

Rigid 258 & 258XL Pipe Cutter

To prevent serious injury, proper assembly of the Pipe Cutter is required. The following procedures should be followed:

1. Connecting the hydraulic foot pump to the cutter.
 - a. Insert the male end of the quick-disconnect coupling into the female end located on the hydraulic cylinder .
 - b. The foot pump relief valve must be depressed to release any line pressure and allow insertion of the quick connector.

Failure to secure the power drive with the reaction arm will result in the rotation of the power drive.

2. Connecting the 700 Power Drive to the cutter.
 - a. Push 774 Square Drive Adapter, spline end first, squarely into power drive face gear until spring loaded adapter pawls catch securely.
 - b. Place power drive with adapter on the cutter. Power drive and adapter connect to the square drive on the cutter. Be sure power drive rests inside the reaction arm at the rear of the cutter
 - c. Hand tighten the two set screws on the 774 square drive adapter to the square drive with 5/16" allen wrench. (Provided with adapter.)

To prevent serious injury, inspect your Pipe Cutters and Power Drive. The following inspection procedures should be performed on a daily basis:

1. Make sure Power Drive is unplugged.
2. Inspect the cutter wheel to insure it is not dull, bent or damaged. Refer to the Special Procedures if it needs to be replaced.
3. Check that the cutter frame rollers are free to rotate under the pipe. Clean debris, pipe scale and dirt from rollers.
4. Insure pipe support ball transfer heads are free to move and are clean of dirt, pipe scale and debris.
5. Insure the three screws and lock washers are tight in the cutter wheel assembly.
6. Check fluid levels in the hydraulic foot pump. Insure fluid level is to the FULL MARK when the ram is fully retracted when checking level of fluid.
7. Check that cutter wheel guard is in place.
8. Inspect the power cord and plug for damage. If the plug has been modified, is missing the grounding pin or if the cord is damaged, do not use the Power Drive until the cord has been replaced.
9. Inspect the Pipe Cutter and Power Drive for any broken, missing, misaligned or binding parts as well as any other conditions which may affect the safe and normal operation of the tool. If any of these conditions are present, do not use the tool until any problem has been repaired.
10. Use tools and accessories that are specifically designed for your Power Cutter and meet the needs of your application. The correct tools and accessories allow you to do the job

successfully and safely. Accessories suitable for use with other equipment may be hazardous when used with this equipment.

11. Clean any oil, grease or dirt from all handles and controls. This reduces the risk of injury due to a tool or control slipping from your grip.

To prevent serious injury, proper set-up of the Pipe Cutter and work area is required. The following procedures should be followed to set-up the machine.

1. Locate a work area that has the following:

- Adequate lighting.
- No flammable liquids, vapors or dust that may ignite.
- Grounded electrical outlet.
- Clear path to the electrical outlet that does not contain any sources of heat or oil, sharp edges or moving parts that may damage electrical cord.
- Dry place for machine and operator. Do not use the machine while standing in water.
- Level ground. Do not use on bench or elevated surface.

2. Set-up guards or barricades to create a minimum of three (3) feet of clearance around the Pipe Cutter and workpiece. This "safety zone" prevents others from accidentally contacting the tool or workpiece and either causing the equipment to tip or becoming entangled in the rotating pipe.

3. Adjust the pivot arm holding the pipe cutter wheel to the correct pipe size (258 only). The pivot arm must be positioned for either 2 1/2" through 4" pipe or 6" through 8".

4. Position the pump behind the cutter and near the power drive so that the operator can safely control the tool and workpiece. It should allow the operator to do the following:

- Stand facing the pipe.
- Have convenient access to the power drive switch and foot pump.

Tool is designed for one person operation.

5. Plug the Power Drive into the electrical outlet making sure to position the power cord along the clear path selected earlier. If the power cord does not reach the outlet, use an extension cord in good condition. Be sure power cord is clear of the cutter wheel.

6. Check the Power Drive to insure it is operating properly.

- Depress the switch and make sure it controls the stopping of the Power Drive by releasing the switch.
- Depress and hold the switch. Inspect the moving parts for misalignment, binding, odd noises or any other unusual conditions that may affect the safe and normal operation of the tool. If such conditions are present, have the power drive serviced.
- Depress switch in the opposite direction. Check that the power drive rotates in an opposite direction

Pipe supports must be used to prevent cutter wheel damage. Failure to properly support the pipe will result in shortened wheel life.

Two (2) ball transfer head pipe supports are shipped with the 258 and 258XL Cutters. When cutting pipe in lengths of 18" or longer, additional pipe supports must be used.

1. The cutter and pipe supports must be positioned so that the pipe sections have a

tendency to fall away from the cutter blade as the pipe is cut. If the cutter wheel is pinched by the pipe, it will damage the cutter wheel.

2. Actual placement of the pipe supports will vary depending on the position of the cutter and the length of pipe.