Core Cutter Parts

1. Adjustable support roller
2. Cutting platen
3. Rotary knife with guard
4. Variable limitation roller (cutting depth adjustment)
5. Momentary push button for machine operation
6. Measuring bar (Adjustable core stop not shown)
7. Drive Chuck

Machine Operation

1. (To adjust the depth of cut) Set the variable limitation roller 4 by placing a sample piece of core over the cutting platen 2 slightly beyond the knife and under the limitation roller. Lower the cutting knife past the edge of the core till it just touches the platen. While keeping the knife in contact with the platen, turn the adjustment knob (to raise or lower the limitation roller) until the roller touches the core surface, then tighten the variable limitation roller knob.

2. (adjust support roller) Swing adjustable support roller 1 to the up position. Raise adjustable support roller to put slight pressure against the core. Tighten thumb screw, allow roller to drop away.

3. On the measuring bar 6 set the adjustable core stop (not shown in this photo) to the desired length of core to be cut.

4. Remove sample core and replace it with the core that is to be cut. Lower the adjustable core stop (not shown) and slide the core out against it. Then raise the adjustable core stop so that it is clear of the core to be cut.

5. Swing the adjustable support roller 1 up and hold in place against the core with one hand, while lowering the momentary switch handle 5 with the other hand (power machine by depressing momentary switch while lowering the handle).

6. The cut piece of core will rest on the extension bar/disc (not shown).

The operator has both hands occupied during the entire cutting process; this minimizes any accidental contact with the rotary knife.
Instructions

General Operation
Plug machine into any 110 volt outlet. Operation of the machine for cutting is controlled from the momentary push button switch mounted in the handle of the cutting arm.

To Cut
1. Slide core over cutting platen and onto the drive chuck. The chuck is self-locking when machine is in rotation.
2. Move the adjustable core stop along the measuring bar to the desired length of cut and lock into position. Pull arm down to stop position.
3. Slide the core to the right along the mandrel until it rests against the adjustable core stop.
4. With one hand, raise the support roller (red knob) and hold it in the up position all during the cutting operation. The cutter arm is brought down with the other hand and the momentary switch in the handle is depressed to start the machine. It will be noted that both hands are occupied during the cutting operation, presenting a desirable safety feature.

The mandrel and rotary knife were made to rotate outwardly as a safety feature, thus preventing anything being drawn in between the knife and core during the cutting operation.
Cutting Platen Assembly - Figure 1

The cutting platen assembly consists of a plastic cutting platen bolted with three (3) cap screws to a metal drive collar. The drive collar contains a half dog point set screw for locking in the keyway of the mandrel. After long cutting service the platen can be removed and replaced as follows:

- Loosen set screw and remove assembly from the mandrel.
- Remove the three (3) retainer screws. Replace old platen with new one.
- Replace screws and tighten.

The life of the cutting platen can be greatly enhanced by moving it laterally along the mandrel to new cutting positions when required. Increments of movement can be as close as 1/16” or even less.

Extension Support Disc - Figure 1

This bar and support disc is used to support the cut portion of core during and after the cutting operation. This is an indispensable feature when cutting long length cores. The bar is held into the mandrel by a ball plunger and can be snapped in or out as required.

Core Cutter Legs Assembly - Figure 2

Assemble machine legs as shown with the angle legs facing inward. Use the four (4) bolts supplied and bolt frame and legs together with the bevel washer resting on the channel.
**Rotary Cutter Assembly** - Figure 3

The cutter assembly contains our unique and adjustable limitation roller. The function of the limitation roller is to limit the depth of knife penetration into the cutting platen. It guarantees that, regardless of the amount of cutting pressure applied by the operator, the depth of penetration will remain constant and increase the life of the platen.

**To Adjust the Limitation Roller**

1. Slide a core (of the wall thickness to be used) over the mandrel (Figure 2) slightly beyond the knife and under the limitation roller.
2. Pull Cutter Arm down until the rotary cutter knife touches the plastic cutting platen and hold down until instructions (3) and (4) are completed.
3. Turn the adjustment knob (to raise or lower the limitation roller) until the roller touches the core surface.
4. Continue to turn the adjustment knob until most of the resiliency of the rubber has been removed.
   
   A little experience at adjusting will provide the minimum of cutter penetration and will prolong the life of the cutting platen. To replace the rotary cutter knife, insert a steel rod through Hole “A” in cutter shaft (behind knife) to hold shaft while backing off nut. After replacing cutting knife, hold shaft again with steel rod and tighten nut.

**Support Roller** - Figure 4

The support roller underneath the cutting platen must be used always. It not only gives support to the core, but also prevents excessive deflection of the mandrel during the cutting operation. From a safety standpoint as described in Instruction #2 of the General Operation (page 2) it should become mandatory. It has an up and down adjustment to suit the various core diameters, and is locked in position by a thumb screw.
Measuring bar - Figure 5

The measuring bar contains a built in scale that is set so that the edge of the rotary cutter knife represents “0” on the scale. The leading edge of the adjustable core stop arm is flush across to the scale so that a direct reading on the scale can be obtained.

The measuring bar will be found in a reversed position when the machine is received. This is done for more compact shipping. When setting up the machine, loosen the set screw on the top of the upright stanchion, remove the bar and reinsert into its proper operating position, making sure that the scale is on top.

Power Source

½ H.P. General All Purpose Single Phase, 115/230 Volt, 60 cycle Capacitor Start 1140 RPM Motor.

Lubrication

Ball bearings on cutter shaft are greased sealed for life. Mandrel Pillow Blocks are equipped with grease fittings for normal lubrication.

The sliding action of the drive chuck along the mandrel, along with the core stop on the measuring bar, can be enhanced by an occasional wiping of the mandrel and measuring bar with light oil.

Warranty

Core Cutters manufactured by us will function as specified on new cores or cores in reasonably used condition. We will replace all parts that prove defective in material or workmanship for a period of one year from date of delivery, provided they have been subject to proper usage. However, this does not include the replacement of parts that have been subject to normal wear such as the rotary cutter, cutting platen, rubber support roller and limitation roller. Commercial Component parts are warranted to original manufacturers guarantee.

The manufacturer is not responsible for any injuries caused by the improper use of the equipment by the purchaser or any of his employees or agents. Protect yourself and others by observing all safety information included in this manual.