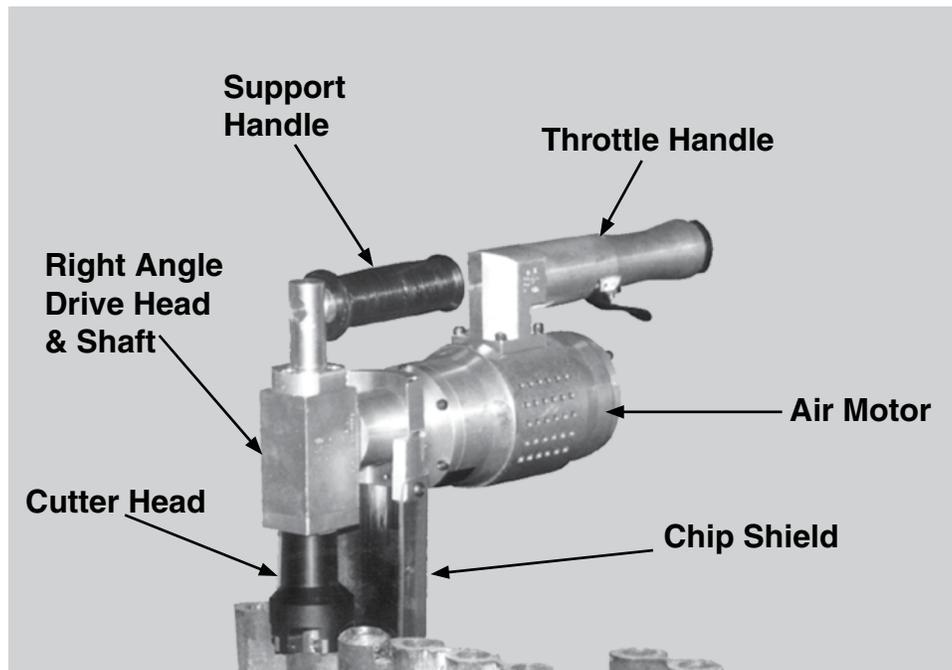


Read Thoroughly and Understand This Publication Before Attempting to Operate the Tool

DANGER! The cutting process requires sharp, exposed cutters and blades rotating at very high speeds. Keep hands and clothing away from the rotating head and blades at all times. Hot metal chips are produced. EYE, EAR, HAND PROTECTION and other PROTECTIVE CLOTHING MUST BE WORN AT ALL TIMES.



HAND HELD APPLICATIONS

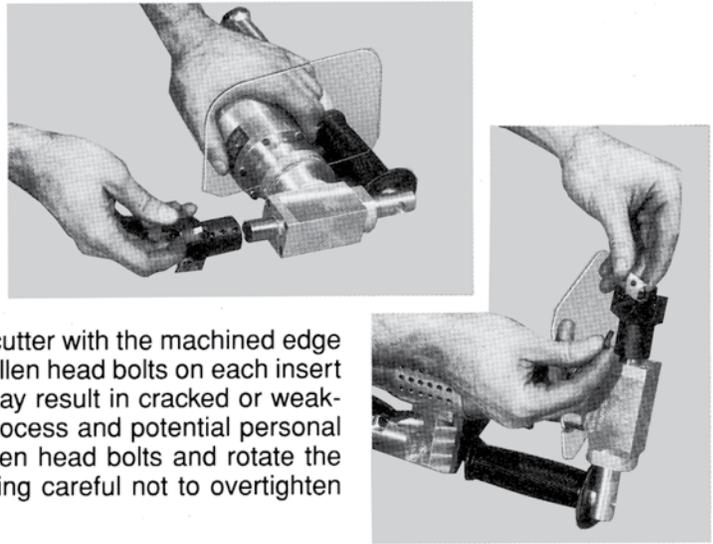


Three types of tube cutters are available - O.D. beveling, water wall membrane removal and an O.D. wall cleaner. All of the cutters are available for tube sizes ranging from 1.25" to 3.0" (31.8 mm to 76.2 mm) O.D. in .250" (6.3 mm) increments. The tube size is stamped on the cutter.

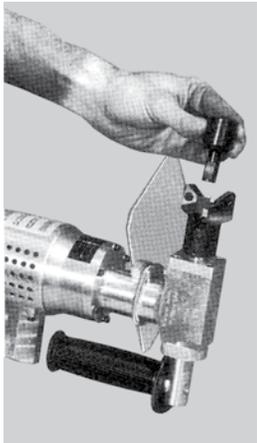
CUTTER HEAD AND CARBIDE INSERT ASSEMBLY

Select the appropriate type and size of cutter for the tube and application. Slide the cutter head onto the drive shaft, being careful that the rectangular keyway is in position on the shaft so there is no keyway showing above the cutter head and the shaft touches the bottom of the cutter head hole. Tighten all allen head bolts completely.

All of the high speed cutter heads use carbide inserts. Each insert has multiple cutting edges. Install the insert onto the cutter with the machined edge of the insert facing the direction of the rotation. Tighten the allen head bolts on each insert securely. **WARNING:** Overtightening the allen head bolts may result in cracked or weakened inserts, which may cause failure during the cutting process and potential personal injury. When the cutting edges become dull, loosen the allen head bolts and rotate the insert to a fresh edge. Re-tighten the allen head bolts, being careful not to overtighten them.



PILOT ASSEMBLY

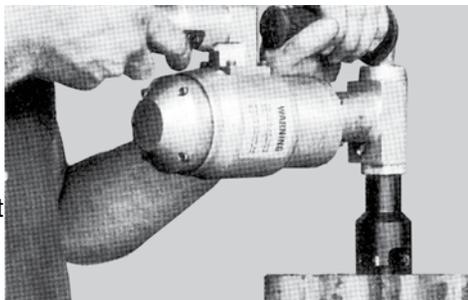


A centering pilot must be used for both accuracy and safety. Pilots are available from .5" to 3.0" (12.7mm to 76.2 mm) diameters in .020" (.508 mm) increments. The pilot size is stamped on the end. Select a pilot size that fits comfortably inside the tube while allowing it to turn freely. Approximately .010" (.254 mm) clearance is recommended. Insert the stem into the cutter head and tighten all allen head bolts securely.

HAND HELD OPERATION

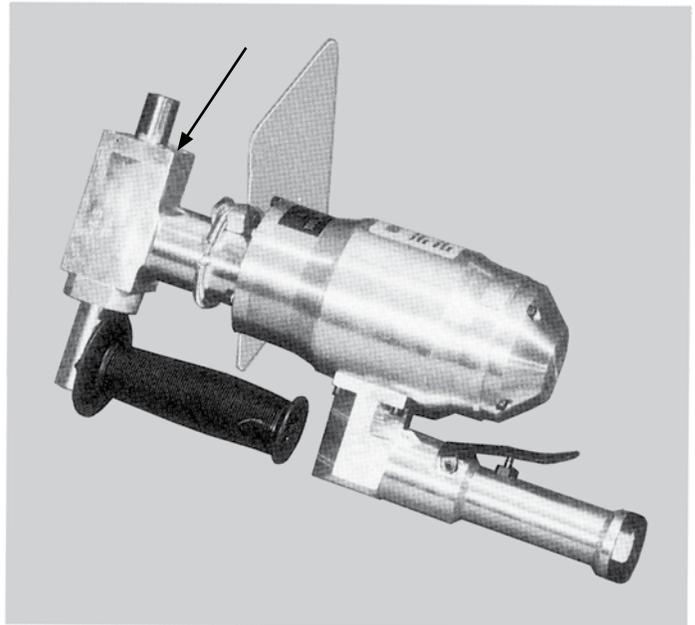
Attach a 1/2" (12.7mm) air hose to the throttle handle. An approved air lubricator and filter must be used.

Holding the tool firmly with one hand on the support handle and the other on the throttle handle, place the pilot into the tube with the inserts NOT touching the tube



end. Disengage the throttle lock and squeeze the throttle fully. **ENTER THE WORK SLOWLY!** Jamming the inserts into the tube abruptly will cause insert damage which will result in poor cutting or complete insert destruction. This may also become a personal injury hazard. Once started, keep constant pressure on the cutter until the desired cut is achieved.

MAINTENANCE



The only regular maintenance required is the addition of a quality lithium based gear grease approximately every 40 hours of operation. If the cutter is still on the drive shaft, remove it. Remove the four socket head cap screws (#25 on the parts page). Remove both the bearing cap (#24) and, then, the main shaft/gear (#26). Apply a liberal amount of grease to the gear. Reassemble ensuring that the four socket head cap screws are securely tightened.

H&S
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