



LOW CLEARANCE ROTARY CUTTER

MODEL: H14S
OPERATION MANUAL



WARNING!

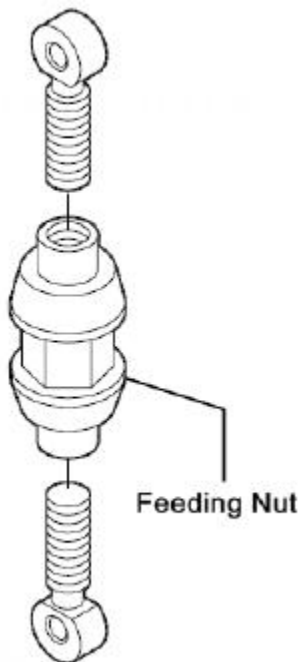
Read this Operator's Manual carefully before using this tool. Failure to understand and follow the contents of this manual may result in electrical shock, fire and/or serious personal injury.

Operating Instructions

First, inspect the wheels to insure they suit the type of pipe that is to be cut.

Make sure bolted rod ends are in proper location for size of pipe to be cut. Feeding Nut should be unscrewed equally until the rod end eye center is about 2 1/4" (57 mm) from the end of the feeding nut.

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 feeding nuts evenly until all 4 wheels touch the pipe. Tighten the feeding nuts every 1/2 revolution of the cutter. The feeding nuts may also be used to pull the cutter around the pipe.

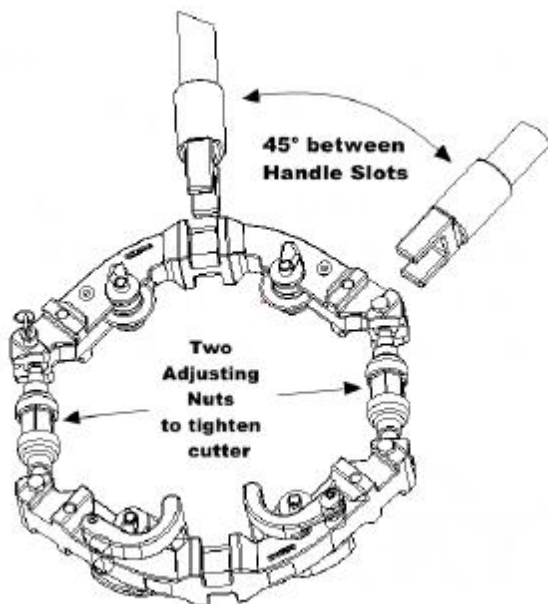


NOTE: Tighten the feeding nuts as tight as possible while still being able to pull the cutter around the pipe. (Handle leverage allows easy tightening - 1/2 revolution of the feeding nut should provide sufficient tension.)

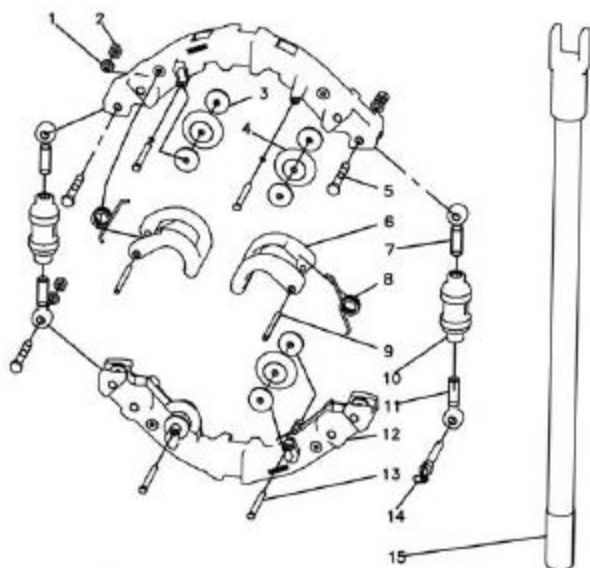
USE LUBRICATING OIL: It will take less effort and prolong the life of the wheels and wheel pins.

BADLY CRUSTED AND RUST SCALED PIPE: Remove the rust and scale from the area to be cut. This will help save cutter wheels and cutting time; and helps square the cutter on the pipe to insure tracking.

HELPFUL HINTS: While cast and ductile iron pipe will fracture along the cut line after penetrating part way, continue feeding the wheels in to make sure the cut is completed. Ductile iron tends to work harden. Continuous feeding and maximum pressure help prevent this. In the event that cutter wheels for iron are not available, cutter wheels for steel pipe can be substituted for use on ductile iron pipe. Be advised that steel cutter wheels may wear faster



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



Spare Parts List

S/N	Ref. No.	Description	QTY
1	09420	washer (3)	3
2	09361	Hex nut (3)	3
3	89413	Roller (8)	8
4	89419	cutter wheel (4)	4
5	09020	bolt (3)	3
6	89423	guide (2)	2
7	89417	right-hand bolt (2)	2
8	89411	guide spring (2)	2
9	03032	heavy-duty guide pin (2)	2
10	89421	feeding nut (2)	2
11	89415	left-hand bolt (2)	2
12	89425	yoke (2)	2
13	89490	wheel pin complete (4)	4
14	89491	yoke pin	2
15	89492	handle complete	1



Hinged Pipe Cutter

MODEL: H2S/ H4S / H6S / H8S



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Hinged Pipe Cutter Operation Manual

Overview

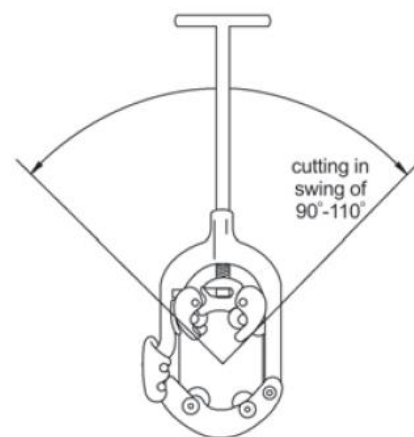
Hinged pipe cutters are suitable for field construction and maintenance for chemical and petroleum industries pipeline.

Operation Instructions

1. Choose the cutter wheel for the right pipe application: steel, cast iron, stainless steel etc.
2. Turn handle to open cutter enough to accommodate the size of pipe to be cut.
3. Place cutter around pipe with spring-loaded guides on top. Connect lower yo

ke by pushing upward to locked position. Turn the cutter handle until the wheels are uniformly touching the pipe.

4. Begin to cut the pipe by moving the entire cutter in a back and forth motion that constitutes a 90 – 110 degree swing.



5. Check to make sure that the wheels are tracking uniformly. If so, tighten the handle one-half turn each time that you bring the cutter handle back toward yourself.

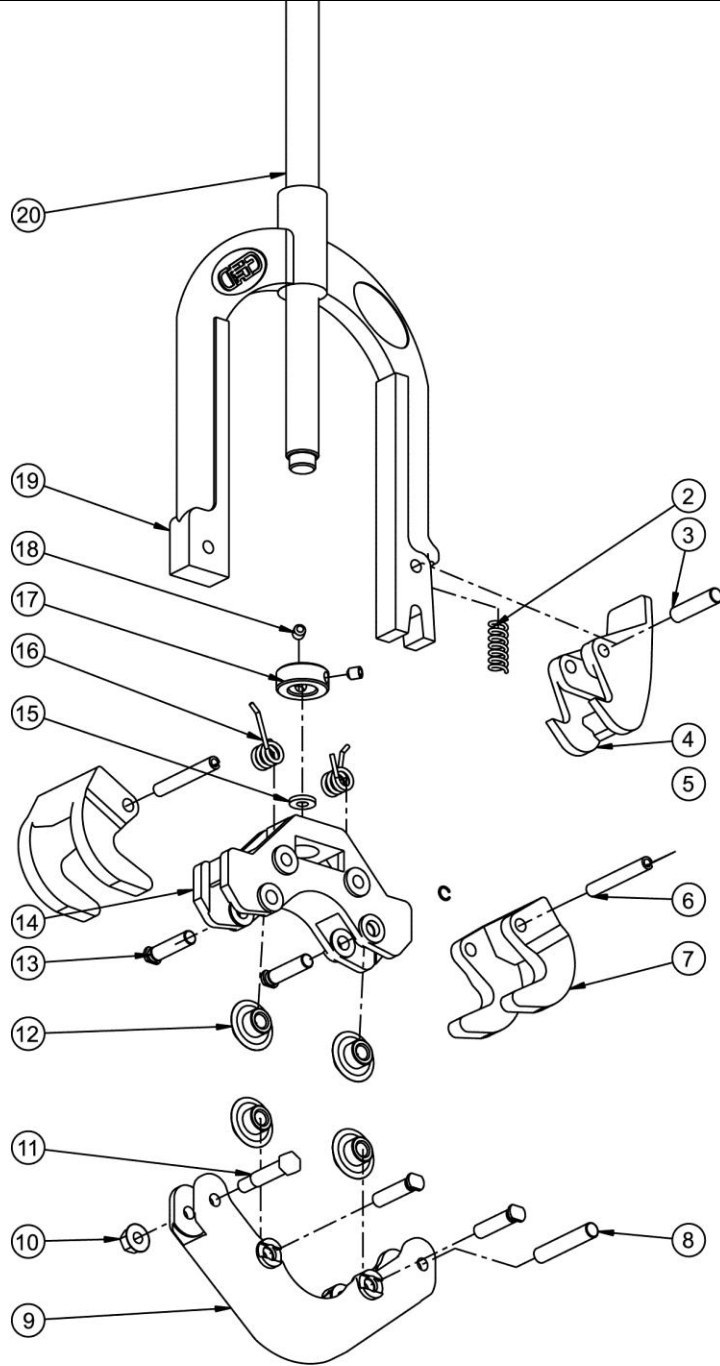
6. Complete the cut by maintaining pressure on the cutter wheels as you continue to swing the cutter in a back and forth motion.

WARNING: DO NOT STOP FOR ANY SIGNIFICANT AMOUNT OF TIME IN THE MIDDLE OF A CUT! THE CUTTING ACTION GENERATES HEAT ON THE PIPE. UPON COOLING, THE WHEELS MAY BECOME WEDGED IN THE TRACK. THIS IS ESPECIALLY TRUE FOR DUCTILE IRON PIPE.

Use Lubricating Oil: It will take less effort and prolong the life of the cutter wheels and pins. DO NOT use cutting oil.

BADLY CRUSTED AND RUST SCALED PIPE: To remove the rust and scale from the area to be cut. it will help save cutter wheels and cutting time; and will help square the cutter on the pipe to insure tracking.

Item. No.	Pipe Style	MAX Wall Thickness	Pipe Size	Net Weight
H2S	Steel Pipe	6mm	1"-2 1/2"	3.1kg
H4S	Steel Pipe	6mm	2"-4"	6.4kg
H6S	Steel Pipe	7mm	4"-6"	8.5kg
H8S	Steel Pipe	8mm	6"-8"	11kg



Spare Parts List:

S/N	DESC	Item No.for H2S	Item No.for H4S	Item No.for H6S	Item No.for H8S	QTY.
1	handle grips		41902016	41902017	41902017	2
2	latch spring	40501022	50702031	50702031	50702031	1
3	latch pin	40402053	40402038	40402038	40402041	1
4	jaw	40905036	40905003	40905006	40905006	1
5	ring	50705007	50705007	50705008	50705008	1
6	guide pin 8*55	D8×55	D8×55	D10×60	D10×60	2
7	guide	40905037	40905004	40905007	40905007	2
8	lower yoke pin	40402053	40402039	40402039	40402039	1
9	lower yoke	40304056	40304043	40304046	40304050	1
10	locknut M8	M8	M8	M8	M8	1
11	hinge bolt	M8×45	M8×45	M8×45	M8×45	1
12	cutter wheel	40601026	40601014	40601017	40601020	4
13	wheel pin	40403017	40403017	40402040	40402040	4
14	crosshead	40304057	40304044	40304047	40304050	1
15	thrust washer	40403056	40401070	40403018	40402041	1
16	guide spring	40503004	50705007	50703005	50703005	2
17	crosshead locknut	40402053	40905005	40402040	40403019	1
18	set screws	M6×6	M8×10	M8×10	M8×10	2
19	upper yoke	40304056	40304042	40304045	40304048	1
20	screw handle	30201014	30201012	30201015	30201016	1

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