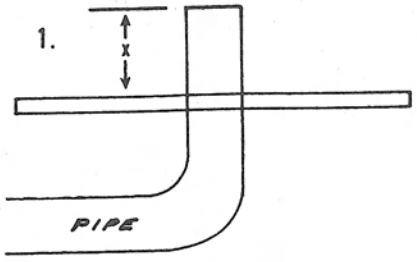
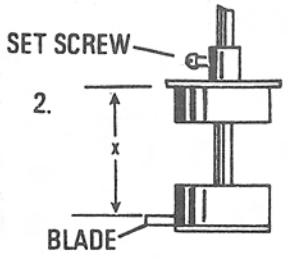
1. Measure desired **"X"** depth

2. Set "X" cutting depth and tighten set screw securely to avoid any change in the **"X"** depth while cutting.

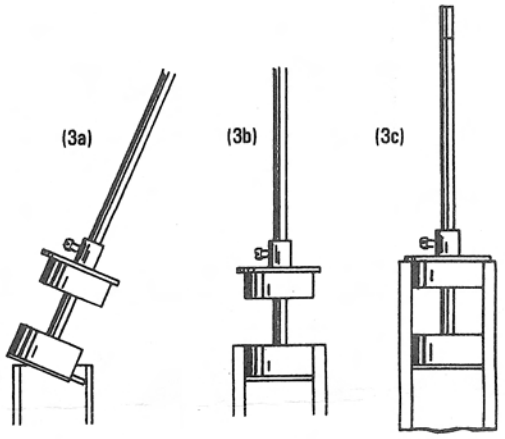




3a. Tip at a shallow angle so that the blade is inside pipe.

3b. Push to depress blade until blade drum will enter pipe.

3c. Push tool into pipe until flange contacts end of pipe.

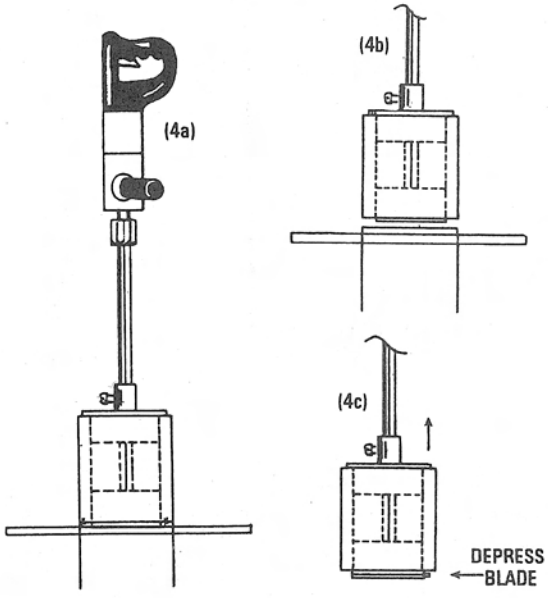


4a. Chuck shaft in HD ½" Drill Motor, ½" capacity, 350-450rm, 4.5-6 rated amps. Keep flange in contact with end of pipe and turn on drill motor. Be sure rotation is clockwise (normal forward). The blade will self feed until cut-off is complete.

NOTE: Hold trigger grip and side handle securely To control torque reaction.

4b. The cut-off portion will remain on the tool.

4c. Depress blade, flush with cutter drum and pull tool out of cut-off portion of pipe.



When the blade is cutting properly, there is a noticeable Torque load which will slow the drill down to about 2/3 of its no-load RPM. Under these conditions a fast cut with very little heat will result.

If the drill is running at or near its no-load RPM the blade IS NOT cutting a positive chip and will generate excessive heat which will soften the plastic and result in a slow cut. This can be caused by:

1. A dull blade
2. Hot chips clogging the blade

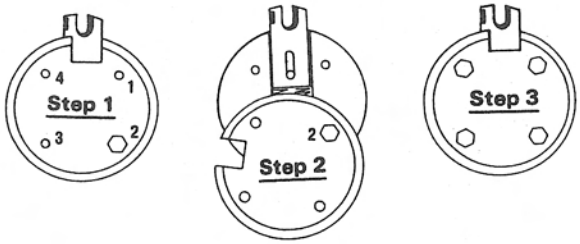
If this happens DONOT continue running the drill at constant speed. Stop for about 30 seconds so the plastic can cool. Now operate the drill in short pulses. This will avoid excessive heat and will usually result in a positive cutting action.

Blade Replacement Instructions

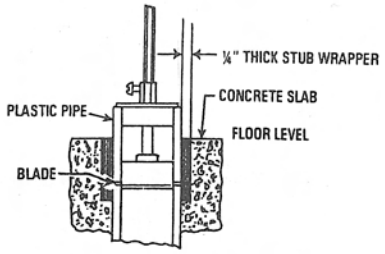
Step 1 Remove screws 1,3,4
Loosen screw 2 – ½ to ¾ turn

Step 2 Swivel retainer plate counterclockwise (left) until it just clears the end of the blade, NO FURTHER, to prevent springs from popping out of tool. Lift out old blade and place new blade in the tool as shown. If blade is in backwards, the tool will not cut. Lubricate the blade, blade cavity and spring cavity with powered graphite.

Step 3 Swivel retainer plate back into place, replace and tighten all four screws.



WHEELER REX PIPE TOOLS



Caution:

DO NOT attempt to cut-off below floor level Without a ¼" thick, soft stub wrapper or equal clearance around outside of pipe. The blade **WILL BE SEVERELY DAMAGED** if it contacts The concrete slabs or other hard floor material.