



PIPE TOOLS & VISES
SINCE 1896



Operating Instructions

Low Clearance Rotary™ Cutters

For cutting steel, ductile iron and cast iron pipe

Catalog No.	Item Code	Pipe Capacity			Length		Weight	
		Steel	Cast Iron & Ductile	Actual Ø mm	in	mm	lbs	kg
LCRC4I	03306		2" - 4"	60 - 125	19	483	9.5	4.3
LCRC4S	03307	2" - 4"		60 - 125	19	483	9.5	4.3
LCRC8S	03309	6" - 8"		159 - 246	58	1473	52	24
LCRC8I	03308		6" - 8"	159 - 246	58	1473	52	24
LCRC12S	03313	10" - 14"		266 - 358	61	1549	60	27
LCRC12I	03312		10" - 12"	266 - 358	61	1549	60	27
LCRC16S	03317	16" - 18"		368 - 462	66	1664	72	33
LCRC16I	03316		14" - 16"	368 - 462	66	1664	72	33

Operating Instructions

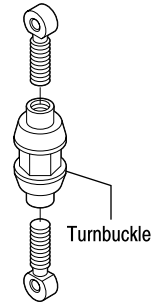
First, inspect the wheels to insure they suit the type of pipe that is to be cut. The cutter wheel chart (Fig. 1) identifies the proper wheel for each application.

Fig. 1

CUTTER WHEEL CHART FOR LOW CLEARANCE ROTARY™ CUTTERS

Item Code	Std. Cat. No.	Std. Pkg.	Reed Cutter	Blade Exposure		Application
				Inches	mm	
03504	HS4	4	LCRC4; H4	0.320	8.1	Steel; Stainless Steel
03505	HSI4	4	LCRC4; H4	0.275	7.0	Steel; Stainless Steel; Cast Iron; Ductile Iron
03512	HX4	4	LCRC4; H4	0.383	9.7	Steel; Stainless Steel; Schd 80
03530	RCS8-36	4	LCRC8; LCRC12; LCRC16; RC20; RC24; RC30; RC36	0.635	16.1	Steel; Stainless Steel
03535	RCI8-30	4	LCRC8; LCRC12; LCRC16; RC20; RC24; RC30; RC36	0.500	12.7	Cast Iron; Ductile Iron (manual)
03545	RCDX	4	LCRC8; LCRC12; LCRC16; RC20; RC24; RC30; RC36	0.531	13.5	Heavy Cast Iron; Ductile Iron (power)
03550	RCX	4	LCRC8; LCRC12; LCRC16; RC20; RC24; RC30; RC36	0.800	20.3	Heavy Wall Steel; Stainless Steel

Make sure bolted rod ends are in proper location for size of pipe to be cut. Turnbuckles should be unscrewed equally until the rod end eye center is about 2 1/4" (57 mm) from the end of the turnbuckles. 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 turnbuckles evenly until all 4 wheels touch the pipe. Tighten the turnbuckles every 1/2 revolution of the cutter. The turnbuckles may also be used to pull the cutter around the pipe.



NOTE: Tighten the turnbuckles 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 turnbuckle 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 with a Reed Descaler (Fig. 2). This will help save cutter wheels and cutting time; and helps square the cutter on the pipe to insure tracking.

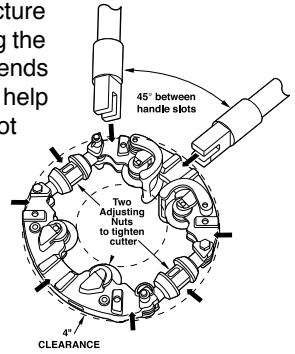
Fig. 2

PIPE DESCALERS

Cat. No.	Item Code	Pipe Capacity		Length	
DS12	08000	3 - 12 in	70 - 300 mm	32 in	810 mm
DS36	08006	3 - 36 in	70 - 910 mm	44 in	1110 mm
DS12B	08008	3 - 12 in	70 - 300 mm	45 in	1143 mm

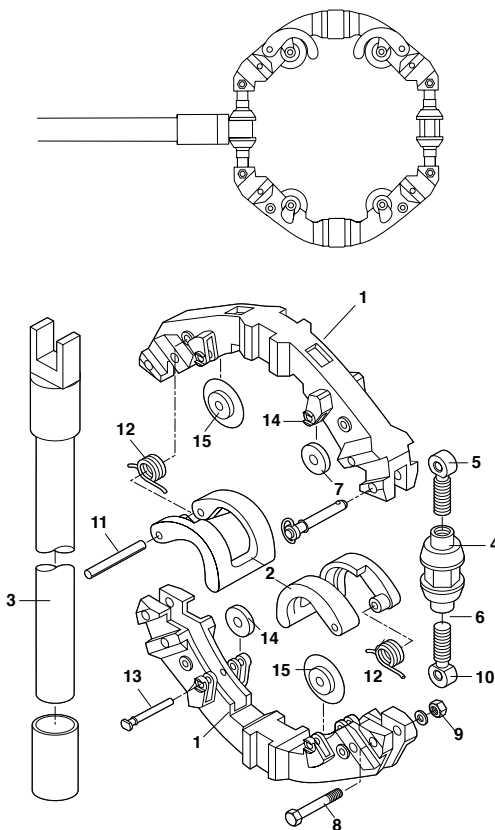
HELPFUL HINTS: While cast and ductile iron pipe will fracture along the cut line after penetrating part way, continue feeding the wheels in to make sure the cut is completed. Ductile iron tends to work harden. Continuous feeding and maximum pressure help prevent this. In the event that cutter wheels 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



Low Clearance Rotary™ Cutters

Replacement Parts



LCRC4 Rotary Cutter Parts List

Ref. No.	Description	Item Code	Qty.
1	Feed Screw	96293	2
2	Quick Release Pin	97545	2
3	HS4 Guide	93046	2
4	Handle	97219	1
5	Machined Yoke	96292	2
6	HS4 Cutter Wheel	03504	4
7	Guide Pin	30030	2
8	Feed Nut	96294	2
9	Guide Spring	40035	2
10	HS4 Wheel Pin	93310	4
11	Handle End	96291	1

Parts List

Ref. No.	Description	LCRC8		LCRC12		LCRC16	
		Item Code	Qty. Used	Item Code	Qty. Used	Item Code	Qty. Used
1	Yoke	93094	2	93095	2	93096	2
2	Guide	93165	2	93166	2	93166	2
3	Handle Assembly	93176	1	93176	1	93176	1
4	Turnbuckle	93169	2	93169	2	93169	2
5	Rod End Right Hand	93172	2	93172	2	93172	2
6	Rod End Left Hand	93173	2	93173	2	93173	2
7	Release Pin	40147	2	40147	2	40147	2
8	Cap Screw	30091	2	30091	2	30091	2
9	Lock Washer	30093	2	30093	2	30093	2
10	Hex Nut	30150	2	30150	2	30150	2
11	Guide Pin	30090	2	30090	2	30090	2
12	Guide Spring	40321	2	40151	2	40340	2
13	Wheel Pin Assembly	93200	4	93200	4	93200	4
14	Roller	93220	8	93220	8	93220	8
15	Cutter Wheel	See cutter wheel reference chart in catalog or price list.					