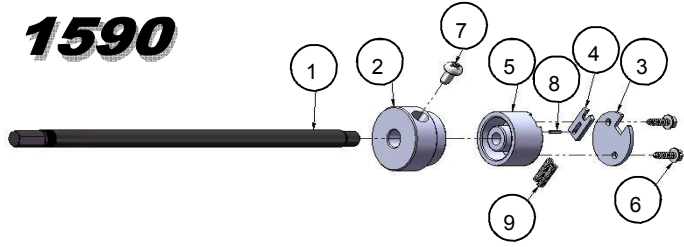


# Internal Pipe Cutter - Parts and Operation

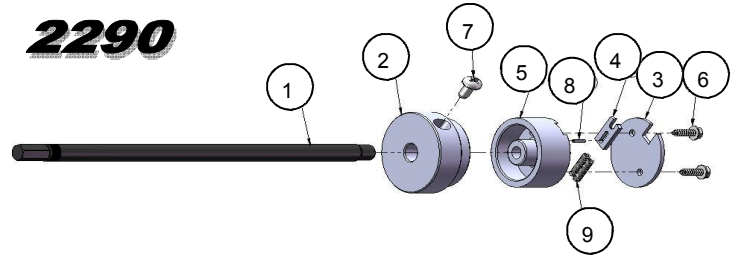
| ITEM NO. | PART NUMBER | DESCRIPTION                            | QTY. |
|----------|-------------|--|------|
| 1        | 2295        | DRIVE SHAFT                            | 1    |
| 2        | 1294        | FLANGED DRUM                           | 1    |
| 3        | 1291        | RETAINER PLATE                         | 1    |
| 4        | 1293        | BLADE                                  | 1    |
| 5        | 1295        | CUTTER DRUM (MACHINE)                  | 1    |
| 6        | 275427      | #10-24 x 5/8" SLTD HX WSHR HD, TYPE F  | 2    |
| 7        | 275432      | 1/4-20 x 1/2" FILLISTER HEAD, PHILLIPS | 1    |
| 8        | 275143      | 3/32" DIA x 5/16" ROLL PIN             | 1    |
| 9        | 275482      | SPRING                                 | 2    |

**1590**



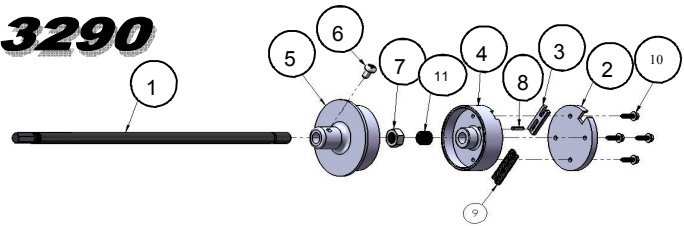
| ITEM NO. | PART NUMBER | DESCRIPTION                            | QTY. |
|----------|-------------|--|------|
| 1        | 2295        | DRIVE SHAFT                            | 1    |
| 2        | 2294        | FLANGED DRUM                           | 1    |
| 3        | 2291        | RETAINER PLATE                         | 1    |
| 4        | 1293        | BLADE                                  | 1    |
| 5        | 2293        | CUTTER DRUM (MACHINED)                 | 1    |
| 6        | 275427      | #10-24 x 5/8" SLTD HX WSHR HD, TYPE F  | 2    |
| 7        | 275432      | 1/4-20 x 1/2" FILLISTER HEAD, PHILLIPS | 1    |
| 8        | 275143      | 3/32" DIA x 5/16" ROLL PIN             | 1    |
| 9        | 275482      | SPRING                                 | 2    |

**2290**



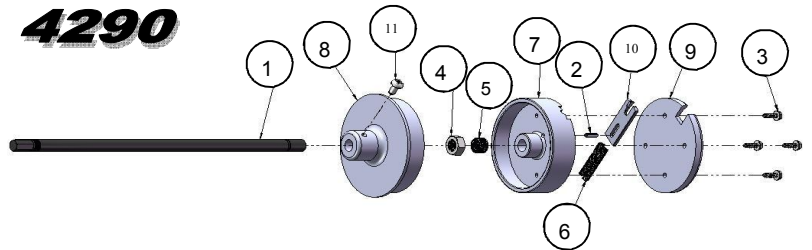
| ITEM NO. | PART NUMBER | DESCRIPTION                            | QTY. |
|----------|-------------|--|------|
| 1        | 3296        | DRIVE SHAFT                            | 1    |
| 2        | 3291        | RETAINER PLATE                         | 1    |
| 3        | 3293        | BLADE                                  | 1    |
| 4        | 3294        | CUTTER DRUM ASSEM                      | 1    |
| 5        | 3297        | FLANGED DRUM                           | 1    |
| 6        | 275432      | 1/4-20 x 1/2" FILLISTER HEAD, PHILLIPS | 1    |
| 7        | 4117        | 1/2"-20 HEX JAM NUT                    | 1    |
| 8        | 275428      | 5/32" DIA x 1/2" ROLL PIN              | 1    |
| 9        | 275429      | Spring 1/4" DIA x 2 1/2" LONG          | 2    |
| 10       | 275427      | #10-24 x 5/8" SLTD HX WSHR HD, TYPE F  | 4    |
| 11       | 275774      | HELICOIL INSERT 1191-8CN-0500          | 1    |

**3290**



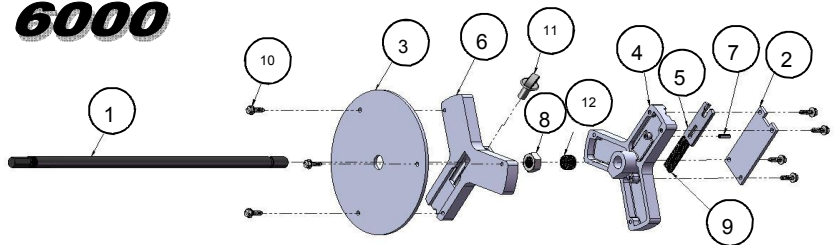
| ITEM NO. | PART NUMBER | DESCRIPTION                            | QTY. |
|----------|-------------|--|------|
| 1        | 3296        | DRIVE SHAFT                            | 1    |
| 2        | 275428      | 5/32" DIA x 1/2" ROLL PIN              | 1    |
| 3        | 275427      | #10-24 x 5/8" SLTD HX WSHR HD, TYPE F  | 4    |
| 4        | 4117        | 1/2"-20 HEX JAM NUT                    | 1    |
| 5        | 275774      | HELICOIL INSERT 1191-8CN-0500          | 1    |
| 6        | 275429      | Spring 1/4" DIA x 2 1/2" LONG          | 2    |
| 7        | 4294        | CUTTER DRUM ASSEM                      | 1    |
| 8        | 4297        | FLANGED DRUM                           | 1    |
| 9        | 4291        | RETAINER PLATE                         | 1    |
| 10       | 4293        | CARBIDE TIPPED BLADE                   | 1    |
| 11       | 275432      | 1/4-20 x 1/2" FILLISTER HEAD, PHILLIPS | 1    |

**4290**

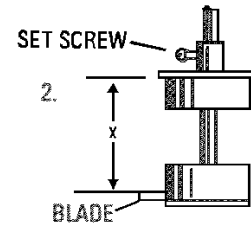
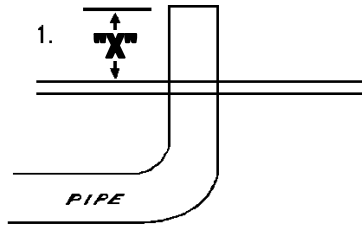


| ITEM NO. | PART NUMBER | DESCRIPTION                           | QTY. |
|----------|-------------|---------------------------------------|------|
| 1        | 3296        | DRIVE SHAFT                           | 1    |
| 2        | 700076      | BLADE COVER                           | 1    |
| 3        | 700025      | GUIDE PLATE                           | 1    |
| 4        | 700085      | CUTTER DRUM (MACHINED)                | 1    |
| 5        | 4293        | CARBIDE TIPPED BLADE                  | 1    |
| 6        | 700084      | DEPTH GAGE (MACHINED)                 | 1    |
| 7        | 275428      | 5/32" DIA x 1/2" ROLL PIN             | 1    |
| 8        | 4117        | 1/2"-20 HEX JAM NUT                   | 1    |
| 9        | 275429      | Spring 1/4" DIA x 2 1/2" LONG         | 2    |
| 10       | 275427      | #10-24 x 5/8" SLTD HX WSHR HD, TYPE F | 7    |
| 11       | 275707      | 5/16-18 x 1" THUMBSCREW               | 1    |
| 12       | 275774      | HELICOIL INSERT 1191-8CN-0500         | 1    |

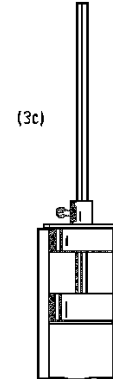
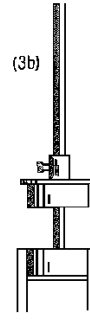
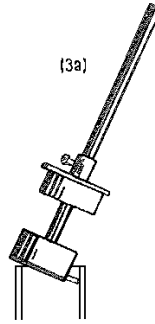
**6000**



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.

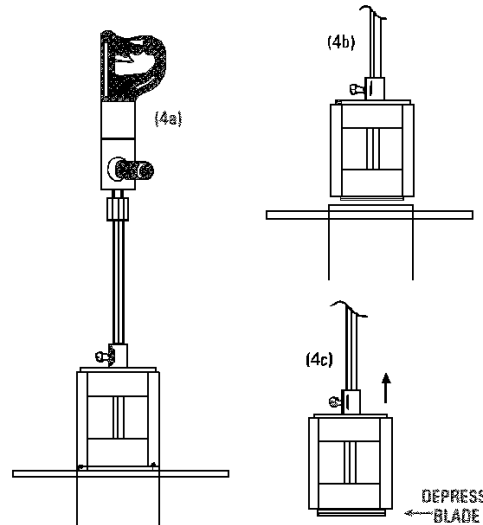


- 3a. Tip at a shallow angle so that the blade is inside of the pipe.
- 3b. Push to depress blade until blade drum will enter the pipe.
- 4a. Chuck shaft in HD 1/2" drill motor, 1/2" capacity, 350-450rpm, 4.5-6 amps. Keep flange in contact with the end of the pipe and turn on drill motor. Be sure rotation is clockwise (normal forward). The blade will self feed until the 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 the 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 DO NOT 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.

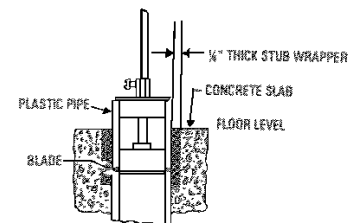
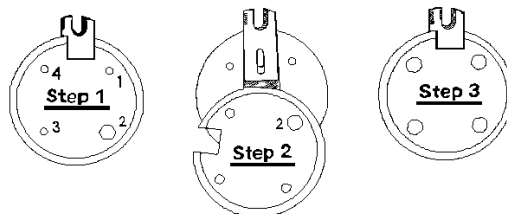
### Blade replacement instructions

**Step 1.** Remove screws 1, 3, 4

Loosen screw 2 - 1/2 to 3/4 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 show. 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.



**CAUTION:** Do Not attempt to cut-off below floor level without a 1/2" thick, soft stub wrapper or equal clearance around the outside of the pipe. The blade will be **severely damaged** if it contacts the concrete slabs or other hard floor materials.





## WHEELER-REX LIMITED LIFETIME WARRANTY

WHEELER-REX covers its products with a Limited Lifetime Warranty, with exception of pipe threading machines which have a Limited Three Year Warranty (including electric motors). Warranties from manufacturers of components used in our products may pre-empt the Wheeler-Rex warranty. Wheeler-Rex warranties against defects in material or workmanship. To take advantage of this warranty, the complete product must be delivered prepaid to Wheeler-Rex or any WHEELER-REX AUTHORIZED SERVICE CENTER. No tools are to be returned to the factory without receiving prior authorization. Obviously, failures due to misuse, abuse, or normal wear and tear are not covered by this warranty. **NO OTHER WARRANTY, WRITTEN, OR ORAL, APPLIES. THERE ARE NO WARRANTIES WHICH EXTEND BEYOND THE DESCRIPTION ON THE FACE HEREOF.** No employee, agent, dealer, or other person is authorized to give any warranty on behalf of Wheeler-Rex. Warranted products will be repaired or replaced at our option, at no charge and returned to you via prepaid transportation. Such replacement or repair is the exclusive remedy available from Wheeler-Rex. Wheeler-Rex is not liable for damage of any sort, including incidental and consequential damages. Some U.S.A. states do not allow the exclusion or limitation of incidental or consequential damages, so the above limitation or exclusion may not apply. This warranty gives you specific legal rights, and you may also have other rights which vary from state to state.

Form # 1031

## WARNING

### GENERAL TOOL OPERATION WARNINGS

#### FOR ALL TOOLS-

1. **Keep Guards in Place** and in working order.
2. **Remove Adjusting Keys and Wrenches** from tool before turning it on.
3. **Keep Work Area Clean.** Cluttered areas and benches invite accidents.
4. **Avoid Dangerous Environment.** Don't use power tools in damp or wet locations. Keep work area well lit. Don't expose power tools to rain.
5. **If you must use an electric tool** in a damp or wet location; make sure it is plugged into a circuit which is protected by a ground fault interrupt.
6. **Keep Children Away. ALL VISITORS SHOULD BE KEPT A SAFE DISTANCE FROM WORK AREA.**
7. **Store Idle Tools** in dry, high, or locked-up place out of reach of children.
8. **Don't Force Tool.** It will do a better and safer job at the rate for which it is designed.
9. **Use Right Tool.** Don't force a small tool or attachment to do the job of a heavy-duty tool.
10. **Wear Proper Apparel.** No loose clothing or jewelry to get caught in moving parts. Rubber gloves and footwear are recommended when working outdoors.
11. **Use Safety Glasses.**
12. **Don't Abuse Cord.** Never carry tool by cord or yank it to disconnect from receptacle. Keep cord from heat, oil, and sharp edges.
13. **Secure Work.** Use clamps or vise to hold work when practical. It's safer than using your hand and it frees both hands to operate tool.
14. **Don't Overreach.** Keep proper footing and balance at all times.
15. **Maintain Tools Properly.** Keep tools sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories. Equipment operators must have proper maintenance & instruction sheets. Be sure the tool operator reads and understands this information. If you don't have current maintenance and instruction sheets, contact the factory & we will supply them at no charge.
16. **Disconnect Tools** when not in use; before servicing; when changing accessories such as dies, cutters, etc.
17. **Avoid Accidental Starting.** Don't carry plugged-in tool with finger on switch. Be sure switch is off when plugging in.
18. **Outdoor Use Extension Cords.** When tool is used outdoors, use only extension cords suitable for use outdoors and so marked.
19. **Wear Ear Protection** if exposed to long periods of very noisy shop operations.
20. **Do not operate tools** while under the influence of alcohol, drugs or medication.