
LCRC16I	03316		14" - 16"	368 - 462	66	1664	72	33

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Operating Instructions

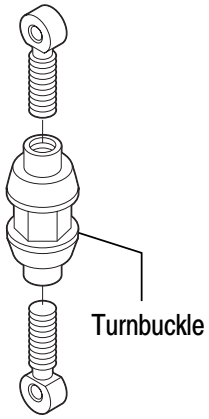
First, inspect the wheels to insure they suit the type of pipe that is to be cut. The cutter wheel chart (Fig. 1) identifies the proper wheel for each application.

Fig. 1

CUTTER WHEEL CHART FOR LOW CLEARANCE ROTARY™ CUTTERS

Item Code	Cat. No.	Std. Pkg.	Reed Cutter	Blade Exposure Inches	MM	Application
03530	RCS8-36	4	LCRC8; LCRC12; LCRC16; RC20; RC24; RC30; RC36	0.635	16.1	Steel; Stainless Steel
03535	RCI8-30	4	LCRC8; LCRC12; LCRC16; RC20; RC24; RC30; RC36	0.500	12.7	Cast Iron; Ductile Iron (manual)
03545	RCDX	4	LCRC8; LCRC12; LCRC16; RC20; RC24; RC30; RC36	0.531	13.5	Heavy Cast Iron; Ductile Iron (power)
03550	RCX	4	LCRC8; LCRC12; LCRC16; RC20; RC24; RC30; RC36	0.800	20.3	Heavy Wall Steel; Stainless Steel

Make sure bolted rod ends are in proper location for size of pipe to be cut. Turnbuckles should be unscrewed equally until the rod end eye center is about 2 1/4" (57 mm) from the end of the turnbuckles. Disconnect a release pin and fit cutter over pipe to be cut. (You may have to disconnect both pins if clearance around the pipe is minimal.) Connect release pin through yoke section and rod end in proper location and place the spring loaded guide section of the cutter on top of the pipe. Hand tighten both turnbuckles evenly until all 4 wheels touch the pipe. Tighten the turnbuckles every 1/2 revolution of the cutter. The turnbuckles may also be used to pull the cutter around the pipe.



NOTE: Tighten the turnbuckles as tight as possible while still being able to pull the cutter around the pipe. (Handle leverage allows easy tightening - 1/2 revolution of the turnbuckle should provide sufficient tension.)

USE LUBRICATING OIL: It will take less effort and prolong the life of the wheels and wheel pins.

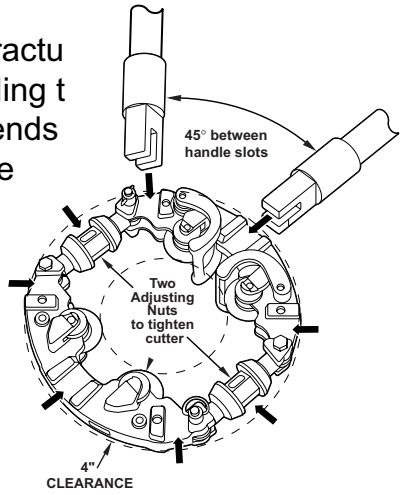
BADLY CRUSTED AND RUST SCALED PIPE: Remove the rust and scale fr m the area to be cut with a Reed Descaler (Fig. 2). This will help save cutt r wheels and cutting time; and helps square the cutter on the pipe to insu e trackin

Fig. 2

PIPE DESCALERS

Cat. No.	Item Code	Pipe Capacity		Length	
DS12	08000	3 - 12 in	70 - 300 mm	32 in	810 mm
DS36	08006	3 - 36 in	70 - 910 mm	44 in	1110 mm
DS12B	08008	3 - 12 in	70 - 300 mm	45 in	1143 mm
DS36B	08010	12 - 36 in	300 - 910 mm	72 in	1829 mm

HELPFUL HINTS: While cast and ductile iron pipe will fractu e along the cut line after penetrating part way, continue feeding t e wheels in to make sure the cut is completed. Ductile iron tends o work harden. Continuous feeding and maximum pressure he p prevent this. In the event that cutter wheels for iron are n t available, cutter wheels for steel pipe can be substituted f r use on ductile iron pipe. Be advised that steel cutter whee s may wear faster



CAUTION: Always wear proper eye protection when using this or any hand tool

Instrucciones De Operación:

Inspeccione las cuchillas (discos) para comprobar que corresponden al tipo de tubo que se va a cortar. Las cuchillas (discos) están marcadas tal como en el cuadro de cuchillas (discos) de la otra cara de esta tarjeta.

Figura 1

PARA CORTAR TUBOS DE ACERO, HIERRO MALEABLE Y HIERRO COLADO

Código del Art.	No. de Catálogo	Paquete estándar	Cortatubos Reed	Exposición de cuchilla Pulg.	MM	Uso
03530	RCS8-36	4	LCRC8; LCRC12; LCRC16; RC20; RC24; RC30; RC36	0.635	16.1	Steel; Stainless Steel
03535	RCI8-30	4	LCRC8; LCRC12; LCRC16; RC20; RC24; RC30; RC36	0.500	12.7	Cast Iron; Ductile Iron (manual)
03545	RCDX	4	LCRC8; LCRC12; LCRC16; RC20; RC24; RC30; RC36	0.531	13.5	Heavy Cast Iron; Ductile Iron (power)
03550	RCX	4	LCRC8; LCRC12; LCRC16; RC20; RC24; RC30; RC36	0.800	20.3	Heavy Wall Steel; Stainless Steel

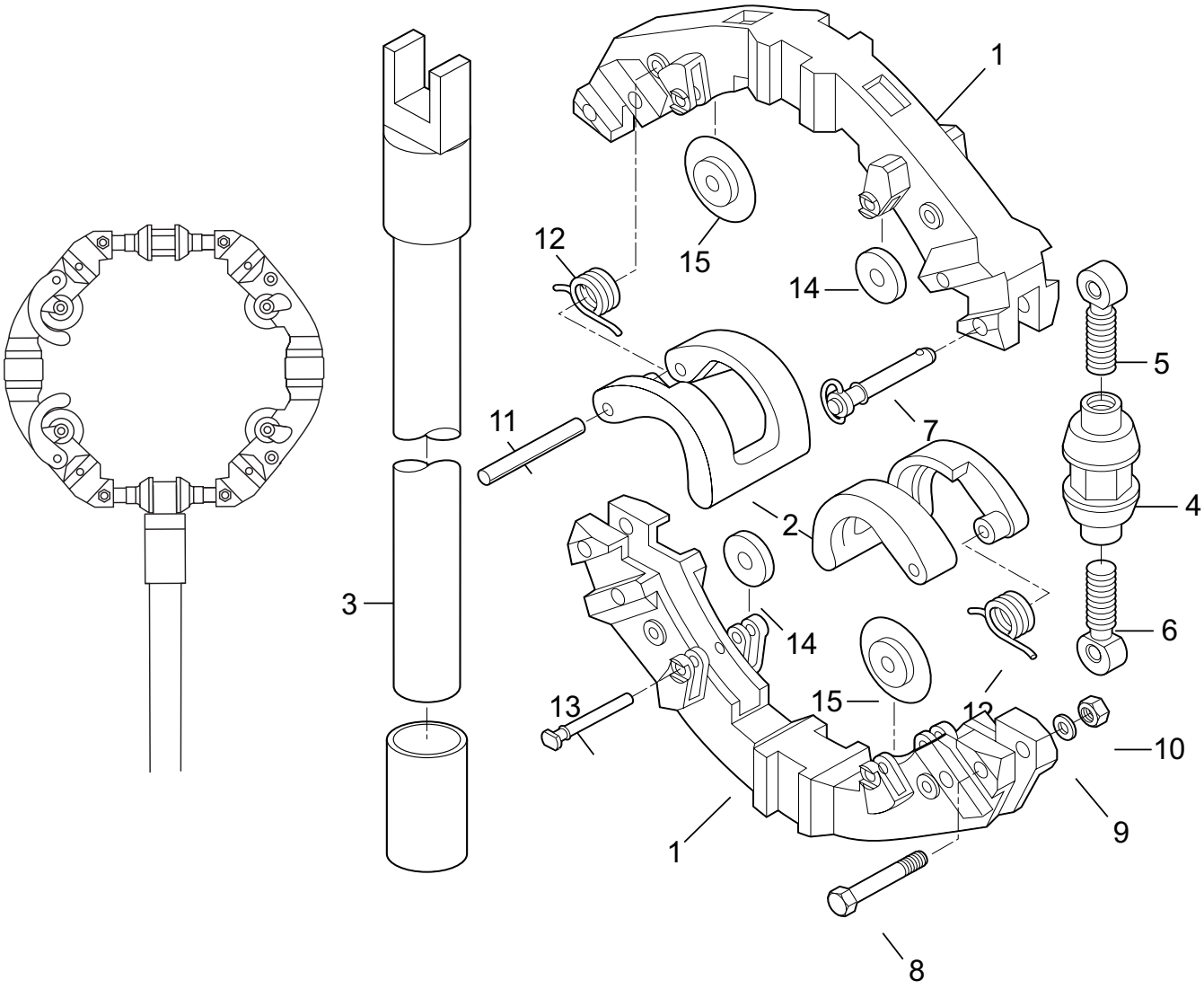
Compruebe que los pernos enroscados se encuentran en la posición correcta para el tamaño del tubo que se va a cortar. Se deben desenroscar los pernos para que los hilos de la rosca queden por igual y hasta que el centro del ojal del extremo del perno se encuentre a unos 57 mm (2 1/4") de la punta de los tensores.

Desconecte un pasador de desenganche y acomode el cortatubo encima del tubo- siempre colocando la porción del cortatubo que contiene la guía de resorte en la parte superior del tubo. Apriete los pernos con la mano por igual, asegurandose que las cuchillas (discos) hagan contacto con el tubo. Dé una vuelta al cortatubo para revisar el alineamiento de las cuchillas (discos).

Para realizar el corte, acomode la parte inferior de la manija del cortatubo para ubicar las muescas en cada una de las secciones del cortatubo, girando el cortatubo alrededor del tubo. Cada vez que llegue a uno de los pernos, aprietelo una media (1/2) revolución (¡que sea a la izquierda ó a la derecha, según la manera que lo apriete y NO lo afloje!). Una vez apretado, se puede usar los pernos para dar vuelta al cortatubo alrededor del tubo.

Low Clearance Rotary™ Cutters

Replacement Parts



Parts List

Ref. No.	Description		LCRC8 Item Code	LCRC8 Qty. Used	LCRC12 Item Code	LCRC12 Qty. Used	LCRC16 Item Code	LCRC16 Qty. Used
1	Yoke	Sabot	93094	2	93095	2	93096	2
2	Guide	Guide	93165	2	93166	2	93166	2
3	Handle Assembly	Manivelle	93176	1	93176	1	93176	1
4	Turnbuckle	Boucle de serrage	93169	2	93169	2	93169	2
5	Rod End Right Hand	Tige filetée (pas à droite)	93172	2	93172	2	93172	2
6	Rod End Left Hand	Tige filetée (pas à gauche)	93173	2	93173	2	93173	2
7	Release Pin	Cheville de dégagement	40147	2	40147	2	40147	2
8	Cap Screw	Boulon fileté	30091	2	30091	2	30091	2
9	Lock Washer	Rondelle d'arrêt	30093	2	30093	2	30093	2
10	Hex Nut	Écrou hexagonal	30150	2	30150	2	30150	2
11	Guide Pin	Cheville de guidage	30090	2	30090	2	30090	2
12	Guide Spring	Ressort de guidage	40321	2	40151	2	40340	2
13	Wheel Pin Assembly	Cheville de molette complète	93200	4	93200	4	93200	4
14	Roller	Disque	93220	8	93220	8	93220	8
15	Cutter Wheel	Molette	See cutter wheel reference chart in catalog or price list.					

Voir le tableau de référence des molettes dans le catalogue ou la liste de prix.