

LUBRICATION

No lubrication is needed and the cutter parts should not be oiled. Dry graphite occasionally applied to the moving parts will assure long life and easy operation.

SAFETY PROCEDURES

OPERATE TOOL UNDER OSHA AND OTHER APPLICABLE SAFETY STANDARDS.

Figure 2

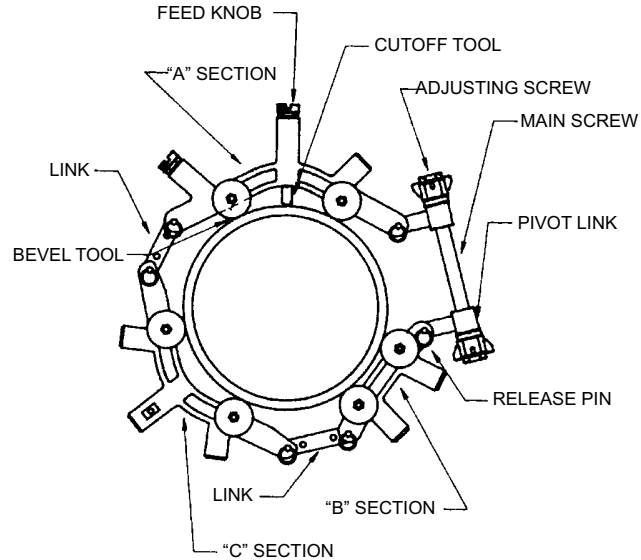


Figure 3

NOMINAL PIPE SIZE (mm)	CUTTER SECTIONS	PIVOT LINK HOLES
6" (160)	A & C	Inner holes
8" (200)	A & C	Outer holes
10" (250)	A, B & C	Inner holes
12" (315)	A, B & C	Outer holes
14" (355)	D* & 2 - C's	1 inner, 1 outer
15" (380)	D & 2 - C's	Outer holes
16" (400)	D & 2 - C's	Outer holes
18" (450)	D, B & 2 - C's	1 inner, 2 outer
20" (500)	D & 3 - C's	2 inner, 1 outer
22" (560)	D & 3 - C's	Outer holes
24" (600)	D, B & 3 - C's	3 inner, 1 outer
27" (700)	D & 4 - C's	2 inner, 2 outer
28" (800)	D & 4 - C's	Outer holes

* Note that for beveling over 12" diameter plastic pipe, the "D" unit, which has the bevel tool-holder at a different angle from the "A" unit, must be used. The "A" unit can be used as a substitute for the "C" unit on larger than 12" diameter pipe.

I-698-13



PIPE TOOLS & VISES SINCE 1896



PLAS OWNER'S MANUAL

CUTTER/BEVELER FOR LARGE DIAMETER PLASTIC PIPE

CAPACITY

- The basic cutter (Figure 2) can be expanded to cut and bevel plastic pipe up to 28" (800 mm) diameter.
- The maximum wall thickness the PLAS will cut is 2" (50 mm).

REED MANUFACTURING COMPANY

1425 WEST EIGHTH ST. ERIE, PA 16502 USA

PHONE: 800-666-3691 OR 814-452-3691 FAX: 800-456-1697 OR 814-455-1697

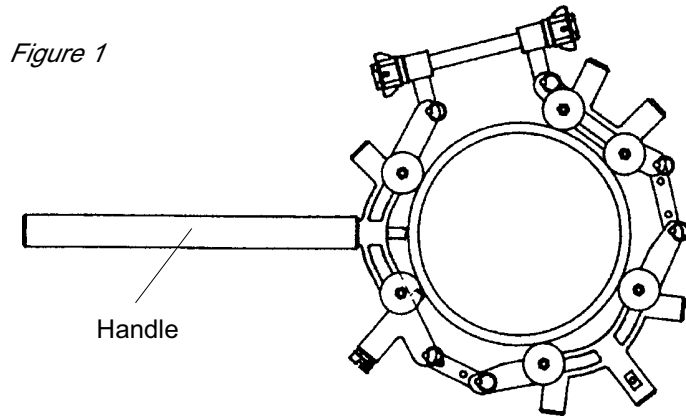
IMPORTANT NOTE

The cutter is equipped with a carbide cut-off tool. For this reason, the cutter must be rotated only in the direction indicated by the arrow. If the cutter is turned backward, the carbide tip may be broken.

OPERATING INSTRUCTIONS

1. The pipe to be cut should be solidly supported and secured. For pipe up to 6", the REED R450+ TriStand is recommended. For pipes larger than 6" (150 mm), use the REED FPV20 Field Pipe Vise.
2. Retract the cutting and beveling tools as far as they will go into the cutter.
3. Set up the cutter for the diameter of pipe being cut by adding/removing "C" sections and changing connecting link holes. Figure 3 lists the proper cutting section combinations for common nominal pipe sizes.
4. If a cut is to be made near the end of an exposed pipe, the assembled cutter can simply be slipped over the end of the pipe.
5. For cuts far the end of the pipe (or in an excavated area where only a portion of the pipe is exposed), disengage one section of the cutter by removing an adjusting nut and pulling the main screw out of one of the pivot links. Place the cutter around the pipe and reassemble the cutter by engaging the main screw through the connecting link and reattaching the adjusting nut.
6. Rotate cutter so that the blade section of the cutter is on top of the pipe. Ensure that all four rollers in the blade section are in contact with the pipe.
7. With the cut-off tool lined up with the desired cut location, tighten nuts equally until cutter is snug, yet will still rotate.
8. Place the aluminum handle over a cutter lug and rotate cutter once around pipe to ensure that the cutter remains tight. If at any point during this rotation the cutter becomes loose, **at that point** tighten the adjusting nuts. The adjusting nuts are spring loaded to allow for greater out-of-round conditions.
9. Alignment Test: Ensure the cutter is aligned properly for a straight cut. Adjust the cut-off tool so it is just touching the pipe. Rotate the cutter one complete revolution, lightly scoring the pipe. After the full rotation, the cut-off tool should return to its original location, indicating that the cutter is aligned properly. If the cut-off tool does not return to its original location, adjust the cutter and repeat the alignment test.

Figure 1



10. Rotate cut-off tool knob until blade makes contact with the pipe. Rotate the cutter in the direction of the arrow by slipping the handle over a cutter lug (Figure 1) and pulling cutter around the pipe until the cutter has made one revolution. Note: The aluminum handle can be used for both rotating cutter and feeding cut-off and bevel tools.
11. Feed the cut-off tool into the pipe, tightening the cut-off tool knob 1/2 turn per revolution of cutter. Excessive turning of cut-off tool knob may damage cut-off tool.
12. Once the cut-off tool is halfway through the pipe, you can begin to bevel. To bevel plastic pipe, rotate the bevel tool knob until the tool touches the pipe. Rotate cutter one revolution to be sure bevel tool does not hit any high spots on the pipe.
13. The bevel tool knob should be rotated only 1/4 turn per one revolution of the cutter. The #4-14 Bevel Tool will produce a 15° bevel up to 5/8" long on both sides of the cut.
14. Once the desired bevel is complete, continue feeding cut-off tool until pipe is completely cut off. *NOTE: Cutting and beveling plastic pipe can be done simultaneously as long as the cut-off tool does not cut off the pipe before the bevel is complete.*

TO CHANGE CUT-OFF AND BEVEL TOOLS

Both cut-off and bevel tools can be replaced in the same manner: Rotate feed knob clockwise until tool comes out of cutter. Reverse the procedure to replace the tool. Ensure that the tools face the proper direction, cutting in the same direction as the arrows on the cast frame.

Dull cut-off tools, if not chipped or broken, can be sharpened by any machine shop that has silicon carbide or diamond wheels. Ordinary grinding wheels will not effectively grind carbide. The bevel tool, made of hardened tool steel, can be sharpened with conventional grinding equipment.