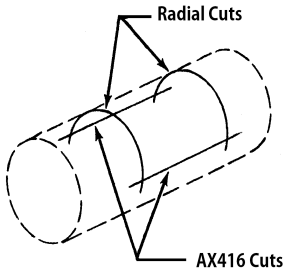
AX416 Operating Instructions

rev. 1 8/16

Step 1

Using a standard radial pipe cutter, cut two circumferential slots the length of your AX416 apart or less and approximately 180 degrees around the pipe.



Step 2

Before setting the AX416 on the pipe to be cut, make sure to retract the wheel body, using the Tee-Handle, until the cutter wheels are up in the carriage body.

Step 3

Place the AX416 on the top of the pipe, centered on the radial cuts made in Step 1. Place chain thread end through the knuckle, screw chain handle on until thread end is fully engaged in handle body. Wrap chain around pipe and put chain ears into notches on body. Repeat for second chain, lightly tighten both chains.

Step 4

Rotate the AX416 approximately 90 degrees until the carriage handle is vertical. Visually ensure that all four gripper pads are contacting the pipe evenly. Tighten chain handles to secure the AX416 to the pipe.

Step 5

Turn the Tee-handle until it stops. The cutter wheels are now in contact with the pipe.

Step 6

Move the handle back and forth, the full stroke of the carriage. Stop in the middle of the cut to turn the Tee-handle clockwise, feeding the cutter wheels into the pipe. Repeat until the cutter wheels break through the pipe. Note: Cutting oil should be applied to the cutter wheels to aid in cutting and extend the life of the cutter wheels.

Step 7

After slot is complete, continue to move carriage handle back and forth while you remove the cutter wheels from the pipe, by turning the Tee-handle counter-clockwise. This helps relieve stress on the cutter wheels.

Step 8

Loosen the chain handles slightly, rotate the AX416 180 degrees and tighten the chain handles. Repeat steps 5-7.

Step 9

When window is cut into the pipe, remove the AX416 from pipe. To ensure that the tool life is optimized, clean any and all debris (dirt, metal, etc) from the AX416. On to the next job.

Made in the USA

Progressive Edge Machining Denver, PA